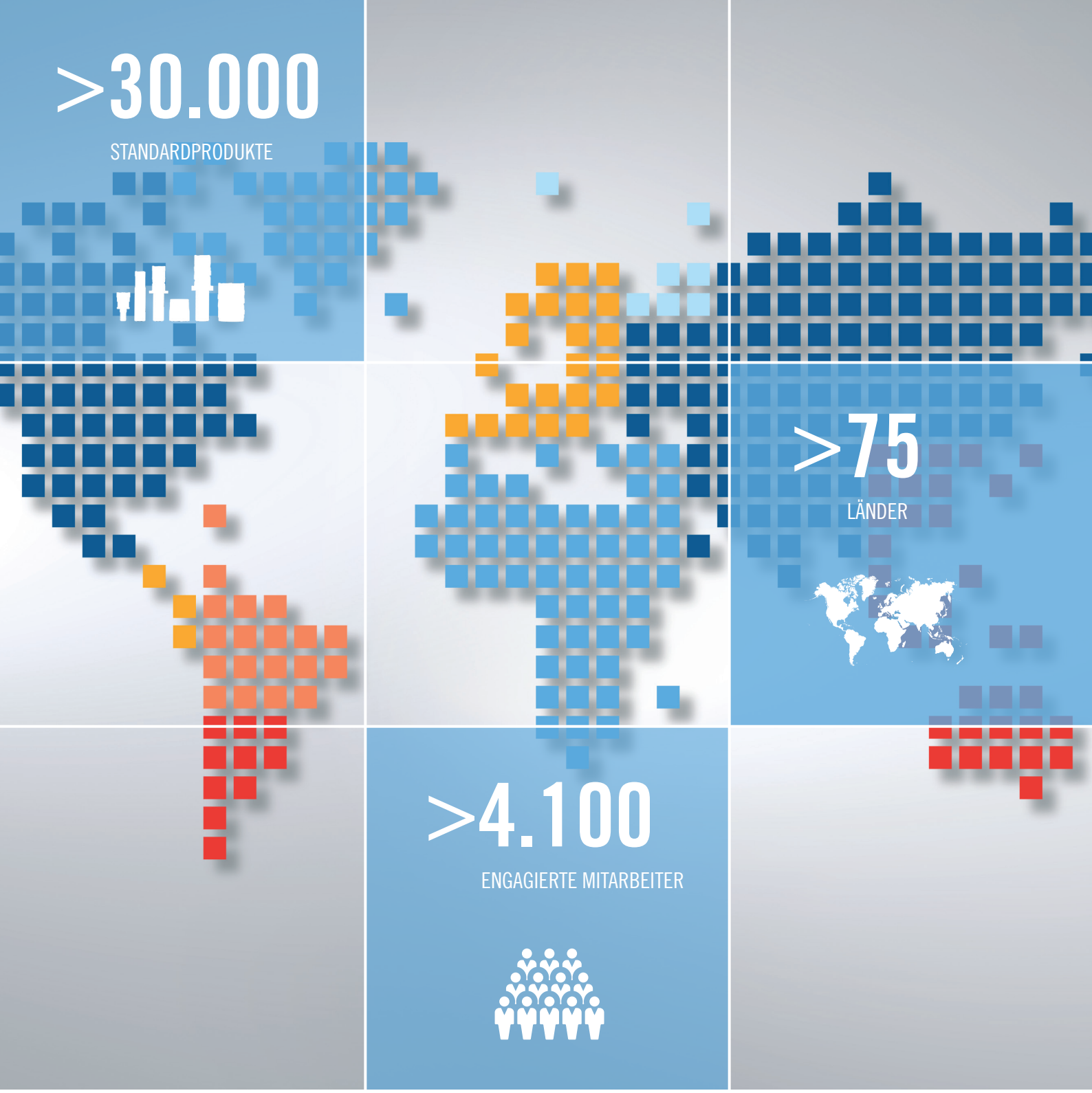


KATALOG & TECHNISCHER GUIDE 2022

FRÄSEN - VOLLHARTMETALL

SECO



EXZELLENTE ZERSPANUNGSLÖSUNGEN

Seco ist einer der weltweit führenden Anbieter von effizienten Zerspanungslösungen. Basierend auf umfassendem Know-how und praktischer Erfahrung optimiert Seco gemeinsam mit seinen Kunden die vielfältigen Prozesse in der spanenden Fertigung. Das Angebot umfasst leistungsstarke Präzisionswerkzeuge für alle Technologien sowie ergänzende Service- und Dienstleistungen: vom Lagermanagement über Maschinenausrüstung, digitales Datenmanagement und Webanwendungen bis hin zur Prozessanalyse der gesamten Fertigung.

www.secotools.com

VOLLHARTMETALLFRÄSER



Jabro Tools bei Lottum, Niederlande, wurde 1976 gegründet und ist seit 2001 eine Tochtergesellschaft von Seco Tools.
Durch kontinuierliche Forschung und permanente Verbesserung des Fertigungsprozesses hat sich Jabro Tools im Laufe der Jahre eine führende Position im Markt erobert.

Die Produkte erfüllen die hohen Anforderungen der High-Tech-Industrie. Seco Jabro fertigt Präzisionswerkzeuge aus Vollhartmetall, in Standard- und in Sonderausführung, für Kunden in den unterschiedlichsten Industriezweigen,

wie z. B.:

- Allgemeiner Maschinenbau
- Werkzeug- und Formenbau
- Luft- und Raumfahrt
- Medizintechnik
- Energieerzeugung
- 3C (Computer, Elektronik (Customer Electronics) und Kommunikation (Communication))

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Übersicht Produktfamilien

SOLID²



Maßstäbe in Leistungsfähigkeit
Die universell einsetzbaren Vollhartmetallfräser sind einfach in der Handhabung und bieten in nahezu allen Werkstoffen ein breites Anwendungsspektrum zu einem hervorragenden Preis-/Leistungsverhältnis.
- Leistungsoptimierte Ausführungen
- Hochflexibler Einsatz durch Längenvielfalt
- Typen JS1x - Hochflexible Werkzeuge für alle Bearbeitungen in Stahl, Rostfrei und Guss
- Typen JS5x - Leistungsoptimierte Universalwerkzeuge für alle Bearbeitungen in Stahl, Rostfrei und Guss. Jabro-Solid² ist verfügbar im Durchmesserbereich von 1 bis 32 mm und in *Zoll 1/32 - 1 1/4*.

Jabro-Solid² beinhaltet auch eine Reihe spezieller leistungsfähiger Fräser für dynamisches Fräsen (JS564 und JS565).
Diese Werkzeuge zeigen eine extrem hohe Leistungsfähigkeit bei klar definiertem Werkzeugweg mit konstantem Kontaktbogen, bei hohen Schnittgeschwindigkeiten und gleichzeitig großer Schnitttiefe.
Alle Fräser der JS500-Reihe verfügen über Fasen (c*45°) mit den folgenden Toleranzen: c = DC</=3=+0,01, 3<DC</=6=+0,02, 6<DC</=10=+0,03, 10<DC</=14=+0,04, 14<DC</=18=+0,05, 18<DC</=24=+0,06,
Alle Jabro-Solid² Produktbezeichnungen sind mit „JS“ gekennzeichnet.
Einen Überblick über alle Produkte der JS² -Reihe finden Sie auf Seite 9.

HSM/TORNADO



Diese Werkzeuge zeichnen sich aus durch hohe Maßtoleranz, kurze Schneiden, Reduzierung des Außendurchmessers und größere Kerndurchmesser für mehr Steifigkeit. Sie eignen sich speziell für Hochgeschwindigkeitsbearbeitung.
Einen Überblick über alle Produkte der HSM/TORNADO-Reihe finden Sie auf Seite 9.

HPM



Hohe Zeitspanvolumen
Ein komplettes Programm an Vollhartmetallfräsern, speziell entwickelt für hohe Zeitspanvolumen in verschiedenen Werkstoffen.
- Durchmesserbereich 2 bis 25 mm
- Speziell angepasste Geometrien und Beschichtungen für einzelne Werkstoffgruppen
- Alle HPM-Produktgruppen sind mit „JHP“ gekennzeichnet.

Einen Überblick über alle Produkte der HPM-Reihe finden Sie auf Seite 10.

HFM



Kosteneffizienter Einsatz
Ein Komplettprogramm an Vollhartmetallfräsern für die Bearbeitung mit hohen Vorschubgeschwindigkeiten. Auch zum Tauchfräsen bestens geeignet.
- Durchmesserbereich von 1 bis 12 mm
- Geringe Vibrationsneigung auch bei großen Werkzeugauskragungen aufgrund geringer radialer Schnittkräfte
- Alle HFM-Produkttypen sind mit „JHF“ gekennzeichnet.

Einen Überblick über alle Produkte für die Hochvorschubbearbeitung finden Sie auf Seite 10.

Übersicht Produktfamilien

MINI



Das Programm an Mini-Fräsern besteht aus Schaftfräsern und Kugelkopffräsern mit kleinen Durchmessern. Universal-Werkzeuge eignen sich für die meisten Werkstoff-Gruppen. Spezifische Werkzeuge eignen sich für Graphite und gehärteten Stahl. Alle Werkzeuge sind mit einer dünnen Beschichtung für optimale Leistung versehen.
Einen Überblick über alle Produkte der MINI-Reihe finden Sie auf Seite 10.

DIAMOND



Verfügbar in einer großen Anzahl an Geometrien in einem großen Durchmesserbereich mit bestmöglichem Substrat für perfekte Adhäsion der Diamantbeschichtung. Die Schaftfräser erhöhen die Produktivität deutlich dank weniger Werkzeugwechsel und hoher Präzision bei hohem Vorschub.
Einen Überblick über alle diamantbeschichteten Produkte finden Sie auf Seite 10.

COMPOSITE



Das Produktprogramm besteht aus diamantbeschichteten, unbeschichteten und PKD-Fräsern mit verschiedenen Geometrien sowie Fräser mit eingelöteter PKD-Spitze. Die Werkzeuge sind speziell für schwierige Zerspanungsbedingungen in anspruchsvollen Werkstoffen optimiert.
Einen Überblick über alle Produkte der Composite-Reihe (JC) finden Sie auf Seite 10.

VHM



Beinhaltet universelle beschichtete und unbeschichtete Schaftfräser speziell zur Zerspanung von Kunststoffen und Aluminium, als Fasfräser oder konisch. Die Produkte bestehen aus hochqualitativen Sorten und Beschichtungen für berechenbare Standzeiten.
Einen Überblick über alle Vollhartmetallfräser finden Sie auf Seite 11.

Übersicht Produktfamilien

CERAMIC



Zur Bearbeitung zäher wärmebeständiger Superlegierungen (HRSA) eignen sich speziell die Hochleistungsfräser.
Einen Überblick über alle CERAMIC-Produkte finden Sie auf Seite 11.

HSS-CO



Kobalthaltiger Schnellarbeitsstahl ist eine Premiumsorte für mehr Leistung im Vergleich zu herkömmlichen Schnellarbeitsstählen. Dank mehr Härte weisen diese Vollhartmetallfräser eine längere Standzeit in abrasiven, wärmebeständigen und exotischen Werkstoffen auf.
Das Spannutdesign, die verschleißfeste Beschichtung und optimierte Kühlschmierstoffkanäle sorgen für hohe Qualität und geringere Werkzeugkosten in diesen anspruchsvollen Werkstoffen.
Einen Überblick über alle HSS-CO-Produkte finden Sie auf Seite 11.

Übersicht Produktfamilien

Produktfamilie	Technologie	Produkt	1xx	4xx	5xx	6xx	7xx	8xx	9xx
Jabro-Solid²	Allgemeine Bearbeitung	JS		■	■		■		
Jabro - HPM	Hochleistungsbearbeitung	JHP	■	■			■		■
Jabro - HFM	Hochvorschubbearbeitung	JHF	■						■
Jabro - Mini	Mikrofräsen	JM	■	■	■	■			■
Jabro - HSM/Tornado	Hochgeschwindigkeitsbearbeitung	JH	■	■			■		■
Jabro - Ceramic	Hochleistungsbearbeitung	JCG					■		
Jabro - Diamond	Graphitbearbeitung	JD				■			
Jabro - Composites	Composite-Bearbeitung	JC, JPD						■	
Jabro - VHM	Allgemeine Bearbeitung	J		■					■
Jabro - HSS-E	Allgemeine Bearbeitung	JCO					■		
SMG									
P1-8					■				■
P11-12					■				■
M1-3					■		■		
M4-5					■		■		
K1-7					■				■
S1-3					■		■		
S11-13					■		■		
H			■		■				
N1				■	■				
N2-3				■	■				
N11				■	■				
TS				■				■	
TP				■				■	
GR						■			
Weitere Informationen zu SMG (Seco Werkstoff-Gruppe), siehe Seite 626									

Zusammenfassung

	Seite	Produktfamilie		P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	Honeycomb	GR
	33	JS²	JSE512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	37		JSE513	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	43		JSE514	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	106		JSB512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
	49		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	67		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
	313		JS412						●	●					●			●				
	316		JS413						●	●					●			●				
	319		JS452						●	●					●			●				
	324		JS453						●	●					●			●				
	99		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
	103		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
	108		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
	112		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
	116		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
	120		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	124		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
	91		JS564	●	○	●	●	●	●	●	●	●	●	●								
	95		JS565	●	○	●	●	●	●	●	●	●	●	●								
	238		JS720			●	●						●									
	252		JS730			●	●						●									
	210		JS754		○	●	●					●	●									
	227		JS755		○	●	●					●	●									
	333	HSM/TORNADO	JH40					●	●		●				●							
	197, 371		JH112					●						●								
	361		JH120											●								
	363		JH130											●								
	192, 368		JH142	●	●			●						●								
	374		JH150					●						●								
	376		JH160	●	○									●								
	340		JH410						●		●				●							
	336		JH421						●		●				●			●				
	342		JH440						●	●	●				●			●				
	344		JH450						●	●	●				●			●				
	346		JH460						●		●		●		●			●				
	291		JH710									●	●									
	301		JHB720			●	●		●	●	●	○	●		●			●				
	303		JH721									●	●									
	305		JH722									●	●									
	295		JH730									●	●									
	279		JH734			●							●									
	281		JH736		●	●							●									
	289		JH740									●	●									
	283		JH744		●	●							●									
	285		JH746		●	●							●									
	287		JH770									●	●									
	299		JH780									●	●									
	293		JH790									●	●									
	128		JH910	●	○	●	●	●				●	●					●				●
	132, 365		JH930	●	○			●				●	●	●								
	134, 195		JHB970	●	○	●	●					●	●									

● Erste Wahl ○ Alternative

Zusammenfassung

	Seite	Produktfamilie		P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TP1	TP2-3	TS2/TP2+N1	TS2/TP2+S12	Honeycomb	GR
	355	HPM	JHP170											●								
	256		JHP750									●	●									
	259		JHP760			●	●															
	263		JHP770										●									
	270		JHP780									●										
	259		JHP794			●	●															
	329		JHP490						●	●												
	188		JHP951	●	○			●														
	182		JHP993	●	○			●														
	297		JHP994									●	●									
	358	HFM	JHF181	○	○			●				●	●	●								
	136		JHF980	●	○	●	●	●				●	●	○								
	385	MINI	JMB112											●								
	378		JME142											●								
	383		JME144											●								
	348		JM403/404/406						●	●												
	350		JM413/416						●	●	●				●		●					
	170		JMB542	●	●	●	●		○	○	○		●	○								○
	173		JMB562	●	●	●	●		○	○	○		●	○								○
	177		JMB563	●	●	●	●		○	○	○		●	○								○
	160		JME542	●	●	●	●		○	○	○		●	○								○
	163		JME562	●	●	●	●		○	○	○		●	○								○
	167		JME564	●	●	●	●		○	○	○		●	○								○
	455	MINI DIAMOND	JMB642/JMB662																			●
	455		JMB662																			●
	453		JME642																			●
	445	DIAMOND	JD620																			●
	447		JD630																			●
	449		JD640																			●
	451		JD660																			●
	393	COMPOSITE	JC845													●		●				
	395		JC850													●		●				
	397		JC860													●		●			●	
	399		JC870													●		●			●	
	405		JC871													●		●			●	
	411		JC875													●		●				
	415		JC876													●		●				
	419		JC877													●		●				
	423		JC880													●		●				
	425		JC885													●		●				
	427		JC898																●	●		
	429		JC899																●	●		
	432	PCD	JPD850													●		●				
	434		JPD880													●		●				
	436		JPD890													●		●				

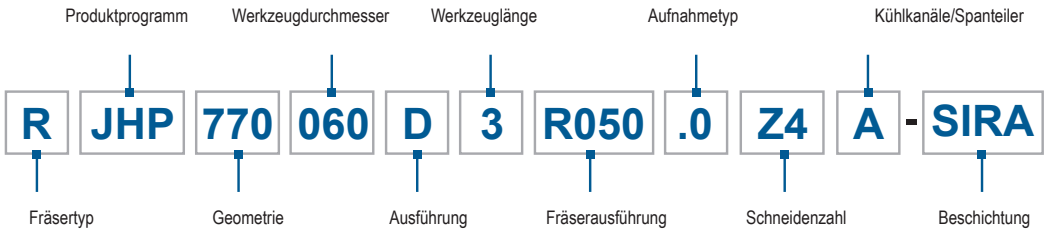
● Erste Wahl ○ Alternative

Zusammenfassung

	Seite	Produktfamilie		P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	Honeycomb	GR
	440	VHM	J28												●							
	143		J36	○	●	○	○	○	○	●	●	○	○		○			○				
	146		HK/HKM	●		●	●	●	●	○		●	●		●			●				
	157		V31	●	○	●	○	●	●	●	●	●	●		●			●				●
	140		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
	438		J93F												●			●				
	277	Ceramic	JCG790									●										
	307	HSS-Co	JCO710			●	●						●									

● Erste Wahl ○ Alternative

Code-Schlüssel



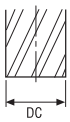
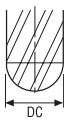
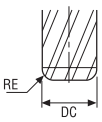
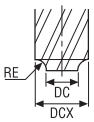
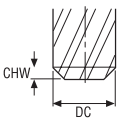
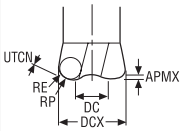
Produktprogramm	Fräsertyp
J = JABRO® VHM JC = JABRO® Composite JD = JABRO® Diamond JH = JABRO® HSM/Tornado JHF = JABRO® HFM JHP = JABRO® HPM JM = JABRO® Mini JS = JABRO® SOLID² JPD = JABRO® PCD JCO = JABRO® HSS-Co JCG = JABRO® Ceramic	Leer = Standard (Katalog) Produkt R = Nachgeschliffenes Produkt (komplett) RK = Nachgeschliffenes Produkt (stirnseitig)

Werkzeuglänge	Schneidenzahl
Eine einzelne Zahl gibt die Werkzeuglänge an, im Vergleich zu anderen Werkzeugen mit derselben Geometrie. Dies ersetzt die früheren Bezeichnungen L, XL, SL, K etc. Bei den meisten Produkten 1 = K, 2 = N, 3 = L, 4 = XL	Anzahl der Schneiden des Fräsers Z. B.: PCEDC 2 = 2 Schneiden, PCEDC 6 = 6 Schneiden

Werkzeugdurchmesser	Kühlkanäle/Spanteiler
Metrisch = 3-stelliger Code (050 = 5 mm) Zoll = 4-stelliger Code (0250 = 1/4") (050 = metrisch, 5 mm) / (.500 = imperial, ½")	Leer = Keine interne Kühlschmierstoffzufuhr A = Mit interner Kühlschmierstoffzufuhr C = Spanteiler

Geometrie	Aufnahmetyp
Eine dreiteilige Zahlenkombination spezifiziert die Schneidgeometrie. Z. B.: 111, 950, 553, 514, etc.	Nennt die verfügbaren Aufnahmetypen .0 = Zylindrisch .3 = Weldon .5 = Whistle Notch .9 = Safe-Lock

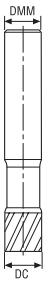
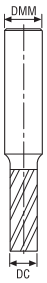
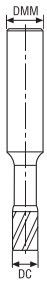
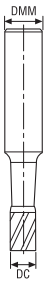
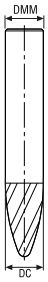
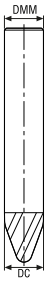
Bezeichnung

Fräserausführung						Beschichtung
Scharfe Schneide	Kugelkopf	Ecken -radius	Konvexradien -fräsen	Eckenfase	Hohe Vorschübe	Ein 4-stelliger Code spezifiziert die Beschichtung des Fräsers.
						MEGA = MEGA MT = MEGA-T M64 = MEGA-64 M64T = MEGA-64-T TRI = TRIBON SIRA = SIRON-A HEMI = HEMI DIA = DIAMOND DURA = DURA NXT = NXT HXT = HXT STAX = STAX
S	B	R...	K...	C	H	

Radiusgröße für Produkte mit konvexem oder konkavem Radius

000 = Für metrische Werkzeuge ist die Ausführung in einem dreistelligen Zahlencode angegeben.
Durch 100 dividiert, erhält man den tatsächlichen Eckenradius in Millimeter.

.000 = Für Werkzeuge in Zollabmessungen ist die Ausführung in einem 4-stelligen Zahlencode angegeben (d. h. ein Punkt, gefolgt von einer dreistelligen Zahl).
Die Abbildung zeigt die Größe des Eckenradius in *Zoll* (e.g. R.100 = Eckenradius 0,100").

Ausführung					
(DC = DMM)		(DC < DMM)			(DC > DMM)
					
D	E	F	G	J	P
Form					
					
N		X		T	

Ihre Vorteile

Individuelle Lösungen - Sonder- und modifizierte Werkzeuge



Falls Standardprodukte nicht für Ihre Anwendung passen, haben wir individuelle Sonderlösungen für Sie. Steigern Sie Ihre Produktivität!
Zusätzlich zu unseren Standardprodukten bieten wir:

Werkzeuge nach Kundenwunsch
Modifizierte Geometrien oder Formwerkzeuge für kundenspezifische Anforderungen. Wir arbeiten mit Ihnen zusammen, um eine passende Lösung zu finden. Zum Beispiel:

- Modifizierte Werkzeuge mit Standard-Geometrie
- VHM-Formfräser für Fasen und Radien (MEP, Mechanised Edge Profiling)
- Tannenbaumfräser
- Schwalbenschwanz
- Konischer Kugelkopf
- Kondylusfräser
- Formwerkzeuge
- Tonnenfräser

Modifizierte Werkzeuge
Für spezielle Anforderungen bietet Seco die Möglichkeit einer schnellen Modifizierung auf Basis von Jabro-Werkzeugen an, wie z.B.:

- Eckenradius/Fase
- Freilegung, inkl. Verlängerung
- Beschichtung (für unbeschichtete Werkzeuge)
- Kleinerer Werkzeugdurchmesser
- Spanbrecher
- Weldon/Safelock
- Externe Kühlschmierstoffzufuhr

NOCH LANGE KEIN GRUND ZUM WEGWERFEN

Dank ihrer hervorragenden Kombination aus Hartmetallsubstraten, hoch verschleißfesten Beschichtungen, optimierter Geometrie und kontrollierter Schneidkantenpräparation zeigen die Hartmetallwerkzeuge der neuesten Generation von Seco bemerkenswerte Leistungen.

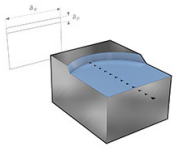
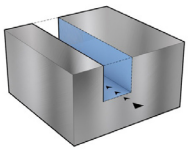
Aber auch die hochwertigsten Werkzeuge weisen früher oder später Zeichen von Verschleiß an der Schneide auf. Bei kontrolliertem Verschleiß und rechtzeitigem Ersatz können diese Werkzeuge wieder aufbereitet werden. Dadurch reduzieren Sie Ihre Anschaffungskosten erheblich. Wir nutzen die gleichen modernen Technologien, um unsere Vollhartmetallfräser nachzuschleifen, wie um neue Fräser herzustellen.

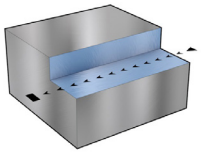
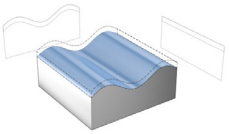
IHRE VORTEILE DURCH NACHSCHLEIFEN

- Die Werkzeuge werden in der original Jabro-Ausführung (Geometrie, Kantenpräparation und Beschichtung) wieder aufbereitet.
- Deutliche Kosteneinsparungen durch wiederholten Einsatz desselben Vollhartmetallwerkzeuges.
- Mit unserer kostenlosen Recondition-Box erhalten Sie gleichzeitig einen vorbereiteten Lieferschein.
- Kostenlose, zuverlässige Abholung am Tag, nachdem Sie Ihren Seco-Kontakt benachrichtigt haben.
- Schneller und einfacher Service - wir haben alles für Sie vorbereitet, Sie brauchen nur noch anzurufen!
- Rücklieferung über den normalen Seco-Lieferweg.
- Sichere Transport- und Lagermöglichkeit der aufbereiteten Werkzeuge durch die gleiche Verpackung wie bei Neuwerkzeugen.
- Ein neuer Versandaufkleber ist beigefügt.
- Recondition ist ein wichtiger Schritt für die Umwelt! Secos Verfahren sind weltweit zertifiziert gemäß ISO14001.
- Die Qualität der einzelnen Verfahren ist durch ISO9001 zertifiziert.



Basisbearbeitungen:

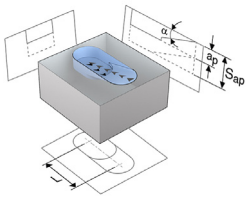
Planfräsen:	Nutfräsen:
Werkstückoberfläche wird erzeugt durch Nebenschneiden. Eingriff: Kleine Schnitttiefe a_p und große Schnittbreite a_e. 	Volle Eingriffsbreite des Fräsers Der volle Durchmesser ist im Eingriff, d.h. a_e entspricht DC und a_p ist bis zu 2 x DC abhängig von der genutzten Zerspanungsmethode. 

Eck-/Konturfräsen:	Kopierfräsen:
Bei der Hauptschneide große Schnitttiefe a_p kleine Eingriffsbreite a_e 	Kleine Spanquerschnitte mit Werkzeugen mit großen Radien (a_p und a_e sind klein). 

Weitere Bearbeitungsstrategien:

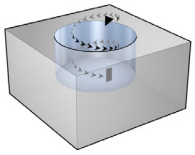
Einwärtskopieren:

Öffnen einer Tasche durch Zustellung in z unter einem Winkel.



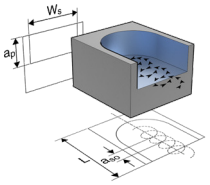
Bohrzirkularfräsen:

Öffnen einer Tasche durch zirkulare Zustellung in z-Richtung.



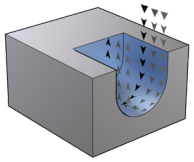
Trochoides Fräsen:

Öffnen einer Nut durch Überlagerung einer Kreisbewegung mit einer Linearbewegung (Trochoides Fräsen ist die Umsetzung von Nutfräsen in Konturfräsen).



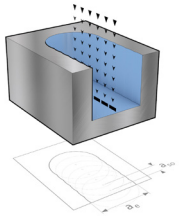
Bohr- und Ziehfräsen:

Bearbeitung einer 3D-Kontur durch bohrende Zustellung.



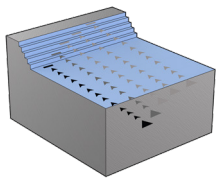
Tauchfräsen:

Öffnen einer tiefen Nut durch Bohrbewegungen in z.



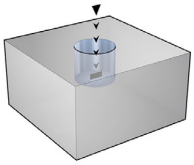
Fräsen in Höhenlinien (Z-Linie):

Bearbeitung einer Oberfläche durch kurze Bohr- und Tauchbewegungen in z, dann Tasche öffnen.



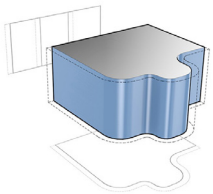
Bohren:

Zustellung in z.



Dynamisches Fräsen:

Gut definierte Werkzeugwege mit konstantem Kontaktbogen für zuverlässige Schrupp-bearbeitungen von einfachen und komplexen Formen.
Die großen axialen (a_p) und kleinen radialen Schnitttiefen (a_e) kombiniert mit hohen Vorschüben pro Zahn (f_z) und Schnittgeschwindigkeiten (v_c) sorgen für hohe Produktivität.



Definitionen, Bearbeitungsstrategien:

Allgemeine Bearbeitung
Bearbeitungsstrategie für allgemeinen Einsatz. Verhältnis a_e-a_p sehr stark abhängig von der Bearbeitung.
Werkzeugmerkmale: Werkzeuge weisen sehr große Schneidenlängen und dünne Kerndurchmesser auf. Keine hohen Toleranzanforderungen.
Maschinenanforderungen: Keine speziellen Anforderungen.
Beim Einsatz der CNC-Technologie sind keine modernen Bearbeitungsmethoden möglich.
Nur durchschnittliche Ergebnisse beim Zeitspanvolumen Q (cm^3/min).
Anwendungsgebiet ist die Kleinserienfertigung mit vielen verschiedenen Werkstoffen.

Hochleistungsbearbeitung (HPM):
Eine Bearbeitungsstrategie, bei der sehr hohe Zeitspanvolumen zu erzielen sind.
Typisch für diese Strategie ist a_e = 1 x DC und a_p = 1 bis 1½ x DC je nach zu bearbeitendem Werkstoff.
Mit HPM erzielen Sie extrem hohe Zeitspanvolumen in weit geringerer Zeit als bei der konventionellen Bearbeitung.
Werkzeugmerkmale: Speziell geformte Spankammern im Werkzeug, Beschichtung, mit oder ohne Weldon.
Maschinenanforderungen: Hohe Stabilität, hohe Energieanforderungen, CNC-Steuerung, stabiles Klemmsystem.
Anwendungsgebiet: Serienproduktion, wo Produktions-/Lieferzeit sehr wichtig ist oder bei Einzelproduktion, wo hohe Zeitspanvolumen Q (cm^3/min) gefordert sind.

Hochvorschubbearbeitung (HFM)
Bearbeitungsstrategie, bei der hohe Vorschübe mit vollem Eingriff im Werkzeugdurchmesser (a_e) in Kombination mit einem kleinen a_p erzielt werden können.
Mit Hochvorschubbearbeitung erzielen Sie Zeitspanvolumen und/oder hohe Oberflächengüten bei einem im Vergleich zur allgemeinen Bearbeitung sehr viel höheren Vorschub.
Werkzeugmerkmale: Speziell entwickelte Schneidengeometrie, sehr kurze Schneidlänge und angepasste Beschichtung.

Maschinenanforderungen: Hohe Stabilität, Möglichkeit für hohe Vorschubgeschwindigkeiten (v_f).
Ein großer Vorteil dieser Technologie ist ihre große Bedienerfreundlichkeit; die Programmierung in CAM lässt sich einfach, sicher und schnell vornehmen. Durch Fräsen in Höhenlinien (mit konstanter Schnitttiefe) kann man ohne viel Erfahrung sogar komplexe Formen recht einfach programmieren.
Anwendungsgebiet: Das Anwendungsgebiet reicht von normalem zu gehärtetem Stahl, Titan und Rostfrei, die Bearbeitung eignet sich sehr gut zum Vorschlichten vor der HSM-Bearbeitung.
Auch für tiefe Taschen geeignet.

Mikrofräsen:
Bearbeitungsstrategie, bei der extrem kleine Werkzeugdurchmesser verwendet werden.
Werkzeugmerkmale: Durchmesserbereich von 0,1 bis 2,0 mm, kleine Schnittlängen, umfangreiches Programm an Freilegungen, hohe Präzision, Beschichtung.

Maschinenanforderungen: Hohe Spindelgenauigkeit, hohe Drehzahlen, CNC-Steuerung.
Anwendungsgebiet: Herstellung von Kavitäten wie Nuten, Taschen, Bohrungen oder Gravierungen in verschiedenen Werkstoffen.

Hochgeschwindigkeitsbearbeitung:
Bearbeitungsstrategie mit einer Kombination aus kleinen Spanquerschnitten und hohen Schnittgeschwindigkeiten sowie hohen Vorschubgeschwindigkeiten
Je nach Bearbeitungsmethode können hohe Zeitspanvolumen und ein geringer R_a-Wert erzielt werden. Typisch für diese Strategie sind die geringen Schnittkräfte, geringe Erwärmung des Werkzeuges und Werkstückes, geringe Gratbildung und hohe Maßgenauigkeit am Werkstück.

Durch die Hochgeschwindigkeitsbearbeitung erzielen Sie Zeitspanvolumen und/oder hohe Oberflächengüten bei einer im Vergleich zur allgemeinen Bearbeitung sehr viel höheren Schnittgeschwindigkeit.
Werkzeugmerkmale: Stabile Ausführung (dicker Kerndurchmesser und kurze Schneidenlänge), durchgängig geformte Spankammern für gute Spanabfuhr, Beschichtung.

Maschinenanforderungen: Schnelle CNC-Steuerung, hohe Maximaldrehzahlen und höchste Stabilität.
Anwendungsgebiet: Werkzeug- und Formenbau bei Vorschlicht- oder Schlichtbearbeitungen in gehärtetem Stahl (48-62 HRC).
Mit dem richtigen Werkzeug und modernen Bearbeitungsmethoden kann diese Technologie bei den meisten anderen Werkstoffen ebenfalls eingesetzt werden.

Dynamisches Fräsen:
Gut definierte Werkzeugwege mit konstantem Kontaktbogen für zuverlässige Schruppbearbeitungen von einfachen und komplexen Formen. Die großen axialen (ap) und kleinen radialen Schnitttiefen (ae) kombiniert mit hohen Vorschüben pro Zahn (fz) und Schnittgeschwindigkeiten (c) sorgen für hohe Produktivität.

Dieses CAM-basierte Schruppverfahren, oder Dynamisches Fräsen, legt den Fokus auf den Kontaktbogen des Werkzeuges und die mittlere Spanlast.

Durch Verringerung des Kontaktbogens, entsteht weniger Wärme bei der Schruppbearbeitung. Der Kontaktbogen wird durch geringe seitliche Zustellungen reduziert. So entsteht weniger Reibung und damit weniger Wärme zwischen Schneidkante und Werkstück. Durch die geringere Werkzeugbelastung gegenüber konventionellen Strategien kann mit erhöhten Vorschüben, Schnittgeschwindigkeiten und größeren Tiefenzustellungen gearbeitet werden.

Dynamisches Fräsen

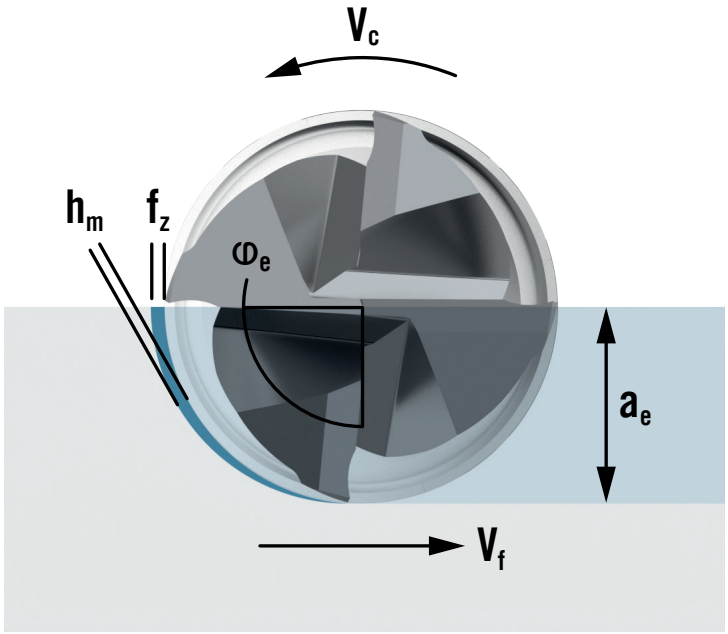
Was versteht man unter „Dynamischem Fräsen“?

Die aktuellen CAM-Pakete bieten Werkzeugbahnen für spezifische Innen-/Außenradien an. Bei konventionellen Werkzeugbahnen ändert sich der Kontaktbogen stets. Die neuen CAM-Software-Pakete verwenden automatisch verschiedene Vorschübe, um den Kontaktbogen zu steuern und die Spanlast konsistent zu halten.
Dieses CAM-basierte Schruppverfahren, oder Dynamisches Fräsen, legt den Fokus auf den Kontaktbogen des Werkzeuges und die mittlere Spanlast. Durch Verringerung des Kontaktbogens, entsteht weniger Wärme bei der Schruppbearbeitung. Der Kontaktbogen wird durch geringe seitliche Zustellungen reduziert. So entsteht weniger Reibung und damit weniger Wärme zwischen Schneidkante und Werkstück. Durch die geringere Werkzeugbelastung gegenüber konventionellen Strategien kann mit erhöhten Vorschüben, Schnittgeschwindigkeiten und größeren Tiefenzustellungen gearbeitet werden. Auch die Zerspankraft ist geringer. Das ermöglicht eine größere Schnitttiefe (APMXS).

Beim Dynamischen Fräsen wird der Kontaktbogen durch Anwendung verschiedener Frässtrategien konstant gehalten.

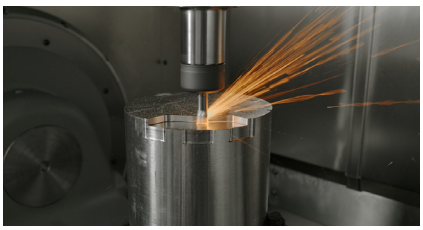
Durch optimale Werkzeugbahnen und einen konstanten Kontaktbogen kann der Werkzeugradius den Innenradius ohne Gefahr einer Überlastung bearbeiten. Mit diesen Merkmalen können unsere Werkzeuge fürs Dynamische Fräsen (JS554-3C, JS564, JS656, JS754, JS755 und JS720) mehr Material pro Durchgang in der Schruppbearbeitung entfernen - das führt zu kürzeren Zykluszeiten und längerer Standzeit. Durch das konstante verbliebene Material kann das Schlichtwerkzeug eine höhere Oberflächengüte bei längerer Standzeit erzeugen.

Einfluss von Kontaktbogen und Vorschub pro Zahn



Ihre Vorteile

Hohe Geschwindigkeiten in Superlegierungen mit JABRO® Ceramic



SiAlON-Keramik, hochfeste Geometrien und verstärkte Stirngeometrien sind die Hauptmerkmale dieser hochoptimierten Werkzeuge. Sie ermöglichen Hochgeschwindigkeitsbearbeitung und Hochleistung. Die Werkzeuge eignen sich für Geschwindigkeiten bis zu 1.200 m/min und bieten deutlich mehr Produktivität im Vergleich zu Standard-Vollhartmetallfräsern.

Bei hohen Temperaturen ist auch eine hohe Drehzahl nötig, um die hohe Geschwindigkeit zu erreichen. Bei hohen Temperaturen werden HRSA weicher (850c +). Die Werkzeuge eignen sich für eine Vielzahl an Strategien, so lange ein konstanter Eingriff und ein konstanter Kontakt mit dem Werkstück besteht.

Das Werkzeug eignet sich zum Eck-, Nut-, Hochvorschub- und dynamischen Fräsen. Um die hohen Schnitttemperaturen beizubehalten, wird Druckluft als Kühlmittel eingesetzt. Bei hohen Geschwindigkeiten ist auch der Rundlauf sehr wichtig.

JABRO®Ceramic Werkzeuge finden Sie auf Seite 277.

Hybrid-Composite-Werkstoffe mit innovativer Geometrie meistern

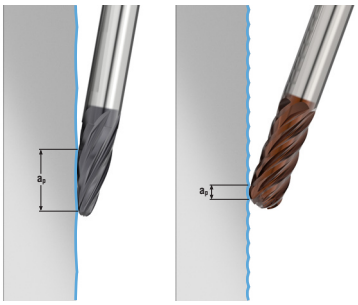


Der JC899 mit patentierter Geometrie eignet sich speziell für hybride Plattenpakete, wie CFRP-Ti und CFRP-Alu. Aufgrund des Linksdralls verhindert das Werkzeug eine Beschädigung der Oberfläche durch Delamination, Absplitterungen oder Spanmarken. Der JC899 mit Linksdrall und der rechtsschneidige STAX-Schlichter sorgen für eine hohe Oberflächengüte und verhindern Späne zwischen den zwei Schichten.

Nachbehandeln, Trennen, Säubern, Entgraten und Zusammenfügen der Werkstücke gehört der Vergangenheit an. Dies erhöht die Effizienz und verlängert die Standzeit.
Die Bohrungsbearbeitung kann mit dem JC898 Hochvorschub-Schruppwerkzeug ersetzt werden. Das Werkzeug wird in Bohrzirkularbearbeitung eingesetzt und ermöglicht dem JC899 einen kontinuierlichen Schnitt. Das erhöht den Ausstoß und verbessert Bohrungsgröße und Toleranz.

JABRO® JC898/JC899 finden Sie auf Seite 427 - 429.

Größere Stepover für schnelleres Schlichten



Für schnelle und zuverlässige Schlichtbearbeitungen sind die neuen Tonnenfräser mit einer konischen oder Tropfen-geometrie versehen, um den Stepover zu vergrößern. Dies ist durch Einsatz moderner CAD/CAM-Systeme möglich. Mithilfe von 5-Achs-Bewegungen bleibt das Werkzeugprofil stets in einem guten Winkel zur Werkstückoberfläche. Zusätzlich zu unseren Standard-Tonnenfräsern bietet Seco diese auch als Sonderlösungen an, z.B. mit Linsenform.

Senken Sie das Risiko bei Mikrozerspanung

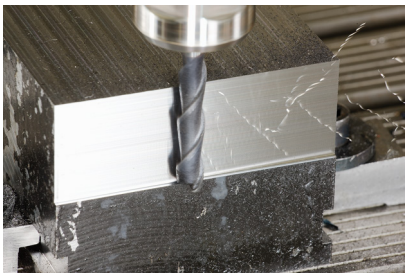


Erreichen Sie Präzision, Genauigkeit und hohe Oberflächengüten für kleinste Werkstücke mit unseren JABRO® Schaftfräsern. Das Produktprogramm an Mini-Fräsern bietet längere Standzeit, mehr Stabilität und Ruhe für Bearbeitungen, die mit dem bloßen Auge kaum sichtbar sind.

Präzise Geometrien, praktisch keine Rundlaufabweichung, moderne Beschichtungen und echte Radiustoleranzen führen zu langer Standzeit und hoher Zuverlässigkeit. Mit den richtigen Zerspanungsbedingungen zeigen die Fräser ihr volles Potenzial. Mit der passenden Werkzeugaufnahme wird die Rundlaufabweichung minimiert.
Auch das CAM-Programm kann mit der SECO JABRO® Vorschuboptimierung durch Berechnung der idealen Drehzahl und Vorschubgeschwindigkeit optimiert werden. Werkzeug und Aufspannung verhindern unvorhersehbare Herausforderungen während Schrupp-, Vorschlicht- und Schlichtbearbeitung.

Einen Überblick über alle JABRO® Mini Werkzeuge finden Sie auf Seite 10, 10.

JS522 Schlichtfräser



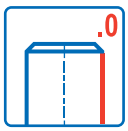
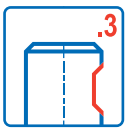
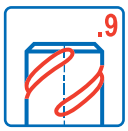
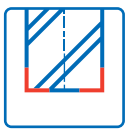
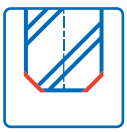
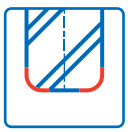
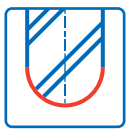
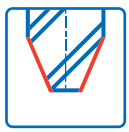
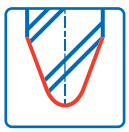
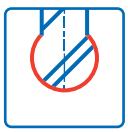
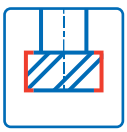
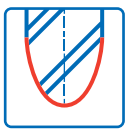
Der JS522 Schlichtfräser erfüllt die Anforderungen der Luft- und Raumfahrtbranche nach Rechtwinkligkeit, höchsten Oberflächengüten, hohem Zeitspanvolumen und effektiver Bearbeitung.

Mit einer Schneidenlänge von 5 x DC, einem größeren Kerndurchmesser und einem leicht negativen Konus, um Durchbiegung zu kompensieren, eignet sich der JS522 speziell zum Schlichten hoher Schultern in einem Durchgang. Dies spart Zeit und bietet hohe Qualität. Das Werkzeug eignet sich für Serienbearbeitungen.

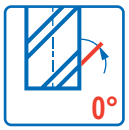
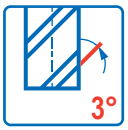
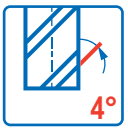
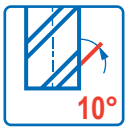
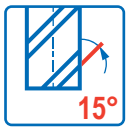
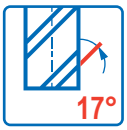
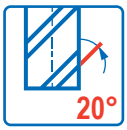
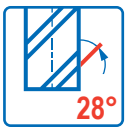
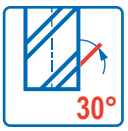
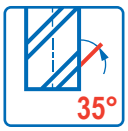
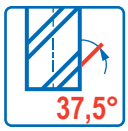
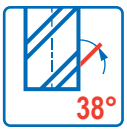
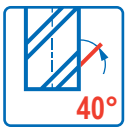
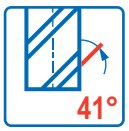
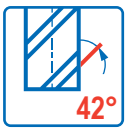
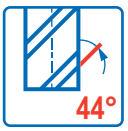
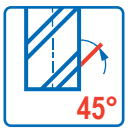
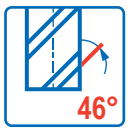
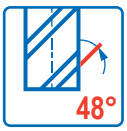
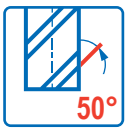
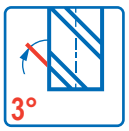
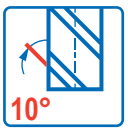
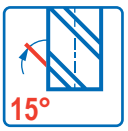
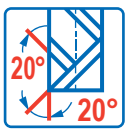
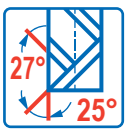
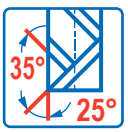
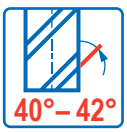
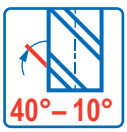
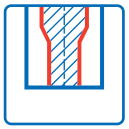
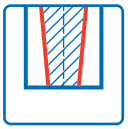
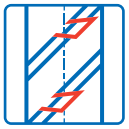
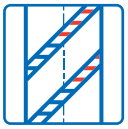
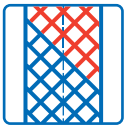
Es hat sich schon oft als Kostensenker in vielen Anwendungen bewährt.

JABRO® JS522 finden Sie auf Seite 103.

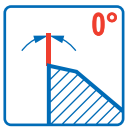
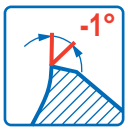
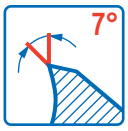
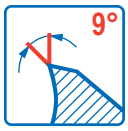
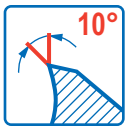
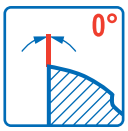
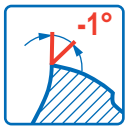
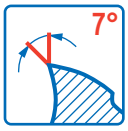
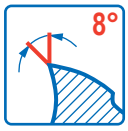
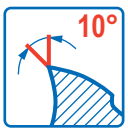
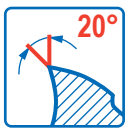
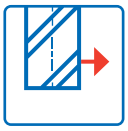
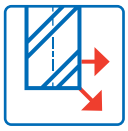
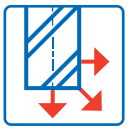
Symbole

 Zentrumsschnitt PCEDC 1	 Zentrumsschnitt PCEDC 2	 Kein Zentrumsschnitt PCEDC 2	 Zentrumsschnitt PCEDC 3	 Kein Zentrumsschnitt PCEDC 3	 Zentrumsschnitt PCEDC 4
 Kein Zentrumsschnitt PCEDC 4	 Kein Zentrumsschnitt PCEDC 5	 Zentrumsschnitt PCEDC 6	 Kein Zentrumsschnitt PCEDC 6	 Kein Zentrumsschnitt PCEDC 7	 Kein Zentrumsschnitt PCEDC 8
 Kein Zentrumsschnitt PCEDC 9					
 Zylindrisch	 Weldon-Schaft	 Safe-Lock™ Schaft			
 Scharfe Schneide	 Eckenfase	 Eckenradius	 Kugelkopf	 Scharfe Schneide konisch	 Konischer Kugelkopf
 Fräser 250°	 T-Form	 Kreissegment			

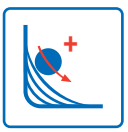
Symbole

 Drallwinkel 0°	 Drallwinkel 3°	 Drallwinkel 4°	 Drallwinkel 10°	 Drallwinkel 15°	 Drallwinkel 17°	 Drallwinkel 20°
 Drallwinkel 25°	 Drallwinkel 28°	 Drallwinkel 30°	 Drallwinkel 35°	 Drallwinkel 37,5°	 Drallwinkel 38°	 Drallwinkel 40°
 Drallwinkel 41°	 Drallwinkel 42°	 Drallwinkel 44°	 Drallwinkel 45°	 Drallwinkel 46°	 Drallwinkel 48°	 Drallwinkel 50°
 Drallwinkel Links 3°	 Drallwinkel Links 10°	 Drallwinkel Links 15°				
 Drallwinkel links/rechts 20° - 20°	 Drallwinkel links/rechts 27° - 25°	 Drallwinkel links/rechts 35° - 25°	 Drallwinkel links/rechts 35° - 30°	 Drallwinkel links/rechts 34° - 36°	 Drallwinkel links/rechts 40° - 42°	 Linksdrall 40° - 10°
 Verstärkter Kern	 Konischer Kern					
 Spanteiler	 Schruppprofil	 Fräserprofil				

Symbole

 Spanwinkel 0°	 Spanwinkel 1°	 Spanwinkel -1°	 Spanwinkel 2°	 Spanwinkel 3°	 Spanwinkel 4°	 Spanwinkel 4-6°
 Spanwinkel 5°	 Spanwinkel 6°	 Spanwinkel 7°	 Spanwinkel 8°	 Spanwinkel 9°	 Spanwinkel 10°	 Spanwinkel 11°
 Spanwinkel 12°	 Spanwinkel -12°	 Spanwinkel 14°	 Spanwinkel 15°	 Spanwinkel 16°	 Spanwinkel 18°	 Spanwinkel 20°
 Spanwinkel -24°						
 Spanwinkel 0°	 Spanwinkel -1°	 Spanwinkel 3°	 Spanwinkel 5°	 Spanwinkel 6°	 Spanwinkel 7°	 Spanwinkel 8°
 Spanwinkel 10°	 Spanwinkel 11°	 Spanwinkel 15°	 Spanwinkel 16°	 Spanwinkel 20°		
 ICC Zentral	 ICC-Y					
 Radial	 Radial/Einwärtskopieren	 Radial/Einwärtskopieren/ Eintauchen				

Symbole

 Diamond	 Dura	 Hemi	 HSCO	 HXT
 Mega	 Mega-T	 Mega-64	 Mega-64-T	 NXT
 Stax	 SIRA	 TAN	 Tribon	 Ceramic
 PCD				
 Nachschleifen möglich	 Dynamisches Fräsen			

ISO-Attribute Vollhartmetallfräser

ISO-Attribute	Erklärung
AP1	Teilweise Schnitttiefe
APMXS	Maximale axiale Schnitttiefe
CA	Kollisionswinkel
CHW	Fasenbreite
DC	Werkzeugdurchmesser
DCX	Maximaler Werkzeugdurchmesser
DMM	Schaftdurchmesser
DN	Hinterer Schneidkopf-Durchmesser
FCEDC	Stirnschneiden
ICC	Interne Kühlmittelkanäle
L	Schneidenlänge
L2	Schneidenlänge 2
LN	Freilegung
LN2	Freilegung 2
LSCN	Länge der Pratze min.
NA	Winkel an der Freilegung
OAL	Gesamtlänge
PCEDC	Anzahl Peripherischneiden
PRFA/2	Halber Profilwinkel
PRFRAD1	Profilradius 1
PRFRAD2	Profilradius 2
PRFRAD3	Profilradius 3
PSIR	Werkzeugeinstellwinkel
RE	Eckenradius
RE2	Eckenradius 2
RP	Programmierter Radius
SA	Kugelsegmentwinkel
SIG	Spitzenwinkel
UTCN	Theoretische Abweichung
WDX0	Maximale Arbeitstiefe 0°
WDX05	Maximale Arbeitstiefe 0,5°
WDX1	Maximale Arbeitstiefe 1°
WDX15	Maximale Arbeitstiefe 1,5°
WDX2	Maximale Arbeitstiefe 2°
WDX3	Maximale Arbeitstiefe 3°

ISO-Attribute Minimaster

ISO-Attribute	Erklärung
APMXE	Maximale radiale Schnitttiefe
APMXS	Maximale axiale Schnitttiefe
AZ	Maximale Schneidenlänge
BEC	Hinterer Fasenwinkel
BHTA	Konuswinkel
CCER	Stirnschneidenradius
Cmax	Maximaler Bohrungsdurchmesser
Cmin	Minimaler Bohrungsdurchmesser
DC	Werkzeugdurchmesser
DCSFMS	Werkzeug-Auflagedurchmesser
DCSFWS	Aufnahmedurchmesser werkstückseitig
DCX	Maximaler Werkzeugdurchmesser
DMM	Schaftdurchmesser
DN	Hinterer Schneidkopf-Durchmesser
FCEDC	Stirnschneiden
FHA	Drallwinkel der Spankammer
KAPRS	Einstellwinkel
LE	Effektive Schneidenlänge
LF	Funktionale Länge
LPR	Länge Überstand
OAL	Gesamtlänge
RA	Freilegungswinkel
RE	Eckenradius
RMPX	Maximaler Einwärtskopierwinkel
RP	Programmierter Radius
RPMX	Maximale Drehzahl
SA	Kugelsegmentwinkel
SIG	Spitzenwinkel
UTCN	Theoretische Abweichung
ZEFP	Effektive Zähnezahl



UNIVERSAL

Seco bietet ein vollständiges Programm an Hochleistungsvollhartmetallfräsern: Schaftfräser, Kugelkopffräser und Schlichtfräser für hohe Produktivität und lange Standzeiten. Das Produktprogramm enthält Universalfräser und optimierte Vollhartmetallfräser für spezielle Werkstoffe.

Universalfräser bieten volle Bearbeitungsflexibilität bei einem guten Preis-Leistungsverhältnis.

- JSE512, JSE513, JSE514, JS553, JS554, JS564, JS565 und JS520 mit 45° Fase
- JS522, JS553, JS554, JH910, JH930, JHF980, J36, JME542, JME562 und JME564 mit Eckenradius
- JS506, JS509, J29 und V31 (Typ V)
- JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 und JMB563 Kugelkopffräser.

Werkzeugauswahl Universal

						
Werkzeugbezeichnung		JSE512	JSE513	JSE514	JS553	JS554
Seite(n)		33	37	43	49	67
Produktfamilie		JS²	JS²	JS²	JS²	JS²
Fräserausführung						
Aufnahmen	Zylindrisch	■	■	■	■	■
	Weldon	■	■	■	■	■
Schneidenzahl		2	3	4	3	4
ICC						
	Metrisch	2-12	2-20	2-25	2-25	3-25
	Zoll				1/8 - 1/2	1/4-1
Verfügbare Längen						
		2	2,3	2,3	1,2,3	1,2,3
Bearbeitung						
						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	●
M1-3		●	●	●	●	●
M4-5		○	○	○	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	●	●
S11-13		○	○	○	●	●
H3 H5 H8 H11 H12 H21 H31		○	○	○	●	●
N1		○	○	○	●	●
N2-3		○	○	○	●	●
N11		○	○	○	●	●
TS1		○	○	○	●	●
TP1		○	○	○	●	●
GR		○	○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative
*JS554 3C ist auch verfügbar. Kann für dynamisches Fräsen angewendet werden.

Werkzeugauswahl Universal

						
Werkzeugbezeichnung		JS564	JS565	JS520	JS522	JSB512
Seite(n)		91	95	99	103	106
Produktfamilie		JS²	JS²	JS²	JS²	JS²
Fräserausführung						
Aufnahmen	Zylindrisch	■	■	■	■	■
	Weldon	■	■	□		
Schneidenzahl		4	5	5,6,8	2	2
ICC						
	Metrisch		4-20	4-25	6-32	2-12
	Zoll					
Verfügbare Längen						
		2,3	2,3	2,3	4	2
Bearbeitung						
						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	●	○
M1-3		●	●	○	●	●
M4-5		●	●	○	●	○
K1-7		●	●	●	●	●
S1-3		●	●	○	○	○
S11-13		●	●	●	●	○
H3 H5 H8 H11 H12 H21 H31		●	●	○		○
N1		●	●	●	●	○
N2-3		●	●	●	●	○
N11		●	●	●	●	○
TS1				●	●	○
TP1				●	●	○
GR				○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

						
Werkzeugbezeichnung		JS532	JS533	JS534	JS506	JS509
Seite(n)		108	112	116	120	124
Produktfamilie		JS²	JS²	JS²	JS²	JS²
Fräserausführung						
Aufnahmen	Zylindrisch	■	■	■	■	■
	Weldon	□	■	■	■	■
Schneidenzahl		2	3	4	3-4	3-4
ICC						
	Metrisch	1-20	1-20	2-20	3-12	3-12
	Zoll					
Verfügbare Längen						
		1,2,3	1,2	1,2,3	2	2
Bearbeitung						
						
SMG						
P1-8		●	●	●	●	●
P11-12		○	○	○	○	○
M1-3		●	●	●	●	●
M4-5		●	●	●	●	●
K1-7		●	●	●	●	●
S1-3		○	○	○	○	○
S11-13		●	●	●	●	●
H3 H5 H8 H11 H12 H21					●	●
N1		●	●	●	●	●
N2-3		●	●	●	●	●
N11		●	●	●	●	●
TS1		●	●	●	●	●
TP1		●	●	●	●	●
GR		○	○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

					
Werkzeugbezeichnung		JH910	JH930	JHB970	JHF980
Seite(n)		128	132, 365	134, 195	136
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
Schneidenzahl		3	5-6, 8	2	2,3,4,5
ICC					
	Metrisch	2-20	6-20	2-16	1-12
	Zoll				
Verfügbare Längen					
		2,3,4	2	1,2,3	1,2,3,4
Bearbeitung					
					
					
SMG					
P1-8		●	●	●	●
P11-12		○	○	○	○
M1-3		●		●	●
M4-5		●		●	●
K1-7		●	●		●
S1-3		●	●	●	●
S11-13		●	●	●	●
H3 H5 H7 H8 H11 H12 H21 H31			●		○
N1					
N2-3					
N11					
TS1					
TP1		●			
GR		●			

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

					
Werkzeugbezeichnung		J29	J36	HK/HKM	V31
Seite(n)		140	143	146	157
Produktfamilie		VHM	VHM	VHM	VHM
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
Schneidenzahl		1	3	2,3,4	4
ICC					
	Metrisch	0,2-6	2-20	1-10	6-28
	Zoll				
Verfügbare Längen					
		2	2	2	2
Bearbeitung					
					
					
SMG					
P1-8		●	○	●	●
P11-12		●	●		○
M1-3		●	○	●	●
M4-5		●	○	●	○
K1-7		●	○	●	●
S1-3		●	○	●	●
S11-13		●	○	●	●
H3 H5 H8 H11 H12 H21		○		●	●
N1		●	○	●	●
N2-3		●	●	○	●
N11		●	●		●
TS1		●	○	●	●
TP1		●	○	●	●
GR		●			●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

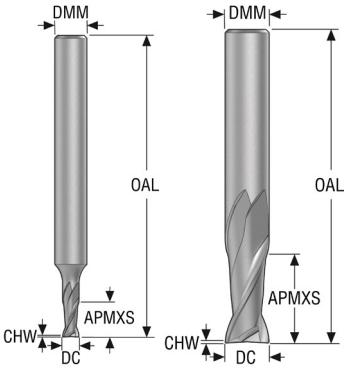
Werkzeugauswahl Universal

							
Werkzeugbezeichnung		JME542	JME562	JME564	JMB542	JMB562	JMB563
Seite(n)		160	163	167	170	173	177
Produktfamilie		MINI	MINI	MINI	MINI	MINI	MINI
Fräserausführung							
Auf-nahmen	Zylindrisch	■	■	■	■	■	■
	Weldon						
Schneidenzahl		2	2	4	2	2	3
ICC							
	Metrisch	2-20	0,5-3,0	0,5-3,0	0,2-3,0	0,5-3,0	1,0-3,0
	Zoll						
Verfügbare Längen							
		1,3,4,5,6	2,4,5,6,7	2,4	1,3,4,5,6	1,2,3,4,5,6	2,4
Bearbeitung							
							
							
SMG							
P1-8		●	●	●	●	●	●
P11-12		●	●	●	●	●	●
M1-3		●	●	●	●	●	●
M4-5		●	●	●	●	●	●
K1-7							
S1-3							
S11-13		●	●	●	●	●	●
H3 H5 H7 H8 H11 H12 H21 H31		○	○	○	○	○	○
N1		○	○	○	○	○	○
N2-3		○	○	○	○	○	○
N11		○	○	○	○	○	○
TS1							
TP1							
GR		○	○	○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JSE512

Allgemeine Bearbeitung – Universal – Eckfräser – 2 Schneiden – Zylindrisch – Fase







- Toleranzen:
- DMM=h5
- DC=e8

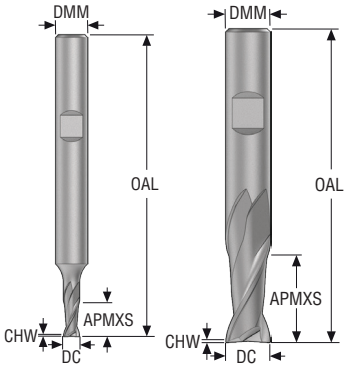
Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JSE512021F2C.0Z2	SIRA	10052986	2	F	2,0	3,0	4,0	50,0	0,02	2	■
JSE512020F2C.0Z2	SIRA	10052990	2	F	2,0	6,0	4,0	57,0	0,02	2	■
JSE512030D2C.0Z2	SIRA	10052987	2	D	3,0	3,0	6,0	50,0	0,03	2	■
JSE512030F2C.0Z2	SIRA	10052991	2	F	3,0	6,0	6,0	57,0	0,03	2	■
JSE512040D2C.0Z2	SIRA	10052988	2	D	4,0	4,0	8,0	50,0	0,04	2	■
JSE512040F2C.0Z2	SIRA	10052992	2	F	4,0	6,0	8,0	57,0	0,04	2	■
JSE512050D2C.0Z2	SIRA	10052989	2	D	5,0	5,0	10,0	50,0	0,05	2	■
JSE512060D2C.0Z2	SIRA	10052993	2	D	6,0	6,0	12,0	57,0	0,06	2	■
JSE512080D2C.0Z2	SIRA	10052994	2	D	8,0	8,0	16,0	63,0	0,08	2	■
JSE512100D2C.0Z2	SIRA	10052995	2	D	10,0	10,0	20,0	72,0	0,1	2	■
JSE512120D2C.0Z2	SIRA	10052996	2	D	12,0	12,0	24,0	83,0	0,12	2	■

■ **Lagerstandard.**

JSE512

Allgemeine Bearbeitung – Universal – Eckfräser – 2 Schneiden – Weldon – Fase





- Toleranzen:
- DMM=h5
- DC=e8



Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE512020F2C.3Z2	SIRA	10053113	2	F	2,0	6,0	4,0	57,0	0,02	2	■
JSE512030F2C.3Z2	SIRA	10053114	2	F	3,0	6,0	6,0	57,0	0,03	2	■
JSE512040F2C.3Z2	SIRA	10053115	2	F	4,0	6,0	8,0	57,0	0,04	2	■
JSE512060D2C.3Z2	SIRA	10053116	2	D	6,0	6,0	12,0	57,0	0,06	2	■
JSE512080D2C.3Z2	SIRA	10053117	2	D	8,0	8,0	16,0	63,0	0,08	2	■
JSE512100D2C.3Z2	SIRA	10053118	2	D	10,0	10,0	20,0	72,0	0,1	2	■
JSE512120D2C.3Z2	SIRA	10053119	2	D	12,0	12,0	24,0	83,0	0,12	2	■

■ **Lagerstandard.**

Schnittdaten – JSE512 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P2	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P3	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P4	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P5	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P6	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P7	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P8	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
P11	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
P12	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
M1	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
M2	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
M3	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
M4	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
M5	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
K1	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K2	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K3	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K4	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K5	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K6	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K7	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
N1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	500 (380 — 630) *1650 (1300 — 2000)*
N11	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	365 (250 — 480) *1200 (830–1500)*
S11	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
S12	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*
S13	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61–120) *280 (210 — 390)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JSE512 Nutfräsen

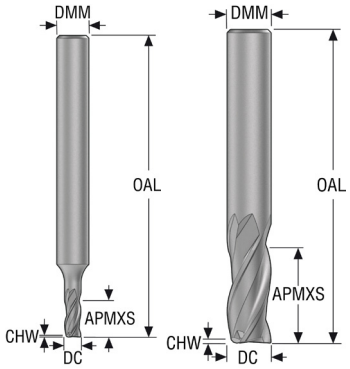
SMG		a_p/DC	f_z								v_c
			2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51–150) *395 (170 — 490)*
P2	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
P3	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51–150) *395 (170 — 490)*
P4	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
P5	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
P6	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
P7	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51–150) *395 (170 — 490)*
P8	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
P11	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (51–100) *230 (170 — 320)*
P12	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
K2	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
K3	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
K4	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
K5	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
K6	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
K7	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50–140) *395 (170 — 450)*
N1	E/M/A	0.40 *0,40*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	400 (300 — 500) *1300 (990–1600)*
N11	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	300 (200 — 390) *980 (660–1200)*
S11	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JSE513

Allgemeine Bearbeitung – Universal – Eckfräser – 3 Schneiden – Zylindrisch – Fase







- Toleranzen:
- DMM=h5
- DC=e8

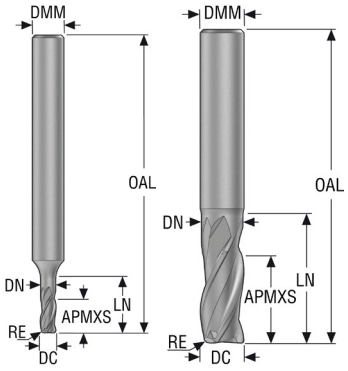
Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JSE513020F2C.0Z3	SIRA	10053000	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JSE513025F2C.0Z3	SIRA	10053001	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JSE513030D2C.0Z3	SIRA	10052998	2	D	3,0	3,0	6,0	50,0	0,03	3	■
JSE513030F2C.0Z3	SIRA	10053002	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JSE513040D2C.0Z3	SIRA	10052999	2	D	4,0	4,0	8,0	50,0	0,04	3	■
JSE513040F2C.0Z3	SIRA	10053003	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JSE513050F2C.0Z3	SIRA	10053004	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JSE513060D2C.0Z3	SIRA	10053005	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JSE513070F2C.0Z3	SIRA	10053006	2	F	7,0	8,0	14,0	63,0	0,07	3	■
JSE513080D2C.0Z3	SIRA	10053007	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JSE513090F2C.0Z3	SIRA	10053008	2	F	9,0	10,0	18,0	72,0	0,09	3	■
JSE513100D2C.0Z3	SIRA	10053009	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JSE513110F2C.0Z3	SIRA	10053010	2	F	11,0	12,0	22,0	83,0	0,11	3	■
JSE513120D2C.0Z3	SIRA	10053011	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JSE513140D2C.0Z3	SIRA	10053012	2	D	14,0	14,0	28,0	80,0	0,14	3	■
JSE513160D2C.0Z3	SIRA	10053013	2	D	16,0	16,0	32,0	92,0	0,16	3	■
JSE513180D2C.0Z3	SIRA	10053014	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JSE513200D2C.0Z3	SIRA	10053015	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JSE513030F3C.0Z3	SIRA	10053038	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JSE513040F3C.0Z3	SIRA	10053039	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JSE513050F3C.0Z3	SIRA	10053040	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JSE513060D3C.0Z3	SIRA	10053046	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JSE513080D3C.0Z3	SIRA	10053047	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JSE513100D3C.0Z3	SIRA	10053048	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JSE513120D3C.0Z3	SIRA	10053049	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JSE513160D3C.0Z3	SIRA	10053050	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JSE513200D3C.0Z3	SIRA	10053052	3	D	20,0	20,0	60,0	125,0	0,2	3	■

■ Lagerstandard.

JSE513

Allgemeine Bearbeitung – Universal – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm

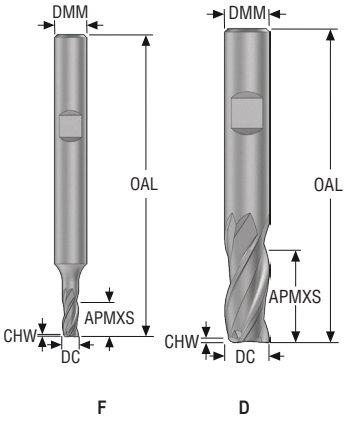


Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JSE513030G2R050.0Z3	SIRA	10053023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	■
JSE513040G2R050.0Z3	SIRA	10053024	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	■
JSE513050G2R050.0Z3	SIRA	10053025	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	■
JSE513060E2R050.0Z3	SIRA	10053026	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	■
JSE513060E2R100.0Z3	SIRA	10053032	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	■
JSE513080E2R050.0Z3	SIRA	10053027	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	■
JSE513080E2R100.0Z3	SIRA	10053033	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	■
JSE513100E2R050.0Z3	SIRA	10053028	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	■
JSE513100E2R100.0Z3	SIRA	10053034	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	■
JSE513120E2R050.0Z3	SIRA	10053029	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	■
JSE513120E2R100.0Z3	SIRA	10053035	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	■
JSE513160E2R050.0Z3	SIRA	10053030	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	■
JSE513160E2R100.0Z3	SIRA	10053036	2	E	16,0	16,0	28,0	92,0	42,0	15,2	1,0	3	■
JSE513200E2R050.0Z3	SIRA	10053031	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	■
JSE513200E2R100.0Z3	SIRA	10053037	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	3	■

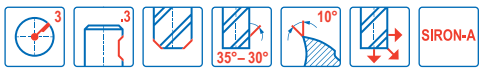
■ **Lagerstandard.**

JSE513

Allgemeine Bearbeitung – Universal – Eckfräser – 3 Schneiden – Weldon – Fase







- Toleranzen:
- DMM=h5
- DC=e8

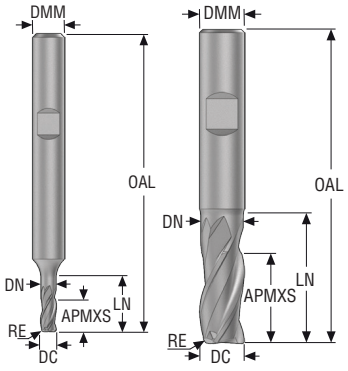
Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE513020F2C.3Z3	SIRA	10053120	2	F	2,0	6,0	4,0	57,0	0,02	3	■
JSE513025F2C.3Z3	SIRA	10053121	2	F	2,5	6,0	5,0	57,0	0,025	3	■
JSE513030F2C.3Z3	SIRA	10053122	2	F	3,0	6,0	6,0	57,0	0,03	3	■
JSE513040F2C.3Z3	SIRA	10053123	2	F	4,0	6,0	8,0	57,0	0,04	3	■
JSE513050F2C.3Z3	SIRA	10053124	2	F	5,0	6,0	10,0	57,0	0,05	3	■
JSE513060D2C.3Z3	SIRA	10053125	2	D	6,0	6,0	12,0	57,0	0,06	3	■
JSE513070F2C.3Z3	SIRA	10053126	2	F	7,0	8,0	14,0	63,0	0,07	3	■
JSE513080D2C.3Z3	SIRA	10053127	2	D	8,0	8,0	16,0	63,0	0,08	3	■
JSE513090F2C.3Z3	SIRA	10053128	2	F	9,0	10,0	18,0	72,0	0,09	3	■
JSE513100D2C.3Z3	SIRA	10053129	2	D	10,0	10,0	20,0	72,0	0,1	3	■
JSE513110F2C.3Z3	SIRA	10053130	2	F	11,0	12,0	22,0	83,0	0,11	3	■
JSE513120D2C.3Z3	SIRA	10053131	2	D	12,0	12,0	24,0	83,0	0,12	3	■
JSE513140D2C.3Z3	SIRA	10053132	2	D	14,0	14,0	28,0	80,0	0,14	3	■
JSE513160D2C.3Z3	SIRA	10053133	2	D	16,0	16,0	32,0	92,0	0,16	3	■
JSE513180D2C.3Z3	SIRA	10053258	2	D	18,0	18,0	35,0	100,0	0,18	3	■
JSE513200D2C.3Z3	SIRA	10053259	2	D	20,0	20,0	35,0	104,0	0,2	3	■
JSE513030F3C.3Z3	SIRA	10053275	3	F	3,0	6,0	10,0	57,0	0,03	3	■
JSE513040F3C.3Z3	SIRA	10053276	3	F	4,0	6,0	14,0	57,0	0,04	3	■
JSE513050F3C.3Z3	SIRA	10053277	3	F	5,0	6,0	18,0	57,0	0,05	3	■
JSE513060D3C.3Z3	SIRA	10053283	3	D	6,0	6,0	20,0	63,0	0,06	3	■
JSE513080D3C.3Z3	SIRA	10053284	3	D	8,0	8,0	28,0	80,0	0,08	3	■
JSE513100D3C.3Z3	SIRA	10053285	3	D	10,0	10,0	35,0	89,0	0,1	3	■
JSE513120D3C.3Z3	SIRA	10053286	3	D	12,0	12,0	42,0	100,0	0,12	3	■
JSE513160D3C.3Z3	SIRA	10053287	3	D	16,0	16,0	50,0	115,0	0,16	3	■
JSE513200D3C.3Z3	SIRA	10053288	3	D	20,0	20,0	60,0	125,0	0,2	3	■

■ **Lagerstandard.**

JSE513

Allgemeine Bearbeitung – Universal – Eckfräser – 3 Schneiden – Weldon – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm



Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JSE513030G2R050.3Z3	SIRA	10053260	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	■
JSE513040G2R050.3Z3	SIRA	10053261	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	■
JSE513050G2R050.3Z3	SIRA	10053262	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	■
JSE513060E2R050.3Z3	SIRA	10053263	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	■
JSE513060E2R100.3Z3	SIRA	10053269	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	■
JSE513080E2R050.3Z3	SIRA	10053264	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	■
JSE513080E2R100.3Z3	SIRA	10053270	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	■
JSE513100E2R050.3Z3	SIRA	10053265	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	■
JSE513100E2R100.3Z3	SIRA	10053271	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	■
JSE513120E2R050.3Z3	SIRA	10053266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	■
JSE513120E2R100.3Z3	SIRA	10053272	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	■
JSE513160E2R050.3Z3	SIRA	10053267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	■
JSE513160E2R100.3Z3	SIRA	10053273	2	E	16,0	16,0	28,0	92,0	42,0	15,2	1,0	3	■
JSE513200E2R050.3Z3	SIRA	10053268	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	■
JSE513200E2R100.3Z3	SIRA	10053274	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	3	■

■ **Lagerstandard.**

Schnittdaten – JSE513 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z															v_c
				2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P2	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P3	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P4	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P5	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P6	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P7	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P8	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
P11	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
P12	M/A/D/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (64–120) *295 (210 — 390)*
M1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
M2	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
M3	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
M4	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
M5	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
K1	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
K2	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
K3	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
K4	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
K5	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
K6	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
K7	A/D/M/E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	155 (65–190) *510 (220 — 620)*
N1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	510 (390 — 630) *1675 (1300 — 2000)*
N11	E/M/A	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	385 (260 — 510) *1275 (860–1600)*
S11	E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
S12	E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*
S13	E	0.200 *0,200*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	90 (65–120) *295 (220 — 390)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JSE513 Nutfräsen

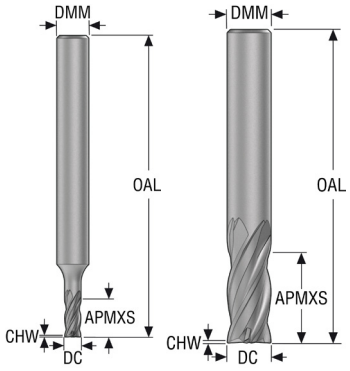
SMG		a_p/DC	f_z															v_c
			2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51–150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P2	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P3	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51–150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P4	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P5	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51–150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P6	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P7	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51–150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P8	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51–150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P11	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (51–100)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
P12	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M1	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M2	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M3	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M4	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M5	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
K1	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K2	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K3	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K4	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K5	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K6	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K7	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50–140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
N1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	400 (310 — 500)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*1300 (1100–1600)*
N11	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	300 (200 — 400)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*980 (660–1300)*
S11	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S12	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S13	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JSE514

Allgemeine Bearbeitung – Universal – Eckfräser – 4 Schneiden – Zylindrisch – Fase







- Toleranzen:
- DMM=h5
- DC=e8

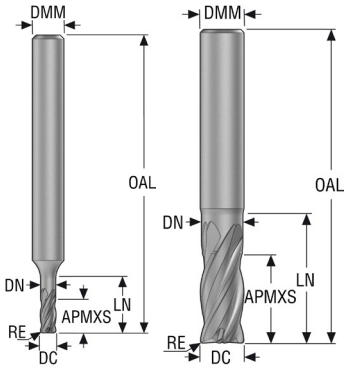
Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JSE514021F2C.0Z4	SIRA	10053053	2	F	2,0	3,0	4,0	50,0	0,02	4	■
JSE514020F2C.0Z4	SIRA	10053057	2	F	2,0	6,0	4,0	57,0	0,02	4	■
JSE514030D2C.0Z4	SIRA	10053054	2	D	3,0	3,0	6,0	50,0	0,03	4	■
JSE514030F2C.0Z4	SIRA	10053058	2	F	3,0	6,0	6,0	57,0	0,03	4	■
JSE514040D2C.0Z4	SIRA	10053055	2	D	4,0	4,0	8,0	50,0	0,04	4	■
JSE514040F2C.0Z4	SIRA	10053059	2	F	4,0	6,0	8,0	57,0	0,04	4	■
JSE514050D2C.0Z4	SIRA	10053056	2	D	5,0	5,0	10,0	50,0	0,05	4	■
JSE514050F2C.0Z4	SIRA	10053060	2	F	5,0	6,0	10,0	57,0	0,05	4	■
JSE514060D2C.0Z4	SIRA	10053061	2	D	6,0	6,0	12,0	57,0	0,06	4	■
JSE514080D2C.0Z4	SIRA	10053062	2	D	8,0	8,0	16,0	63,0	0,08	4	■
JSE514100D2C.0Z4	SIRA	10053063	2	D	10,0	10,0	20,0	72,0	0,1	4	■
JSE514120D2C.0Z4	SIRA	10053064	2	D	12,0	12,0	24,0	83,0	0,12	4	■
JSE514160D2C.0Z4	SIRA	10053067	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JSE514180D2C.0Z4	SIRA	10053068	2	D	18,0	18,0	35,0	100,0	0,18	4	■
JSE514200D2C.0Z4	SIRA	10053069	2	D	20,0	20,0	35,0	104,0	0,2	4	■
JSE514250D2C.0Z4	SIRA	10053070	2	D	25,0	25,0	40,0	125,0	0,25	4	■
JSE514030F3C.0Z4	SIRA	10053090	3	F	3,0	6,0	10,0	57,0	0,03	4	■
JSE514040F3C.0Z4	SIRA	10053091	3	F	4,0	6,0	14,0	57,0	0,04	4	■
JSE514050F3C.0Z4	SIRA	10053092	3	F	5,0	6,0	18,0	57,0	0,05	4	■
JSE514060D3C.0Z4	SIRA	10053093	3	D	6,0	6,0	20,0	63,0	0,06	4	■
JSE514080D3C.0Z4	SIRA	10053094	3	D	8,0	8,0	28,0	80,0	0,08	4	■
JSE514100D3C.0Z4	SIRA	10053095	3	D	10,0	10,0	35,0	89,0	0,1	4	■
JSE514120D3C.0Z4	SIRA	10053096	3	D	12,0	12,0	42,0	100,0	0,12	4	■
JSE514160D3C.0Z4	SIRA	10053097	3	D	16,0	16,0	50,0	115,0	0,16	4	■
JSE514200D3C.0Z4	SIRA	10053098	3	D	20,0	20,0	60,0	125,0	0,2	4	■

■ **Lagerstandard.**

JSE514

Allgemeine Bearbeitung – Universal – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm

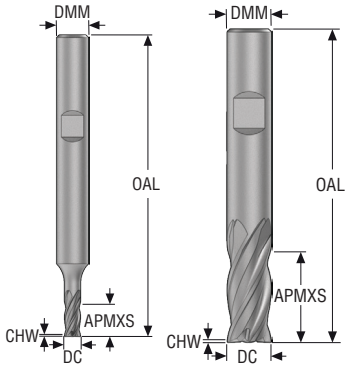


Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JSE514030G2R050.0Z4	SIRA	10053071	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	■
JSE514040G2R050.0Z4	SIRA	10053072	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	■
JSE514050G2R050.0Z4	SIRA	10053073	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	■
JSE514060E2R050.0Z4	SIRA	10053074	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JSE514060E2R100.0Z4	SIRA	10053081	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JSE514080E2R050.0Z4	SIRA	10053075	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JSE514080E2R100.0Z4	SIRA	10053082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JSE514100E2R050.0Z4	SIRA	10053076	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JSE514100E2R100.0Z4	SIRA	10053083	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JSE514120E2R050.0Z4	SIRA	10053077	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JSE514120E2R100.0Z4	SIRA	10053084	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JSE514160E2R050.0Z4	SIRA	10053078	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JSE514160E2R100.0Z4	SIRA	10053087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JSE514200E2R050.0Z4	SIRA	10053079	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	■
JSE514200E2R100.0Z4	SIRA	10053088	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	■
JSE514250E2R050.0Z4	SIRA	10053080	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	■
JSE514250E2R100.0Z4	SIRA	10053089	2	E	25,0	25,0	40,0	125,0	66,0	23,8	1,0	4	■

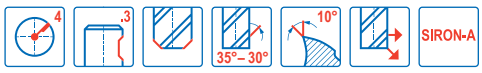
■ **Lagerstandard.**

JSE514

Allgemeine Bearbeitung – Universal – Eckfräser – 4 Schneiden – Weldon – Fase







- Toleranzen:
- DMM=h5
- DC=e8

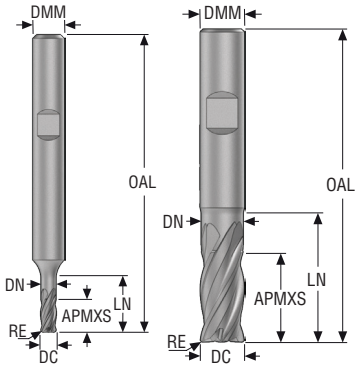
Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JSE514020F2C.3Z4	SIRA	10053289	2	F	2,0	6,0	4,0	57,0	0,02	4	■
JSE514030F2C.3Z4	SIRA	10053290	2	F	3,0	6,0	6,0	57,0	0,03	4	■
JSE514040F2C.3Z4	SIRA	10053291	2	F	4,0	6,0	8,0	57,0	0,04	4	■
JSE514050F2C.3Z4	SIRA	10053292	2	F	5,0	6,0	10,0	57,0	0,05	4	■
JSE514060D2C.3Z4	SIRA	10053293	2	D	6,0	6,0	12,0	57,0	0,06	4	■
JSE514080D2C.3Z4	SIRA	10053294	2	D	8,0	8,0	16,0	63,0	0,08	4	■
JSE514100D2C.3Z4	SIRA	10053295	2	D	10,0	10,0	20,0	72,0	0,1	4	■
JSE514120D2C.3Z4	SIRA	10053296	2	D	12,0	12,0	24,0	83,0	0,12	4	■
JSE514160D2C.3Z4	SIRA	10053297	2	D	16,0	16,0	32,0	92,0	0,16	4	■
JSE514180D2C.3Z4	SIRA	10053298	2	D	18,0	18,0	35,0	100,0	0,18	4	■
JSE514200D2C.3Z4	SIRA	10053299	2	D	20,0	20,0	35,0	104,0	0,2	4	■
JSE514250D2C.3Z4	SIRA	10053300	2	D	25,0	25,0	40,0	125,0	0,25	4	■
JSE514030F3C.3Z4	SIRA	10053321	3	F	3,0	6,0	10,0	57,0	0,03	4	■
JSE514040F3C.3Z4	SIRA	10053322	3	F	4,0	6,0	14,0	57,0	0,04	4	■
JSE514050F3C.3Z4	SIRA	10053323	3	F	5,0	6,0	18,0	57,0	0,05	4	■
JSE514060D3C.3Z4	SIRA	10053324	3	D	6,0	6,0	20,0	63,0	0,06	4	■
JSE514080D3C.3Z4	SIRA	10053325	3	D	8,0	8,0	28,0	80,0	0,08	4	■
JSE514100D3C.3Z4	SIRA	10053326	3	D	10,0	10,0	35,0	89,0	0,1	4	■
JSE514120D3C.3Z4	SIRA	10053327	3	D	12,0	12,0	42,0	100,0	0,12	4	■
JSE514160D3C.3Z4	SIRA	10053328	3	D	16,0	16,0	50,0	115,0	0,16	4	■
JSE514200D3C.3Z4	SIRA	10053329	3	D	20,0	20,0	60,0	125,0	0,2	4	■

■ **Lagerstandard.**

JSE514

Allgemeine Bearbeitung – Universal – Eckfräser – 4 Schneiden – Weldon – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm



Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JSE514030G2R050.3Z4	SIRA	10053301	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	■
JSE514040G2R050.3Z4	SIRA	10053302	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	■
JSE514050G2R050.3Z4	SIRA	10053306	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	■
JSE514060E2R050.3Z4	SIRA	10053307	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JSE514060E2R100.3Z4	SIRA	10053314	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JSE514080E2R050.3Z4	SIRA	10053308	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JSE514080E2R100.3Z4	SIRA	10053315	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JSE514100E2R050.3Z4	SIRA	10053309	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JSE514100E2R100.3Z4	SIRA	10053316	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JSE514120E2R050.3Z4	SIRA	10053310	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JSE514120E2R100.3Z4	SIRA	10053317	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JSE514160E2R050.3Z4	SIRA	10053311	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JSE514160E2R100.3Z4	SIRA	10053318	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JSE514200E2R050.3Z4	SIRA	10053312	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	■
JSE514200E2R100.3Z4	SIRA	10053319	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	■
JSE514250E2R050.3Z4	SIRA	10053313	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	■
JSE514250E2R100.3Z4	SIRA	10053320	2	E	25,0	25,0	40,0	125,0	66,0	23,8	1,0	4	■

■ **Lagerstandard.**

Schnittdaten – JSE514 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	160 (67 –190) *520 (220 — 620)*
P3	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P4	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P5	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P6	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P7	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P8	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P11	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
P12	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
M1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
M2	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
M3	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
M4	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
M5	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
K1	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K2	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K3	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K4	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K5	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K6	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K7	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
N1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	410 (280 — 540) *1350 (920–1700)*
S11	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
S12	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*
S13	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69–130) *310 (230 — 420)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JSE514 Nutfräsen

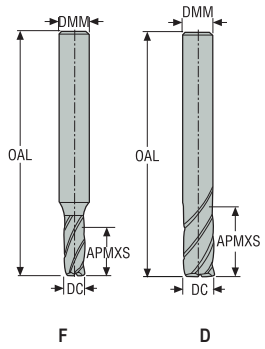
SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51–150) *395 (170 — 490)*
P2	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51–150) *395 (170 — 490)*
P3	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51–150) *395 (170 — 490)*
P4	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–140) *395 (170 — 450)*
P5	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51–150) *395 (170 — 490)*
P6	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–140) *395 (170 — 450)*
P7	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51–150) *395 (170 — 490)*
P8	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (51–150) *395 (170 — 490)*
P11	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (51–100) *230 (170 — 320)*
P12	M/A/D/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
K2	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
K3	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
K4	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
K5	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
K6	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
K7	A/D/M/E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	120 (50–150) *395 (170 — 490)*
N1	E/M/A	0.30 *0,30*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	400 (300 — 500) *1300 (990–1600)*
N11	E/M/A	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	300 (200 — 390) *980 (660–1200)*
S11	E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.40 *0,40*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.075 *0,0030*	70 (50 — 99) *230 (170 — 320)*

Schnittdaten, siehe Seite 457 - 464

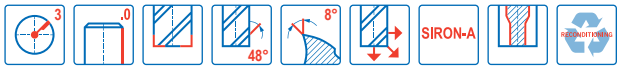
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide







- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

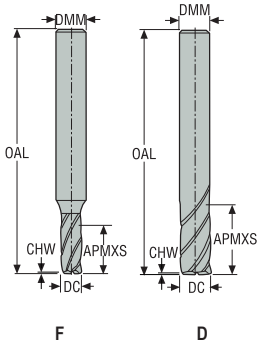
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-A	02733910	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-A	02733912	2	F	5,0	6,0	12,0	55,0	3	■
553060SZ3.0-SIRON-A	02733914	2	D	6,0	6,0	14,0	55,0	3	■
553080SZ3.0-SIRON-A	02733918	2	D	8,0	8,0	18,0	60,0	3	■
553100SZ3.0-SIRON-A	02733922	2	D	10,0	10,0	22,0	70,0	3	■

■ **Lagerstandard.**

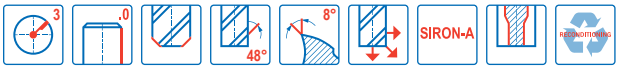
JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenfase





- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

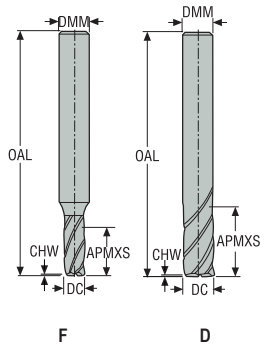


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JS553020F1C.0Z3-SIRA	10041466	1	F	2,0	6,0	3,0	40,0	0,025	3	■
JS553030F1C.0Z3-SIRA	10041467	1	F	3,0	6,0	4,0	40,0	0,035	3	■
JS553040F1C.0Z3-SIRA	10041468	1	F	4,0	6,0	6,0	40,0	0,045	3	■
JS553045F1C.0Z3-SIRA	10041469	1	F	4,5	6,0	6,0	40,0	0,045	3	■
JS553050F1C.0Z3-SIRA	10041470	1	F	5,0	6,0	7,0	40,0	0,055	3	■
JS553055F1C.0Z3-SIRA	10041472	1	F	5,5	6,0	8,0	40,0	0,055	3	■
JS553060D1C.0Z3-SIRA	10041473	1	D	6,0	6,0	8,0	40,0	0,075	3	■
JS553080D1C.0Z3-SIRA	10041474	1	D	8,0	8,0	11,0	50,0	0,1	3	■
JS553100D1C.0Z3-SIRA	10041475	1	D	10,0	10,0	13,0	57,0	0,125	3	■
JS553120D1C.0Z3-SIRA	10041476	1	D	12,0	12,0	15,0	65,0	0,15	3	■
553020Z3.0-SIRON-A	02679241	2	F	2,0	6,0	5,0	50,0	0,025	3	■
553025Z3.0-SIRON-A	02679352	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-A	02679353	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-A	02679359	2	F	3,5	6,0	9,0	55,0	0,035	3	■
553040Z3.0-SIRON-A	02679360	2	F	4,0	6,0	10,0	55,0	0,045	3	■
553045Z3.0-SIRON-A	02679361	2	F	4,5	6,0	12,0	55,0	0,045	3	■
553050Z3.0-SIRON-A	02679364	2	F	5,0	6,0	12,0	55,0	0,055	3	■
553055Z3.0-SIRON-A	02679365	2	F	5,5	6,0	14,0	55,0	0,055	3	■
553060Z3.0-SIRON-A	02679368	2	D	6,0	6,0	14,0	55,0	0,075	3	■
553075Z3.0-SIRON-A	02733916	2	F	7,5	8,0	18,0	60,0	0,1	3	■
553080Z3.0-SIRON-A	02679371	2	D	8,0	8,0	18,0	60,0	0,1	3	■
553095Z3.0-SIRON-A	02733920	2	F	9,5	10,0	22,0	70,0	0,125	3	■
553100Z3.0-SIRON-A	02679374	2	D	10,0	10,0	22,0	70,0	0,125	3	■
553115Z3.0-SIRON-A	02733925	2	F	11,5	12,0	26,0	80,0	0,15	3	■
553120Z3.0-SIRON-A	02679380	2	D	12,0	12,0	26,0	80,0	0,15	3	■
553140Z3.0-SIRON-A	02733932	2	D	14,0	14,0	30,0	85,0	0,175	3	■
553160Z3.0-SIRON-A	02679384	2	D	16,0	16,0	34,0	90,0	0,2	3	■
553200Z3.0-SIRON-A	02679389	2	D	20,0	20,0	42,0	110,0	0,25	3	■
553250Z3.0-SIRON-A	02679393	2	D	25,0	25,0	52,0	125,0	0,3	3	■

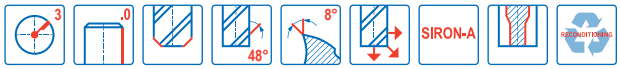
■ **Lagerstandard.**

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenfase







- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

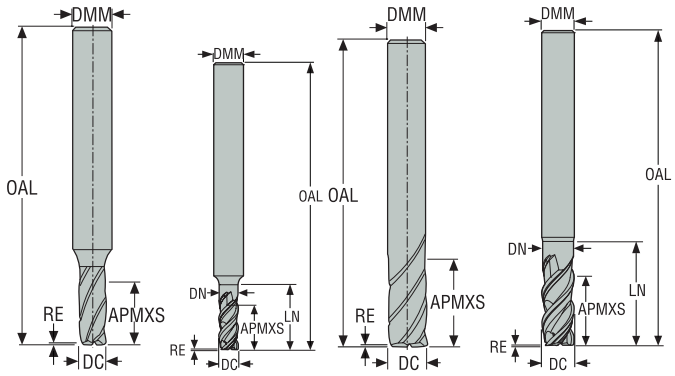
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
553L020Z3.0-SIRON-A	02733962	3	F	2,0	6,0	7,0	50,0	0,025	3	■
553L030Z3.0-SIRON-A	02733971	3	F	3,0	6,0	10,0	55,0	0,035	3	■
553L040Z3.0-SIRON-A	02733972	3	F	4,0	6,0	14,0	60,0	0,045	3	■
553L050Z3.0-SIRON-A	02733974	3	F	5,0	6,0	18,0	60,0	0,055	3	■
553L060Z3.0-SIRON-A	02733982	3	D	6,0	6,0	20,0	65,0	0,075	3	■
553L080Z3.0-SIRON-A	02733986	3	D	8,0	8,0	28,0	70,0	0,1	3	■
553L100Z3.0-SIRON-A	02733992	3	D	10,0	10,0	35,0	85,0	0,125	3	■
553L120Z3.0-SIRON-A	02733994	3	D	12,0	12,0	40,0	95,0	0,15	3	■
553L160Z3.0-SIRON-A	02733996	3	D	16,0	16,0	50,0	110,0	0,2	3	■
553L200Z3.0-SIRON-A	02733998	3	D	20,0	20,0	60,0	125,0	0,25	3	■
553L250Z3.0-SIRON-A	02734000	3	D	25,0	25,0	75,0	150,0	0,3	3	■

■ **Lagerstandard.**

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius







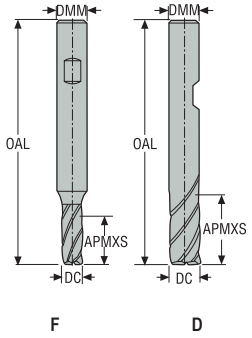
- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS553020G2R050.0Z3-SIRA	02881683	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	■
553030R015Z3.0-SIRON-A	02733908	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	■
JS553030G2R050.0Z3-SIRA	02881684	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	■
553040R020Z3.0-SIRON-A	02733911	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,2	3	■
JS553040G2R050.0Z3-SIRA	02881685	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	■
553050R020Z3.0-SIRON-A	02687282	2	F	5,0	6,0	12,0	55,0	14,7	5,0	0,2	3	■
JS553050G2R050.0Z3-SIRA	02881686	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	■
553060R020Z3.0-SIRON-A	02679369	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	■
JS553060E2R050.0Z3-SIRA	02881687	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	■
JS553060E2R100.0Z3-SIRA	02881688	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	■
553080R050Z3.0-SIRON-A	02679372	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	■
553100R050Z3.0-SIRON-A	02679375	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	■
553100R100Z3.0-SIRON-A	02679376	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	■
553100R200Z3.0-SIRON-A	02810364	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	■
553100R250Z3.0-SIRON-A	02810365	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	■
553100R310Z3.0-SIRON-A	02810366	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	■
553120R050Z3.0-SIRON-A	02679381	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	■
553120R100Z3.0-SIRON-A	02679382	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	■
553120R200Z3.0-SIRON-A	02810367	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	■
553120R250Z3.0-SIRON-A	02810368	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	■
553120R310Z3.0-SIRON-A	02810369	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	■
553160R050Z3.0-SIRON-A	02679385	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	■
553160R100Z3.0-SIRON-A	02679386	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	■
553160R200Z3.0-SIRON-A	02810370	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	■
553160R250Z3.0-SIRON-A	02810371	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	■
553160R310Z3.0-SIRON-A	02810372	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	■
553160R400Z3.0-SIRON-A	02810373	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	■
553200R050Z3.0-SIRON-A	02679390	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	■
553200R100Z3.0-SIRON-A	02679391	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	■
JS553200E2R200.0Z3-SIRA	02881689	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	■
553250R050Z3.0-SIRON-A	02679395	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	■
553250R100Z3.0-SIRON-A	02679396	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	■

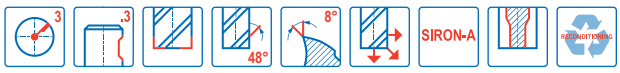
■ **Lagerstandard.**

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Weldon – Scharfe Schneide







- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

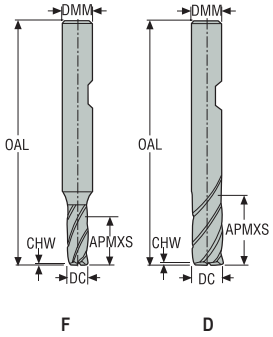
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
553020SZ3.0-SIRON-AW	02733936	2	F	2,0	6,0	5,0	50,0	3	■
553030SZ3.0-SIRON-AW	02733939	2	F	3,0	6,0	7,0	50,0	3	■
553040SZ3.0-SIRON-AW	02733943	2	F	4,0	6,0	10,0	55,0	3	■
553050SZ3.0-SIRON-AW	02733945	2	F	5,0	6,0	12,0	55,0	3	■
553060SZ3.0-SIRON-AW	02733946	2	D	6,0	6,0	14,0	55,0	3	■
553080SZ3.0-SIRON-AW	02733950	2	D	8,0	8,0	18,0	60,0	3	■
553100SZ3.0-SIRON-AW	02733952	2	D	10,0	10,0	22,0	70,0	3	■

■ **Lagerstandard.**

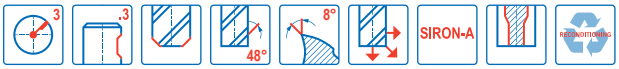
JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Weldon – Eckenfase





- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

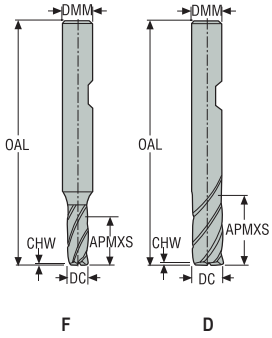


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS553020F1C.3Z3-SIRA	10041477	1	F	2,0	6,0	3,0	40,0	0,025	3	■
JS553030F1C.3Z3-SIRA	10041478	1	F	3,0	6,0	4,0	40,0	0,035	3	■
JS553040F1C.3Z3-SIRA	10041479	1	F	4,0	6,0	6,0	40,0	0,045	3	■
JS553045F1C.3Z3-SIRA	10041480	1	F	4,5	6,0	6,0	40,0	0,045	3	■
JS553050F1C.3Z3-SIRA	10041481	1	F	5,0	6,0	7,0	40,0	0,055	3	■
JS553055F1C.3Z3-SIRA	10041482	1	F	5,5	6,0	8,0	40,0	0,055	3	■
JS553060D1C.3Z3-SIRA	10041483	1	D	6,0	6,0	8,0	40,0	0,075	3	■
JS553080D1C.3Z3-SIRA	10041484	1	D	8,0	8,0	11,0	50,0	0,1	3	□
JS553100D1C.3Z3-SIRA	10041485	1	D	10,0	10,0	13,0	57,0	0,125	3	□
JS553120D1C.3Z3-SIRA	10041486	1	D	12,0	12,0	15,0	65,0	0,15	3	□
553020Z3.0-SIRON-AW	02697423	2	F	2,0	6,0	5,0	50,0	0,025	3	□
553025Z3.0-SIRON-AW	02700354	2	F	2,5	6,0	7,0	50,0	0,025	3	■
553030Z3.0-SIRON-AW	02700355	2	F	3,0	6,0	7,0	50,0	0,035	3	■
553035Z3.0-SIRON-AW	02700357	2	F	3,5	6,0	9,0	55,0	0,035	3	■
553040Z3.0-SIRON-AW	02700358	2	F	4,0	6,0	10,0	55,0	0,045	3	■
553045Z3.0-SIRON-AW	02700359	2	F	4,5	6,0	12,0	55,0	0,045	3	□
553050Z3.0-SIRON-AW	02700360	2	F	5,0	6,0	12,0	55,0	0,055	3	■
553055Z3.0-SIRON-AW	02700361	2	F	5,5	6,0	14,0	55,0	0,055	3	□
553060Z3.3-SIRON-A	02679367	2	D	6,0	6,0	14,0	55,0	0,075	3	■
553075Z3.3-SIRON-A	02733915	2	F	7,5	8,0	18,0	60,0	0,1	3	■
553080Z3.3-SIRON-A	02679370	2	D	8,0	8,0	18,0	60,0	0,1	3	■
553095Z3.3-SIRON-A	02733919	2	F	9,5	10,0	22,0	70,0	0,125	3	■
553100Z3.3-SIRON-A	02679373	2	D	10,0	10,0	22,0	70,0	0,125	3	■
553115Z3.3-SIRON-A	02733923	2	F	11,5	12,0	26,0	80,0	0,15	3	■
553120Z3.3-SIRON-A	02679379	2	D	12,0	12,0	26,0	80,0	0,15	3	■
553140Z3.3-SIRON-A	02733929	2	D	14,0	14,0	30,0	85,0	0,175	3	■
553160Z3.3-SIRON-A	02679383	2	D	16,0	16,0	34,0	90,0	0,2	3	■
553200Z3.3-SIRON-A	02679388	2	D	20,0	20,0	42,0	110,0	0,25	3	■
553250Z3.3-SIRON-A	02679392	2	D	25,0	25,0	52,0	125,0	0,3	3	■

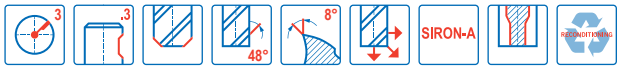
□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Weldon – Eckenfase







- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

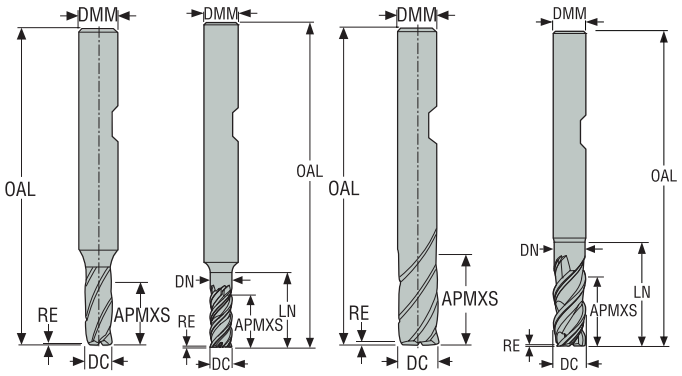
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
553L020Z3.0-SIRON-AW	02734001	3	F	2,0	6,0	7,0	50,0	0,025	3	□
553L030Z3.0-SIRON-AW	02734006	3	F	3,0	6,0	10,0	55,0	0,035	3	■
553L040Z3.0-SIRON-AW	02734007	3	F	4,0	6,0	14,0	60,0	0,045	3	■
553L050Z3.0-SIRON-AW	02734008	3	F	5,0	6,0	18,0	60,0	0,055	3	□
553L060Z3.3-SIRON-A	02733980	3	D	6,0	6,0	20,0	65,0	0,075	3	■
553L080Z3.3-SIRON-A	02733984	3	D	8,0	8,0	28,0	70,0	0,1	3	■
553L100Z3.3-SIRON-A	02733988	3	D	10,0	10,0	35,0	85,0	0,125	3	■
553L120Z3.3-SIRON-A	02733993	3	D	12,0	12,0	40,0	95,0	0,15	3	■
553L160Z3.3-SIRON-A	02733995	3	D	16,0	16,0	50,0	110,0	0,2	3	■
553L200Z3.3-SIRON-A	02733997	3	D	20,0	20,0	60,0	125,0	0,25	3	■
553L250Z3.3-SIRON-A	02733999	3	D	25,0	25,0	75,0	150,0	0,3	3	■

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Weldon – Eckenradius







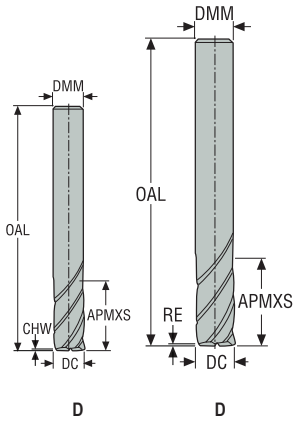
- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

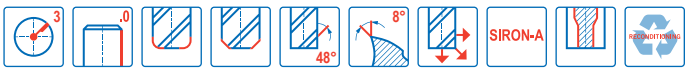
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS553020G2R050.3Z3-SIRA	02881690	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	□
553030R015Z3.0-SIRON-AW	02733941	2	F	3,0	6,0	7,0	50,0	8,5	3,0	0,15	3	□
JS553030G2R050.3Z3-SIRA	02881691	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	□
553040R020Z3.0-SIRON-AW	02733944	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,2	3	□
JS553040G2R050.3Z3-SIRA	02881692	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	□
553050R020Z3.0-SIRON-AW	02703763	2	F	5,0	6,0	12,0	55,0	14,7	5,0	0,2	3	□
JS553050G2R050.3Z3-SIRA	02881693	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	□
553060R020Z3.0-SIRON-AW	02700364	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	□
JS553060E2R050.3Z3-SIRA	02881694	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	□
JS553060E2R100.3Z3-SIRA	02881695	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	■
553080R050Z3.0-SIRON-AW	02700366	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	■
553100R050Z3.0-SIRON-AW	02700369	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	□
553100R100Z3.0-SIRON-AW	02700371	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	□
553100R200Z3.3-SIRON-A	02810422	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	□
553100R250Z3.3-SIRON-A	02810423	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	□
553100R310Z3.3-SIRON-A	02810424	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	□
553120R050Z3.0-SIRON-AW	02700373	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	□
553120R100Z3.0-SIRON-AW	02700374	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	□
553120R200Z3.3-SIRON-A	02810425	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	□
553120R250Z3.3-SIRON-A	02810426	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	□
553120R310Z3.3-SIRON-A	02810427	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	□
553160R050Z3.0-SIRON-AW	02700378	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	□
553160R100Z3.0-SIRON-AW	02700381	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	□
553160R200Z3.3-SIRON-A	02810428	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	□
553160R250Z3.3-SIRON-A	02810429	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	□
553160R310Z3.3-SIRON-A	02810430	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	□
553160R400Z3.3-SIRON-A	02810431	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	□
553200R050Z3.0-SIRON-AW	02700383	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	■
553200R100Z3.0-SIRON-AW	02700384	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	□
JS553200E2R200.3Z3-SIRA	02881696	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	□
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	□
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase – Zoll







- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist

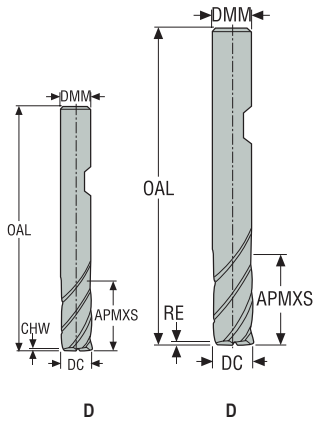
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll	Zoll	Zoll		
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000	0.001	–	3	■
5530250Z3.0-SIRON-A	02712688	2	D	0.250	0.250	0.500	2.500	0.003	–	3	■
5530250R015Z3.0-SIRON-A	02712689	2	D	0.250	0.250	0.500	2.500	–	0.015	3	■
5530312Z3.0-SIRON-A	02712690	2	D	0.313	0.313	0.625	2.500	0.004	–	3	■
5530312R015Z3.0-SIRON-A	02712693	2	D	0.313	0.313	0.625	2.500	–	0.015	3	■
5530375Z3.0-SIRON-A	02712694	2	D	0.375	0.375	0.750	3.000	0.005	–	3	■
5530375R015Z3.0-SIRON-A	02712695	2	D	0.375	0.375	0.750	3.000	–	0.015	3	■
5530375R030Z3.0-SIRON-A	02712696	2	D	0.375	0.375	0.750	3.000	–	0.030	3	■
5530500Z3.0-SIRON-A	02712699	2	D	0.500	0.500	1.000	3.500	0.006	–	3	■
5530500R015Z3.0-SIRON-A	02712701	2	D	0.500	0.500	1.000	3.500	–	0.015	3	■
5530500R030Z3.0-SIRON-A	02712703	2	D	0.500	0.500	1.000	3.500	–	0.030	3	■

■ **Lagerstandard.**

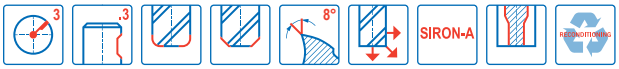
JS553

Hochleistung – Universal – Schaftfräser – 3 Schneiden – Weldon – Eckenradius oder Fase – Zoll





- Toleranzen:
- DMM=h5
- DC=e7



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Weldon
				Zoll	Zoll	Zoll	Zoll	Zoll	Zoll		
5530500Z3.3-SIRON-A	02712697	2	D	0.500	0.500	1.000	3.500	0.006	–	3	■
5530500R015Z3.3-SIRON-A	02712700	2	D	0.500	0.500	1.000	3.500	–	0.015	3	■
5530500R030Z3.3-SIRON-A	02712702	2	D	0.500	0.500	1.000	3.500	–	0.030	3	■

■ **Lagerstandard.**

Schnittdaten – JS553 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	220 (190 — 240) *720 (630–780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	165 (150–190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	170 (150–190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	145 (130–160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82–100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	115 (100–120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82–100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	45 (36 — 53) *150 (120–170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	37 (30 — 44) *120 (99–140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (160–190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	145 (140–170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (120–140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	120 (110–140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140–170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	620 (520–720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (340 — 460) *1300 (1200–1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	310 (260 — 350) *1025 (860–1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	43 (26 — 60) *140 (86–190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	35 (21 — 48) *115 (69–150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	30 (19 — 42) *100 (63–130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (78–130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (60–100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (49–72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	290 (180 — 400) *950 (600–1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	300 (180 — 410) *980 (600–1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	195 (170 — 220) *640 (560–720)*
P2	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	165 (140–180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	135 (120–150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	145 (130–160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	130 (120–140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	95 (85–100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	48 (39 — 58) *155 (130–190)*
M4	E	0.70 *0,70*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (30 — 43) *120 (99–140)*
M5	E	0.70 *0,70*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	30 (25 — 36) *100 (83–110)*
K1	E	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	145 (140–170) *475 (460 — 550)*
K2	E	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	125 (120–150) *410 (400 — 490)*
K3	E	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	110 (110–120) *360 (370 — 390)*
K4	E	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (96–120) *345 (320 — 390)*
K5	E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
K6	E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	200 (180 — 230) *660 (600–750)*
K7	E	0.80 *0,80*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	175 (150–190) *570 (500 — 620)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	375 (320 — 430) *1225 (1100–1400)*
N3	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	290 (250 — 330) *950 (830–1000)*
S1	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	34 (21 — 47) *110 (69–150)*
S2	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56–120)*
S3	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50–100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	85 (63–110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52–77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52–77) *215 (180 — 250)*
H11	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 98) *260 (220 — 320)*
H12	M/A/D	1.0 *1,0*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	65 (52–77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52–77) *215 (180 — 250)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (150 — 340) *800 (500–1100)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (160 — 350) *820 (530–1100)*
GR1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	490 (400 — 580) *1600 (1400–1900)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	220 (190 — 240) *720 (630–780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	165 (150–190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	160 (140–180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	170 (150–190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	160 (140–180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	145 (130–160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82–100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	115 (100–120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82–100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	45 (36 — 53) *150 (120–170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	37 (30 — 44) *120 (99–140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	165 (160–190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	145 (140–170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	125 (120–140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	120 (110–140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	155 (140–170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	195 (170 — 220) *640 (560–720)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	620 (520–720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	400 (340 — 460) *1300 (1200–1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	310 (260 — 350) *1025 (860–1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	43 (26 — 60) *140 (86–190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	35 (21 — 48) *115 (69–150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	30 (19 — 42) *100 (63–130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	110 (78–130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	85 (60–100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.020 *0,00080*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	60 (49–72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	290 (180 — 400) *950 (600–1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	300 (180 — 410) *980 (600–1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Nutfräsen – Zoll

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	195 (170 — 220) *640 (560–720)*
P2	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	165 (140–180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120–150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130–160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	130 (120–140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	95 (85–100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 58) *155 (130–190)*
M4	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	36 (30 — 43) *120 (99–140)*
M5	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	30 (25 — 36) *100 (83–110)*
K1	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	145 (140–170) *475 (460 — 550)*
K2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	125 (120–150) *410 (400 — 490)*
K3	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	110 (110–120) *360 (370 — 390)*
K4	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	105 (96–120) *345 (320 — 390)*
K5	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	135 (120–150) *445 (400 — 490)*
K6	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	200 (180 — 230) *660 (600–750)*
K7	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	175 (150–190) *570 (500 — 620)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS553 Nutfräsen – Zoll

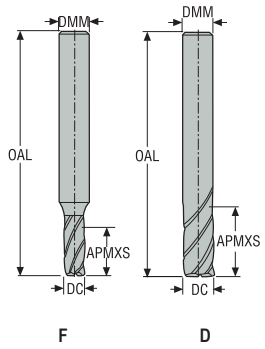
SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	375 (320 — 430) *1225 (1100–1400)*
N3	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	290 (250 — 330) *950 (830–1000)*
S1	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	34 (21 — 47) *110 (69–150)*
S2	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	27 (17 — 38) *90 (56–120)*
S3	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	23 (15 — 32) *75 (50–100)*
S11	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	85 (63–110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52–77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52–77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52–77) *215 (180 — 250)*
H31	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	49 (39 — 58) *160 (130–190)*
TS1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	245 (150 — 340) *800 (500–1100)*
TP1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	250 (160 — 350) *820 (530–1100)*
GR1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	490 (400 — 580) *1600 (1400–1900)*

Schnittdaten, siehe Seite 457 - 464

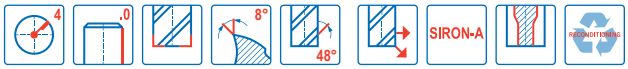
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide







- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

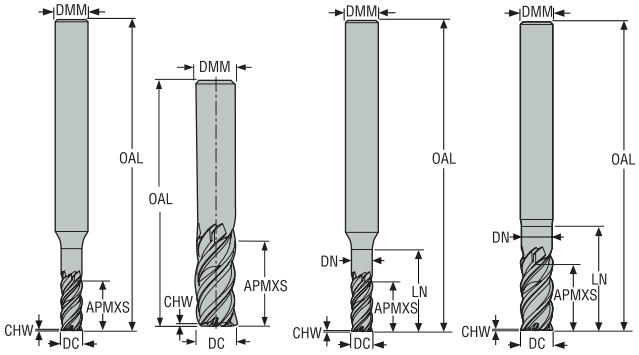
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	■
554050SZ4.0-SIRON-A	02733812	2	F	5,0	6,0	12,0	55,0	4	■
554060SZ4.0-SIRON-A	02733814	2	D	6,0	6,0	14,0	55,0	4	■
554080SZ4.0-SIRON-A	02733815	2	D	8,0	8,0	18,0	60,0	4	■
554100SZ4.0-SIRON-A	02733816	2	D	10,0	10,0	22,0	70,0	4	■

■ **Lagerstandard.**

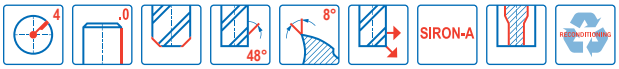
JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenfase





- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

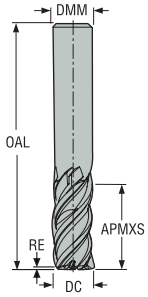


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS554040F1C.0Z4-SIRA	10041454	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,045	4	■
JS554060D1C.0Z4-SIRA	10041455	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	■
JS554080D1C.0Z4-SIRA	10041456	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	■
JS554100D1C.0Z4-SIRA	10041457	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	■
JS554120D1C.0Z4-SIRA	10041458	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	■
JS554160D1C.0Z4-SIRA	10041459	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	■
JS554030G2C.0Z4-SIRA	03029956	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	■
554030Z4.0-SIRON-A	02733455	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554040G2C.0Z4-SIRA	03029957	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	■
554040Z4.0-SIRON-A	02733459	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554050G2C.0Z4-SIRA	03029958	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	■
554050Z4.0-SIRON-A	02733813	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554060E2C.0Z4-SIRA	03029959	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	■
554060Z4.0-SIRON-A	02679503	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554080E2C.0Z4-SIRA	03029961	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	■
554080Z4.0-SIRON-A	02679512	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	■
JS554100E2C.0Z4-SIRA	03029963	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	■
554100Z4.0-SIRON-A	02679537	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	■
JS554120E2C.0Z4-SIRA	03029966	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	■
554120Z4.0-SIRON-A	02679548	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	■
JS554160E2C.0Z4-SIRA	03029970	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	■
554160Z4.0-SIRON-A	02679560	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	■
JS554200E2C.0Z4-SIRA	03029972	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	■
554200Z4.0-SIRON-A	02679566	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	■
554250Z4.0-SIRON-A	02679573	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	■
554L030Z4.0-SIRON-A	02733818	3	F	3,0	6,0	12,0	55,0	13,7	3,0	0,035	4	■
554L040Z4.0-SIRON-A	02733823	3	F	4,0	6,0	16,0	60,0	17,7	4,0	0,045	4	■
554L050Z4.0-SIRON-A	02733825	3	F	5,0	6,0	20,0	65,0	21,7	5,0	0,055	4	■
554L060Z4.0-SIRON-A	02733828	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	■
554L080Z4.0-SIRON-A	02733830	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	■
554L100Z4.0-SIRON-A	02733832	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	■
554L120Z4.0-SIRON-A	02733834	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	■
554L160Z4.0-SIRON-A	02733836	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	■
554L200Z4.0-SIRON-A	02733838	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	■
554L250Z4.0-SIRON-A	02733841	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	■

■ **Lagerstandard.**

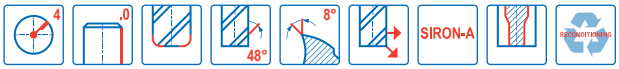
JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius



D





- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

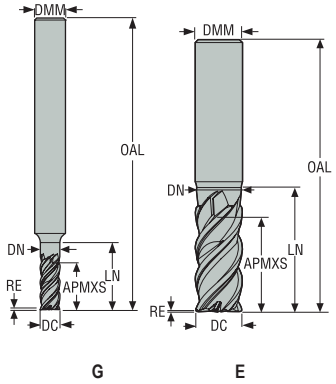
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
554060R020Z4.0-SIRON-A	02679507	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.0-SIRON-A	02679514	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.0-SIRON-A	02679540	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.0-SIRON-A	02679544	2	D	10,0	10,0	22,0	70,0	1,0	4	■
554120R050Z4.0-SIRON-A	02679552	2	D	12,0	12,0	26,0	80,0	0,5	4	■
554120R100Z4.0-SIRON-A	02679557	2	D	12,0	12,0	26,0	80,0	1,0	4	■
554160R050Z4.0-SIRON-A	02679562	2	D	16,0	16,0	34,0	90,0	0,5	4	■
554160R100Z4.0-SIRON-A	02679564	2	D	16,0	16,0	34,0	90,0	1,0	4	■
554160R200Z4.0-SIRON-A	02810437	2	D	16,0	16,0	34,0	90,0	2,0	4	■
554160R310Z4.0-SIRON-A	02810439	2	D	16,0	16,0	34,0	90,0	3,1	4	■
554160R400Z4.0-SIRON-A	02810441	2	D	16,0	16,0	34,0	90,0	4,0	4	■
554200R050Z4.0-SIRON-A	02679568	2	D	20,0	20,0	42,0	100,0	0,5	4	■
554200R100Z4.0-SIRON-A	02679571	2	D	20,0	20,0	42,0	100,0	1,0	4	■
554200R250Z4.0-SIRON-A	02810443	2	D	20,0	20,0	42,0	100,0	2,5	4	■
554200R310Z4.0-SIRON-A	02810445	2	D	20,0	20,0	42,0	100,0	3,1	4	■
554200R400Z4.0-SIRON-A	02810447	2	D	20,0	20,0	42,0	100,0	4,0	4	■
554250R050Z4.0-SIRON-A	02679575	2	D	25,0	25,0	52,0	125,0	0,5	4	■
554250R100Z4.0-SIRON-A	02679577	2	D	25,0	25,0	52,0	125,0	1,0	4	■
554250R310Z4.0-SIRON-A	02810449	2	D	25,0	25,0	52,0	125,0	3,1	4	■
554250R400Z4.0-SIRON-A	02810452	2	D	25,0	25,0	52,0	125,0	4,0	4	■

■ Lagerstandard.

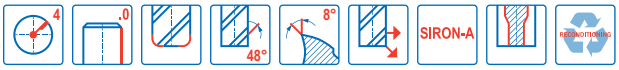
JS554

Hochleistung– Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

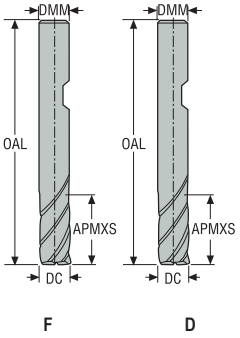


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2R015.0Z4-SIRA	02881697	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	■
JS554040G2R020.0Z4-SIRA	02881698	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	■
JS554050G2R020.0Z4-SIRA	02881699	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	■
JS554060E2R020.0Z4-SIRA	03029960	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	■
JS554060E2R050.0Z4-SIRA	02881700	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	■
JS554060E2R100.0Z4-SIRA	03029948	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	■
JS554080E2R050.0Z4-SIRA	03029962	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	■
JS554080E2R100.0Z4-SIRA	02881701	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	■
JS554100E2R050.0Z4-SIRA	03029964	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	■
JS554100E2R100.0Z4-SIRA	03029965	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	■
JS554100E2R200.0Z4-SIRA	02881702	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	■
JS554100E2R250.0Z4-SIRA	03029949	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	■
JS554120E2R050.0Z4-SIRA	03029968	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	■
JS554120E2R100.0Z4-SIRA	03029969	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	■
JS554120E2R200.0Z4-SIRA	02881703	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	■
JS554120E2R250.0Z4-SIRA	02881704	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	■
JS554120E2R300.0Z4-SIRA	03029950	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	■
JS554160E2R050.0Z4-SIRA	03029971	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	■
JS554160E2R600.0Z4-SIRA	03093685	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	■
JS554200E2R200.0Z4-SIRA	02881705	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	■
JS554200E2R600.0Z4-SIRA	03029951	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	■
JS554250E2R600.0Z4-SIRA	03093686	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	■

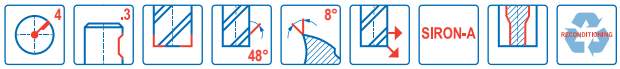
■ **Lagerstandard.**

JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Weldon – Scharfe Schneide







- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

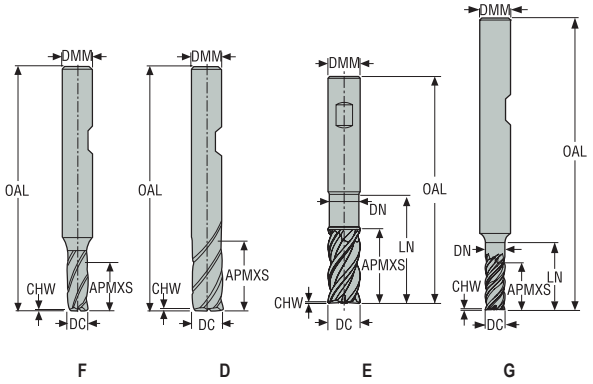
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0	6,0	12,0	55,0	4	☐
554060SZ4.0-SIRON-AW	02733848	2	D	6,0	6,0	14,0	55,0	4	☐
554080SZ4.0-SIRON-AW	02733849	2	D	8,0	8,0	18,0	60,0	4	☐
554100SZ4.0-SIRON-AW	02733850	2	D	10,0	10,0	22,0	70,0	4	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

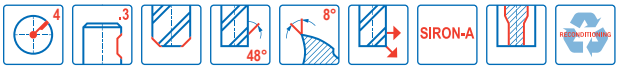
JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenfase





- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

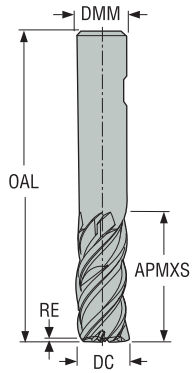


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554040F1C.3Z4-SIRA	10041460	1	F	4,0	6,0	6,0	40,0	9,0	4,05	0,045	4	■
JS554060D1C.3Z4-SIRA	10041461	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	■
JS554080D1C.3Z4-SIRA	10041462	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	□
JS554100D1C.3Z4-SIRA	10041463	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	□
JS554120D1C.3Z4-SIRA	10041464	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	□
JS554160D1C.3Z4-SIRA	10041465	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	□
JS554030G2C.3Z4-SIRA	03029973	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	□
554030Z4.3-SIRON-A	02733450	2	F	3,0	6,0	7,0	50,0	8,7	3,0	0,035	4	■
JS554040G2C.3Z4-SIRA	03029974	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	□
554040Z4.3-SIRON-A	02733456	2	F	4,0	6,0	10,0	55,0	11,7	4,0	0,045	4	■
JS554050G2C.3Z4-SIRA	03029975	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	□
554050Z4.3-SIRON-A	02733461	2	F	5,0	6,0	12,0	55,0	13,7	5,0	0,055	4	■
JS554060E2C.3Z4-SIRA	03029976	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	□
554060Z4.3-SIRON-A	02679502	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	■
JS554080E2C.3Z4-SIRA	03029978	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	□
554080Z4.3-SIRON-A	02679511	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	■
JS554100E2C.3Z4-SIRA	03029980	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	□
554100Z4.3-SIRON-A	02679535	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	■
JS554120E2C.3Z4-SIRA	03029983	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	□
554120Z4.3-SIRON-A	02679547	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	■
JS554160E2C.3Z4-SIRA	03029986	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	□
554160Z4.3-SIRON-A	02679559	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	■
JS554200E2C.3Z4-SIRA	03029988	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	□
554200Z4.3-SIRON-A	02679565	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	■
554250Z4.3-SIRON-A	02679572	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	■
554L030Z4.3-SIRON-A	02733817	3	F	3,0	6,0	12,0	55,0	13,7	3,0	0,035	4	■
554L040Z4.3-SIRON-A	02733820	3	F	4,0	6,0	16,0	60,0	17,7	4,0	0,045	4	■
554L050Z4.3-SIRON-A	02733824	3	F	5,0	6,0	20,0	65,0	21,7	5,0	0,055	4	■
554L060Z4.3-SIRON-A	02733827	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	■
554L080Z4.3-SIRON-A	02733829	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	■
554L100Z4.3-SIRON-A	02733831	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	■
554L120Z4.3-SIRON-A	02733833	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	■
554L160Z4.3-SIRON-A	02733835	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	■
554L200Z4.3-SIRON-A	02733837	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	■
554L250Z4.3-SIRON-A	02733839	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	■

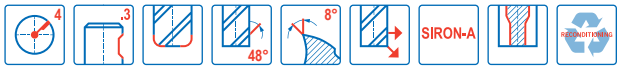
■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenradius



D





- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

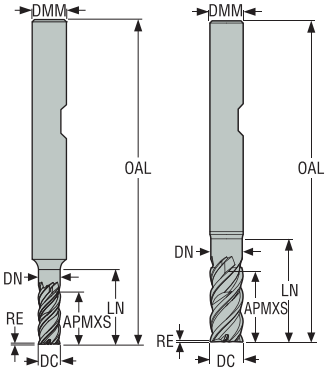
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
554060R020Z4.3-SIRON-A	02679506	2	D	6,0	6,0	14,0	55,0	0,2	4	■
554080R050Z4.3-SIRON-A	02679513	2	D	8,0	8,0	18,0	60,0	0,5	4	■
554100R050Z4.3-SIRON-A	02679539	2	D	10,0	10,0	22,0	70,0	0,5	4	■
554100R100Z4.3-SIRON-A	02679542	2	D	10,0	10,0	22,0	70,0	1,0	4	■
554120R050Z4.3-SIRON-A	02679549	2	D	12,0	12,0	26,0	80,0	0,5	4	■
554120R100Z4.3-SIRON-A	02679554	2	D	12,0	12,0	26,0	80,0	1,0	4	■
554160R050Z4.3-SIRON-A	02679561	2	D	16,0	16,0	34,0	90,0	0,5	4	■
554160R100Z4.3-SIRON-A	02679563	2	D	16,0	16,0	34,0	90,0	1,0	4	■
554160R200Z4.3-SIRON-A	02810436	2	D	16,0	16,0	34,0	90,0	2,0	4	■
554160R310Z4.3-SIRON-A	02810438	2	D	16,0	16,0	34,0	90,0	3,1	4	■
554160R400Z4.3-SIRON-A	02810440	2	D	16,0	16,0	34,0	90,0	4,0	4	■
554200R050Z4.3-SIRON-A	02679567	2	D	20,0	20,0	42,0	100,0	0,5	4	■
554200R100Z4.3-SIRON-A	02679570	2	D	20,0	20,0	42,0	100,0	1,0	4	■
554200R250Z4.3-SIRON-A	02810442	2	D	20,0	20,0	42,0	100,0	2,5	4	■
554200R310Z4.3-SIRON-A	02810444	2	D	20,0	20,0	42,0	100,0	3,1	4	■
554200R400Z4.3-SIRON-A	02810446	2	D	20,0	20,0	42,0	100,0	4,0	4	■
554250R050Z4.3-SIRON-A	02679574	2	D	25,0	25,0	52,0	125,0	0,5	4	■
554250R100Z4.3-SIRON-A	02679576	2	D	25,0	25,0	52,0	125,0	1,0	4	■
554250R310Z4.3-SIRON-A	02810448	2	D	25,0	25,0	52,0	125,0	3,1	4	■
554250R400Z4.3-SIRON-A	02810451	2	D	25,0	25,0	52,0	125,0	4,0	4	■

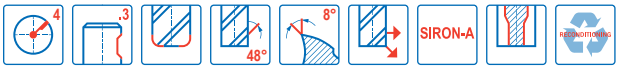
■ Lagerstandard.

JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenradius







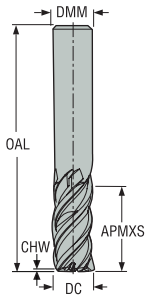
- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS554030G2R015.3Z4-SIRA	02881706	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	☐
JS554040G2R020.3Z4-SIRA	02881946	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	☐
JS554050G2R020.3Z4-SIRA	02881708	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	☐
JS554060E2R020.3Z4-SIRA	03029977	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	☐
JS554060E2R050.3Z4-SIRA	02881709	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	☐
JS554060E2R100.3Z4-SIRA	03029952	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	☐
JS554080E2R050.3Z4-SIRA	03029979	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	☐
JS554080E2R100.3Z4-SIRA	02881710	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	☐
JS554100E2R050.3Z4-SIRA	03029981	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	☐
JS554100E2R100.3Z4-SIRA	03029982	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	☐
JS554100E2R200.3Z4-SIRA	02881711	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	☐
JS554100E2R250.3Z4-SIRA	03029953	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	☐
JS554120E2R050.3Z4-SIRA	03029984	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	■
JS554120E2R100.3Z4-SIRA	03029985	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	☐
JS554120E2R200.3Z4-SIRA	02881712	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	☐
JS554120E2R250.3Z4-SIRA	02881713	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	☐
JS554120E2R300.3Z4-SIRA	03029954	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	☐
JS554160E2R050.3Z4-SIRA	03029987	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	☐
JS554160E2R600.3Z4-SIRA	03093687	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	☐
JS554200E2R200.3Z4-SIRA	02881714	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	☐
JS554200E2R600.3Z4-SIRA	03029955	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	☐
JS554250E2R600.3Z4-SIRA	03093688	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	☐

■ **Lagerstandard.** ☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

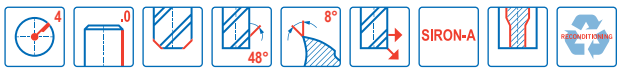
JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenfase – Zoll



D





- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist

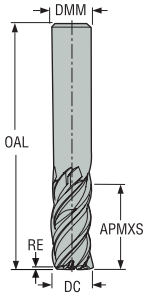
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll	Zoll		
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4	■
5540375Z4.0-SIRON-A	02711344	2	D	0.375	0.375	0.750	3.000	0.005	4	■
5540500Z4.0-SIRON-A	02711611	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540625Z4.0-SIRON-A	02711626	2	D	0.625	0.625	1.250	3.750	0.008	4	■
5540750Z4.0-SIRON-A	02711643	2	D	0.750	0.750	1.500	4.000	0.010	4	■
5541000Z4.0-SIRON-A	02711660	2	D	1.000	1.000	2.000	5.000	0.012	4	■

■ **Lagerstandard.**

JS554

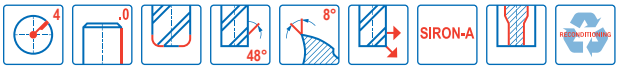
Hochleistung – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll





D

- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±.0008 *Zoll*
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist

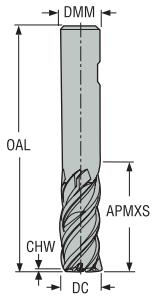


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll	Zoll		
5540250R015Z4.0-SIRON-A	02711335	2	D	0.250	0.250	0.500	2.500	0.015	4	■
5540312R015Z4.0-SIRON-A	02711341	2	D	0.313	0.313	0.625	2.500	0.015	4	■
5540375R015Z4.0-SIRON-A	02711588	2	D	0.375	0.375	0.750	3.000	0.015	4	■
5540375R030Z4.0-SIRON-A	02711589	2	D	0.375	0.375	0.750	3.000	0.030	4	■
5540500R015Z4.0-SIRON-A	02711614	2	D	0.500	0.500	1.000	3.500	0.015	4	■
5540500R030Z4.0-SIRON-A	02711616	2	D	0.500	0.500	1.000	3.500	0.030	4	■
5540500R125Z4.0-SIRON-A	02842370	2	D	0.500	0.500	1.000	3.500	0.125	4	■
5540625R015Z4.0-SIRON-A	02711629	2	D	0.625	0.625	1.250	3.750	0.015	4	■
5540625R030Z4.0-SIRON-A	02711631	2	D	0.625	0.625	1.250	3.750	0.030	4	■
5540625R125Z4.0-SIRON-A	02842371	2	D	0.625	0.625	1.250	3.750	0.125	4	■
5540750R030Z4.0-SIRON-A	02711647	2	D	0.750	0.750	1.500	4.000	0.030	4	■
5540750R060Z4.0-SIRON-A	02711655	2	D	0.750	0.750	1.500	4.000	0.060	4	■

■ **Lagerstandard.**

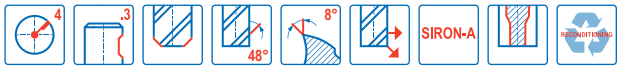
JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenfase – Zoll



D





- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich

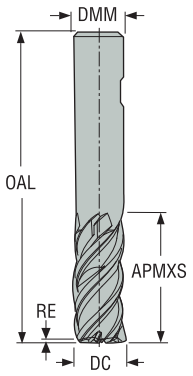
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				Zoll	Zoll	Zoll	Zoll	Zoll		
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	■

■ **Lagerstandard.**

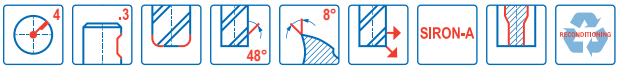
JS554

Hochleistung – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenradius – Zoll





D



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±.0008 *Zoll*
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				Zoll	Zoll	Zoll	Zoll	Zoll		
5540500R015Z4.3-SIRON-A	02711613	2	D	0.500	0.500	1.000	3.500	0.015	4	■
5540500R030Z4.3-SIRON-A	02711615	2	D	0.500	0.500	1.000	3.500	0.030	4	■
5540500R125Z4.3-SIRON-A	02856456	2	D	0.500	0.500	1.000	3.500	0.125	4	□
5540625R125Z4.3-SIRON-A	02856457	2	D	0.625	0.625	1.250	3.750	0.125	4	□
5541000R060Z4.3-SIRON-A	02711663	2	D	1.000	1.000	2.000	5.000	0.060	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS554 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630–780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	210 (190 — 240) *690 (630–780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (140–170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (150–180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140–170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130–150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79–100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96–120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79–100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120–160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96–130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	175 (160–190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	155 (140–170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	130 (120–140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (110–140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140–170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
N1	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510–710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100–1400)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890–1200)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72–120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44–78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H11	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	95 (75–110) *310 (250 — 360)*
H12	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	90 (73–100) *295 (240 — 320)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110–190) *510 (370 — 620)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600–1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600–1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	195 (170 — 220) *640 (560–720)*
P2	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	165 (140–180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	130 (120–140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85–100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	48 (39 — 57) *155 (130–180)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	36 (29 — 43) *120 (96–140)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 36) *100 (83–110)*
K1	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	155 (140–170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	115 (110–120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	110 (96–120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	200 (180 — 220) *660 (600–720)*
K7	E	0.70 *0,70*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	175 (150–190) *570 (500 — 620)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
N1	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	370 (310 — 430) *1225 (1100–1400)*
N3	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	290 (250 — 330) *950 (830–1000)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 34) *100 (83–110)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56–120)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50–100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63–110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52–76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52–76) *215 (180 — 240)*
H11	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 97) *260 (220 — 310)*
H12	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (60 — 89) *245 (200 — 290)*
H21	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	125 (90–160) *410 (300 — 520)*
TS1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500–1000)*
TP1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500–1100)*
GR1	A	0.80 *0,80*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300–1900)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630–780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 240) *690 (630–780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	155 (140–170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	165 (150–180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140–170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130–150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79–100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96–120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79–100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120–160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96–130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	175 (160–190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	155 (140–170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (120–140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	125 (110–140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	155 (140–170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510–710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100–1400)*
N3	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890–1200)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	38 (32 — 44) *125 (110–140)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	35 (21 — 48) *115 (69–150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	30 (19 — 42) *100 (63–130)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72–120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44–78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.15 *0,0060*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110–190) *510 (370 — 620)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.080 *0,0032*	0.095 *0,0038*	60 (48–71) *195 (160 — 230)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600–1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600–1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Nutfräsen – Zoll

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	195 (170 — 220) *640 (560–720)*
P2	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	165 (140–180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120–150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	130 (120–140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	95 (85–100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	48 (39 — 57) *155 (130–180)*
M4	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	36 (29 — 43) *120 (96–140)*
M5	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 36) *100 (83–110)*
K1	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	155 (140–170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	115 (110–120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	110 (96–120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120–150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	200 (180 — 220) *660 (600–720)*
K7	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	175 (150–190) *570 (500 — 620)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554 Nutfräsen – Zoll

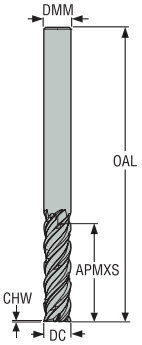
SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	370 (310 — 430) *1225 (1100–1400)*
N3	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	290 (250 — 330) *950 (830–1000)*
S1	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 34) *100 (83–110)*
S2	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	27 (17 — 38) *90 (56–120)*
S3	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	23 (15 — 32) *75 (50–100)*
S11	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63–110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52–76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52–76) *215 (180 — 240)*
H21	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	125 (90–160) *410 (300 — 520)*
H31	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 57) *155 (130–180)*
TS1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500–1000)*
TP1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500–1100)*
GR1	A	0.80 *0,80*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300–1900)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

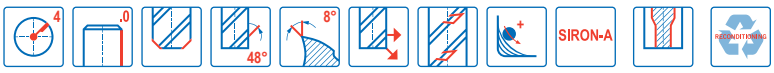
JS554-3C

Dynamisches Fräsen – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenfase



D





- Toleranzen:
- DMM= h5
- DC= e7
- Spanteiler
- Nachschleifen möglich

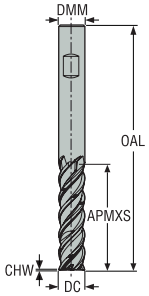
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.0Z4C-SIRA	02810479	3	D	■	10,0	10,0	40,0	85,0	0,125	4	■
JS554120D3C.0Z4C-SIRA	02810481	3	D	■	12,0	12,0	45,0	100,0	0,15	4	■
JS554160D3C.0Z4C-SIRA	02810483	3	D	■	16,0	16,0	55,0	115,0	0,2	4	■
JS554200D3C.0Z4C-SIRA	02810485	3	D	■	20,0	20,0	65,0	125,0	0,25	4	■
JS554250D3C.0Z4C-SIRA	02810486	3	D	■	25,0	25,0	85,0	150,0	0,3	4	■

■ **Lagerstandard.**

JS554-3C

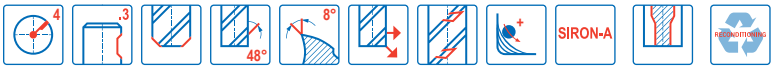
Dynamisches Fräsen – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenfase





D

- Toleranzen:
- DMM= h5
- DC= e7
- Spanteiler
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS554060D3C.3Z4C-SIRA	02810474	3	D	■	6,0	6,0	23,0	65,0	0,075	4	■
JS554080D3C.3Z4C-SIRA	02810476	3	D	■	8,0	8,0	32,0	75,0	0,1	4	■
JS554100D3C.3Z4C-SIRA	02810478	3	D	■	10,0	10,0	40,0	85,0	0,125	4	■
JS554120D3C.3Z4C-SIRA	02810480	3	D	■	12,0	12,0	45,0	100,0	0,15	4	■
JS554160D3C.3Z4C-SIRA	02810482	3	D	■	16,0	16,0	55,0	115,0	0,2	4	■
JS554200D3C.3Z4C-SIRA	02810484	3	D	■	20,0	20,0	65,0	125,0	0,25	4	■
JS554250D3C.3Z4C-SIRA	02810487	3	D	■	25,0	25,0	85,0	150,0	0,3	4	■

■ **Lagerstandard.**

Schnittdaten – JS554-3C Dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	350 (320 — 380) *1150 (1100–1200)*
P2	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100–1200)*
P3	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	295 (270 — 320) *970 (890–1000)*
P4	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	260 (240 — 280) *850 (790 — 910)*
P5	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (230 — 270) *820 (760 — 880)*
P6	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	280 (260 — 300) *920 (860 — 980)*
P7	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	265 (240 — 290) *870 (790 — 950)*
P8	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	250 (230 — 270) *820 (760 — 880)*
P11	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	245 (230 — 270) *800 (760 — 880)*
P12	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (140–160) *490 (460 — 520)*
M1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	180 (160 — 210) *590 (530 — 680)*
M2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (130–170) *490 (430 — 550)*
M3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	100 (90–100) *330 (300 — 320)*
M4	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	75 (70 — 85) *245 (230 — 270)*
M5	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	65 (59–71) *215 (200 — 230)*
K1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100–1200)*
K2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
K3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	255 (240 — 280) *840 (790 — 910)*
K4	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (220 — 260) *800 (730 — 850)*
K5	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (140–160) *490 (460 — 520)*
K6	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (200 — 230) *710 (660–750)*
K7	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	190 (180 — 200) *620 (600 — 650)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS554-3C Dynamisches Fräsen

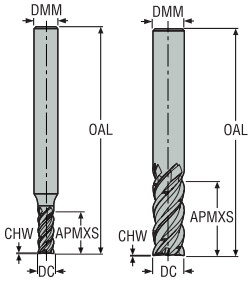
SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	750 (650 — 840) *2450 (2200 — 2700)*
N2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	480 (420 — 540) *1575 (1400–1700)*
N3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	320 (280 — 360) *1050 (920–1100)*
N11	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	375 (330 — 420) *1225 (1100–1300)*
S1	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	50 (40 — 60) *165 (140–190)*
S2	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	40 (33 — 48) *130 (110–150)*
S3	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	25 (20 — 29) *80 (66 — 95)*
S11	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	195 (130 — 220) *640 (430–720)*
S12	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	150 (100–160) *490 (330 — 520)*
S13	E	0.100 *0,100*	3.6 *3,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	120 (80–130) *395 (270 — 420)*
H5	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	200 (190 — 220) *660 (630–720)*
H8	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630–720)*
H11	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	255 (240 — 280) *840 (790 — 910)*
H12	M/A/D	0.100 *0,100*	3.6 *3,6*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	205 (190 — 220) *670 (630–720)*
H21	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630–720)*

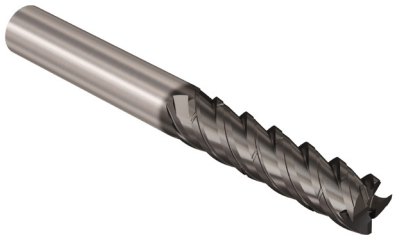
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS564

Dynamisches Fräsen – Universal – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenfase







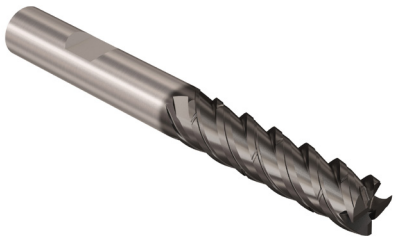
- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist

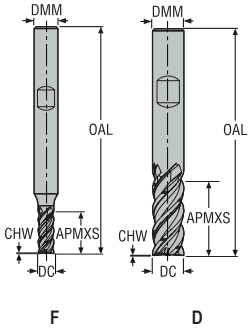
Bezeichnung	Produkt-nummer	Längen-index	Spanteiler		DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	0,06	4	■
JS564060D2C.0Z4C-NXT	03067341	2	D	■	6,0	6,0	15,0	57,0	0,075	4	■
JS564080D2C.0Z4C-NXT	03067342	2	D	■	8,0	8,0	20,0	63,0	0,1	4	■
JS564100D2C.0Z4C-NXT	03067343	2	D	■	10,0	10,0	25,0	72,0	0,125	4	■
JS564120D2C.0Z4C-NXT	03067344	2	D	■	12,0	12,0	30,0	83,0	0,15	4	■
JS564160D2C.0Z4C-NXT	03067345	2	D	■	16,0	16,0	40,0	99,0	0,2	4	■
JS564200D2C.0Z4C-NXT	03067346	2	D	■	20,0	20,0	50,0	114,0	0,25	4	■
JS564060D3C.0Z4C-NXT	03067347	3	D	■	6,0	6,0	23,0	64,0	0,075	4	■
JS564080D3C.0Z4C-NXT	03067348	3	D	■	8,0	8,0	32,0	74,0	0,1	4	■
JS564100D3C.0Z4C-NXT	03067349	3	D	■	10,0	10,0	40,0	88,0	0,125	4	■
JS564120D3C.0Z4C-NXT	03067350	3	D	■	12,0	12,0	45,0	99,0	0,15	4	■
JS564160D3C.0Z4C-NXT	03067351	3	D	■	16,0	16,0	55,0	114,0	0,2	4	■
JS564200D3C.0Z4C-NXT	03067352	3	D	■	20,0	20,0	65,0	126,0	0,25	4	■

■ **Lagerstandard.**

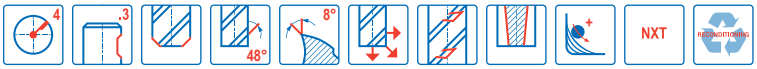
JS564

Dynamisches Fräsen – Universal – Schaftfräser – 4 Schneiden – Weldon – Eckenfase





- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist



Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS564030F2C.3Z4C-NXT	03067353	2	F	■	3,0	6,0	7,0	57,0	0,04	4	■
JS564040F2C.3Z4C-NXT	03067354	2	F	■	4,0	6,0	10,0	57,0	0,05	4	■
JS564050F2C.3Z4C-NXT	03067355	2	F	■	5,0	6,0	12,5	57,0	0,06	4	■
JS564060D2C.3Z4C-NXT	03067356	2	D	■	6,0	6,0	15,0	57,0	0,075	4	■
JS564080D2C.3Z4C-NXT	03067357	2	D	■	8,0	8,0	20,0	63,0	0,1	4	■
JS564100D2C.3Z4C-NXT	03067358	2	D	■	10,0	10,0	25,0	72,0	0,125	4	■
JS564120D2C.3Z4C-NXT	03067359	2	D	■	12,0	12,0	30,0	83,0	0,15	4	■
JS564160D2C.3Z4C-NXT	03067360	2	D	■	16,0	16,0	40,0	99,0	0,2	4	■
JS564200D2C.3Z4C-NXT	03067361	2	D	■	20,0	20,0	50,0	114,0	0,25	4	■
JS564060D3C.3Z4C-NXT	03067362	3	D	■	6,0	6,0	23,0	64,0	0,075	4	■
JS564080D3C.3Z4C-NXT	03067363	3	D	■	8,0	8,0	32,0	74,0	0,1	4	■
JS564100D3C.3Z4C-NXT	03067364	3	D	■	10,0	10,0	40,0	88,0	0,125	4	■
JS564120D3C.3Z4C-NXT	03067365	3	D	■	12,0	12,0	45,0	99,0	0,15	4	■
JS564160D3C.3Z4C-NXT	03067366	3	D	■	16,0	16,0	55,0	114,0	0,2	4	■
JS564200D3C.3Z4C-NXT	03067367	3	D	■	20,0	20,0	65,0	126,0	0,25	4	■

■ **Lagerstandard.**

Schnittdaten – JS564 Eckfräsen dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	305 (270 — 340) *1000 (890–1100)*
P2	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	295 (260 — 330) *970 (860–1000)*
P3	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (230 — 290) *850 (760 — 950)*
P4	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P5	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	215 (190 — 240) *710 (630–780)*
P6	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	240 (210 — 270) *790 (690 — 880)*
P7	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P8	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	215 (190 — 240) *710 (630–780)*
P11	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	200 (180 — 220) *660 (600–720)*
P12	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (120–140) *425 (400 — 450)*
M1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	195 (170 — 210) *640 (560 — 680)*
M2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140–170) *520 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110–140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110–140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92–120) *360 (310 — 390)*
K1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	260 (230 — 290) *850 (760 — 950)*
K2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
K3	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	195 (170 — 210) *640 (560 — 680)*
K4	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (170 — 200) *610 (560 — 650)*
K5	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	115 (99–120) *375 (330 — 390)*
K6	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150–180) *540 (500 — 590)*
K7	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS564 Eckfräsen dynamisches Fräsen

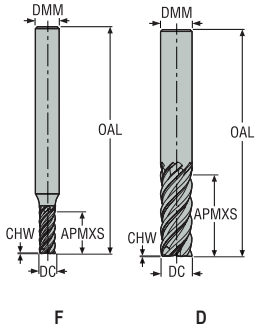
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600–790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	450 (390 — 510) *1475 (1300–1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400–1900)*
N11	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	350 (300 — 390) *1150 (990–1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	60 (37 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	50 (30 — 69) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	43 (26 — 60) *140 (86–190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140–180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110–140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110–140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140–180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140–180) *520 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.018 *0,00070*	0.024 *0,00095*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	125 (110–140) *410 (370 — 450)*

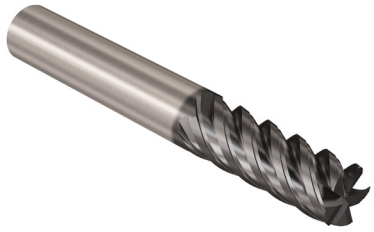
Schnittdaten, siehe Seite 457 - 464

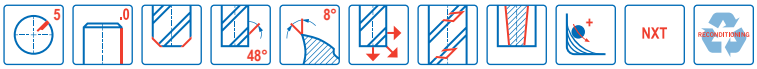
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS565

Dynamisches Fräsen – Universal – Schaftfräser – 5 Schneiden – Zylindrisch – Eckenfase







- Toleranzen:
- DMM = h5
- DC = e7
- PCEDC5= ohne Spanteiler
- PCEDC5C= mit Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist

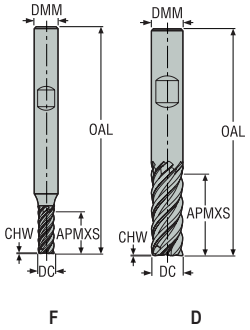
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	0,06	5	■
JS565050F2C.0Z5C-NXT	03067379	2	F	■	5,0	6,0	12,5	57,0	0,06	5	■
JS565060D2C.0Z5-NXT	03067371	2	D	–	6,0	6,0	15,0	57,0	0,075	5	■
JS565060D2C.0Z5C-NXT	03067380	2	D	■	6,0	6,0	15,0	57,0	0,075	5	■
JS565080D2C.0Z5-NXT	03067372	2	D	–	8,0	8,0	20,0	63,0	0,1	5	■
JS565080D2C.0Z5C-NXT	03067381	2	D	■	8,0	8,0	20,0	63,0	0,1	5	■
JS565100D2C.0Z5-NXT	03067373	2	D	–	10,0	10,0	25,0	72,0	0,125	5	■
JS565100D2C.0Z5C-NXT	03067382	2	D	■	10,0	10,0	25,0	72,0	0,125	5	■
JS565120D2C.0Z5-NXT	03067374	2	D	–	12,0	12,0	30,0	83,0	0,15	5	■
JS565120D2C.0Z5C-NXT	03067383	2	D	■	12,0	12,0	30,0	83,0	0,15	5	■
JS565160D2C.0Z5-NXT	03067375	2	D	–	16,0	16,0	40,0	99,0	0,2	5	■
JS565160D2C.0Z5C-NXT	03067384	2	D	■	16,0	16,0	40,0	99,0	0,2	5	■
JS565200D2C.0Z5-NXT	03067376	2	D	–	20,0	20,0	50,0	114,0	0,25	5	■
JS565200D2C.0Z5C-NXT	03067385	2	D	■	20,0	20,0	50,0	114,0	0,25	5	■
JS565060D3C.0Z5C-NXT	03067386	3	D	■	6,0	6,0	23,0	64,0	0,075	5	■
JS565080D3C.0Z5C-NXT	03067387	3	D	■	8,0	8,0	32,0	74,0	0,1	5	■
JS565100D3C.0Z5C-NXT	03067388	3	D	■	10,0	10,0	40,0	88,0	0,125	5	■
JS565120D3C.0Z5C-NXT	03067389	3	D	■	12,0	12,0	45,0	99,0	0,15	5	■
JS565160D3C.0Z5C-NXT	03067390	3	D	■	16,0	16,0	55,0	114,0	0,2	5	■
JS565200D3C.0Z5C-NXT	03067391	3	D	■	20,0	20,0	65,0	126,0	0,25	5	■

■ **Lagerstandard.**

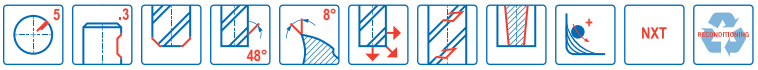
JS565

Dynamisches Fräsen – Universal – Schaftfräser – 5 Schneiden – Weldon – Eckenfase





- Toleranzen:
- DMM = h5
- DC = e7
- PCEDC5= ohne Spanteiler
- PCEDC5C= mit Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist



Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS565040F2C.3Z5-NXT	03067393	2	F	–	4,0	6,0	10,0	57,0	0,05	5	■
JS565040F2C.3Z5C-NXT	03067402	2	F	■	4,0	6,0	10,0	57,0	0,05	5	■
JS565050F2C.3Z5-NXT	03067394	2	F	–	5,0	6,0	12,5	57,0	0,06	5	■
JS565050F2C.3Z5C-NXT	03067403	2	F	■	5,0	6,0	12,5	57,0	0,06	5	■
JS565060D2C.3Z5-NXT	03067395	2	D	–	6,0	6,0	15,0	57,0	0,075	5	■
JS565060D2C.3Z5C-NXT	03067404	2	D	■	6,0	6,0	15,0	57,0	0,075	5	■
JS565080D2C.3Z5-NXT	03067396	2	D	–	8,0	8,0	20,0	63,0	0,1	5	■
JS565080D2C.3Z5C-NXT	03067405	2	D	■	8,0	8,0	20,0	63,0	0,1	5	■
JS565100D2C.3Z5-NXT	03067397	2	D	–	10,0	10,0	25,0	72,0	0,125	5	■
JS565100D2C.3Z5C-NXT	03067406	2	D	■	10,0	10,0	25,0	72,0	0,125	5	■
JS565120D2C.3Z5-NXT	03067398	2	D	–	12,0	12,0	30,0	83,0	0,15	5	■
JS565120D2C.3Z5C-NXT	03067407	2	D	■	12,0	12,0	30,0	83,0	0,15	5	■
JS565160D2C.3Z5-NXT	03067399	2	D	–	16,0	16,0	40,0	99,0	0,2	5	■
JS565160D2C.3Z5C-NXT	03067408	2	D	■	16,0	16,0	40,0	99,0	0,2	5	■
JS565200D2C.3Z5-NXT	03067400	2	D	–	20,0	20,0	50,0	114,0	0,25	5	■
JS565200D2C.3Z5C-NXT	03067409	2	D	■	20,0	20,0	50,0	114,0	0,25	5	■
JS565060D3C.3Z5C-NXT	03067410	3	D	■	6,0	6,0	23,0	64,0	0,075	5	■
JS565080D3C.3Z5C-NXT	03067411	3	D	■	8,0	8,0	32,0	74,0	0,1	5	■
JS565100D3C.3Z5C-NXT	03067412	3	D	■	10,0	10,0	40,0	88,0	0,125	5	■
JS565120D3C.3Z5C-NXT	03067413	3	D	■	12,0	12,0	45,0	99,0	0,15	5	■
JS565160D3C.3Z5C-NXT	03067414	3	D	■	16,0	16,0	55,0	114,0	0,2	5	■
JS565200D3C.3Z5C-NXT	03067415	3	D	■	20,0	20,0	65,0	126,0	0,25	5	■

■ **Lagerstandard.**

Schnittdaten – JS565 Eckfräsen dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	325 (270 — 340) *1075 (890–1100)*
P2	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	315 (260 — 330) *1025 (860–1000)*
P3	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	280 (230 — 290) *920 (760 — 950)*
P4	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P5	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	230 (190 — 240) *750 (630–780)*
P6	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	260 (210 — 270) *850 (690 — 880)*
P7	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P8	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	230 (190 — 240) *750 (630–780)*
P11	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	225 (190 — 230) *740 (630–750)*
P12	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	140 (120–140) *460 (400 — 450)*
M1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	205 (180 — 210) *670 (600 — 680)*
M2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	170 (140–170) *560 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110–140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110–140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92–120) *360 (310 — 390)*
K1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	275 (230 — 290) *900 (760 — 950)*
K2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
K3	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	205 (170 — 210) *670 (560 — 680)*
K4	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	200 (170 — 200) *660 (560 — 650)*
K5	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	120 (98–120) *395 (330 — 390)*
K6	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	175 (150–180) *570 (500 — 590)*
K7	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (130–160) *510 (430 — 520)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS565 Eckfräsen dynamisches Fräsen

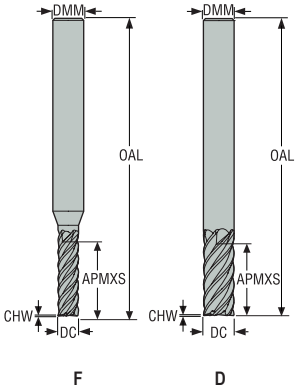
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	740 (600–790) *2425 (2000 — 2500)*
N2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	475 (390 — 510) *1550 (1300–1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400–1900)*
N11	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	370 (300 — 390) *1225 (990–1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	60 (38 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	50 (30–70) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	43 (27 — 60) *140 (89–190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140–180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110–140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110–140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140–180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	155 (140–180) *510 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (110–140) *395 (370 — 450)*

Schnittdaten, siehe Seite 457 - 464

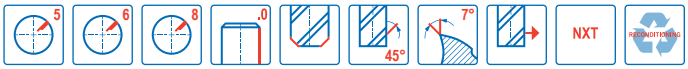
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS520

Hochleistung – Universal – Schaftfräser – 5-8 Schneiden – Zylindrisch – Eckenfase







- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

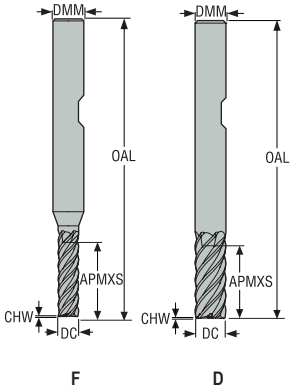
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	■
JS520060D2C.0Z5-NXT	02927478	2	D	6,0	6,0	15,0	57,0	0,06	5	■
JS520060D2C.0Z6-NXT	02927479	2	D	6,0	6,0	15,0	57,0	0,06	6	■
JS520080D2C.0Z5-NXT	02927482	2	D	8,0	8,0	20,0	63,0	0,08	5	■
JS520080D2C.0Z6-NXT	02927483	2	D	8,0	8,0	20,0	63,0	0,08	6	■
JS520100D2C.0Z6-NXT	02927486	2	D	10,0	10,0	25,0	72,0	0,1	6	■
JS520120D2C.0Z6-NXT	02927488	2	D	12,0	12,0	25,0	83,0	0,12	6	■
JS520140D2C.0Z6-NXT	02927490	2	D	14,0	14,0	30,0	83,0	0,14	6	■
JS520160D2C.0Z6-NXT	02927491	2	D	16,0	16,0	30,0	92,0	0,16	6	■
JS520160D2C.0Z8-NXT	02927492	2	D	16,0	16,0	30,0	92,0	0,16	8	■
JS520200D2C.0Z8-NXT	02927495	2	D	20,0	20,0	35,0	104,0	0,2	8	■
JS520250D2C.0Z8-NXT	02927497	2	D	25,0	25,0	50,0	125,0	0,25	8	■
JS520040F3C.0Z5-NXT	02927475	3	F	4,0	6,0	15,0	57,0	0,04	5	■
JS520050F3C.0Z5-NXT	02927477	3	F	5,0	6,0	19,0	57,0	0,05	5	■
JS520060D3C.0Z5-NXT	02927480	3	D	6,0	6,0	20,0	63,0	0,06	5	■
JS520060D3C.0Z6-NXT	02927481	3	D	6,0	6,0	20,0	63,0	0,06	6	■
JS520080D3C.0Z5-NXT	02927484	3	D	8,0	8,0	30,0	80,0	0,08	5	■
JS520080D3C.0Z6-NXT	02927485	3	D	8,0	8,0	30,0	80,0	0,08	6	■
JS520100D3C.0Z6-NXT	02927487	3	D	10,0	10,0	40,0	89,0	0,1	6	■
JS520120D3C.0Z6-NXT	02927489	3	D	12,0	12,0	45,0	100,0	0,12	6	■
JS520160D3C.0Z6-NXT	02927493	3	D	16,0	16,0	65,0	125,0	0,16	6	■
JS520160D3C.0Z8-NXT	02927494	3	D	16,0	16,0	65,0	125,0	0,16	8	■
JS520200D3C.0Z8-NXT	02927496	3	D	20,0	20,0	65,0	125,0	0,2	8	■
JS520250D3C.0Z8-NXT	02927498	3	D	25,0	25,0	75,0	150,0	0,25	8	■

■ **Lagerstandard.**

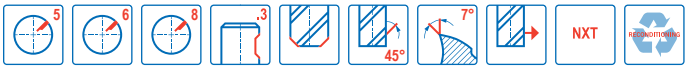
JS520

Hochleistung – Universal – Schaftfräser – 5-8 Schneiden – Weldon – Eckenfase





- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS520040F2C.3Z5-NXT	02927499	2	F	4,0	6,0	10,0	57,0	0,04	5	□
JS520050F2C.3Z5-NXT	02927501	2	F	5,0	6,0	12,0	57,0	0,05	5	□
JS520060D2C.3Z5-NXT	02927503	2	D	6,0	6,0	15,0	57,0	0,06	5	□
JS520060D2C.3Z6-NXT	02927504	2	D	6,0	6,0	15,0	57,0	0,06	6	□
JS520080D2C.3Z5-NXT	02927507	2	D	8,0	8,0	20,0	63,0	0,08	5	□
JS520080D2C.3Z6-NXT	02927508	2	D	8,0	8,0	20,0	63,0	0,08	6	□
JS520100D2C.3Z6-NXT	02927511	2	D	10,0	10,0	25,0	72,0	0,1	6	□
JS520120D2C.3Z6-NXT	02927513	2	D	12,0	12,0	25,0	83,0	0,12	6	□
JS520140D2C.3Z6-NXT	02927515	2	D	14,0	14,0	30,0	83,0	0,14	6	□
JS520160D2C.3Z6-NXT	02927516	2	D	16,0	16,0	30,0	92,0	0,16	6	□
JS520160D2C.3Z8-NXT	02927517	2	D	16,0	16,0	30,0	92,0	0,16	8	■
JS520200D2C.3Z8-NXT	02927520	2	D	20,0	20,0	35,0	104,0	0,2	8	■
JS520250D2C.3Z8-NXT	02927522	2	D	25,0	25,0	50,0	125,0	0,25	8	□
JS520040F3C.3Z5-NXT	02927500	3	F	4,0	6,0	15,0	57,0	0,04	5	□
JS520050F3C.3Z5-NXT	02927502	3	F	5,0	6,0	19,0	57,0	0,05	5	□
JS520060D3C.3Z5-NXT	02927505	3	D	6,0	6,0	20,0	63,0	0,06	5	□
JS520060D3C.3Z6-NXT	02927506	3	D	6,0	6,0	20,0	63,0	0,06	6	□
JS520080D3C.3Z5-NXT	02927509	3	D	8,0	8,0	30,0	80,0	0,08	5	□
JS520080D3C.3Z6-NXT	02927510	3	D	8,0	8,0	30,0	80,0	0,08	6	□
JS520100D3C.3Z6-NXT	02927512	3	D	10,0	10,0	40,0	89,0	0,1	6	□
JS520120D3C.3Z6-NXT	02927514	3	D	12,0	12,0	45,0	100,0	0,12	6	□
JS520160D3C.3Z6-NXT	02927518	3	D	16,0	16,0	65,0	125,0	0,16	6	□
JS520160D3C.3Z8-NXT	02927519	3	D	16,0	16,0	65,0	125,0	0,16	8	□
JS520200D3C.3Z8-NXT	02927521	3	D	20,0	20,0	65,0	125,0	0,2	8	□
JS520250D3C.3Z8-NXT	02927523	3	D	25,0	25,0	75,0	150,0	0,25	8	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS520 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (120 — 250) *590 (400 — 820)*
P2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370–780)*
P3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (95 — 210) *510 (320 — 680)*
P4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	135 (84–180) *445 (280 — 590)*
P5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	130 (81–180) *425 (270 — 590)*
P6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	145 (90 — 200) *475 (300 — 650)*
P7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (85–190) *460 (280 — 620)*
P8	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	130 (80–170) *425 (270 — 550)*
P11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	195 (160 — 230) *640 (530–750)*
P12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100–140) *410 (330 — 450)*
M1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (130–180) *490 (430 — 590)*
M2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100–150) *410 (330 — 490)*
M3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	100 (75–120) *330 (250 — 390)*
M4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (58 — 96) *245 (200 — 310)*
M5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (49 — 80) *215 (170 — 260)*
K1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370–780)*
K2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	155 (97 — 210) *510 (320 — 680)*
K3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (82–180) *445 (270 — 590)*
K4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (79–170) *410 (260 — 550)*
K5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (48–100) *245 (160 — 320)*
K6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	110 (69–150) *360 (230 — 490)*
K7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (62–130) *330 (210 — 420)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS520 Eckfräsen

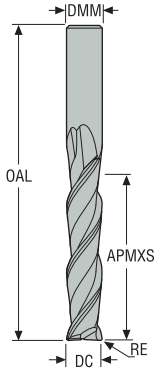
SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500–1800)*
N2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	320 (290 — 350) *1050 (960–1100)*
N3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	215 (200 — 230) *710 (660–750)*
N11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (350 — 450) *1300 (1200–1400)*
S1	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	75 (63 — 86) *245 (210 — 280)*
S2	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (50–70) *195 (170 — 220)*
S3	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	40 (30 — 49) *130 (99–160)*
S11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	105 (92–110) *345 (310 — 360)*
S12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	80 (71 — 90) *260 (240 — 290)*
S13	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (56–71) *215 (190 — 230)*
H5	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (64–180) *410 (210 — 590)*
H8	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66–190) *425 (220 — 620)*
H11	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	160 (81 — 240) *520 (270–780)*
H12	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	150 (76 — 220) *490 (250–720)*
H21	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66–190) *425 (220 — 620)*
H31	M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (51–150) *330 (170 — 490)*
TS1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500–1800)*
TP1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	395 (350 — 440) *1300 (1200–1400)*
GR1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500–1800)*

Schnittdaten, siehe Seite 457 - 464

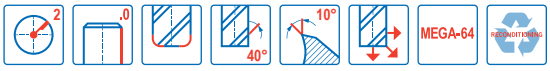
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS522

Hochleistung – Universal – Schaftfräser – 2 Schneiden – Hohe Schulter – Zylindrisch – Eckenradius



D





- Toleranzen:
- Rundlaufabweichung = Ø6-Ø8 <0,01, Ø10-Ø12 <0,015, Ø16-Ø32 <0,02
- DMM = h5
- DC = -0,02/-0,04 mm
- RE= 0,1+0,1 mm, RE= 0,5 ±0,03 mm
  RE= 3,1 ±0,05 mm, RE= 4 ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
522060R010Z2.0-MEGA-64	02747756	4	D	6,0	6,0	30,0	80,0	0,1	2	■
522080R010Z2.0-MEGA-64	02747763	4	D	8,0	8,0	40,0	85,0	0,1	2	■
522100R010Z2.0-MEGA-64	02747765	4	D	10,0	10,0	50,0	100,0	0,1	2	■
522120R010Z2.0-MEGA-64	02747766	4	D	12,0	12,0	60,0	115,0	0,1	2	■
522160R050Z2.0-MEGA-64	02747767	4	D	16,0	16,0	80,0	150,0	0,5	2	■
522160R310Z2.0-MEGA-64	02747768	4	D	16,0	16,0	80,0	150,0	3,1	2	■
JS522160D4R600.0Z2-M64	03093681	4	D	16,0	16,0	80,0	150,0	6,0	2	■
522200R050Z2.0-MEGA-64	02747769	4	D	20,0	20,0	100,0	175,0	0,5	2	■
522200R310Z2.0-MEGA-64	02747770	4	D	20,0	20,0	100,0	175,0	3,1	2	■
JS522200D4R600.0Z2-M64	03093682	4	D	20,0	20,0	100,0	175,0	6,0	2	■
522250R050Z2.0-MEGA-64	02747771	4	D	25,0	25,0	125,0	205,0	0,5	2	■
522250R310Z2.0-MEGA-64	02747772	4	D	25,0	25,0	125,0	205,0	3,1	2	■
522250R400Z2.0-MEGA-64	02747773	4	D	25,0	25,0	125,0	205,0	4,0	2	■
JS522250D4R600.0Z2-M64	03093683	4	D	25,0	25,0	125,0	205,0	6,0	2	■
522320R050Z2.0-MEGA-64	02747774	4	D	32,0	32,0	160,0	245,0	0,5	2	■
522320R400Z2.0-MEGA-64	02747775	4	D	32,0	32,0	160,0	245,0	4,0	2	■
JS522320D4R600.0Z2-M64	03093684	4	D	32,0	32,0	160,0	245,0	6,0	2	■

■ **Lagerstandard.**

*JS522 Schlichtfräser mit langer Schneide sorgt für exzellente Oberflächengüten und Rechtwinkligkeit bei hohen Schultern.

Schnittdaten – JS522 Eckfräsen/Vorschlichten

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
P1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	160 (140–170) *520 (460 — 550)*
P2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	155 (140–170) *510 (460 — 550)*
P3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (150–180) *540 (500 — 590)*
P4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	145 (130–160) *475 (430 — 520)*
P5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (130–160) *460 (430 — 520)*
P6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	120 (110–140) *395 (370 — 450)*
P7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	115 (95–130) *375 (320 — 420)*
P8	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	105 (89–120) *345 (300 — 390)*
P11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	105 (87–120) *345 (290 — 390)*
P12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	65 (55–75) *215 (190 — 240)*
M1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	110 (86–130) *360 (290 — 420)*
M2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (71–110) *295 (240 — 360)*
M3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	80 (61–100) *260 (210 — 320)*
M4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	60 (47–76) *195 (160 — 240)*
M5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (39 — 63) *165 (130 — 200)*
K1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (100–130) *395 (330 — 420)*
K2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	105 (87–120) *345 (290 — 390)*
K3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (74–100) *295 (250 — 320)*
K4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 98) *280 (240 — 320)*
K5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (81–120) *330 (270 — 390)*
K6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	150 (120–170) *490 (400 — 550)*
K7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (110–150) *425 (370 — 490)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS522 Eckfräsen/Vorschlichten

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
N1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100–1600)*
N2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (210 — 400) *980 (690–1300)*
N3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	200 (140 — 260) *660 (460 — 850)*
N11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (260 — 350) *980 (860–1100)*
S1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	48 (39 — 57) *155 (130–180)*
S2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	39 (31 — 46) *130 (110–150)*
S3	E/M/A	0.0300 *0,0300*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	42 (32 — 51) *140 (110–160)*
S11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	125 (100–140) *410 (330 — 450)*
S12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	95 (77–110) *310 (260 — 360)*
S13	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (61 — 90) *245 (210 — 290)*
TS1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400–1900)*
TP1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100–1600)*
GR1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400–1900)*

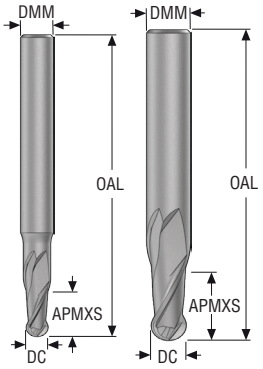
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JSB512

Allgemeine Bearbeitung – Universal – Kugelkopf – 2 Schneiden – Zylindrisch





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm



Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
					mm	mm	mm	mm		
JSB512020F2B.0Z2	SIRA	10053561	2	F	2,0	3,0	3,0	40,0	2	■
JSB512030D2B.0Z2	SIRA	10053562	2	D	3,0	3,0	5,0	40,0	2	■
JSB512040D2B.0Z2	SIRA	10053563	2	D	4,0	4,0	6,0	50,0	2	■
JSB512050F2B.0Z2	SIRA	10053564	2	F	5,0	6,0	8,0	57,0	2	■
JSB512060D2B.0Z2	SIRA	10053565	2	D	6,0	6,0	9,0	57,0	2	■
JSB512080D2B.0Z2	SIRA	10053566	2	D	8,0	8,0	12,0	63,0	2	■
JSB512100D2B.0Z2	SIRA	10053567	2	D	10,0	10,0	15,0	72,0	2	■
JSB512120D2B.0Z2	SIRA	10053568	2	D	12,0	12,0	18,0	83,0	2	■

■ **Lagerstandard.**

Schnittdaten – JSB512 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P2	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P3	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P4	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P5	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P6	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P7	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P8	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
P11	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
P12	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
M1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
M2	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
M3	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
M4	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
M5	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
K1	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
K2	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
K3	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
K4	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
K5	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	145 (61–180) *475 (210 — 590)*
K6	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
K7	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63–180) *490 (210 — 590)*
N1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	500 (380 — 620) *1650 (1300 — 2000)*
N11	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	375 (260 — 500) *1225 (860–1600)*
S11	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (66–130) *295 (220 — 420)*
S12	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*
S13	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63–120) *295 (210 — 390)*

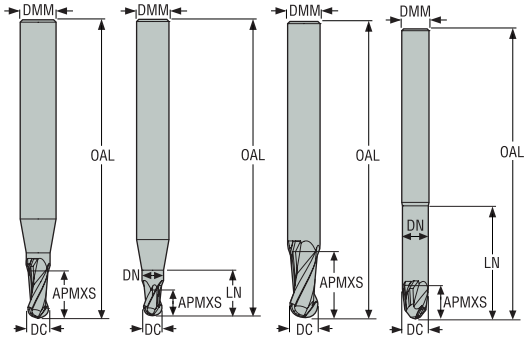
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

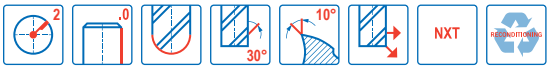
JS532

Hochleistung – Universal – Kugelkopf – 2 Schneiden – Zylindrisch





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

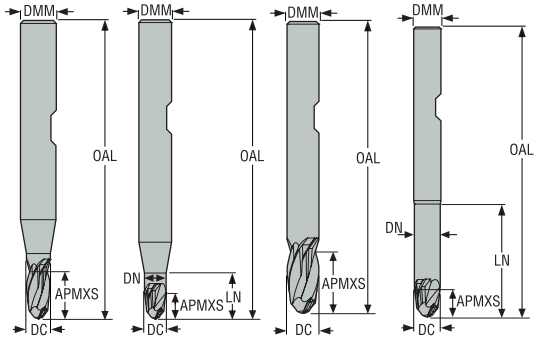


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS532010F1B.0Z2-NXT	02928193	1	F	1,0	3,0	2,0	38,0	3,1	1,0	0,5	2	■
JS532015F1B.0Z2-NXT	02928194	1	F	1,5	3,0	3,0	38,0	4,6	1,5	0,75	2	■
JS532020F1B.0Z2-NXT	02928195	1	F	2,0	3,0	4,0	38,0	6,1	2,0	1,0	2	■
JS532025F1B.0Z2-NXT	02928197	1	F	2,5	3,0	5,0	38,0	7,1	2,5	1,25	2	■
JS532030D1B.0Z2-NXT	02928199	1	D	3,0	3,0	6,0	38,0	–	–	1,5	2	■
JS532035F1B.0Z2-NXT	02928202	1	F	3,5	6,0	7,0	57,0	9,6	3,5	1,75	2	■
JS532040F1B.0Z2-NXT	02928203	1	F	4,0	6,0	8,0	57,0	10,75	4,0	2,0	2	■
JS532045F1B.0Z2-NXT	02928206	1	F	4,5	6,0	9,0	57,0	11,75	4,5	2,25	2	■
JS532050F1B.0Z2-NXT	02928207	1	F	5,0	6,0	10,0	57,0	12,75	5,0	2,5	2	■
JS532060D1B.0Z2-NXT	02928210	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	■
JS532080D1B.0Z2-NXT	02928213	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	■
JS532100D1B.0Z2-NXT	02928216	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	■
JS532120D1B.0Z2-NXT	02928219	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	■
JS532160D1B.0Z2-NXT	02928222	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	■
JS532200D1B.0Z2-NXT	02928225	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	■
JS532020G2B.0Z2-NXT	02928196	2	G	2,0	3,0	2,0	38,0	8,0	1,9	1,0	2	■
JS532030E2B.0Z2-NXT	02928200	2	E	3,0	3,0	3,0	38,0	10,0	2,85	1,5	2	■
JS532040G2B.0Z2-NXT	02928204	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	2	■
JS532050G2B.0Z2-NXT	02928208	2	G	5,0	6,0	5,0	57,0	20,0	4,8	2,5	2	■
JS532060E2B.0Z2-NXT	02928211	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	■
JS532080E2B.0Z2-NXT	02928214	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	■
JS532100E2B.0Z2-NXT	02928217	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	■
JS532120E2B.0Z2-NXT	02928220	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	■
JS532160E2B.0Z2-NXT	02928223	2	E	16,0	16,0	16,0	125,0	72,0	15,2	8,0	2	■
JS532030E3B.0Z2-NXT	02928201	3	E	3,0	3,0	3,0	52,0	20,0	2,85	1,5	2	■
JS532040G3B.0Z2-NXT	02928205	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	■
JS532050G3B.0Z2-NXT	02928209	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	■
JS532060E3B.0Z2-NXT	02928212	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	■
JS532080E3B.0Z2-NXT	02928215	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	■
JS532100E3B.0Z2-NXT	02928218	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	■
JS532120E3B.0Z2-NXT	02928221	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	■
JS532160E3B.0Z2-NXT	02928224	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	■

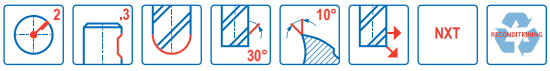
■ **Lagerstandard.**

JS532

Hochleistung – Universal – Kugelkopf – 2 Schneiden – Weldon







- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS532035F1B.3Z2-NXT	02928254	1	F	3,5	6,0	7,0	57,0	9,6	3,5	1,75	2	☐
JS532040F1B.3Z2-NXT	02928255	1	F	4,0	6,0	8,0	57,0	10,75	4,0	2,0	2	☐
JS532045F1B.3Z2-NXT	02928258	1	F	4,5	6,0	9,0	57,0	11,75	4,5	2,25	2	☐
JS532050F1B.3Z2-NXT	02928259	1	F	5,0	6,0	10,0	57,0	12,75	5,0	2,5	2	☐
JS532060D1B.3Z2-NXT	02928263	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	☐
JS532080D1B.3Z2-NXT	02928266	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	☐
JS532100D1B.3Z2-NXT	02928269	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	☐
JS532120D1B.3Z2-NXT	02928272	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	☐
JS532160D1B.3Z2-NXT	02928275	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	☐
JS532200D1B.3Z2-NXT	02928278	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	☐
JS532040G2B.3Z2-NXT	02928256	2	G	4,0	6,0	4,0	57,0	18,0	3,8	2,0	2	☐
JS532050G2B.3Z2-NXT	02928260	2	G	5,0	6,0	5,0	57,0	18,0	4,8	2,5	2	☐
JS532060E2B.3Z2-NXT	02928264	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	☐
JS532080E2B.3Z2-NXT	02928267	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	☐
JS532100E2B.3Z2-NXT	02928270	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	☐
JS532120E2B.3Z2-NXT	02928273	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	☐
JS532160E2B.3Z2-NXT	02928276	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	2	☐
JS532040G3B.3Z2-NXT	02928257	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	☐
JS532050G3B.3Z2-NXT	02928261	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	☐
JS532060E3B.3Z2-NXT	02928265	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	☐
JS532080E3B.3Z2-NXT	02928268	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	☐
JS532100E3B.3Z2-NXT	02928271	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	☐
JS532120E3B.3Z2-NXT	02928274	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	☐
JS532160E3B.3Z2-NXT	02928277	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS532 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	205 (140–180) *670 (460 — 590)*
P2	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	200 (130–180) *660 (430 — 590)*
P3	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	170 (110–150) *560 (370 — 490)*
P4	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.10 *0,0040*	150 (97–130) *490 (320 — 420)*
P5	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	145 (93–130) *475 (310 — 420)*
P6	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	160 (110–140) *520 (370 — 450)*
P7	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (98–140) *490 (330 — 450)*
P8	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	145 (93–130) *475 (310 — 420)*
P11	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	170 (110–150) *560 (370 — 490)*
P12	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	100 (64 — 92) *330 (210 — 300)*
M1	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	195 (170 — 220) *640 (560–720)*
M2	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	115 (93–130) *375 (310 — 420)*
M3	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	95 (73–110) *310 (240 — 360)*
M4	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	70 (55 — 85) *230 (190 — 270)*
M5	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	60 (46–71) *195 (160 — 230)*
K1	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	195 (180 — 210) *640 (600 — 680)*
K2	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	170 (160–180) *560 (530 — 590)*
K3	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	145 (130–150) *475 (430 — 490)*
K4	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	140 (130–150) *460 (430 — 490)*
K5	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	165 (150–180) *540 (500 — 590)*
K6	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	245 (220 — 270) *800 (730 — 880)*
K7	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	210 (190 — 230) *690 (630–750)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS532 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	610 (520–710) *2000 (1800 — 2300)*
N2	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	395 (330 — 450) *1300 (1100–1400)*
N3	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.200 *0,200*	0.30 *0,30*	0.0050 *0,00020*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	415 (370 — 460) *1350 (1300–1500)*
S1	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	60 (52–72) *195 (180 — 230)*
S2	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	50 (42 — 58) *165 (140–190)*
S3	E	0.100 *0,100*	0.10 *0,10*	0.0036 *0,00014*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.018 *0,00070*	0.020 *0,00080*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	32 (22 — 42) *105 (73–130)*
S11	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (94–110) *345 (310 — 360)*
S12	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (72 — 92) *260 (240 — 300)*
S13	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.080 *0,0032*	0.090 *0,0036*	65 (57–72) *215 (190 — 230)*
TS1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
TP1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
GR1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*

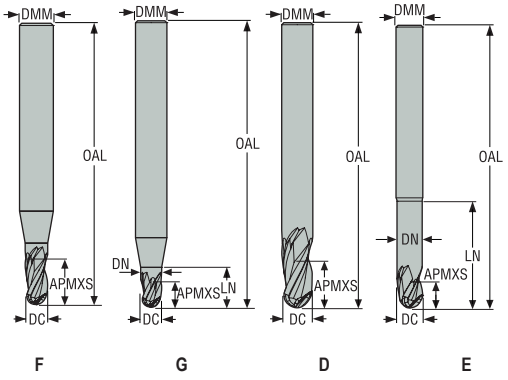
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

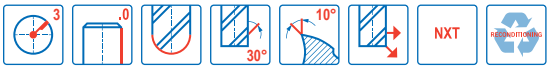
JS533

Hochleistung – Universal – Kugelkopf – 3 Schneiden – Zylindrisch





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

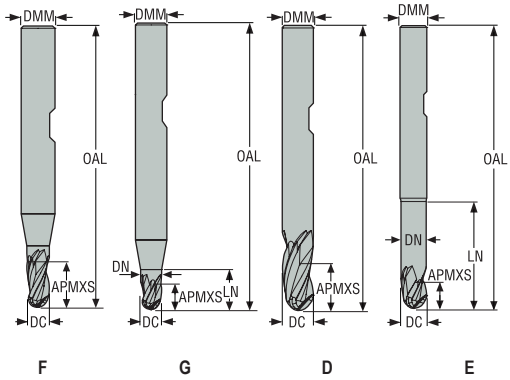


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS533010F1B.0Z3-NXT	02928284	1	F	1,0	3,0	2,0	38,0	3,0	1,05	0,5	3	■
JS533015F1B.0Z3-NXT	02928286	1	F	1,5	3,0	3,0	38,0	4,6	1,55	0,75	3	■
JS533020F1B.0Z3-NXT	02928287	1	F	2,0	3,0	4,0	38,0	5,6	2,05	1,0	3	■
JS533030D1B.0Z3-NXT	02928289	1	D	3,0	3,0	6,0	38,0	–	–	1,5	3	■
JS533040F1B.0Z3-NXT	02928291	1	F	4,0	6,0	8,0	57,0	10,75	4,05	2,0	3	■
JS533050F1B.0Z3-NXT	02928293	1	F	5,0	6,0	10,0	57,0	13,75	5,05	2,5	3	■
JS533060D1B.0Z3-NXT	02928295	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	■
JS533080D1B.0Z3-NXT	02928297	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	■
JS533100D1B.0Z3-NXT	02928299	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	■
JS533120D1B.0Z3-NXT	02928301	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	■
JS533160D1B.0Z3-NXT	02928303	1	D	16,0	16,0	32,0	110,0	–	–	8,0	3	■
JS533200D1B.0Z3-NXT	02928305	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	■
JS533020G2B.0Z3-NXT	02928288	2	G	2,0	3,0	2,0	38,0	7,0	1,9	1,0	3	■
JS533030E2B.0Z3-NXT	02928290	2	E	3,0	3,0	3,0	38,0	9,0	2,85	1,5	3	■
JS533040G2B.0Z3-NXT	02928292	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	■
JS533050G2B.0Z3-NXT	02928294	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	■
JS533060E2B.0Z3-NXT	02928296	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	■
JS533080E2B.0Z3-NXT	02928298	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	■
JS533100E2B.0Z3-NXT	02928300	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	■
JS533120E2B.0Z3-NXT	02928302	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	■
JS533160E2B.0Z3-NXT	02928304	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	3	■

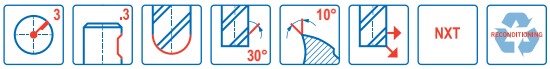
■ **Lagerstandard.**

JS533

Hochleistung – Universal – Kugelkopf – 3 Schneiden – Weldon







- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS533040F1B.3Z3-NXT	02928323	1	F	4,0	6,0	8,0	57,0	10,75	4,05	2,0	3	☐
JS533050F1B.3Z3-NXT	02928325	1	F	5,0	6,0	10,0	57,0	13,75	5,05	2,5	3	☐
JS533060D1B.3Z3-NXT	02928326	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	☐
JS533080D1B.3Z3-NXT	02928328	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	☐
JS533100D1B.3Z3-NXT	02928330	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	☐
JS533120D1B.3Z3-NXT	02928332	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	☐
JS533160D1B.3Z3-NXT	02928334	1	D	16,0	16,0	32,0	109,0	–	–	8,0	3	☐
JS533200D1B.3Z3-NXT	02928336	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	☐
JS533040G2B.3Z3-NXT	02928324	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	☐
JS533050G2B.3Z3-NXT	02928341	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	☐
JS533060E2B.3Z3-NXT	02928327	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	☐
JS533080E2B.3Z3-NXT	02928329	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	☐
JS533100E2B.3Z3-NXT	02928331	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	☐
JS533120E2B.3Z3-NXT	02928333	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	☐
JS533160E2B.3Z3-NXT	02928335	2	E	16,0	16,0	16,0	122,0	70,0	15,2	8,0	3	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS533 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	200 (180 — 220) *660 (600–720)*
P2	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	195 (170 — 220) *640 (560–720)*
P3	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	165 (150–180) *540 (500 — 590)*
P4	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	145 (130–160) *475 (430 — 520)*
P5	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	140 (130–160) *460 (430 — 520)*
P6	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	155 (140–170) *510 (460 — 550)*
P7	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	150 (130–160) *490 (430 — 520)*
P8	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	140 (120–150) *460 (400 — 490)*
P11	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130–160) *460 (430 — 520)*
P12	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	85 (73 — 97) *280 (240 — 310)*
M1	E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	125 (99–140) *410 (330 — 450)*
M2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (80–120) *330 (270 — 390)*
M3	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	70 (50 — 90) *230 (170 — 290)*
M4	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	55 (38 — 67) *180 (130 — 210)*
M5	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	44 (32 — 56) *145 (110–180)*
K1	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	145 (130–160) *475 (430 — 520)*
K2	E	0.0300 *0,0300*	0.80 *0,80*	0.0036 *0,00014*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	125 (110–140) *410 (370 — 450)*
K3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (91–110) *345 (300 — 360)*
K4	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (100–140) *395 (330 — 450)*
K5	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (61 — 84) *230 (210 — 270)*
K6	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (89–120) *345 (300 — 390)*
K7	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	155 (130–180) *510 (430 — 590)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS533 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	800 (700 — 900) *2625 (2300 — 2900)*
N2	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	510 (450 — 570) *1675 (1500–1800)*
N3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	345 (300 — 380) *1125 (990–1200)*
N11	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	400 (350 — 450) *1300 (1200–1400)*
S1	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (90–110) *330 (300 — 360)*
S2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	80 (73 — 88) *260 (240 — 280)*
S11	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	130 (120–140) *425 (400 — 450)*
S12	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (91–110) *330 (300 — 360)*
S13	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	80 (70 — 85) *260 (230 — 270)*
TS1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
TP1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
GR1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*

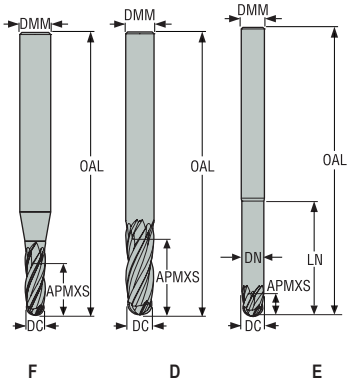
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

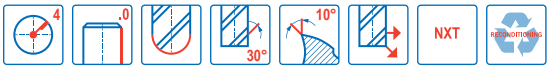
JS534

Hochleistung – Universal – Kugelkopf – 4 Schneiden – Zylindrisch





- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

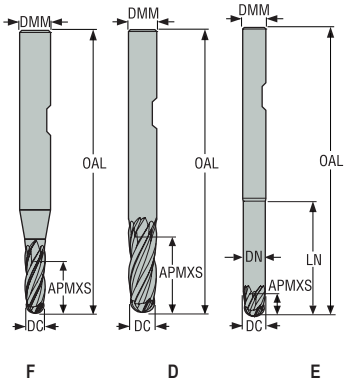


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS534020F1B.0Z4-NXT	02928366	1	F	2,0	3,0	6,0	38,0	6,7	2,05	1,0	4	■
JS534030D1B.0Z4-NXT	02928367	1	D	3,0	3,0	9,0	38,0	–	–	1,5	4	■
JS534040F1B.0Z4-NXT	02928368	1	F	4,0	6,0	12,0	57,0	14,0	4,05	2,0	4	■
JS534050F1B.0Z4-NXT	02928370	1	F	5,0	6,0	15,0	57,0	17,0	5,05	2,5	4	■
JS534060D1B.0Z4-NXT	02928372	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	■
JS534080D1B.0Z4-NXT	02928375	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	■
JS534100D1B.0Z4-NXT	02928378	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	■
JS534120D1B.0Z4-NXT	02928381	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	■
JS534160D1B.0Z4-NXT	02928384	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	■
JS534200D1B.0Z4-NXT	02928387	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	■
JS534040F2B.0Z4-NXT	02928369	2	F	4,0	6,0	20,0	63,0	22,0	4,05	2,0	4	■
JS534050F2B.0Z4-NXT	02928371	2	F	5,0	6,0	25,0	75,0	27,0	5,05	2,5	4	■
JS534060D2B.0Z4-NXT	02928373	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	■
JS534080D2B.0Z4-NXT	02928376	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	■
JS534100D2B.0Z4-NXT	02928379	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	■
JS534120D2B.0Z4-NXT	02928382	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	■
JS534160D2B.0Z4-NXT	02928385	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	■
JS534060E3B.0Z4-NXT	02928374	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	■
JS534080E3B.0Z4-NXT	02928377	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	■
JS534100E3B.0Z4-NXT	02928380	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	■
JS534120E3B.0Z4-NXT	02928383	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	■
JS534160E3B.0Z4-NXT	02928386	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	■
JS534200E3B.0Z4-NXT	02928388	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	■

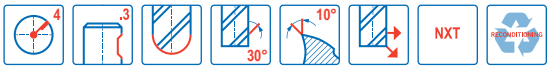
■ **Lagerstandard.**

JS534

Hochleistung – Universal – Kugelkopf – 4 Schneiden – Weldon







- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS534040F1B.3Z4-NXT	02928390	1	F	4,0	6,0	12,0	57,0	14,0	4,05	2,0	4	☐
JS534050F1B.3Z4-NXT	02928392	1	F	5,0	6,0	15,0	57,0	17,0	5,05	2,5	4	☐
JS534060D1B.3Z4-NXT	02928394	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	☐
JS534080D1B.3Z4-NXT	02928397	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	☐
JS534100D1B.3Z4-NXT	02928400	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	☐
JS534120D1B.3Z4-NXT	02928403	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	☐
JS534160D1B.3Z4-NXT	02928406	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	☐
JS534200D1B.3Z4-NXT	02928409	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	☐
JS534040F2B.3Z4-NXT	02928391	2	F	4,0	6,0	20,0	63,0	22,0	4,05	2,0	4	☐
JS534050F2B.3Z4-NXT	02928393	2	F	5,0	6,0	25,0	75,0	27,0	5,05	2,5	4	☐
JS534060D2B.3Z4-NXT	02928395	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	☐
JS534080D2B.3Z4-NXT	02928398	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	☐
JS534100D2B.3Z4-NXT	02928401	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	☐
JS534120D2B.3Z4-NXT	02928404	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	☐
JS534160D2B.3Z4-NXT	02928407	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	☐
JS534060E3B.3Z4-NXT	02928396	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	☐
JS534080E3B.3Z4-NXT	02928399	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	☐
JS534100E3B.3Z4-NXT	02928402	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	☐
JS534120E3B.3Z4-NXT	02928405	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	☐
JS534160E3B.3Z4-NXT	02928408	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	☐
JS534200E3B.3Z4-NXT	02928410	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS534 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	345 (310 — 370) *1125 (1100–1200)*
P2	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	335 (300 — 360) *1100 (990–1100)*
P3	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	290 (260 — 310) *950 (860–1000)*
P4	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	255 (230 — 280) *840 (760 — 910)*
P5	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
P6	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	230 (210 — 250) *750 (690 — 820)*
P7	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	220 (200 — 240) *720 (660–780)*
P8	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	205 (190 — 220) *670 (630–720)*
P11	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	210 (190 — 230) *690 (630–750)*
P12	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	125 (120–130) *410 (400 — 420)*
M1	E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
M2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (130–160) *475 (430 — 520)*
M3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (140–180) *510 (460 — 590)*
M4	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	120 (100–130) *395 (330 — 420)*
M5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	100 (83–110) *330 (280 — 360)*
K1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
K2	E	0.0300 *0,0300*	4.0 *4,0*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	215 (200 — 230) *710 (660–750)*
K3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	180 (160–190) *590 (530 — 620)*
K4	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	170 (160–180) *560 (530 — 590)*
K5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	200 (180 — 220) *660 (600–720)*
K6	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	295 (260 — 330) *970 (860–1000)*
K7	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	260 (230 — 280) *850 (760 — 910)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS534 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	1025 (910–1100) *3375 (3000 — 3600)*
N2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	910 (780–1000) *2975 (2600 — 3200)*
N3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	600 (520 — 690) *1975 (1800 — 2200)*
N11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	500 (440 — 560) *1650 (1500–1800)*
S1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	110 (88–110) *360 (290 — 360)*
S2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (71 — 90) *295 (240 — 290)*
S3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (63 — 87) *280 (210 — 280)*
S11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	185 (150–180) *610 (500 — 590)*
S12	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	140 (120–140) *460 (400 — 450)*
S13	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	110 (91–110) *360 (300 — 360)*
TS1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
TP1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
GR1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*

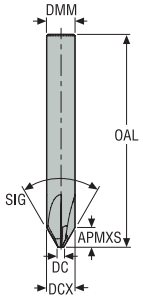
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS506

Allgemeine Bearbeitung – Universal – Eckenfase – 3-4 Schneiden – Zylindrisch





N

- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich, wenn DMM ≥ Ø6 ist

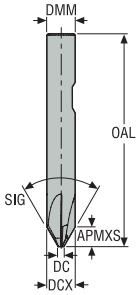


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm			
JS506030N2CZ3.0-SIRA	02881622	2	N	0,6	3,0	3,0	2,0	50,0	60,0	3	■
JS506040N2CZ3.0-SIRA	02881623	2	N	0,8	4,0	4,0	2,7	50,0	60,0	3	■
JS506060N2CZ4.0-SIRA	02881624	2	N	1,2	6,0	6,0	4,1	57,0	60,0	4	■
JS506080N2CZ4.0-SIRA	02881626	2	N	1,6	8,0	8,0	5,5	63,0	60,0	4	■
JS506100N2CZ4.0-SIRA	02881628	2	N	2,0	10,0	10,0	6,9	72,0	60,0	4	■
JS506120N2CZ4.0-SIRA	02881630	2	N	2,4	12,0	12,0	8,3	83,0	60,0	4	■

■ **Lagerstandard.**

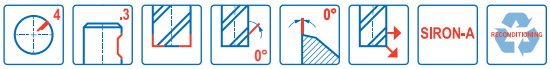
JS506

Allgemeine Bearbeitung – Universal – Eckenfase – 3-4 Schneiden – Weldon



N





- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Weldon
				mm	mm	mm	mm	mm			
JS506060N2CZ4.3-SIRA	02881625	2	N	1,2	6,0	6,0	4,1	57,0	60,0	4	■
JS506080N2CZ4.3-SIRA	02881627	2	N	1,6	8,0	8,0	5,5	63,0	60,0	4	■
JS506100N2CZ4.3-SIRA	02881629	2	N	2,0	10,0	10,0	6,9	72,0	60,0	4	■
JS506120N2CZ4.3-SIRA	02881631	2	N	2,4	12,0	12,0	8,3	83,0	60,0	4	■

■ **Lagerstandard.**

Schnittdaten – JS506 Anfasen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	200 (180 — 220) *660 (600–720)*
P2	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	195 (180 — 220) *640 (600–720)*
P3	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	170 (150–190) *560 (500 — 620)*
P4	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	150 (130–160) *490 (430 — 520)*
P5	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130–160) *460 (430 — 520)*
P6	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	160 (140–180) *520 (460 — 590)*
P7	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	150 (140–170) *490 (460 — 550)*
P8	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	140 (130–160) *460 (430 — 520)*
P11	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (130–160) *475 (430 — 520)*
P12	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.013 *0,00050*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	85 (75 — 97) *280 (250 — 310)*
M1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	120 (95–140) *395 (320 — 450)*
M2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	95 (76–110) *310 (250 — 360)*
M3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 80) *195 (150 — 260)*
M4	E/M/A	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	46 (33 — 60) *150 (110–190)*
M5	E/M/A	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	39 (27 — 50) *130 (89–160)*
K1	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	200 (180 — 220) *660 (600–720)*
K2	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	170 (150–190) *560 (500 — 620)*
K3	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (130–160) *475 (430 — 520)*
K4	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130–150) *460 (430 — 490)*
K5	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.018 *0,00070*	0.024 *0,00095*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	85 (72 — 93) *280 (240 — 300)*
K6	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	125 (110–130) *410 (370 — 420)*
K7	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.018 *0,00070*	0.024 *0,00095*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	105 (92–120) *345 (310 — 390)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS506 Anfasen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500–1700)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	305 (280 — 330) *1000 (920–1000)*
N3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	205 (190 — 220) *670 (630–720)*
N11	E/M/A	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	270 (250 — 290) *890 (830 — 950)*
S1	E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	41 (14 — 68) *135 (46 — 220)*
S2	E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	33 (12 — 55) *110 (40–180)*
S3	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	28 (9.5 — 47) *90 (32–150)*
S11	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	95 (68–110) *310 (230 — 360)*
S12	E	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	70 (53 — 90) *230 (180 — 290)*
S13	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	55 (41 — 69) *180 (140 — 220)*
H5	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	65 (45 — 83) *215 (150 — 270)*
H8	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	60 (44 — 81) *195 (150 — 260)*
H11	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	80 (57–100) *260 (190 — 320)*
H12	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	70 (51 — 94) *230 (170 — 300)*
H21	M/A/D	0.0500 *0,0500*	1.5 *1,5*	0.011 *0,00044*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	60 (44 — 81) *195 (150 — 260)*
TS1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500–1700)*
TP1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500–1700)*
GR1	A/D	0.100 *0,100*	0.55 *0,55*	0.019 *0,00075*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	475 (430 — 520) *1550 (1500–1700)*

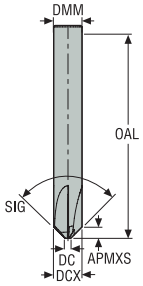
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS509

Allgemeine Bearbeitung – Universal – Eckenfase – 3-4 Schneiden – Zylindrisch





N

- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich, wenn DMM ≥ Ø6 ist

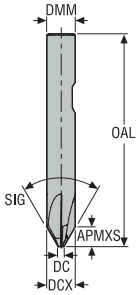


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm			
JS509030N2CZ3.0-SIRA	02881634	2	N	0,6	3,0	3,0	1,2	50,0	90,0	3	■
JS509040N2CZ3.0-SIRA	02881635	2	N	0,8	4,0	4,0	1,6	50,0	90,0	3	■
JS509060N2CZ4.0-SIRA	02881636	2	N	1,2	6,0	6,0	2,4	57,0	90,0	4	■
JS509080N2CZ4.0-SIRA	02881638	2	N	1,6	8,0	8,0	3,2	63,0	90,0	4	■
JS509100N2CZ4.0-SIRA	02881640	2	N	2,0	10,0	10,0	4,0	72,0	90,0	4	■
JS509120N2CZ4.0-SIRA	02881642	2	N	2,4	12,0	12,0	4,8	83,0	90,0	4	■

■ **Lagerstandard.**

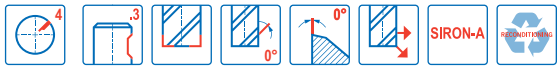
JS509

Allgemeine Bearbeitung – Universal – Eckenfase – 3-4 Schneiden – Weldon



N





- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DCX	DMM	APMXS	OAL	SIG°	PCEDC	Weldon
				mm	mm	mm	mm	mm			
JS509060N2CZ4.3-SIRA	02881637	2	N	1,2	6,0	6,0	2,4	57,0	90,0	4	■
JS509080N2CZ4.3-SIRA	02881639	2	N	1,6	8,0	8,0	3,2	63,0	90,0	4	■
JS509100N2CZ4.3-SIRA	02881641	2	N	2,0	10,0	10,0	4,0	72,0	90,0	4	■
JS509120N2CZ4.3-SIRA	02881643	2	N	2,4	12,0	12,0	4,8	83,0	90,0	4	■

■ **Lagerstandard.**

Schnittdaten – JS509 Anfasen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	380 (340 — 430) *1250 (1200–1400)*
P2	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	370 (330 — 420) *1225 (1100–1300)*
P3	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	320 (280 — 360) *1050 (920–1100)*
P4	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	280 (250 — 310) *920 (830–1000)*
P5	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	270 (240 — 300) *890 (790 — 980)*
P6	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (270 — 340) *1000 (890–1100)*
P7	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	285 (250 — 320) *940 (830–1000)*
P8	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.032 *0,0013*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	270 (240 — 300) *890 (790 — 980)*
P11	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	280 (250 — 310) *920 (830–1000)*
P12	M/A/D/E	0.100 *0,100*	0.55 *0,55*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	165 (150–180) *540 (500 — 590)*
M1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	115 (81–150) *375 (270 — 490)*
M4	E/M/A	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	90 (61–110) *295 (210 — 360)*
M5	E/M/A	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	75 (51 — 95) *245 (170 — 310)*
K1	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.034 *0,0013*	0.044 *0,0017*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	375 (330 — 420) *1225 (1100–1300)*
K2	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	325 (290 — 360) *1075 (960–1100)*
K3	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	275 (240 — 310) *900 (790–1000)*
K4	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	265 (230 — 290) *870 (760 — 950)*
K5	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	155 (140–170) *510 (460 — 550)*
K6	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	230 (210 — 260) *750 (690 — 850)*
K7	A/D/M/E	0.100 *0,100*	0.55 *0,55*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	200 (180 — 220) *660 (600–720)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS509 Anfasen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
N2	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	580 (530 — 630) *1900 (1800 — 2000)*
N3	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	385 (350 — 420) *1275 (1200–1300)*
N11	E/M/A	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	510 (470 — 560) *1675 (1600–1800)*
S1	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	70 (24–110) *230 (79 — 360)*
S2	E	0.100 *0,100*	0.55 *0,55*	0.017 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	55 (19 — 94) *180 (63 — 300)*
S3	E	0.100 *0,100*	0.55 *0,55*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	49 (17 — 80) *160 (56 — 260)*
S11	E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	175 (130 — 220) *570 (430–720)*
S12	E	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	135 (99–170) *445 (330 — 550)*
S13	E	0.100 *0,100*	0.55 *0,55*	0.026 *0,0010*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (77–130) *345 (260 — 420)*
H5	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	115 (80–140) *375 (270 — 450)*
H8	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (78–140) *360 (260 — 450)*
H11	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	145 (110–190) *475 (370 — 620)*
H12	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (91–170) *425 (300 — 550)*
H21	M/A/D	0.0500 *0,0500*	1.2 *1,2*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (78–140) *360 (260 — 450)*
TS1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
TP1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*
GR1	A/D	0.100 *0,100*	0.55 *0,55*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	900 (810 — 980) *2950 (2700 — 3200)*

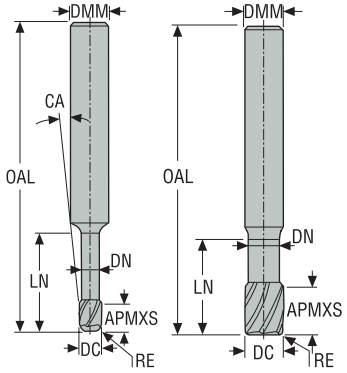
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

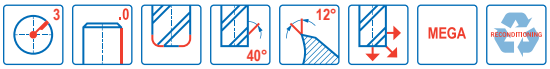
JH910

Hohe Geschwindigkeit – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

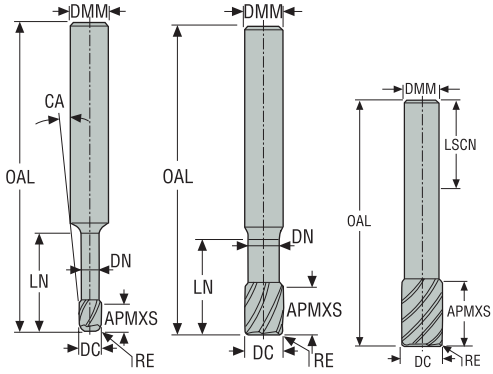


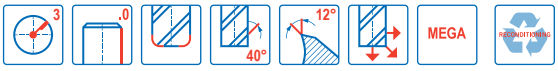
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	–		
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0	3	■
910030R010-MEGA	00020073	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,1	–	3	■
910030R020-MEGA	00020142	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,2	–	3	■
910035R020-MEGA	00020144	2	G	3,5	6,0	5,0	50,0	9,0	3,2	0,2	6,0	3	■
910040R020-MEGA	00020151	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,2	5,0	3	■
910040R030-MEGA	00020152	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,3	5,0	3	■
910040R050-MEGA	00020155	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,5	5,0	3	■
910050R020-MEGA	00020159	2	G	5,0	6,0	6,0	50,0	11,0	4,6	0,2	2,5	3	■
910060R020-MEGA	00020160	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,2	–	3	■
910060R030-MEGA	00020161	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,3	–	3	■
910060R050-MEGA	00020162	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,5	–	3	■
910080R020-MEGA	00020163	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,2	–	3	■
910080R050-MEGA	00020164	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,5	–	3	■
910100R020-MEGA	00020165	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,2	–	3	■
910100R050-MEGA	00020166	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,5	–	3	■
910100R100-MEGA	00020167	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	3	■
910120R050-MEGA	00020168	2	E	12,0	12,0	15,0	80,0	30,0	11,4	0,5	–	3	■
910120R100-MEGA	00020169	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,0	–	3	■

■ **Lagerstandard.**

JH910

Hohe Geschwindigkeit – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	LSCN	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	–	mm		
910L020-MEGA	00022002	3	G	2,0	3,0	3,0	60,0	10,0	1,9	0,2	2,5	28,0	3	■
910L030-MEGA	00022003	3	E	3,0	3,0	4,0	60,0	14,0	2,8	0,2	–	28,0	3	■
910L040-MEGA	00022004	3	G	4,0	6,0	5,0	65,0	18,0	3,7	0,2	3,0	36,0	3	■
910L050-MEGA	00022005	3	G	5,0	6,0	6,0	65,0	22,0	4,6	0,2	1,5	36,0	3	■
910L060-MEGA	00022006	3	E	6,0	6,0	7,0	80,0	26,0	5,6	0,3	–	36,0	3	■
910L080-MEGA	00022007	3	E	8,0	8,0	9,0	85,0	36,0	7,4	0,5	–	36,0	3	■
910L100-MEGA	00022009	3	E	10,0	10,0	12,0	100,0	45,0	9,4	0,5	–	40,0	3	■
910L120-MEGA	00022011	3	E	12,0	12,0	15,0	125,0	54,0	11,4	0,5	–	45,0	3	■
910L160-MEGA	00022013	3	E	16,0	16,0	18,0	125,0	65,0	15,4	1,0	–	48,0	3	■
910RS070-MEGA	00021772	4	P	7,0	6,0	8,0	100,0	–	–	0,3	–	36,0	3	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	–	0,5	–	36,0	3	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	–	0,5	–	40,0	3	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	–	0,6	–	45,0	3	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	–	0,6	–	48,0	3	■

■ Lagerstandard.

Schnittdaten – JH910 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	455 (410 — 500) *1500 (1400–1600)*
P2	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	445 (400 — 490) *1450 (1400–1600)*
P3	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	385 (350 — 420) *1275 (1200–1300)*
P4	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	335 (300 — 370) *1100 (990–1200)*
P5	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	320 (290 — 350) *1050 (960–1100)*
P6	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	360 (330 — 400) *1175 (1100–1300)*
P7	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	340 (310 — 370) *1125 (1100–1200)*
P8	M/E/A	0.0400 *0,0400*	1.1 *1,1*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	320 (290 — 350) *1050 (960–1100)*
P11	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	330 (300 — 360) *1075 (990–1100)*
P12	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	195 (180 — 210) *640 (600 — 680)*
M1	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	200 (180 — 220) *660 (600–720)*
M2	M/E/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	160 (150–170) *520 (500 — 550)*
M3	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	110 (91–120) *360 (300 — 390)*
M4	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	80 (68 — 94) *260 (230 — 300)*
M5	M/E/A	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	70 (57–78) *230 (190 — 250)*
K1	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	315 (270 — 350) *1025 (890–1100)*
K2	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	270 (240 — 310) *890 (790–1000)*
K3	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	230 (200 — 260) *750 (660 — 850)*
K4	A/E	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K5	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	280 (240 — 320) *920 (790–1000)*
K6	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	415 (350 — 480) *1350 (1200–1500)*
K7	A/E	0.0300 *0,0300*	0.80 *0,80*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	355 (300 — 410) *1175 (990–1300)*
S1	E/M/A	0.0300 *0,0300*	0.70 *0,70*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	115 (93–130) *375 (310 — 420)*
S2	E/M/A	0.0300 *0,0300*	0.70 *0,70*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	95 (75–110) *310 (250 — 360)*
S3	E/M/A	0.0200 *0,0200*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.13 *0,0050*	0.14 *0,0055*	50 (40 — 59) *165 (140–190)*
S11	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	175 (160–190) *570 (530 — 620)*
S12	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	135 (120–150) *445 (400 — 490)*
S13	E/M/A	0.0400 *0,0400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.17 *0,0065*	105 (90–110) *345 (300 — 360)*
TP1	A	0.150 *0,150*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.15 *0,0060*	205 (180 — 240) *670 (600–780)*
GR1	A	0.500 *0,500*	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.18 *0,0070*	610 (510–710) *2000 (1700 — 2300)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JH910 Nutfräsen

SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	215 (200 — 230) *710 (660–750)*
P4	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	180 (170–190) *590 (560 — 620)*
P6	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	200 (180 — 220) *660 (600–720)*
P7	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	180 (170–190) *590 (560 — 620)*
P11	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	195 (180 — 210) *640 (600 — 680)*
P12	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	115 (110–120) *375 (370 — 390)*
M1	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	120 (110–130) *395 (370 — 420)*
M2	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	95 (86–100) *310 (290 — 320)*
M3	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (51–70) *195 (170 — 220)*
M4	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	45 (38 — 52) *150 (130–170)*
M5	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	38 (32 — 43) *125 (110–140)*
K1	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	175 (160 — 200) *570 (530 — 650)*
K2	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	150 (140–170) *490 (460 — 550)*
K3	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	130 (120–140) *425 (400 — 450)*
K4	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	125 (110–140) *410 (370 — 450)*
K5	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	150 (130–170) *490 (430 — 550)*
K6	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	220 (190 — 250) *720 (630 — 820)*
K7	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 220) *620 (560–720)*
S1	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (50–74) *195 (170 — 240)*
S2	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	50 (41 — 60) *165 (140–190)*
S3	E/M/A	0.080 *0,080*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	25 (21 — 30) *80 (69 — 98)*
S11	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	100 (85–110) *330 (280 — 360)*
S12	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	75 (65 — 84) *245 (220 — 270)*
S13	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (51 — 65) *195 (170 — 210)*
TP1	A	0.24 *0,24*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	150 (130–170) *490 (430 — 550)*
GR1	A	0.36 *0,36*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	600 (510–700) *1975 (1700 — 2200)*

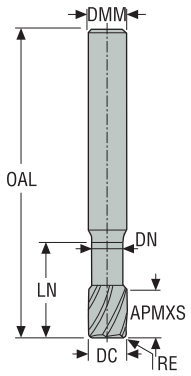
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH930

Hohe Geschwindigkeit – Universal – Schaftfräser – 5-8 Spannuten – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	■

■ **Lagerstandard.**

Schnittdaten – JH930 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300–1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200–1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100–1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920–1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890–1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990–1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920–1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890–1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920–1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560–720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530–720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760–1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660–1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62–100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110–160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140–180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110–140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81–110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41–71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41–71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860–1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730–1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130–180) *510 (430 — 590)*

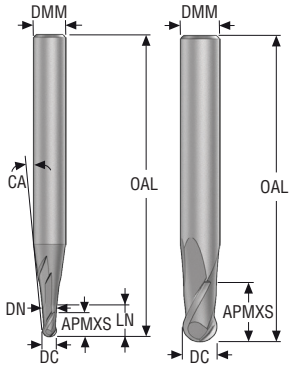
Schnittdaten, siehe Seite 457 - 464

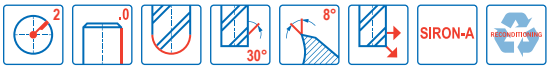
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHB970

Hohe Geschwindigkeit – Universal – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Sorte	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
					mm	mm	mm	mm	mm	mm									
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	10,0	11,0	11,5	12,1	12,8	–	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	–	2	–	–	–	–	–	–	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	–	2	–	–	–	–	–	–	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	–	2	–	–	–	–	–	–	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	–	2	–	–	–	–	–	–	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	5,0	5,7	6,0	6,2	6,5	7,3	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	7,0	8,8	9,4	10,0	10,7	12,8	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	10,0	13,6	15,0	16,8	–	–	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	–	2	–	–	–	–	–	–	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	–	2	–	–	–	–	–	–	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	–	2	–	–	–	–	–	–	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	–	2	–	–	–	–	–	–	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	–	2	–	–	–	–	–	–	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	–	2	–	–	–	–	–	–	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	–	2	–	–	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf a_n (l_{an}, ref)*

Schnittdaten – JHB970 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630–750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600–750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140–170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140–170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150–190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140–180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140–170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140–170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80–100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55–75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140–180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120–150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140–190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110–150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66–120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79–100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

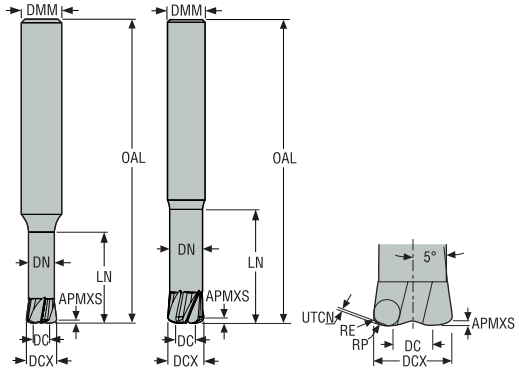
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHF980

Hohe Vorschübe – Universal – 2-5 Schneiden – Zylindrisch – Eckenradius





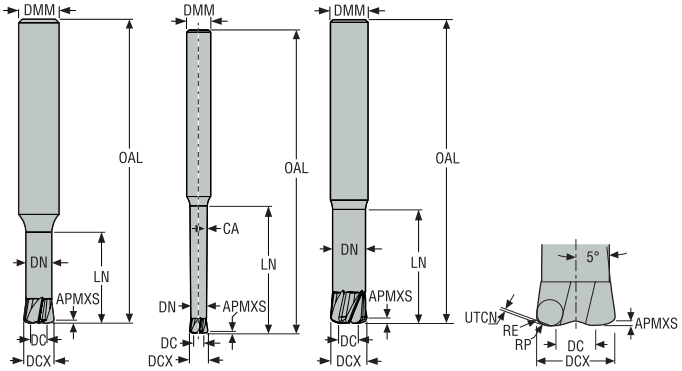
- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- CA= Kollisionswinkel
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm			
980K080Z3-MEGA	02587115	1	E	8,0	4,0	8,0	0,4	70,0	12,0	3,0	0,6	0,935	0,198	–	3	■
JHF980080E1H.0Z5-MEGA	03003384	1	E	8,0	4,0	8,0	0,4	70,0	12,0	7,0	0,6	0,935	0,198	–	5	■
980K100Z3-MEGA	02587117	1	E	10,0	5,0	10,0	0,45	80,0	15,0	3,8	0,8	1,176	0,232	–	3	■
JHF980100E1H.0Z5-MEGA	03003385	1	E	10,0	5,0	10,0	0,45	80,0	15,0	8,8	0,8	1,176	0,232	–	5	■
980K120Z3-MEGA	02587118	1	E	12,0	6,0	12,0	0,5	80,0	18,0	4,6	1,0	1,417	0,265	–	3	■
JHF980120E1H.0Z5-MEGA	03003386	1	E	12,0	6,0	12,0	0,5	80,0	18,0	10,6	1,0	1,417	0,265	–	5	■
980010-MEGA	02587111	2	G	1,0	0,5	6,0	0,07	40,0	3,0	0,7	0,07	0,127	0,028	19,5	2	■
980015-MEGA	02511199	2	G	1,5	0,75	6,0	0,1	40,0	4,5	1,2	0,1	0,183	0,043	14,0	2	■
980020-MEGA	02511221	2	G	2,0	1,0	6,0	0,15	40,0	6,0	1,7	0,15	0,269	0,055	11,0	2	■
980030-MEGA	02511224	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,0	2	■
JHF980030G2H.0Z4-MEGA	03003387	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,12	4	■
980040-MEGA	02511229	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	2	■
JHF980040G2H.0Z4-MEGA	03003388	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	4	■
980050-MEGA	02511233	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	2,0	2	■
JHF980050G2H.0Z4-MEGA	03003389	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	1,77	4	■
980060-MEGA	02511314	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	3,0	2	■
JHF980060G2H.0Z4-MEGA	03003390	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	2,86	4	■
980080-MEGA	02511322	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	2	■
JHF980080E2H.0Z5-MEGA	03003391	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	5	■
980100-MEGA	02511341	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	2	■
980100Z3-MEGA	02511342	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	3	■
JHF980100E2H.0Z5-MEGA	03003392	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	5	■
980120-MEGA	02511346	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	2	■
980120Z3-MEGA	02511347	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	3	■
JHF980120E2H.0Z5-MEGA	03003393	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	5	■

■ **Lagerstandard.**
*UTCN = Theoretische Abweichung

JHF980

Hohe Vorschübe – Universal – 2-5 Spannuten – Zylindrisch – Eckenradius



G J E E



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,05 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA	NA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm		mm		
980ML010-MEGA	02587113	3	G	1,0	0,5	6,0	0,07	40,0	5,0	0,7	0,07	0,127	0,028	15,5	0,0	2	■
980ML015-MEGA	02511219	3	G	1,5	0,75	6,0	0,1	40,0	7,5	1,2	0,1	0,183	0,043	10,5	0,0	2	■
980ML020-MEGA	02511222	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,0	0,0	2	■
JHF980020G3H.0Z4-MEGA	03003394	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,46	0,0	4	■
980ML030-MEGA	02511225	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	5,0	0,0	2	■
JHF980030G3H.0Z4-MEGA	03003395	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	4,79	0,0	4	■
980ML040-MEGA	02511231	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,5	0,0	2	■
JHF980040G3H.0Z4-MEGA	03003396	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,59	0,0	4	■
980ML050-MEGA	02511234	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,5	0,0	2	■
JHF980050G3H.0Z4-MEGA	03003397	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,12	0,0	4	■
980ML060-MEGA	02511315	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	2,0	0,0	2	■
JHF980060G3H.0Z4-MEGA	03003398	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	1,8	0,0	4	■
980ML080-MEGA	02511338	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	0,0	2	■
JHF980080E3H.0Z5-MEGA	03003399	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	0,0	5	■
980ML100-MEGA	02511344	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	0,0	2	■
JHF980100E3H.0Z5-MEGA	03003400	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	0,0	5	■
980ML120-MEGA	02511348	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	0,0	2	■
JHF980120E3H.0Z5-MEGA	03003401	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	0,0	5	■
980TL010-MEGA	02587114	4	J	1,0	0,5	6,0	0,07	40,0	7,0	0,7	0,07	0,127	0,028	13,0	0,5	2	■
980TL015-MEGA	02511220	4	J	1,5	0,75	6,0	0,1	40,0	10,5	1,2	0,1	0,183	0,043	8,5	0,5	2	■
980TL020-MEGA	02511223	4	J	2,0	1,0	6,0	0,15	50,0	14,0	1,7	0,15	0,269	0,055	6,5	0,5	2	■
980TL030-MEGA	02511226	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,5	0,5	2	■
JHF980030J4H.0Z4-MEGA	03003402	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,63	0,5	4	■
980TL040-MEGA	02511232	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	2,0	0,5	2	■
JHF980040J4H.0Z4-MEGA	03003403	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	1,93	0,5	4	■
980TL050-MEGA	02511240	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	1,0	0,5	2	■
JHF980050J4H.0Z4-MEGA	03003404	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	0,82	0,5	4	■
980TL060-MEGA	02511321	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,5	0,5	2	■
JHF980060J4H.0Z4-MEGA	03003405	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,33	0,5	4	■
980TL080-MEGA	02511340	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,5	2	■
JHF980080E4H.0Z5-MEGA	03003406	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,0	5	■
980TL100-MEGA	02511345	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,5	2	■
JHF980100E4H.0Z5-MEGA	03003407	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,0	5	■
980TL120-MEGA	02511349	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,5	2	■
JHF980120E4H.0Z5-MEGA	03003408	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,0	5	■

■ **Lagerstandard.** *UTCN = Theoretische Abweichung

Schnittdaten – JHF980 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z										v_c
				1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	0.40 *0,016*	0.50 *0,020*	0.60 *0,024*	385 (350 — 430) *1275 (1200–1400)*
P2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	0.40 *0,016*	0.50 *0,020*	0.60 *0,024*	375 (340 — 410) *1225 (1200–1300)*
P3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	0.40 *0,016*	0.50 *0,020*	0.60 *0,024*	325 (290 — 360) *1075 (960–1100)*
P4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	0.40 *0,016*	0.50 *0,020*	0.60 *0,024*	285 (260 — 310) *940 (860–1000)*
P5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	0.40 *0,016*	0.50 *0,020*	0.60 *0,024*	275 (250 — 300) *900 (830 — 980)*
P6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.044 *0,0017*	0.070 *0,0028*	0.090 *0,0036*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.28 *0,011*	0.36 *0,014*	0.44 *0,017*	0.55 *0,022*	215 (190 — 240) *710 (630–780)*
P7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.044 *0,0017*	0.070 *0,0028*	0.090 *0,0036*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.28 *0,011*	0.36 *0,014*	0.44 *0,017*	0.55 *0,022*	205 (180 — 230) *670 (600–750)*
P8	E/M/A	0.30 *0,30*	0.040 *0,040*	0.044 *0,0017*	0.070 *0,0028*	0.090 *0,0036*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.28 *0,011*	0.36 *0,014*	0.44 *0,017*	0.55 *0,022*	190 (170 — 210) *620 (560 — 680)*
P11	E/M/A	0.30 *0,30*	0.040 *0,040*	0.044 *0,0017*	0.070 *0,0028*	0.090 *0,0036*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.28 *0,011*	0.36 *0,014*	0.44 *0,017*	0.55 *0,022*	195 (170 — 220) *640 (560–720)*
P12	E/M/A	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	120 (110–130) *395 (370 — 420)*
M1	E/M/A	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	150 (140–160) *490 (460 — 520)*
M3	E/M/A	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	115 (98–130) *375 (330 — 420)*
M4	E/M/A	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	85 (73–100) *280 (240 — 320)*
M5	E/M/A	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	70 (61 — 83) *230 (210 — 270)*
K1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	195 (170 — 220) *640 (560–720)*
K3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	165 (150–180) *540 (500 — 590)*
K4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	155 (140–170) *510 (460 — 550)*
K5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.032 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.40 *0,016*	165 (140–190) *540 (460 — 620)*
K6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.032 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.40 *0,016*	245 (200 — 290) *800 (660 — 950)*
K7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.032 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.40 *0,016*	210 (170 — 250) *690 (560 — 820)*
S1	E	0.30 *0,30*	0.022 *0,022*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	60 (50–74) *195 (170 — 240)*
S2	E	0.30 *0,30*	0.022 *0,022*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	50 (41 — 60) *165 (140–190)*
S3	E	0.30 *0,30*	0.022 *0,022*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	37 (25 — 49) *120 (83–160)*
S11	E	0.30 *0,30*	0.022 *0,022*	0.036 *0,0014*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	0.28 *0,011*	0.36 *0,014*	0.42 *0,017*	175 (160–190) *570 (530 — 620)*
S12	E	0.30 *0,30*	0.022 *0,022*	0.036 *0,0014*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	0.28 *0,011*	0.36 *0,014*	0.42 *0,017*	135 (120–150) *445 (400 — 490)*
S13	E	0.30 *0,30*	0.022 *0,022*	0.036 *0,0014*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	0.28 *0,011*	0.36 *0,014*	0.42 *0,017*	105 (90–110) *345 (300 — 360)*
H5	M/A/D	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	115 (98–130) *375 (330 — 420)*
H8	M/A/D	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	115 (98–130) *375 (330 — 420)*
H21	M/A/D	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	115 (98–130) *375 (330 — 420)*
H31	M/A/D	0.30 *0,30*	0.036 *0,036*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	0.48 *0,019*	90 (74–100) *295 (250 — 320)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JHF980 Nutfräsen

SMG		a_p/DCX	f_z										v_c
			1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	340 (310 — 370) *1125 (1100–1200)*
P2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	330 (300 — 360) *1075 (990–1100)*
P3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	285 (260 — 310) *940 (860–1000)*
P4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	250 (230 — 270) *820 (760 — 880)*
P5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	165 (150–180) *540 (500 — 590)*
P11	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (150–190) *560 (500 — 620)*
P12	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	105 (90–110) *345 (300 — 360)*
M1	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	165 (150–180) *540 (500 — 590)*
M2	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	130 (120–140) *425 (400 — 450)*
M3	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (85–110) *330 (280 — 360)*
M4	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	65 (53–72) *215 (180 — 230)*
K1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	160 (140–180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	135 (120–150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	130 (120–140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	135 (110–150) *445 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	195 (160 — 230) *640 (530–750)*
K7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	42 (34 — 50) *140 (120–160)*
S3	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	31 (21 — 41) *100 (69–130)*
S11	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	155 (140–170) *510 (460 — 550)*
S12	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	120 (110–130) *395 (370 — 420)*
S13	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	95 (82–100) *310 (270 — 320)*
H5	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86–110) *330 (290 — 360)*
H8	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86–110) *330 (290 — 360)*
H21	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86–110) *330 (290 — 360)*
H31	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (65 — 88) *245 (220 — 280)*

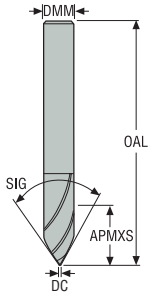
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

J29

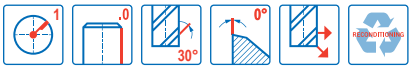
Allgemeine Bearbeitung – Universal – Gravierfräser – 1 Schneide – Zylindrisch





D

- Toleranzen:
- DMM=h5
- Nachschleifen möglich, wenn DMM ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	SIG°	PCEDC	Zylindrisch
				mm	mm	mm	mm			
29030	00029373	2	D	0,2	3,0	2,6	40,0	60,0	1	■
29040	00029381	2	D	0,2	4,0	3,5	50,0	60,0	1	■
29060	00029396	2	D	0,2	6,0	5,2	50,0	60,0	1	■

■ **Lagerstandard.**

Schnittdaten – J29 Nutfräsen

SMG		a_p/DC	f_z			v_c
			3	4	6	
P1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	42 (32 — 63) *140 (110 — 200)*
P2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.30 *0,012*	41 (32 — 61) *135 (110 — 200)*
P3	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	36 (28 — 54) *120 (92–170)*
P4	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 47) *100 (79–150)*
P5	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
P6	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	34 (26 — 51) *110 (86–160)*
P7	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	32 (25 — 48) *105 (83–150)*
P8	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	30 (23 — 45) *100 (76–140)*
P11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 46) *100 (79–150)*
P12	E	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.18 *0,0070*	19 (15 — 29) *60 (50 — 95)*
M1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
M2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
M3	E	0.50 *0,50*	0.18 *0,0070*	0.19 *0,0075*	0.22 *0,0085*	24 (18 — 35) *80 (60–110)*
M4	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	18 (14 — 27) *60 (46 — 88)*
M5	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	15 (12 — 22) *49 (40–72)*
K1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
K2	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	26 (21 — 40) *85 (69–130)*
K3	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	22 (17 — 33) *70 (56–100)*
K4	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	21 (17 — 32) *70 (56–100)*
K5	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	13 (9.8–19) *43 (33 — 62)*
K6	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	19 (15 — 28) *60 (50 — 91)*
K7	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	16 (13 — 25) *50 (43 — 82)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – J29 Nutfräsen

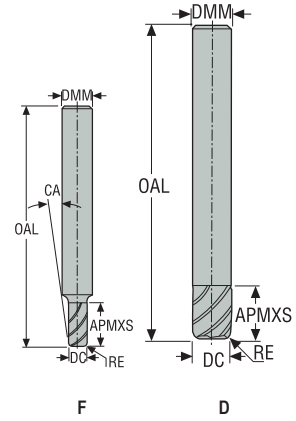
SMG		a_p/DC	f_z			v_c
			3	4	6	
N1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
N2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	19 (15 — 29) *60 (50 — 95)*
N3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	13 (9.8–19) *43 (33 — 62)*
N11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	17 (14 — 26) *55 (46 — 85)*
S1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	43 (33 — 64) *140 (110 — 200)*
S2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	34 (27 — 51) *110 (89–160)*
S3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
S11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 59) *130 (99–190)*
S12	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
S13	E	0.50 *0,50*	0.19 *0,0075*	0.20 *0,0080*	0.24 *0,0095*	24 (18 — 35) *80 (60–110)*
H5	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
H8	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79–150)*
H11	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 58) *130 (99–190)*
H12	M/A/D	0.50 *0,50*	0.12 *0,0048*	0.12 *0,0048*	0.14 *0,0055*	12 (9.1–18) *39 (30 — 59)*
H21	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79–150)*
H31	M/A/D	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.17 *0,0065*	24 (19 — 36) *80 (63–110)*
TS1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
TP1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*
GR1	D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76–140)*

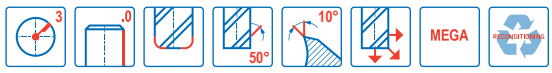
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

J36

Allgemeine Bearbeitung – Universal – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- RE= Ø2-Ø12= +0,05 mm
- RE= Ø14-Ø20= +0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
36020-MEGA	00025621	2	F	2,0	3,0	9,0	40,0	0,1	2,5	3	■
36030-MEGA	00025626	2	D	3,0	3,0	12,0	40,0	0,1	–	3	■
36040-MEGA	00025628	2	D	4,0	4,0	14,0	50,0	0,1	–	3	■
36050-MEGA	00025651	2	D	5,0	5,0	20,0	50,0	0,1	–	3	■
36060-MEGA	00025663	2	D	6,0	6,0	20,0	65,0	0,1	–	3	■
36080-MEGA	00025674	2	D	8,0	8,0	20,0	65,0	0,2	–	3	■
36100-MEGA	00025680	2	D	10,0	10,0	25,0	75,0	0,2	–	3	■
36120-MEGA	00025681	2	D	12,0	12,0	25,0	75,0	0,2	–	3	■
36160-MEGA	00025689	2	D	16,0	16,0	30,0	90,0	0,5	–	3	■
36200-MEGA	00025692	2	D	20,0	20,0	40,0	100,0	0,5	–	3	■

■ **Lagerstandard.**

Schnittdaten – J36 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	200 (170 — 220) *660 (560–720)*
P2	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	190 (170 — 210) *620 (560 — 680)*
P3	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	170 (150–190) *560 (500 — 620)*
P4	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130–160) *490 (430 — 520)*
P5	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130–160) *460 (430 — 520)*
P6	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	160 (140–180) *520 (460 — 590)*
P7	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	150 (130–170) *490 (430 — 550)*
P8	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	140 (130–160) *460 (430 — 520)*
P11	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	145 (130–160) *475 (430 — 520)*
P12	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (79–100) *295 (260 — 320)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	115 (92–140) *375 (310 — 450)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	95 (76–110) *310 (250 — 360)*
M3	E	0.100 *0,100*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	75 (56 — 95) *245 (190 — 310)*
M4	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43–73) *195 (150 — 230)*
M5	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	48 (36 — 60) *155 (120–190)*
K1	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130–160) *460 (430 — 520)*
K2	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	125 (110–140) *410 (370 — 450)*
K3	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	105 (91–120) *345 (300 — 390)*
K4	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	100 (87–110) *330 (290 — 360)*
K5	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	60 (53 — 69) *195 (180 — 220)*
K6	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	90 (76–100) *295 (250 — 320)*
K7	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	80 (67 — 89) *260 (220 — 290)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – J36 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	650 (540–750) *2125 (1800 — 2400)*
N2	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	415 (350 — 480) *1350 (1200–1500)*
N3	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	275 (240 — 320) *900 (790–1000)*
N11	E	0.300 *0,300*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	305 (260 — 350) *1000 (860–1100)*
S1	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	70 (60 — 83) *230 (200 — 270)*
S2	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	60 (48 — 67) *195 (160 — 210)*
S3	E	0.120 *0,120*	0.90 *0,90*	0.0036 *0,00014*	0.0055 *0,00022*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	39 (30 — 48) *130 (99–150)*
S11	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	100 (89–110) *330 (300 — 360)*
S12	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	80 (68 — 87) *260 (230 — 280)*
S13	E	0.300 *0,300*	1.0 *0,90*	0.0085 *0,00036*	0.013 *0,00050*	0.017 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (54 — 69) *195 (180 — 220)*
TS1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600–1800)*
TP1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600–1800)*

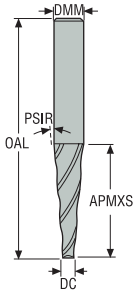
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

HK

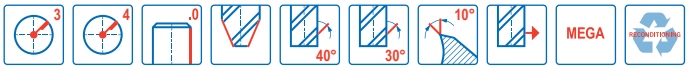
Allgemeine Bearbeitung – Universal – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

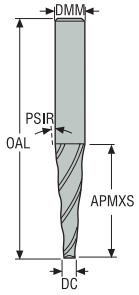


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK020-040-MEGA	00028666	2	N	4,0	6,0	20,0	65,0	2,0	3	■
HK020-050-MEGA	00028669	2	N	5,0	8,0	30,0	75,0	2,0	3	■
HK020-100-MEGA	00028694	2	N	10,0	12,0	28,0	80,0	2,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

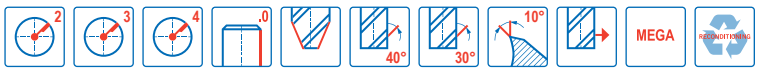
HKM-HK

Allgemeine Bearbeitung – Universal – Konisch – 2-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



N





- Toleranzen:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

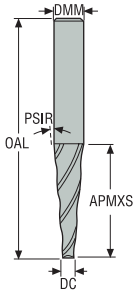
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HKM030-015-MEGA	00028738	2	N	1,5	3,0	6,0	40,0	3,0	2	■
HK030-025-MEGA	00028741	2	N	2,5	6,0	20,0	65,0	3,0	3	■
HK030-033-MEGA	00028744	2	N	3,0	8,0	30,0	75,0	3,0	3	■
HK030-065-MEGA	00028759	2	N	6,0	12,0	55,0	110,0	3,0	3	■
HK030-083-MEGA	00028771	2	N	8,0	12,0	30,0	80,0	3,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

HKM-HK

Allgemeine Bearbeitung – Universal – Konisch – 2-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

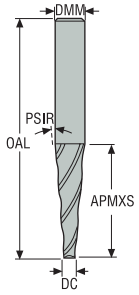


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HKM050-010-MEGA	00028947	2	N	1,0	3,0	4,0	40,0	5,0	2	■
HKM050-015-MEGA	00028952	2	N	1,5	3,0	6,0	40,0	5,0	2	■
HKM050-020-MEGA	00028954	2	N	2,0	4,0	10,0	50,0	5,0	2	■
HKM050-025-MEGA	00028958	2	N	2,5	5,0	10,0	50,0	5,0	2	■
HK050-025-MEGA	00028960	2	N	2,5	6,0	20,0	65,0	5,0	3	■
HK050-032-MEGA	00028972	2	N	3,0	8,0	28,0	70,0	5,0	3	■
HK050-0420-MEGA	00028998	2	N	4,0	8,0	22,0	65,0	5,0	3	■
HK050-050-MEGA	00029012	2	N	5,0	12,0	40,0	100,0	5,0	3	■
HK050-063-MEGA	00029014	2	N	6,0	12,0	32,0	90,0	5,0	3	■
HK050-065-MEGA	00029017	2	N	6,0	16,0	55,0	110,0	5,0	3	■
HK050-103-MEGA	00029020	2	N	10,0	16,0	32,0	90,0	5,0	4	■
HK050-105-MEGA	00029025	2	N	10,0	20,0	55,0	115,0	5,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

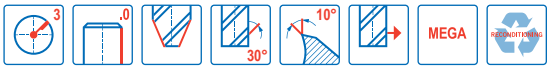
HK

Allgemeine Bearbeitung – Universal – Konisch – 3 Schneiden – Zylindrisch – Scharfe Schneide konisch



N





- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

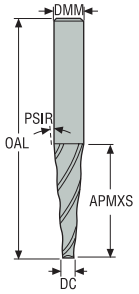
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK070-025-MEGA	00029030	2	N	2,5	8,0	22,0	65,0	7,0	3	■
HK070-050-MEGA	00029034	2	N	5,0	12,0	28,0	80,0	7,0	3	■

■ **Lagerstandard.**
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HK

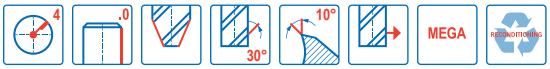
Allgemeine Bearbeitung – Universal – Konisch – 4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

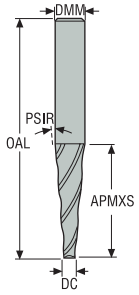


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK080-083-MEGA	00029041	2	N	8,0	18,0	35,0	90,0	8,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

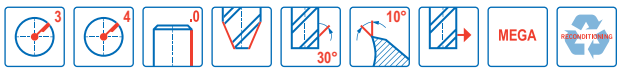
HK

Allgemeine Bearbeitung – Universal – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



N





- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

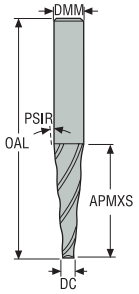
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK100-025-MEGA	00029052	2	N	2,5	10,0	20,0	75,0	10,0	3	■
HK100-030-MEGA	00029066	2	N	3,0	14,0	30,0	90,0	10,0	3	■
HK100-050-MEGA	00029069	2	N	5,0	16,0	30,0	90,0	10,0	3	■
HK100-080-MEGA	00029083	2	N	8,0	20,0	32,0	90,0	10,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

HK

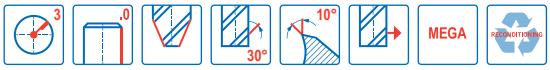
Allgemeine Bearbeitung – Universal – Konisch – 3 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

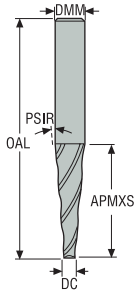


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK110-020-MEGA	00029110	2	N	2,0	10,0	20,0	75,0	11,0	3	■
HK110-050-MEGA	00029117	2	N	5,0	14,0	20,0	80,0	11,0	3	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

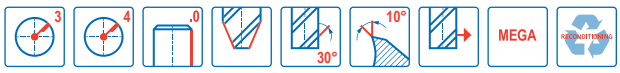
HK

Allgemeine Bearbeitung – Universal – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



N





- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

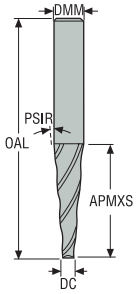
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK150-025	00029119	2	N	2,5	14,0	20,0	80,0	15,0	3	■
HK150-025-MEGA	00029151	2	N	2,5	14,0	20,0	80,0	15,0	3	■
HK150-040	00029124	2	N	4,0	12,0	15,0	65,0	15,0	3	■
HK150-040-MEGA	00029154	2	N	4,0	12,0	15,0	65,0	15,0	3	■
HK150-0651	00029133	2	N	6,5	12,0	10,0	65,0	15,0	3	■
HK150-0651-MEGA	00029160	2	N	6,5	12,0	10,0	65,0	15,0	3	■
HK150-0652	00029138	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-0652-MEGA	00029161	2	N	6,5	20,0	25,0	90,0	15,0	3	■
HK150-080	00029149	2	N	8,0	20,0	20,0	80,0	15,0	4	■
HK150-080-MEGA	00029162	2	N	8,0	20,0	20,0	80,0	15,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

HK

Allgemeine Bearbeitung – Universal – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

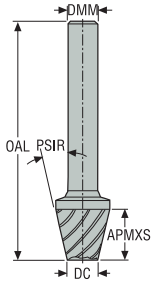


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK200-025	00029165	2	N	2,5	10,0	10,0	75,0	20,0	3	■
HK200-025-MEGA	00029168	2	N	2,5	10,0	10,0	75,0	20,0	3	■
HK200-045	00029166	2	N	4,5	16,0	15,0	90,0	20,0	4	■
HK200-045-MEGA	00029203	2	N	4,5	16,0	15,0	90,0	20,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

HK

Allgemeine Bearbeitung – Universal – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



N





- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

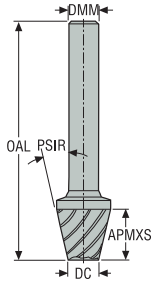
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK300-025	00029208	2	N	2,5	10,0	10,0	75,0	30,0	3	■
HK300-025-MEGA	00029211	2	N	2,5	10,0	10,0	75,0	30,0	3	■
HK300-045	00029210	2	N	4,5	16,0	16,0	90,0	30,0	4	■
HK300-045-MEGA	00029212	2	N	4,5	16,0	16,0	90,0	30,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

HK

Allgemeine Bearbeitung – Universal – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

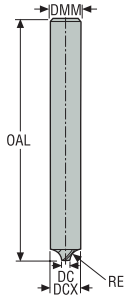


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm			
HK450-025	00029215	2	N	2,5	12,0	10,0	75,0	45,0	3	■
HK450-025-MEGA	00029229	2	N	2,5	12,0	10,0	75,0	45,0	3	■
HK450-045	00029217	2	N	4,5	16,0	16,0	90,0	45,0	4	■
HK450-045-MEGA	00029232	2	N	4,5	16,0	16,0	90,0	45,0	4	■

■ **Lagerstandard.**
Schnittdaten finden Sie auch in My Pages - Suggest auf www.secotools.com

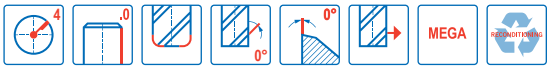
V31

Allgemeine Bearbeitung – Universal – Konkav – 4 Schneiden – Zylindrisch



D





- Toleranzen:
- DMM= h5
- DC= ±0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DCX	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
31100-MEGA	00029307	2	D	4,0	6,0	6,0	1,0	64,0	1,0	4	■
31200-MEGA	00029315	2	D	4,0	8,0	8,0	2,0	75,0	2,0	4	■
31300-MEGA	00029326	2	D	4,0	10,0	10,0	3,0	75,0	3,0	4	■
31400-MEGA	00029328	2	D	4,0	12,0	12,0	4,0	75,0	4,0	4	■
31050-MEGA	00029285	2	D	5,0	6,0	6,0	0,5	64,0	0,5	4	■
31150-MEGA	00029313	2	D	5,0	8,0	8,0	1,5	75,0	1,5	4	■
31250-MEGA	00029324	2	D	5,0	10,0	10,0	2,5	75,0	2,5	4	■
31350-MEGA	00029327	2	D	5,0	12,0	12,0	3,5	75,0	3,5	4	■
31500-MEGA	00029330	2	D	6,0	16,0	16,0	5,0	75,0	5,0	4	■
31600-MEGA	00029331	2	D	8,0	20,0	20,0	6,0	80,0	6,0	4	■
31999-MEGA	00029335	2	D	8,0	28,0	25,0	10,0	80,0	10,0	4	■
31800-MEGA	00029333	2	D	9,0	25,0	25,0	8,0	75,0	8,0	4	■

■ **Lagerstandard.**

Schnittdaten – V31 Eckfräsen/Schruppen

SMG		a_p/D_c	f_z								v_c
			6	8	10	12	16	20	25	28	
P1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	290 (195 — 310) *950 (640–1100)*
P2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	280 (190 — 305) *910 (620–1000)*
P3	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	210 (145 — 230) *680 (475–760)*
P5	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0034*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
P6	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	215 (145 — 230) *710 (475–760)*
P8	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	205 (140 — 220) *670 (460–730)*
P11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	210 (140 — 225) *680 (460–740)*
M1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
M3	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	150 (105–165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	110 (75–120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	95 (65–100) *310 (220 — 320)*
K1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
K2	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	175 (120–190) *570 (400 — 620)*
K3	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	150 (100–160) *490 (320 — 530)*
K4	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	140 (95–150) *460 (310 — 490)*
K5	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	125 (85–135) *410 (280 — 445)*
K7	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	105 (70–115) *345 (220 — 375)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – V31 Eckfräsen/Schruppen

SMG		a_p/D_c	f_z								v_c
			6	8	10	12	16	20	25	28	
N1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	315 (215 — 340) *1025 (710–1125)*
N2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
N3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	135 (90–145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
S1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460–730)*
S2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460–730)*
S3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
S11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	265 (180 — 285) *870 (590 — 940)*
S12	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
S13	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	0,075 *0,003*	0,080 *0,0032*	155 (105–165) *510 (345 — 540)*
H5	M/A	0,24 *0,24*	0,034 *0,0013*	0,046 *0,0018*	0,055 *0,0022*	0,070 *0,0028*	0,090 *0,0036*	0,11 *0,0044*	0,13 *0,0050*	0,14 *0,0055*	275 (185 — 295) *900 (610 — 950)*
H8	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H21	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H31	M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
TS1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
TP1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*
GR1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445–730)*

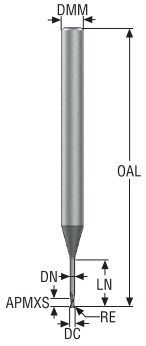
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JME542

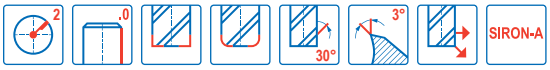
Mini – Universal – Eckfräser – 2 Schneiden – DMM 4 – Zylindrisch – scharf oder Eckenradius





G

- Toleranzen:
- Rundlaufabweichung = <0,007 mm
- DMM= h5
- DC= Ø0,2-Ø0,4= 0,-0,01 mm
- DC= Ø0,5-Ø3,0= 0,-0,013 mm
- RE= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME542002G1S.0Z2-SIRA	03171095	1	G	0,2	4,0	0,3	45,0	0,4	0,18	–	2	14,41	0,56	0,63	0,69	0,75	0,81	0,91	■
JME542003G1S.0Z2-SIRA	03171096	1	G	0,3	4,0	0,45	45,0	0,6	0,28	–	2	14,0	0,76	0,85	0,92	0,99	1,06	1,17	■
JME542004G1S.0Z2-SIRA	03171128	1	G	0,4	4,0	0,6	45,0	0,8	0,37	–	2	13,5	1,12	1,19	1,26	1,32	1,38	1,49	■
JME542005G1R005.0Z2-SIRA	03171097	1	G	0,5	4,0	0,8	45,0	1,0	0,46	0,05	2	13,17	1,32	1,4	1,47	1,54	1,61	1,73	■
JME542006G1R005.0Z2-SIRA	03171098	1	G	0,6	4,0	0,9	45,0	1,2	0,56	0,05	2	12,76	1,52	1,61	1,69	1,77	1,84	1,97	■
JME542008G1R005.0Z2-SIRA	03171129	1	G	0,8	4,0	1,2	45,0	1,6	0,76	0,05	2	11,96	1,92	2,03	2,13	2,22	2,3	2,46	■
JME542010G1R010.0Z2-SIRA	03171099	1	G	1,0	4,0	1,5	50,0	2,0	0,95	0,1	2	11,22	2,32	2,45	2,56	2,65	2,74	2,94	■
JME542012G1R010.0Z2-SIRA	03171100	1	G	1,2	4,0	1,8	50,0	2,4	1,15	0,1	2	10,43	2,77	2,87	2,99	3,1	3,2	3,43	■
JME542015G1R015.0Z2-SIRA	03171130	1	G	1,5	4,0	2,3	50,0	3,0	1,45	0,15	2	9,2	3,47	3,61	3,73	3,85	3,98	4,26	■
JME542005G3R005.0Z2-SIRA	03171102	3	G	0,5	4,0	0,8	45,0	2,5	0,46	0,05	2	11,03	2,82	2,98	3,1	3,21	3,32	3,56	■
JME542006G3R005.0Z2-SIRA	03171103	3	G	0,6	4,0	0,9	45,0	3,0	0,56	0,05	2	10,36	3,32	3,5	3,64	3,76	3,89	4,18	■
JME542008G3R005.0Z2-SIRA	03171131	3	G	0,8	4,0	1,2	45,0	4,0	0,76	0,05	2	9,14	4,32	4,54	4,7	4,86	5,03	5,4	■
JME542010G3R010.0Z2-SIRA	03171104	3	G	1,0	4,0	1,5	50,0	5,0	0,95	0,1	2	8,09	5,32	5,58	5,77	5,96	6,16	6,61	■
JME542012G3R010.0Z2-SIRA	03171105	3	G	1,2	4,0	1,8	50,0	6,0	1,15	0,1	2	7,13	6,32	6,62	6,83	7,06	7,3	7,84	■
JME542015G3R015.0Z2-SIRA	03171132	3	G	1,5	4,0	2,3	50,0	7,5	1,45	0,15	2	5,89	7,82	8,16	8,43	8,7	9,0	9,66	■
JME542020G3R015.0Z2-SIRA	03171106	3	G	2,0	4,0	3,0	50,0	10,0	1,94	0,15	2	4,14	10,47	10,83	11,18	11,55	11,95	12,83	■
JME542025G3R015.0Z2-SIRA	03171108	3	G	2,5	4,0	3,8	50,0	12,5	2,4	0,15	2	2,79	12,97	13,41	13,84	14,3	14,79	–	■
JME542030G3R015.0Z2-SIRA	03171134	3	G	3,0	4,0	4,5	60,0	15,0	2,85	0,15	2	1,67	15,68	16,17	16,69	17,24	–	–	■
JME542005G4R005.0Z2-SIRA	03171109	4	G	0,5	4,0	0,8	45,0	4,0	0,46	0,05	2	9,49	4,32	4,54	4,7	4,86	5,03	5,4	■
JME542006G4R005.0Z2-SIRA	03171110	4	G	0,6	4,0	0,9	45,0	5,0	0,56	0,05	2	8,56	5,32	5,58	5,77	5,96	6,17	6,62	■
JME542008G4R005.0Z2-SIRA	03171135	4	G	0,8	4,0	1,2	45,0	7,0	0,76	0,05	2	7,05	7,32	7,65	7,9	8,16	8,44	9,07	■
JME542010G4R010.0Z2-SIRA	03171111	4	G	1,0	4,0	1,5	50,0	8,5	0,95	0,1	2	6,1	8,82	9,2	9,49	9,81	10,15	10,9	■
JME542012G4R010.0Z2-SIRA	03171112	4	G	1,2	4,0	1,8	50,0	10,0	1,15	0,1	2	5,27	10,32	10,75	11,09	11,46	11,85	12,73	■
JME542015G4R015.0Z2-SIRA	03171136	4	G	1,5	4,0	2,3	50,0	12,0	1,45	0,15	2	4,29	12,47	12,9	13,31	13,75	14,22	15,27	■
JME542020G4R015.0Z2-SIRA	03171113	4	G	2,0	4,0	3,0	60,0	16,0	1,94	0,15	2	2,9	16,47	17,02	17,57	18,15	18,78	–	■
JME542025G4R015.0Z2-SIRA	03171114	4	G	2,5	4,0	3,8	60,0	20,0	2,4	0,15	2	1,88	20,47	21,15	21,83	22,55	–	–	■
JME542030G4R015.0Z2-SIRA	03171137	4	G	3,0	4,0	4,5	70,0	24,0	2,85	0,15	2	1,1	24,68	25,45	26,27	–	–	–	■
JME542015G5R015.0Z2-SIRA	03171115	5	G	1,5	4,0	2,3	60,0	15,0	1,45	0,15	2	3,64	15,47	15,99	16,5	17,05	17,64	18,95	■
JME542020G5R015.0Z2-SIRA	03171116	5	G	2,0	4,0	3,0	60,0	20,0	1,94	0,15	2	2,41	20,47	21,15	21,83	22,55	23,33	–	■
JME542025G5R015.0Z2-SIRA	03171138	5	G	2,5	4,0	3,8	70,0	25,0	2,4	0,15	2	1,54	25,47	26,3	27,15	28,06	–	–	■
JME542030G5R015.0Z2-SIRA	03171117	5	G	3,0	4,0	4,5	70,0	30,0	2,85	0,15	2	0,9	30,68	31,64	–	–	–	–	■
JME542015G6R015.0Z2-SIRA	03171118	6	G	1,5	4,0	2,3	70,0	22,5	1,45	0,15	2	2,64	22,97	23,73	24,49	25,29	26,18	–	■
JME542020G6R015.0Z2-SIRA	03171139	6	G	2,0	4,0	3,0	70,0	30,0	1,94	0,15	2	1,7	30,47	31,46	32,48	33,56	–	–	■
JME542025G6R015.0Z2-SIRA	03171119	6	G	2,5	4,0	3,8	80,0	37,5	2,4	0,15	2	1,07	37,97	39,2	40,46	–	–	–	■
JME542030G6R015.0Z2-SIRA	03171120	6	G	3,0	4,0	4,5	90,0	45,0	2,85	0,15	2	0,61	45,68	47,11	–	–	–	–	■

■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf a_{η} (la_{η}, ref)*

Schnittdaten – JME542 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	415 (370 — 460) *1350 (1300–1500)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	405 (360 — 440) *1325 (1200–1400)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (310 — 380) *1150 (1100–1200)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 340) *1000 (920–1100)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860–1000)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990–1100)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920–1100)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860–1000)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890–1000)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160–190) *570 (530 — 620)*
M1	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (110–150) *445 (370 — 490)*
M5	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (92–130) *360 (310 — 420)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	380 (340 — 420) *1250 (1200–1300)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	510 (440 — 580) *1675 (1500–1900)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860–1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 200) *570 (530 — 650)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960–1100)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 330) *970 (890–1000)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	195 (170 — 210) *640 (560 — 680)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200–1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JME542 Nutfräsen

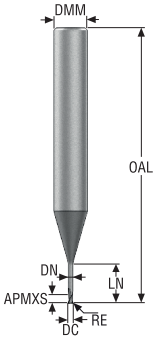
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660–750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600–720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.022 *0,00085*	0.026 *0,0010*	0.028 *0,0011*	110 (98–120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120–160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91–130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91–130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N2	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N3	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	350 (300 — 400) *1150 (990–1300)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120–150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	110 (93–120) *360 (310 — 390)*
H3	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H7	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600–750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	120 (110–130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 400) *1150 (990–1300)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JME562

Mini – Universal – Eckfräser – 2 Schneiden – DMM 6 – Zylindrisch – Eckenradius



G





- Toleranzen:
- Rundlaufabweichung = <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME562005G2R005.0Z2-SIRA	03171145	2	G	0,5	6,0	0,8	50,0	1,5	0,46	0,05	2	13,48	1,82	1,93	2,02	2,1	2,18	2,34	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0	0,9	50,0	2,0	0,56	0,05	2	12,9	2,32	2,45	2,56	2,66	2,75	2,95	■
JME562008G2R005.0Z2-SIRA	03171147	2	G	0,8	6,0	1,2	50,0	2,5	0,76	0,05	2	12,28	2,82	2,98	3,1	3,21	3,32	3,56	■
JME562010G2R010.0Z2-SIRA	03171148	2	G	1,0	6,0	1,5	50,0	4,0	0,95	0,1	2	10,85	4,32	4,54	4,7	4,86	5,02	5,39	■
JME562012G2R010.0Z2-SIRA	03171150	2	G	1,2	6,0	1,8	50,0	4,5	1,15	0,1	2	10,31	4,82	5,06	5,23	5,41	5,59	6,0	■
JME562015G2R015.0Z2-SIRA	03171151	2	G	1,5	6,0	2,3	50,0	5,0	1,45	0,15	2	9,67	5,47	5,68	5,86	6,05	6,25	6,71	■
JME562018G2R015.0Z2-SIRA	03171152	2	G	1,8	6,0	2,7	50,0	5,4	1,75	0,15	2	9,12	5,87	6,09	6,28	6,49	6,71	7,2	■
JME562020G2R015.0Z2-SIRA	03171153	2	G	2,0	6,0	3,0	50,0	6,0	1,94	0,15	2	8,53	6,47	6,71	6,92	7,15	7,39	7,93	■
JME562025G2R015.0Z2-SIRA	03171154	2	G	2,5	6,0	3,8	60,0	7,5	2,4	0,15	2	7,15	7,97	8,26	8,52	8,8	9,1	9,77	■
JME562030G2R015.0Z2-SIRA	03171155	2	G	3,0	6,0	4,5	60,0	9,0	2,85	0,15	2	5,81	9,68	9,98	10,3	10,64	11,01	11,82	■
JME562005G4R005.0Z2-SIRA	03171156	4	G	0,5	6,0	0,8	50,0	3,5	0,46	0,05	2	11,54	3,82	4,02	4,17	4,31	4,46	4,79	■
JME562006G4R005.0Z2-SIRA	03171157	4	G	0,6	6,0	0,9	50,0	4,2	0,56	0,05	2	10,93	4,52	4,75	4,92	5,08	5,26	5,64	■
JME562008G4R005.0Z2-SIRA	03171158	4	G	0,8	6,0	1,2	50,0	5,6	0,76	0,05	2	9,81	5,92	6,2	6,41	6,62	6,85	7,36	■
JME562010G4R010.0Z2-SIRA	03171159	4	G	1,0	6,0	1,5	50,0	7,0	0,95	0,1	2	8,86	7,32	7,65	7,9	8,16	8,44	9,06	■
JME562012G4R010.0Z2-SIRA	03171160	4	G	1,2	6,0	1,8	50,0	8,4	1,15	0,1	2	8,0	8,72	9,1	9,39	9,7	10,03	10,77	■
JME562015G4R015.0Z2-SIRA	03171162	4	G	1,5	6,0	2,3	50,0	10,5	1,45	0,15	2	6,86	10,97	11,35	11,71	12,1	12,52	13,44	■
JME562020G4R015.0Z2-SIRA	03171163	4	G	2,0	6,0	3,0	60,0	14,0	1,94	0,15	2	5,36	14,47	14,96	15,44	15,95	16,5	17,72	■
JME562025G4R015.0Z2-SIRA	03171164	4	G	2,5	6,0	3,8	65,0	17,5	2,4	0,15	2	4,18	17,97	18,57	19,17	19,8	20,49	22,0	■
JME562030G4R015.0Z2-SIRA	03171165	4	G	3,0	6,0	4,5	70,0	21,0	2,85	0,15	2	3,22	21,68	22,36	23,08	23,85	24,67	26,5	■
JME562005G5R005.0Z2-SIRA	03171166	5	G	0,5	6,0	0,8	50,0	5,0	0,46	0,05	2	10,42	5,32	5,58	5,77	5,96	6,17	6,62	■
JME562006G5R005.0Z2-SIRA	03171167	5	G	0,6	6,0	0,9	50,0	6,0	0,56	0,05	2	9,71	6,32	6,62	6,83	7,06	7,31	7,85	■
JME562008G5R005.0Z2-SIRA	03171168	5	G	0,8	6,0	1,2	50,0	8,0	0,76	0,05	2	8,48	8,32	8,68	8,96	9,26	9,58	10,29	■
JME562010G5R010.0Z2-SIRA	03171169	5	G	1,0	6,0	1,5	50,0	10,0	0,95	0,1	2	7,48	10,32	10,75	11,09	11,46	11,85	12,73	■
JME562012G5R010.0Z2-SIRA	03171170	5	G	1,2	6,0	1,8	50,0	12,0	1,15	0,1	2	6,62	12,32	12,81	13,22	13,66	14,13	15,18	■
JME562015G5R015.0Z2-SIRA	03171171	5	G	1,5	6,0	2,3	60,0	15,0	1,45	0,15	2	5,54	15,47	15,99	16,5	17,05	17,64	18,95	■
JME562020G5R015.0Z2-SIRA	03171172	5	G	2,0	6,0	3,0	60,0	20,0	1,94	0,15	2	4,19	20,47	21,15	21,83	22,55	23,33	25,06	■
JME562025G5R015.0Z2-SIRA	03171173	5	G	2,5	6,0	3,8	70,0	25,0	2,4	0,15	2	3,19	25,47	26,3	27,15	28,06	29,03	31,18	■
JME562030G5R015.0Z2-SIRA	03171174	5	G	3,0	6,0	4,5	70,0	30,0	2,85	0,15	2	2,41	30,68	31,64	32,66	33,75	34,92	–	■

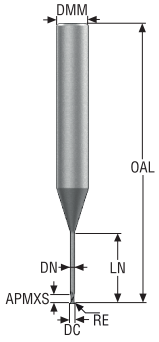
■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

JME562

Mini – Universal – Eckfräser – 2 Schneiden – DMM 6 – Zylindrisch – Eckenradius





G

- Toleranzen:
- Rundlaufabweichung = <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME562010G6R010.0Z2-SIRA	03171175	6	G	1,0	6,0	1,5	60,0	15,0	0,95	0,1	2	5,94	15,32	15,9	16,41	16,96	17,55	18,85	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	2	5,14	18,32	19,0	19,61	20,26	20,96	22,52	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	2	4,2	22,97	23,73	24,49	25,31	26,18	28,12	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	2	3,07	30,47	31,46	32,48	33,56	34,72	37,3	■
JME562025G6R015.0Z2-SIRA	03171179	6	G	2,5	6,0	3,8	80,0	37,5	2,4	0,15	2	2,28	37,97	39,2	40,46	41,81	43,26	–	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	2	1,7	45,68	47,11	48,63	50,26	–	–	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	2	4,93	20,32	21,06	21,74	22,46	23,24	24,97	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	2	4,2	24,32	25,18	26,0	26,87	27,79	29,86	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	2	3,38	30,47	31,46	32,48	33,56	34,72	37,3	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2	2,42	40,47	41,78	43,12	44,56	46,11	–	■
JME562025G7R015.0Z2-SIRA	03171185	7	G	2,5	6,0	3,8	90,0	50,0	2,4	0,15	2	1,78	50,47	52,09	53,77	55,57	–	–	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	2	1,31	60,68	62,58	64,61	–	–	–	■

■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JME562 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	415 (370 — 460) *1350 (1300–1500)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	405 (360 — 440) *1325 (1200–1400)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (310 — 380) *1150 (1100–1200)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 340) *1000 (920–1100)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860–1000)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990–1100)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920–1100)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860–1000)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890–1000)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160–190) *570 (530 — 620)*
M1	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (110–150) *445 (370 — 490)*
M5	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (92–130) *360 (310 — 420)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	380 (340 — 420) *1250 (1200–1300)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	510 (440 — 580) *1675 (1500–1900)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860–1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 200) *570 (530 — 650)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960–1100)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 330) *970 (890–1000)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	195 (170 — 210) *640 (560 — 680)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200–1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JME562 Nutfräsen

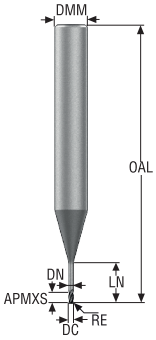
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660–750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600–720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.022 *0,00085*	0.026 *0,0010*	0.028 *0,0011*	110 (98–120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120–160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91–130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91–130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N2	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N3	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	350 (300 — 400) *1150 (990–1300)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120–150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	110 (93–120) *360 (310 — 390)*
H3	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H7	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600–750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	120 (110–130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 400) *1150 (990–1300)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JME564

Mini – Universal – Eckfräser – 4 Schneiden – DMM 6 – Zylindrisch – Eckenradius



G





- Toleranzen:
- Rundlaufabweichung = <0-0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME564005G2R005.0Z4-SIRA	03227166	2	G	0,5	6,0	1,0	50,0	1,5	0,46	0,05	4	13,48	1,82	1,93	2,02	2,1	2,18	2,34	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	4	12,9	2,32	2,45	2,56	2,66	2,75	2,95	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	4	12,28	2,82	2,98	3,1	3,21	3,32	3,56	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	4	10,85	4,32	4,54	4,7	4,86	5,02	5,39	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	4	10,31	4,82	5,06	5,23	5,41	5,59	6,0	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	4	9,67	5,47	5,68	5,86	6,05	6,25	6,71	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	4	8,53	6,47	6,71	6,92	7,15	7,39	7,93	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	4	7,15	7,97	8,26	8,52	8,8	9,1	9,77	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	4	5,81	9,68	9,98	10,3	10,64	11,01	11,82	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	4	11,54	3,82	4,02	4,17	4,32	4,46	4,79	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	4	10,93	4,52	4,75	4,92	5,08	5,26	5,64	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	4	9,81	5,92	6,2	6,41	6,62	6,85	7,36	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	4	8,86	7,32	7,65	7,9	8,16	8,44	9,06	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	4	8,0	8,72	9,1	9,39	9,7	10,03	10,77	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	4	6,86	10,97	11,35	11,71	12,1	12,52	13,44	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	4	5,36	14,47	14,96	15,44	15,95	16,5	17,72	■
JME564025G4R015.0Z4-SIRA	03171208	4	G	2,5	6,0	5,0	60,0	17,5	2,4	0,15	4	4,18	17,97	18,57	19,17	19,8	20,49	22,0	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	4	3,22	21,68	22,36	23,08	23,85	24,67	26,5	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JME564 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z									v_c
				0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (360 — 430) *1300 (1200–1400)*
P2	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200–1300)*
P3	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990–1100)*
P4	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860–1000)*
P5	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P6	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920–1100)*
P7	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 320) *970 (890–1000)*
P8	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P11	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (260 — 310) *940 (860–1000)*
P12	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (160–180) *560 (530 — 590)*
M1	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (200 — 280) *770 (660 — 910)*
M2	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530–720)*
M3	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530–720)*
M4	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	145 (120–160) *475 (400 — 520)*
M5	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (99–140) *395 (330 — 450)*
N1	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 410) *1200 (1100–1300)*
N11	E/M/A	0.100 *0,100*	0.90 *0,90*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	490 (430 — 560) *1600 (1500–1800)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (250 — 320) *940 (830–1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 250) *720 (630 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (150–190) *560 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95–150) *410 (320 — 490)*
H5	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	240 (210 — 260) *790 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95–150) *410 (320 — 490)*
H8	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (270 — 340) *1000 (890–1100)*
H12	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	275 (250 — 310) *900 (830–1000)*
H21	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.048 *0,0019*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.65 *0,50*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	390 (340 — 440) *1300 (1200–1400)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JME564 Nutfräsen

SMG		a_p/DC	f_z									v_c
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P2	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	245 (220 — 270) *800 (730 — 880)*
P3	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	210 (190 — 230) *690 (630–750)*
P4	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P5	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160–190) *570 (530 — 620)*
P6	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600–720)*
P7	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P8	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160–190) *570 (530 — 620)*
P11	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P12	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.026 *0,0010*	0.030 *0,0012*	105 (96–110) *345 (320 — 360)*
M1	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (110–150) *445 (370 — 490)*
M2	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89–120) *360 (300 — 390)*
M3	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89–120) *360 (300 — 390)*
M4	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (67 — 95) *260 (220 — 310)*
M5	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (56–79) *215 (190 — 250)*
N1	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200–1400)*
N2	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200–1400)*
N3	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	260 (230 — 290) *850 (760 — 950)*
N11	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	345 (300 — 390) *1125 (990–1200)*
S11	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120–150) *445 (400 — 490)*
S13	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	105 (92–120) *345 (310 — 390)*
H3	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H5	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (140–170) *520 (460 — 550)*
H7	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H8	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140–170) *520 (460 — 550)*
H11	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600–720)*
H12	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	185 (170 — 200) *610 (560 — 650)*
H21	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140–170) *520 (460 — 550)*
H31	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	120 (110–130) *395 (370 — 420)*
GR1	A	0.20 *0,20*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.024 *0,00095*	0.026 *0,0010*	325 (280 — 370) *1075 (920–1200)*

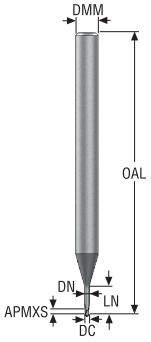
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JMB542

Mini – Universal – Kugelkopf – 2 Schneiden – DMM 4 – Zylindrisch





G

- Toleranzen:
- Rundlaufabweichung =<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB542002G1B.0Z2-SIRA	03171221	1	G	0,2	4,0	0,2	45,0	0,4	0,18	0,1	2	14,57	0,56	0,62	0,67	0,73	0,78	0,88	■
JMB542003G1B.0Z2-SIRA	03171222	1	G	0,3	4,0	0,3	45,0	0,6	0,28	0,15	2	14,24	0,76	0,83	0,9	0,96	1,02	1,13	■
JMB542004G1B.0Z2-SIRA	03171223	1	G	0,4	4,0	0,4	45,0	0,8	0,37	0,2	2	13,81	1,12	1,18	1,24	1,29	1,35	1,45	■
JMB542005G1B.0Z2-SIRA	03171224	1	G	0,5	4,0	0,5	45,0	1,0	0,46	0,25	2	13,47	1,32	1,39	1,45	1,51	1,57	1,68	■
JMB542006G1B.0Z2-SIRA	03171225	1	G	0,6	4,0	0,6	45,0	1,2	0,56	0,3	2	13,14	1,52	1,59	1,67	1,73	1,8	1,92	■
JMB542008G1B.0Z2-SIRA	03171226	1	G	0,8	4,0	0,8	45,0	1,6	0,76	0,4	2	12,46	1,92	2,01	2,1	2,17	2,25	2,39	■
JMB542010G1B.0Z2-SIRA	03171228	1	G	1,0	4,0	1,0	50,0	2,0	0,95	0,5	2	11,77	2,23	2,43	2,52	2,61	2,69	2,85	■
JMB542012G1B.0Z2-SIRA	03171229	1	G	1,2	4,0	1,2	50,0	2,4	1,15	0,6	2	11,07	2,72	2,84	2,95	3,04	3,13	3,32	■
JMB542015G1B.0Z2-SIRA	03171230	1	G	1,5	4,0	1,5	50,0	3,0	1,45	0,75	2	9,88	3,47	3,59	3,69	3,79	3,89	4,13	■
JMB542005G3B.0Z2-SIRA	03171231	3	G	0,5	4,0	0,5	45,0	2,5	0,46	0,25	2	11,25	2,82	2,97	3,09	3,19	3,29	3,52	■
JMB542006G3B.0Z2-SIRA	03171233	3	G	0,6	4,0	0,6	45,0	3,0	0,56	0,3	2	10,61	3,32	3,49	3,62	3,74	3,86	4,12	■
JMB542008G3B.0Z2-SIRA	03171234	3	G	0,8	4,0	0,8	45,0	4,0	0,76	0,4	2	9,44	4,32	4,53	4,68	4,83	4,98	5,32	■
JMB542010G3B.0Z2-SIRA	03171235	3	G	1,0	4,0	1,0	50,0	5,0	0,95	0,5	2	8,38	5,32	5,56	5,74	5,92	6,11	6,53	■
JMB542012G3B.0Z2-SIRA	03171236	3	G	1,2	4,0	1,2	50,0	6,0	1,15	0,6	2	7,44	6,32	6,6	6,8	7,01	7,23	7,73	■
JMB542015G3B.0Z2-SIRA	03171237	3	G	1,5	4,0	1,5	50,0	7,5	1,45	0,75	2	6,13	7,97	8,24	8,48	8,74	9,02	9,64	■
JMB542020G3B.0Z2-SIRA	03171238	3	G	2,0	4,0	2,0	50,0	10,0	1,94	1,0	2	4,4	10,47	10,81	11,13	11,47	11,83	12,64	■
JMB542025G3B.0Z2-SIRA	03171239	3	G	2,5	4,0	2,5	50,0	12,5	2,4	1,25	2	3,0	12,97	13,38	13,77	14,19	14,64	–	■
JMB542030G3B.0Z2-SIRA	03171240	3	G	3,0	4,0	3,0	60,0	15,0	2,85	1,5	2	1,81	15,68	16,13	16,6	17,11	–	–	■
JMB542005G4B.0Z2-SIRA	03171241	4	G	0,5	4,0	0,5	45,0	4,0	0,46	0,25	2	9,65	4,32	4,53	4,69	4,84	5,0	5,36	■
JMB542006G4B.0Z2-SIRA	03171242	4	G	0,6	4,0	0,6	45,0	5,0	0,56	0,3	2	8,74	5,32	5,57	5,75	5,94	6,13	6,57	■
JMB542008G4B.0Z2-SIRA	03171243	4	G	0,8	4,0	0,8	45,0	7,0	0,76	0,4	2	7,23	7,32	7,64	7,88	8,13	8,4	8,99	■
JMB542010G4B.0Z2-SIRA	03171244	4	G	1,0	4,0	1,0	50,0	8,5	0,95	0,5	2	6,27	8,82	9,19	9,47	9,77	10,09	10,81	■
JMB542012G4B.0Z2-SIRA	03171245	4	G	1,2	4,0	1,2	50,0	10,0	1,15	0,6	2	5,44	10,32	10,73	11,06	11,41	11,79	12,62	■
JMB542015G4B.0Z2-SIRA	03171246	4	G	1,5	4,0	1,5	50,0	12,0	1,45	0,75	2	4,44	12,47	12,88	13,27	13,69	14,14	15,14	■
JMB542020G4B.0Z2-SIRA	03171247	4	G	2,0	4,0	2,0	60,0	16,0	1,94	1,0	2	3,02	16,47	17,0	17,51	18,07	18,66	19,98	■
JMB542025G4B.0Z2-SIRA	03171248	4	G	2,5	4,0	2,5	60,0	20,0	2,4	1,25	2	1,97	20,47	21,11	21,76	22,45	–	–	■
JMB542030G4B.0Z2-SIRA	03171249	4	G	3,0	4,0	3,0	70,0	24,0	2,85	1,5	2	1,16	24,68	25,41	26,19	–	–	–	■
JMB542015G5B.0Z2-SIRA	03171250	5	G	1,5	4,0	1,5	60,0	15,0	1,45	0,75	2	3,75	15,47	15,97	16,47	16,99	17,56	18,81	■
JMB542020G5B.0Z2-SIRA	03171251	5	G	2,0	4,0	2,0	60,0	20,0	1,94	1,0	2	2,5	20,47	21,12	21,77	22,47	23,22	–	■
JMB542025G5B.0Z2-SIRA	03171252	5	G	2,5	4,0	2,5	70,0	25,0	2,4	1,25	2	1,61	25,47	26,27	27,08	27,95	–	–	■
JMB542030G5B.0Z2-SIRA	03171253	5	G	3,0	4,0	3,0	70,0	30,0	2,85	1,5	2	0,93	30,68	31,6	–	–	–	–	■
JMB542015G6B.0Z2-SIRA	03171254	6	G	1,5	4,0	1,5	70,0	22,5	1,45	0,75	2	2,7	22,97	23,71	24,45	25,25	26,1	–	■
JMB542020G6B.0Z2-SIRA	03171255	6	G	2,0	4,0	2,0	70,0	30,0	1,94	1,0	2	1,74	30,47	31,43	32,42	33,48	–	–	■
JMB542025G6B.0Z2-SIRA	03171256	6	G	2,5	4,0	2,5	80,0	37,5	2,4	1,25	2	1,1	37,97	39,16	40,39	–	–	–	■
JMB542030G6B.0Z2-SIRA	03171257	6	G	3,0	4,0	3,0	90,0	45,0	2,85	1,5	2	0,63	45,68	47,07	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf a_{η} (la_{η}, ref)*

Schnittdaten – JMB542 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100–1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100–1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920–1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860–1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140–170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110–150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90–120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500–1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500–1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960–1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300–1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830–1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150–190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890–1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200–1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JMB542 Nutfräsen

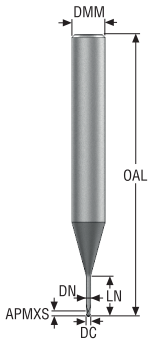
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660–750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600–720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (98–120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120–160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90–130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90–130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N2	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N3	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (300 — 390) *1150 (990–1200)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120–150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	105 (93–120) *345 (310 — 390)*
H3	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H7	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600–750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	120 (110–130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 390) *1150 (990–1200)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

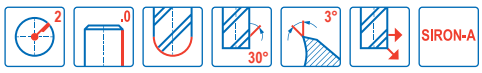
JMB562

Mini – Universal – Kugelkopf – 2 Schneiden – DMM6 – Zylindrisch



G





- Toleranzen:
- Rundlaufabweichung =<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB562005G2B.0Z2-SIRA	03171261	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	2	13,69	1,82	1,91	2,0	2,08	2,15	2,3	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	2	13,13	2,32	2,44	2,54	2,63	2,72	2,9	■
JMB562008G2B.0Z2-SIRA	03171263	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	2	12,6	2,82	2,96	3,07	3,18	3,27	3,49	■
JMB562010G2B.0Z2-SIRA	03171264	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	2	11,15	4,32	4,52	4,68	4,68	4,97	5,3	■
JMB562012G2B.0Z2-SIRA	03171265	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	2	10,67	4,82	5,04	5,2	5,36	5,52	5,89	■
JMB562015G2B.0Z2-SIRA	03171266	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	2	10,07	5,47	5,66	5,82	5,99	6,17	6,58	■
JMB562018G2B.0Z2-SIRA	03171267	2	G	1,8	6,0	1,8	50,0	5,4	1,75	0,9	2	9,61	5,87	6,07	6,23	6,41	6,61	7,03	■
JMB562020G2B.0Z2-SIRA	03171268	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	2	9,05	6,47	6,68	6,87	7,06	7,28	7,75	■
JMB562025G2B.0Z2-SIRA	03171269	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	2	7,71	7,97	8,22	8,45	8,69	8,95	9,53	■
JMB562030G2B.0Z2-SIRA	03171270	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	2	6,35	9,68	9,94	10,21	10,51	10,82	11,52	■
JMB562005G4B.0Z2-SIRA	03171271	4	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	2	11,7	3,82	4,01	4,16	4,29	4,43	4,74	■
JMB562006G4B.0Z2-SIRA	03171272	4	G	0,6	6,0	0,6	50,0	4,2	0,56	0,3	2	11,1	4,52	4,74	4,9	5,06	5,22	5,59	■
JMB562008G4B.0Z2-SIRA	03171273	4	G	0,8	6,0	0,8	50,0	5,6	0,76	0,4	2	10,02	5,92	6,19	6,39	6,59	6,8	7,28	■
JMB562010G4B.0Z2-SIRA	03171274	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	2	9,06	7,32	7,64	7,87	8,12	8,38	8,97	■
JMB562012G4B.0Z2-SIRA	03171275	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	2	8,22	8,72	9,08	9,35	9,65	9,96	10,66	■
JMB562015G4B.0Z2-SIRA	03171276	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	2	7,07	10,97	11,33	11,67	12,04	12,43	13,31	■
JMB562020G4B.0Z2-SIRA	03171277	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	2	5,57	14,47	14,93	15,38	15,87	16,38	17,54	■
JMB562025G4B.0Z2-SIRA	03171278	4	G	2,5	6,0	2,5	65,0	17,5	2,4	1,25	2	4,38	17,97	18,53	19,1	19,69	20,34	21,76	■
JMB562030G4B.0Z2-SIRA	03171279	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	2	3,38	21,68	22,32	22,99	23,71	24,49	26,21	■
JMB562005G5B.0Z2-SIRA	03171280	5	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	2	10,54	5,32	5,57	5,76	5,94	6,14	6,58	■
JMB562006G5B.0Z2-SIRA	03171281	5	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	2	9,85	6,32	6,61	6,82	7,04	7,27	7,79	■
JMB562008G5B.0Z2-SIRA	03171282	5	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	2	8,64	8,32	8,67	8,94	9,23	9,54	10,22	■
JMB562010G5B.0Z2-SIRA	03171283	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	2	7,63	10,32	10,73	11,06	11,42	11,8	12,64	■
JMB562012G5B.0Z2-SIRA	03171284	5	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	2	6,77	12,32	12,79	13,19	13,61	14,06	15,07	■
JMB562015G5B.0Z2-SIRA	03171285	5	G	1,5	6,0	1,5	60,0	15,0	1,45	0,75	2	5,68	15,47	15,97	16,47	16,99	17,56	18,81	■
JMB562020G5B.0Z2-SIRA	03171287	5	G	2,0	6,0	2,0	60,0	20,0	1,94	1,0	2	4,32	20,47	21,12	21,77	22,47	23,22	24,88	■
JMB562025G5B.0Z2-SIRA	03171288	5	G	2,5	6,0	2,5	70,0	25,0	2,4	1,25	2	3,3	25,47	26,27	27,08	27,95	28,88	30,94	■
JMB562030G5B.0Z2-SIRA	03171289	5	G	3,0	6,0	3,0	70,0	30,0	2,85	1,5	2	2,5	30,68	31,6	32,58	33,62	34,73	–	■

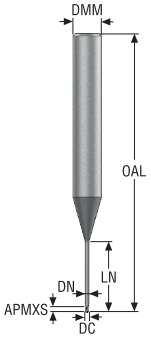
■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

JMB562

Mini – Universal – Kugelkopf – 2 Schneiden – DMM 6 – Zylindrisch





G

- Toleranzen:
- Rundlaufabweichung =<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB562010G6B.0Z2-SIRA	03171290	6	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	2	6,04	15,32	15,89	16,39	16,92	17,49	18,76	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	2	5,24	18,32	18,98	19,58	20,21	20,89	22,41	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	2	4,28	22,97	23,71	24,45	25,25	26,1	27,99	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	2	3,14	30,47	31,43	32,42	33,48	34,6	37,11	■
JMB562025G6B.0Z2-SIRA	03171294	6	G	2,5	6,0	2,5	80,0	37,5	2,4	1,25	2	2,34	37,97	39,16	40,39	41,7	43,11	–	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	2	1,74	45,68	47,07	48,55	50,13	–	–	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	2	4,99	20,32	21,05	21,71	22,42	23,19	24,88	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	2	4,27	24,32	25,17	25,97	26,82	27,73	29,75	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	2	3,43	30,47	31,44	32,44	33,5	34,64	37,17	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2	2,47	40,47	41,75	43,07	44,48	45,99	–	■
JMB562025G7B.0Z2-SIRA	03171300	7	G	2,5	6,0	2,5	90,0	50,0	2,4	1,25	2	1,81	50,47	52,05	53,7	55,46	–	–	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	2	1,34	60,68	62,54	64,52	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JMB562 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100–1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100–1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920–1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860–1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140–170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110–150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90–120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500–1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500–1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960–1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300–1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830–1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150–190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90–140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890–1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200–1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JMB562 Nutfräsen

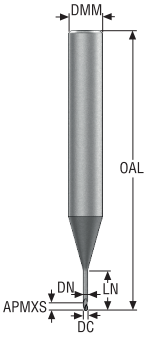
SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660–750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600–720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (98–120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120–160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90–130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90–130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N2	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200–1400)*
N3	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (300 — 390) *1150 (990–1200)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120–150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	105 (93–120) *345 (310 — 390)*
H3	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H7	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61–100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600–750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150–180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	120 (110–130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 390) *1150 (990–1200)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

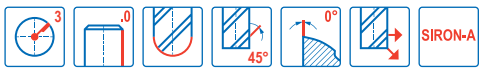
JMB563

Mini – Universal – Kugelkopf – 3 Schneiden – DMM 6 – Zylindrisch



G





- Toleranzen:
- Rundlaufabweichung =<0,007 mm
- DMM= h5
- DC= 0,-0,02 mm
- RE= ±0,01 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB563010G2B.0Z3-SIRA	03171307	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	3	11,15	4,32	4,52	4,68	4,68	4,97	5,3	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	3	10,67	4,82	5,04	5,2	5,36	5,52	5,89	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	3	10,07	5,47	5,66	5,82	5,99	6,17	6,58	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	3	9,05	6,47	6,68	6,87	7,06	7,28	7,75	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	3	7,71	7,97	8,22	8,45	8,69	8,95	9,53	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	3	6,35	9,68	9,94	10,21	10,51	10,83	11,52	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	3	9,06	7,32	7,64	7,87	8,12	8,38	8,97	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	3	8,22	8,72	9,08	9,35	9,65	9,96	10,66	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	3	7,07	10,97	11,33	11,67	12,04	12,43	13,31	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	3	5,57	14,47	14,93	15,38	15,87	16,38	17,54	■
JMB563025G4B.0Z3-SIRA	03171320	4	G	2,5	6,0	2,5	60,0	17,5	2,4	1,25	3	4,38	17,97	18,53	19,1	19,69	20,34	21,76	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3	3,38	21,68	22,32	22,99	23,71	24,49	26,21	■

■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf a_p (l_{ap}, ref)*

Schnittdaten – JMB563 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				1	1.2	1.5	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	460 (410 — 500) *1500 (1400–1600)*
P2	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	445 (400 — 490) *1450 (1400–1600)*
P3	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200–1300)*
P4	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 370) *1125 (1100–1200)*
P5	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960–1100)*
P6	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100–1300)*
P7	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 380) *1125 (1100–1200)*
P8	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960–1100)*
P11	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	230 (190 — 270) *750 (630 — 880)*
P12	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120–160) *445 (400 — 520)*
M1	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (230 — 320) *890 (760–1000)*
M2	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M3	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M4	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	165 (140–190) *540 (460 — 620)*
M5	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120–160) *445 (400 — 520)*
N1	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N2	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N3	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (350 — 440) *1300 (1200–1400)*
N11	E/M/A	0.100 *0,100*	0.65 *0,65*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	520 (450 — 590) *1700 (1500–1900)*
S11	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (300 — 390) *1125 (990–1200)*
S12	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (230 — 300) *870 (760 — 980)*
S13	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (180 — 230) *670 (600–750)*
H3	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120–190) *510 (400 — 620)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860–1000)*
H7	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120–190) *510 (400 — 620)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860–1000)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	375 (330 — 420) *1225 (1100–1300)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (310 — 380) *1125 (1100–1200)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860–1000)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	450 (390 — 510) *1475 (1300–1600)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.



STAHL UND GUSS

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Stahl und Guss besteht aus Schaft-, Kugelkopf- und Kreissegmentfräsern.

- JHP993, JHP951 und JH142 mit Fase oder Eckenradius
- JHB970, JH112, JH150, JH160 Kugelkopffräser

Werkzeugauswahl Stahl und Guss

					
Werkzeugbezeichnung		JHP993	JHP951	JH142	JHB970
Seite(n)		182	188	192, 368	134, 134, 195
Produktfamilie		HPM	HPM	HSM/TORNADO	HSM/TORNADO
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon	■	■		
Schneidenzahl		3,4,5	3,4,5	2-4-5-6	2
ICC					
	Metrisch	4-25	3-20	2-12	2-16
	Zoll				
Verfügbare Längen					
		2,3	2	2,3,6	1,2,3
Bearbeitung					
					
					
SMG					
P1		●	●	●	●
P2		●	●	●	●
P3		●	●	●	●
P4		●	●	●	●
P5		●	●	●	●
P6		●	●	●	●
P7		●	●	●	●
P8		●	●	●	●
P11-12		○	○	●	○
K1		●	●	●	
K2		●	●	●	
K3		●	●	●	
K4		●	●	●	
K5		●	●	●	
K6		●	●	●	
K7		●	●	●	

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Stahl und Guss

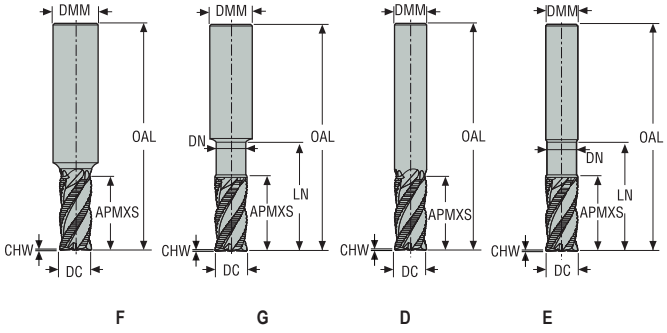
				
Werkzeugbezeichnung		JH112	JH150	JH160
Seite(n)		197, 371	374	376
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung				
Aufnahmen	Zylindrisch	■	■	■
	Weldon			
Schneidenzahl		2	4	4
ICC				
	Metrisch	2-12	6-12	3-12
	Zoll			
Verfügbare Längen				
		1,2,3,4,5,6	2	2
Bearbeitung				
				
SMG				
P1				●
P2				●
P3				●
P4				●
P5				●
P6				●
P7				●
P8				●
P11-12				○
K1		●	●	
K2		●	●	
K3		●	●	
K4		●	●	
K5		●	●	
K6		●	●	
K7		●	●	

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

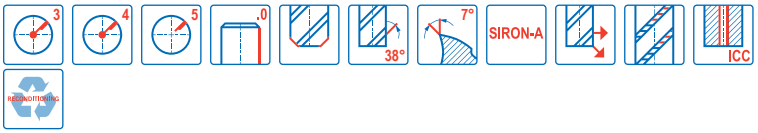
JHP993

Hochleistung – Stahl – Schaftfräser – 3-5 Schneiden – Zylindrisch – Eckenfase





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

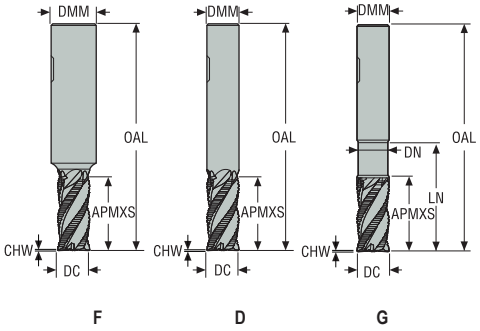


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.0Z3-SIRA	02826806	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.0Z4-SIRA	02826808	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.0Z4-SIRA	02826809	2	D	–	6,0	6,0	14,0	55,0	–	–	0,2	4	■
JHP993075F2C.0Z4-SIRA	02826811	2	F	–	7,5	8,0	17,0	60,0	20,0	7,5	0,2	4	■
JHP993080D2C.0Z4A-SIRA	02826814	2	D	■	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993080D2C.0Z4-SIRA	02826812	2	D	–	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993095F2C.0Z4-SIRA	02826816	2	F	–	9,5	10,0	20,0	70,0	23,0	9,5	0,2	4	■
JHP993100D2C.0Z4A-SIRA	02826818	2	D	■	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993100D2C.0Z4-SIRA	02826817	2	D	–	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993115F2C.0Z4-SIRA	02826820	2	F	–	11,5	12,0	25,0	80,0	28,0	11,5	0,2	4	■
JHP993120D2C.0Z4A-SIRA	02826822	2	D	■	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993120D2C.0Z4-SIRA	02826821	2	D	–	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993140D2C.0Z4-SIRA	02826824	2	D	–	14,0	14,0	30,0	80,0	–	–	0,3	4	■
JHP993160D2C.0Z4A-SIRA	02856501	2	D	■	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.0Z4-SIRA	02856499	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.0Z5-SIRA	02826825	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	5	■
JHP993200D2C.0Z4A-SIRA	02856506	2	D	■	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.0Z4-SIRA	02856505	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.0Z5-SIRA	02826828	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	5	■
JHP993250D2C.0Z4A-SIRA	02856510	2	D	■	25,0	25,0	52,0	125,0	–	–	0,5	4	■
JHP993040G3C.0Z3-SIRA	02826807	3	G	–	4,0	6,0	10,0	55,0	15,0	3,7	0,15	3	■
JHP993060E3C.0Z4-SIRA	02826810	3	E	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	■
JHP993080E3C.0Z4-SIRA	02826815	3	E	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	■
JHP993100E3C.0Z4-SIRA	02826819	3	E	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	■
JHP993120E3C.0Z4-SIRA	02826823	3	E	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	■
JHP993160E3C.0Z4-SIRA	02856502	3	E	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	■
JHP993200E3C.0Z4-SIRA	02856507	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	■

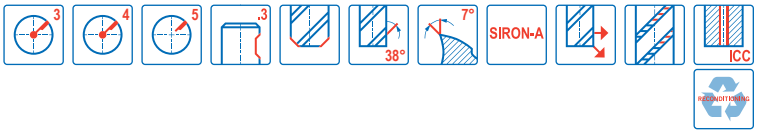
■ **Lagerstandard.**

JHP993

Hochleistung – Stahl – Schaftfräser – 3-5 Schneiden – Weldon – Eckenfase







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP993040F2C.3Z3-SIRA	02828150	2	F	–	4,0	6,0	10,0	50,0	12,56	4,0	0,15	3	■
JHP993050F2C.3Z4-SIRA	02828152	2	F	–	5,0	6,0	12,0	55,0	14,75	5,0	0,15	4	■
JHP993060D2C.3Z4-SIRA	02828153	2	D	–	6,0	6,0	14,0	55,0	–	–	0,2	4	■
JHP993075F2C.3Z4-SIRA	02828155	2	F	–	7,5	8,0	17,0	60,0	20,0	7,5	0,2	4	■
JHP993080D2C.3Z4A-SIRA	02828246	2	D	■	8,0	8,0	16,0	60,0	–	–	0,2	4	□
JHP993080D2C.3Z4-SIRA	02828156	2	D	–	8,0	8,0	18,0	60,0	–	–	0,2	4	■
JHP993095F2C.3Z4-SIRA	02828158	2	F	–	9,5	10,0	20,0	70,0	23,0	9,5	0,2	4	■
JHP993100D2C.3Z4A-SIRA	02828247	2	D	■	10,0	10,0	22,0	70,0	–	–	0,2	4	□
JHP993100D2C.3Z4-SIRA	02828159	2	D	–	10,0	10,0	22,0	70,0	–	–	0,2	4	■
JHP993120D2C.3Z4A-SIRA	02828248	2	D	■	12,0	12,0	26,0	80,0	–	–	0,2	4	□
JHP993120D2C.3Z4-SIRA	02828162	2	D	–	12,0	12,0	26,0	80,0	–	–	0,2	4	■
JHP993140D2C.3Z4-SIRA	02828164	2	D	–	14,0	14,0	30,0	80,0	–	–	0,3	4	■
JHP993160D2C.3Z4A-SIRA	02856512	2	D	■	16,0	16,0	34,0	90,0	–	–	0,3	4	□
JHP993160D2C.3Z4-SIRA	02856500	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	4	■
JHP993160D2C.3Z5-SIRA	02828165	2	D	–	16,0	16,0	34,0	90,0	–	–	0,3	5	■
JHP993200D2C.3Z4A-SIRA	02856513	2	D	■	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.3Z4-SIRA	02856504	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	4	■
JHP993200D2C.3Z5-SIRA	02828167	2	D	–	20,0	20,0	42,0	100,0	–	–	0,5	5	■
JHP993250D2C.3Z4A-SIRA	02856514	2	D	■	25,0	25,0	52,0	125,0	–	–	0,5	4	□
JHP993250D2C.3Z4-SIRA	02856509	2	D	–	25,0	25,0	52,0	125,0	–	–	0,5	4	■
JHP993060E3C.3Z4-SIRA	02828154	3	E	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	■
JHP993080E3C.3Z4-SIRA	02828157	3	E	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	■
JHP993100E3C.3Z4-SIRA	02828160	3	E	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	■
JHP993120E3C.3Z4-SIRA	02828163	3	E	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	■
JHP993160E3C.3Z4-SIRA	02856503	3	E	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	■
JHP993200E3C.3Z4-SIRA	02856508	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	■
JHP993200E3C.3Z5-SIRA	02828168	3	E	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	5	■
JHP993250E3C.3Z4-SIRA	02856511	3	E	–	25,0	25,0	52,0	150,0	90,0	24,0	0,5	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP993 Eckfräsen PCEDC=3 und PCEDC=4

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	195 (170 — 220) *640 (560–720)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	175 (150–190) *570 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	165 (150–190) *540 (500 — 620)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	160 (140–180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	170 (150–190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	110 (95–120) *360 (320 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600–720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	170 (150–190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	160 (140–180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	100 (86–110) *330 (290 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	145 (130–160) *475 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	125 (110–140) *410 (370 — 450)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JHP993 Eckfräsen PCEDC=5 und PCEDC=6

SMG		a_e/DC	a_p/DC	f_z		v_c
				16	20	
P1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.22 *0,0085*	205 (180 — 230) *670 (600–750)*
P2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560–720)*
P3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	170 (150–190) *560 (500 — 620)*
P4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140–170) *510 (460 — 550)*
P5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130–160) *475 (430 — 520)*
P6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	165 (150–180) *540 (500 — 590)*
P7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140–170) *510 (460 — 550)*
P8	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	145 (130–160) *475 (430 — 520)*
P11	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130–170) *490 (430 — 550)*
P12	E/M/A	0.376 *0,376*	1.0 *1,0*	0.11 *0,0044*	0.13 *0,0050*	100 (85–110) *330 (280 — 360)*
K1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560–720)*
K2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	175 (160 — 200) *570 (530 — 650)*
K3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130–170) *490 (430 — 550)*
K4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130–160) *475 (430 — 520)*
K5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	85 (75 — 99) *280 (250 — 320)*
K6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	125 (110–140) *410 (370 — 450)*
K7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	110 (96–120) *360 (320 — 390)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JHP993 Nutfräsen PCEDC=3 und PCEDC=4

SMG		a_p/DC	f_z										v_c
			4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	200 (180 — 220)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*660 (600–720)*
P2	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	195 (170 — 220)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*640 (560–720)*
P3	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	165 (150–190)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*540 (500 — 620)*
P4	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	145 (130–160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*475 (430 — 520)*
P5	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	140 (130–160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*460 (430 — 520)*
P6	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	155 (140–170)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*510 (460 — 550)*
P7	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	150 (130–160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*490 (430 — 520)*
P8	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	140 (130–160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*460 (430 — 520)*
P11	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	145 (130–160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*475 (430 — 520)*
P12	E/M/A	1.5	0.028	0.034	0.040	0.055	0.070	0.080	0.090	0.10	0.12	0.13	90 (76–100)
		1,5	*0,0011*	*0,0013*	*0,0016*	*0,0022*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0048*	*0,0050*	*295 (250 — 320)*
K1	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.20	195 (170 — 220)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0080*	*640 (560–720)*
K2	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	170 (150–190)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*560 (500 — 620)*
K3	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	145 (130–160)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*475 (430 — 520)*
K4	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	135 (120–150)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*445 (400 — 490)*
K5	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.15	0.17	80 (70 — 93)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*260 (230 — 300)*
K6	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.16	0.19	120 (110–130)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0065*	*0,0075*	*395 (370 — 420)*
K7	E/M/A	1.5	0.032	0.040	0.048	0.065	0.080	0.095	0.11	0.13	0.15	0.17	105 (90–110)
		1,5	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0038*	*0,0044*	*0,0050*	*0,0060*	*0,0065*	*345 (300 — 360)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JHP993 Nutfräsen PCEDC=5 und PCEDC=6

SMG		a_p/DC	f_z		v_c
			16	20	
P1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.20 *0,0080*	160 (140–180) *520 (460 — 590)*
P2	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	155 (140–170) *510 (460 — 550)*
P3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	135 (120–150) *445 (400 — 490)*
P4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	120 (110–130) *395 (370 — 420)*
P5	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (99–130) *375 (330 — 420)*
P6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	130 (120–140) *425 (400 — 450)*
P7	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110–130) *395 (370 — 420)*
P8	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	115 (99–130) *375 (330 — 420)*
P11	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110–130) *395 (370 — 420)*
P12	E/M/A	0.44 *0,44*	0.11 *0,0044*	0.13 *0,0050*	80 (68 — 89) *260 (230 — 290)*
K1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	160 (140–180) *520 (460 — 590)*
K2	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	140 (120–150) *460 (400 — 490)*
K3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110–130) *395 (370 — 420)*
K4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (97–120) *375 (320 — 390)*
K5	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	70 (60–79) *230 (200 — 250)*
K6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	100 (86–110) *330 (290 — 360)*
K7	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	90 (77–100) *295 (260 — 320)*

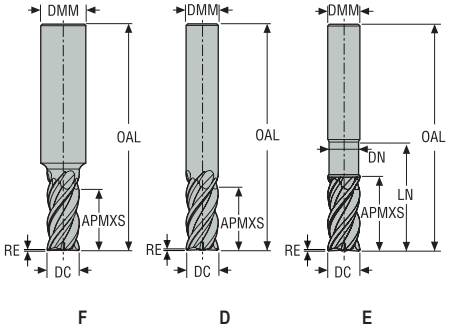
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHP951

Hochleistung – Schaftfräser – Stahl – 3-5 Schneiden – Zylindrisch – Eckenradius oder Fase





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

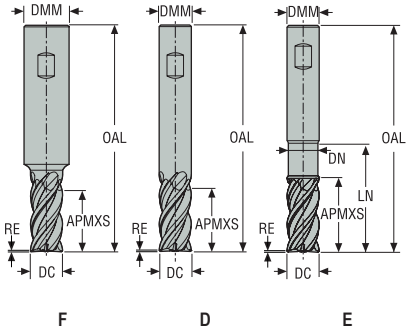


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
JHP951030F2C.0Z3-SIRA	02828192	2	F	3,0	6,0	8,0	50,0	10,25	3,0	0,1	–	3	■
JHP951030F2R020.0Z3-SIRA	02828191	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,2	3	■
JHP951030F2R050.0Z3-SIRA	02828190	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,5	3	■
JHP951040F2C.0Z4-SIRA	02828197	2	F	4,0	6,0	10,0	55,0	13,25	4,0	0,15	–	4	■
JHP951040F2R020.0Z4-SIRA	02828194	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,2	4	■
JHP951040F2R050.0Z4-SIRA	02828195	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,5	4	■
JHP951050F2C.0Z4-SIRA	02828201	2	F	5,0	6,0	12,0	55,0	15,25	5,0	0,2	–	4	■
JHP951050F2R020.0Z4-SIRA	02828199	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,2	4	■
JHP951050F2R050.0Z4-SIRA	02828198	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,5	4	■
JHP951060D2C.0Z4-SIRA	02828205	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	■
JHP951060D2R020.0Z4-SIRA	02828203	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	■
JHP951060D2R050.0Z4-SIRA	02828202	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	■
JHP951080D2C.0Z4-SIRA	02828212	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	■
JHP951080D2R020.0Z4-SIRA	02828209	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	■
JHP951080D2R050.0Z4-SIRA	02828207	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	■
JHP951080D2R100.0Z4-SIRA	02828208	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	■
JHP951100E2C.0Z4-SIRA	02828218	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	■
JHP951100E2R050.0Z4-SIRA	02828216	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	■
JHP951100E2R100.0Z4-SIRA	02828214	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	■
JHP951120E2C.0Z4-SIRA	02828226	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	■
JHP951120E2R050.0Z4-SIRA	02828224	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	■
JHP951120E2R100.0Z4-SIRA	02828222	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	■
JHP951160E2C.0Z4-SIRA	02927873	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	■
JHP951160E2C.0Z5-SIRA	02828232	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.0Z4-SIRA	02927875	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	■
JHP951160E2R050.0Z5-SIRA	02828230	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	■
JHP951160E2R100.0Z4-SIRA	02927876	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	■
JHP951160E2R100.0Z5-SIRA	02828231	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	■

■ **Lagerstandard.**

JHP951

Hochleistung – Schaftfräser – Stahl – 3-5 Schneiden – Weldon – Eckenradius oder Fase







- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JHP951030F2C.3Z3-SIRA	02828193	2	F	3,0	6,0	8,0	50,0	10,25	3,0	0,1	–	3	■
JHP951030F2R020.3Z3-SIRA	02828260	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,2	3	■
JHP951030F2R050.3Z3-SIRA	02828259	2	F	3,0	6,0	8,0	50,0	10,25	3,0	–	0,5	3	□
JHP951040F2C.3Z4-SIRA	02828196	2	F	4,0	6,0	10,0	55,0	13,25	4,0	0,15	–	4	■
JHP951040F2R020.3Z4-SIRA	02828261	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,2	4	□
JHP951040F2R050.3Z4-SIRA	02828262	2	F	4,0	6,0	10,0	55,0	13,25	4,0	–	0,5	4	□
JHP951050F2C.3Z4-SIRA	02828200	2	F	5,0	6,0	12,0	55,0	15,25	5,0	0,2	–	4	■
JHP951050F2R020.3Z4-SIRA	02828264	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,2	4	□
JHP951050F2R050.3Z4-SIRA	02828263	2	F	5,0	6,0	12,0	55,0	15,25	5,0	–	0,5	4	□
JHP951060D2C.3Z4-SIRA	02828206	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	■
JHP951060D2R020.3Z4-SIRA	02828266	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	□
JHP951060D2R050.3Z4-SIRA	02828265	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	□
JHP951080D2C.3Z4-SIRA	02828210	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	■
JHP951080D2R020.3Z4-SIRA	02828269	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	□
JHP951080D2R050.3Z4-SIRA	02828267	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	■
JHP951080D2R100.3Z4-SIRA	02828268	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	□
JHP951100E2C.3Z4-SIRA	02828220	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	■
JHP951100E2R050.3Z4-SIRA	02828271	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	□
JHP951100E2R100.3Z4-SIRA	02828270	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	□
JHP951120E2C.3Z4-SIRA	02828228	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	■
JHP951120E2R050.3Z4-SIRA	02828273	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	□
JHP951120E2R100.3Z4-SIRA	02828272	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	□
JHP951160E2C.3Z4-SIRA	02927874	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	■
JHP951160E2C.3Z5-SIRA	02828233	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	■
JHP951160E2R050.3Z4-SIRA	02927879	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	□
JHP951160E2R050.3Z5-SIRA	02828275	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	□
JHP951160E2R100.3Z4-SIRA	02927880	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	□
JHP951160E2R100.3Z5-SIRA	02828276	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	□
JHP951200E2R050.3Z4-SIRA	02927877	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	0,5	4	■
JHP951200E2R050.3Z5-SIRA	02828235	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	0,5	5	■
JHP951200E2R100.3Z4-SIRA	02927878	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	1,0	4	■
JHP951200E2R100.3Z5-SIRA	02828234	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	1,0	5	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP951 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z									v_c
				3	4	5	6	8	10	12	16	20	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	220 (200 — 250) *720 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	170 (150–190) *560 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150–180) *540 (500 — 590)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	175 (150–190) *570 (500 — 620)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140–180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150–190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	110 (94–120) *360 (310 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	200 (180 — 220) *660 (600–720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150–190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140–180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	100 (85–110) *330 (280 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	140 (130–160) *460 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	125 (110–140) *410 (370 — 450)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JHP951 Nutfräsen

SMG		a_p/DC	f_z									v_c
			3	4	5	6	8	10	12	16	20	
P1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*
P2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	165 (150–180) *540 (500 — 590)*
P4	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130–160) *475 (430 — 520)*
P5	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (120–150) *460 (400 — 490)*
P6	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	155 (140–170) *510 (460 — 550)*
P7	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130–160) *475 (430 — 520)*
P8	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (120–150) *460 (400 — 490)*
P11	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130–160) *475 (430 — 520)*
P12	E/M/A	1.5 *1,5*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	85 (75 — 99) *280 (250 — 320)*
K1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560–720)*
K2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	170 (150–190) *560 (500 — 620)*
K3	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (130–160) *460 (430 — 520)*
K4	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	135 (120–150) *445 (400 — 490)*
K5	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	80 (70 — 92) *260 (230 — 300)*
K6	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	120 (110–130) *395 (370 — 420)*
K7	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	105 (89–110) *345 (300 — 360)*

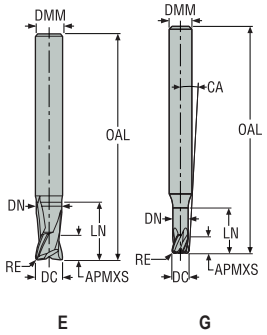
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

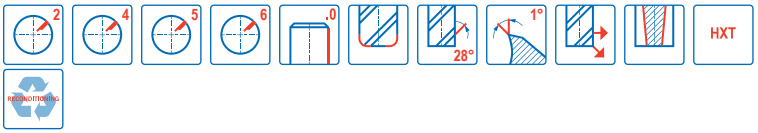
JH142

Hohe Geschwindigkeit – Hochpräzise – Torisch – Gehärteter Stahl – 2-6 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

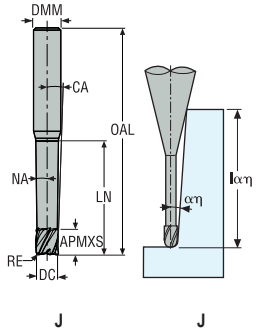


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	9,13	9,4	9,63	9,83	10,02	10,35	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	9,13	9,38	9,6	9,8	9,98	10,3	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	12,0	–	–	–	–	–	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	12,0	–	–	–	–	–	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	12,0	–	–	–	–	–	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	16,0	–	–	–	–	–	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	20,0	–	–	–	–	–	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	20,0	–	–	–	–	–	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	24,0	–	–	–	–	–	■

■ **Lagerstandard.** Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

JH142

Hohe Geschwindigkeit – Hochpräzise – Torisch – Gehärteter Stahl – 2-5 Spannuten – Zylindrisch – Eckenradius







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	2	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	13,87	20,76	21,48	22,16	22,9	–	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	13,87	20,76	21,48	22,16	22,9	–	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	19,15	30,8	31,82	32,83	–	–	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	19,15	30,78	31,78	32,78	–	–	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	27,67	41,12	42,44	–	–	–	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	27,67	41,11	42,41	–	–	–	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	27,67	41,09	42,38	–	–	–	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	27,67	41,08	42,35	–	–	–	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	29,67	50,97	52,62	–	–	–	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	29,67	50,95	52,59	–	–	–	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	29,67	50,91	52,53	–	–	–	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	5,23	11,4	21,0	21,71	22,45	24,11	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	5,23	11,14	20,99	21,69	22,43	24,06	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	9,57	20,92	31,32	32,35	33,46	–	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	9,57	20,3	31,29	32,31	33,39	–	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	13,87	30,85	41,65	–	–	–	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	13,87	30,6	41,65	–	–	–	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	13,87	29,98	41,6	–	–	–	■

■ **Lagerstandard.** Für WDX-Werte: Max. Schnitttiefe bezogen auf αη (lαη, ref)*

Schnittdaten – JH142 Eckfräsen/Schruppen

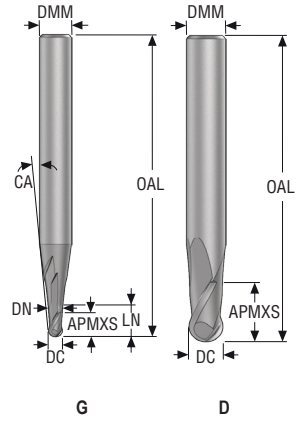
SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600–1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500–1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300–1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200–1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100–1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300–1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200–1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100–1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200–1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100–1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960–1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100–1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600–1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400–1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72–110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960–1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72–110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960–1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200–1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100–1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960–1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120–160) *460 (400 — 520)*

Schnittdaten, siehe Seite 457 - 464

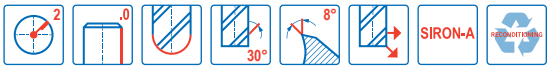
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHB970

Hohe Geschwindigkeit – Universal – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Sorte	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
					mm	mm	mm	mm	mm	mm									
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	2,5	2	10,0	11,0	11,5	12,1	12,8	–	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	–	2	–	–	–	–	–	–	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	–	2	–	–	–	–	–	–	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	–	2	–	–	–	–	–	–	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	–	2	–	–	–	–	–	–	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	7,5	2	5,0	5,7	6,0	6,2	6,5	7,3	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	4,5	2	7,0	8,8	9,4	10,0	10,7	12,8	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,0	2	10,0	13,6	15,0	16,8	–	–	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	–	2	–	–	–	–	–	–	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	–	2	–	–	–	–	–	–	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	–	2	–	–	–	–	–	–	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	–	2	–	–	–	–	–	–	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	8,0	2	4,0	4,7	4,9	5,1	5,4	6,0	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	5,5	2	6,0	7,4	7,8	8,3	9,0	10,6	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	3,0	2	8,0	10,8	11,9	13,3	15,2	–	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	2,5	2	12,0	15,8	17,4	19,4	22,2	–	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	–	2	–	–	–	–	–	–	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	–	2	–	–	–	–	–	–	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	–	2	–	–	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf a_p (l_{ap}, ref)*

Schnittdaten – JHB970 Eckfräsen/Schruppen

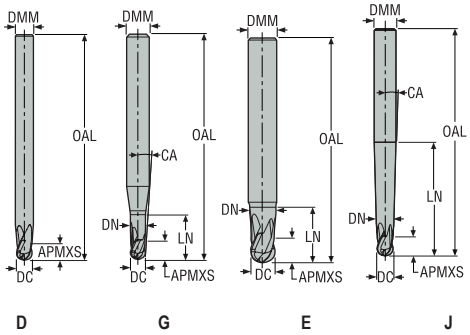
SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630–750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600–750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140–170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140–170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150–190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140–180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140–170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140–170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80–100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55–75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140–180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120–150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140–190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110–150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66–120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79–100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

Schnittdaten, siehe Seite 457 - 464

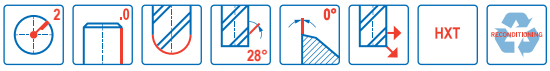
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH112

Hohe Geschwindigkeit – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

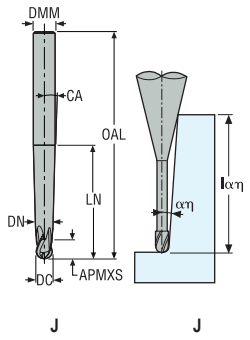
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm									
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	6,45	2	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	6,96	7,29	7,66	8,08	8,56	9,78	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	–	–	–	–	–	–	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	–	–	–	–	–	–	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	–	–	–	–	–	–	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	–	–	–	–	–	–	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	10,79	11,1	11,42	11,77	–	–	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	–	2	–	–	–	–	–	–	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	–	2	–	–	–	–	–	–	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	–	–	–	–	–	–	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	–	–	–	–	–	–	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	5,66	5,87	6,1	6,36	6,64	7,31	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	6,97	7,31	7,7	8,14	8,65	9,95	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	8,62	9,24	9,99	10,9	12,05	15,49	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	9,62	10,31	11,14	12,15	13,42	17,25	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	14,09	15,1	16,31	17,79	19,64	25,2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	16,0	–	–	–	–	–	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	20,0	–	–	–	–	–	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	24,0	–	–	–	–	–	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	20,66	21,59	22,61	23,73	24,98	27,94	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	20,97	22,18	23,55	25,11	26,92	31,51	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	21,62	23,39	25,53	28,13	–	–	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	52,09	56,58	–	–	–	–	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	–	2	–	–	–	–	–	–	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	–	2	–	–	–	–	–	–	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	–	2	–	–	–	–	–	–	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	–	2	–	–	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf a_p (l_{ap}, ref)*

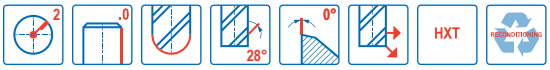
JH112

Hohe Geschwindigkeit – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm									
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	3,3	2	3,09	3,43	3,91	4,63	5,81	14,63	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	2,2	2	5,7	6,75	8,51	12,03	22,61	–	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	1,2	2	10,58	15,35	32,07	–	–	–	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	1,6	2	11,47	14,56	20,93	41,46	–	–	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	1,1	2	14,72	21,24	44,08	–	–	–	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	1,0	2	20,71	29,7	59,65	–	–	–	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	1,0	2	22,16	30,75	56,56	–	–	–	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	2,0	2	11,59	13,99	18,22	27,78	69,22	–	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	1,8	2	16,24	19,64	25,68	39,27	98,24	–	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	0,8	2	26,26	43,99	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf αη (lαη, ref)*

Schnittdaten – JH112 Kopierfräsen/ Feinbearbeitung

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500–730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200–1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200–1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560–790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500–750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790–1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500–750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790–1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990–1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920–1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790–1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960–1400)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JH112 Eckfräsen/Schruppen

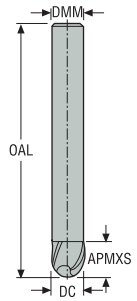
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100–1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890–1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760–1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730–1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830–1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200–1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100–160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100–160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560–780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

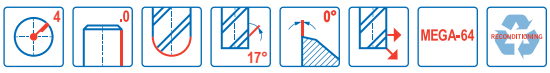
JH150

Hohe Geschwindigkeit – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch



D





- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich

Bezeichnung		Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	4	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	4	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	4	■

■ **Lagerstandard.**

Schnittdaten – JH150 Eckfräsen/Schruppen

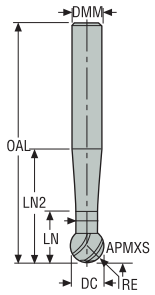
SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100–1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890–1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890–1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300–1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200–1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88–120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88–120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630–750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130–180) *410 (430 — 590)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

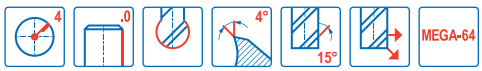
JH160

Hohe Geschwindigkeit – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch



E





- Toleranzen:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	9,0	1,8	1,5	4	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	11,0	2,4	2,0	4	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	13,0	3,0	2,5	4	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	17,3	3,6	3,0	4	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	21,3	4,8	4,0	4	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	27,9	6,0	5,0	4	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	31,8	7,2	6,0	4	■

■ **Lagerstandard.**

Schnittdaten – JH160 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450–700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300–1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200–1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100–1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200–1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200–1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100–1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100–1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91–110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100–1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91–110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100–1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400–1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200–1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100–1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.



ROSTFREI UND ISO-S-WERKSTOFFE

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Rostfrei und ISO-S-Werkstoffen besteht aus Schaft-, Kugelkopf- und Kreissegmentfräsern.

- JS754, JS755, JS720, JHP750, JHP760, JHP770, JHP780, JHP794, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994 und JCO710 Schaftfräser mit Fase oder Eckenradius
- JS730, JH780, JHB720, JH721 und JH722 Kugelkopffräser
- JH734, JH736, JH744 und JH746 Kreissegmentfräser

Werkzeugauswahl Rostfrei und ISO-S-Werkstoffe



Werkzeugbezeichnung		JS754	JS755	JS720	JS730	JHP750	JHP760	JHP770
Seite(n)		210	227	238	252	256	259	263
Produktfamilie		JS²	JS²	JS²	JS²	HPM	HPM	HPM
Fräserausführung								
Aufnahmen	Zylindrisch	■	■	■	■	■	■	■
	Weldon	■	■	■	□	■	■	■
	Safe-Lock	□	□	□	□			□
Schneidenzahl		4	5	6-9	6	2-4	2,3,4	4-5
ICC		■					■	■
	Metrisch	3-25	6-25	6-25	6-25	2-20	4-25	6-25
	Zoll							
Verfügbare Längen								
		2,3	2,3	2,3	2,3	1,2	2,3	2
Bearbeitung								
								
								
								
SMG								
M1		•	•	•	•		•	
M2		•	•	•	•		•	
M3		•	•	•	•		•	
M4		•	•	•	•		•	
M5		•	•	•	•		•	
S1		•	•			•		
S2		•	•			•		
S3		•	•			•		
S11		•	•	•	•	•		•
S12		•	•	•	•	•		•
S13		•	•	•	•	•		•

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
• Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und ISO-S-Werkstoffe

								
Werkzeugbezeichnung		JHP780	JHP794	JCG790	JH734	JH736	JH744	JH746
Seite(n)		270	259	277	279	281	283	285
Produktfamilie		HPM	HPM	Ceramic	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung								
Aufnahmen	Zylindrisch	■		■	■	■	■	■
	Weldon	■	■					
	Safe-Lock	□						
Schneidenzahl		4	4	5-6	4	6	4	6
ICC		■	■				■	■
	Metrisch	6-25	6-25	6-25	6-16	10-16	4-16	10-16
	Zoll							
Verfügbare Längen								
		2	2	2	2	2	2,4	2
Bearbeitung								
								
								
SMG								
M1			•		•	•	•	•
M2			•		•	•	•	•
M3			•		•	•	•	•
M4			•					
M5			•					
S1		•		•				
S2		•		•				
S3		•		•				
S11					•	•	•	•
S12					•	•	•	•
S13					•	•	•	•

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
• Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und ISO-S-Werkstoffe

							
Werkzeugbezeichnung		JH770	JH740	JH710	JH790	JH730	JHP994
Seite(n)		287	289	291	293	295	297
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HPM
Fräserausführung							
Auf-nahmen	Zylindrisch	■	■	■	■	■	■
	Weldon						
	Safe-Lock						
Schneidenzahl		3,4,5,6	4-5	5	6	6-7	4
ICC							
	Metrisch	3-10	6-10	6-8	9,5	8-10	6-10
	Zoll						
Verfügbare Längen							
		2	2	2	2-3	2	3
Bearbeitung							
							
SMG							
M1							
M2							
M3							
M4							
M5							
S1							
S2		●	●	●	●	●	●
S3							
S11		●	●	●	●	●	●
S12		●	●	●	●	●	●
S13							

■ Lagerstandard ☐ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. ☐ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und ISO-S-Werkstoffe

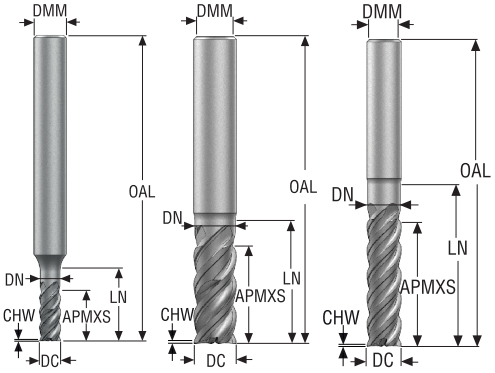
						
Werkzeugbezeichnung		JH780	JHB720	JH721	JH722	JCO710
Seite(n)		299	301	303	305	307
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSS-Co
Fräserausführung						
Auf-nahmen	Zylindrisch	■	■	■	■	
	Weldon					■
	Safe-Lock					
Schneidenzahl		4	3	6	6	4-6
ICC						
	Metrisch	1,83-4,89	2-16	6-8	10	16-40
	Zoll					
Verfügbare Längen						
		2	2	2	2	2,4
Bearbeitung						
						
						
SMG						
M1			●			●
M2			●			●
M3			●			●
M4			●			●
M5			●			●
S1			○			
S2		●	○	●	●	
S3			○			
S11			●	●	●	●
S12		●	●	●	●	●
S13			●			●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

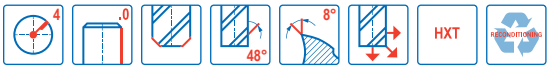
JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenfase





- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

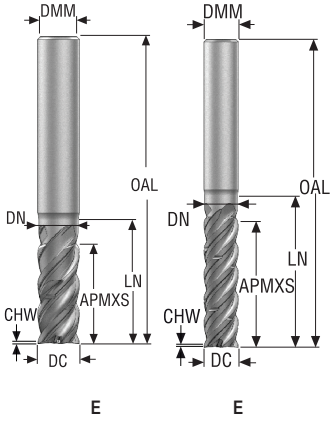


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS754030G2C.0Z4-HXT	03186807	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	■
JS754040G2C.0Z4-HXT	03186808	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	■
JS754050G2C.0Z4-HXT	03186809	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	4	■
JS754060E2C.0Z4-HXT	03186810	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754060E3C.0Z4-HXT	03186823	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E2C.0Z4-HXT	03186811	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754080E3C.0Z4-HXT	03186824	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E2C.0Z4-HXT	03186812	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754100E3C.0Z4-HXT	03186825	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E2C.0Z4-HXT	03186813	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754120E3C.0Z4-HXT	03186826	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E2C.0Z4-HXT	03186814	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754160E3C.0Z4-HXT	03186827	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E2C.0Z4-HXT	03186815	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■
JS754200E3C.0Z4-HXT	03186828	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■
JS754250E2C.0Z4-HXT	03186816	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	■
JS754250E3C.0Z4-HXT	03186829	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	■

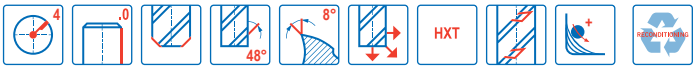
■ **Lagerstandard.**

JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenfase – Spanteiler







- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich

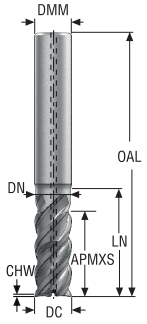
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.0Z4C-HXT	03186817	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4C-HXT	03186818	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.0Z4C-HXT	03200550	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.0Z4C-HXT	03200551	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.0Z4C-HXT	03186830	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.0Z4C-HXT	03186831	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.0Z4C-HXT	03186832	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.0Z4C-HXT	03186833	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■

■ **Lagerstandard.**

JS754

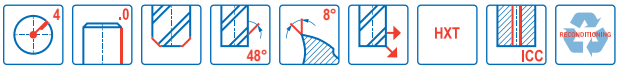
Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenfase – ICC





E

- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

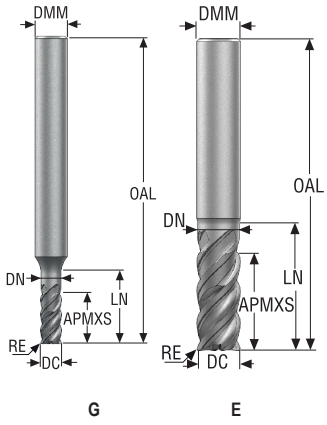


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.0Z4A-HXT	03186836	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.0Z4A-HXT	03186837	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.0Z4A-HXT	03186838	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.0Z4A-HXT	03186839	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■

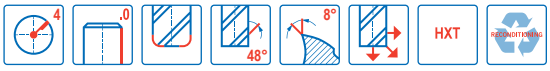
■ **Lagerstandard.**

JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

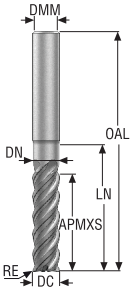
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS754030G2R020.0Z4-HXT	03186840	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	4	■
JS754040G2R020.0Z4-HXT	03186841	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4	■
JS754050G2R020.0Z4-HXT	03186842	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	4	■
JS754060E2R020.0Z4-HXT	03186843	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	■
JS754060E2R050.0Z4-HXT	03186844	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JS754060E2R100.0Z4-HXT	03186845	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JS754080E2R050.0Z4-HXT	03186846	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JS754080E2R100.0Z4-HXT	03186847	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JS754100E2R050.0Z4-HXT	03186848	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JS754100E2R100.0Z4-HXT	03186849	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JS754100E2R150.0Z4-HXT	03200552	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	■
JS754100E2R200.0Z4-HXT	03186850	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	■
JS754100E2R300.0Z4-HXT	03186851	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	■
JS754120E2R050.0Z4-HXT	03186852	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JS754120E2R100.0Z4-HXT	03186853	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JS754120E2R150.0Z4-HXT	03200553	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	■
JS754120E2R200.0Z4-HXT	03186854	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	■
JS754120E2R300.0Z4-HXT	03186855	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	■
JS754160E2R050.0Z4-HXT	03186856	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JS754160E2R100.0Z4-HXT	03186857	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JS754160E2R200.0Z4-HXT	03186858	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	■
JS754160E2R300.0Z4-HXT	03186859	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	■
JS754160E2R400.0Z4-HXT	03186860	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	■
JS754160E2R600.0Z4-HXT	03186861	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	■
JS754200E2R050.0Z4-HXT	03186862	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	■
JS754200E2R100.0Z4-HXT	03186863	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	■
JS754200E2R200.0Z4-HXT	03186864	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	■
JS754200E2R300.0Z4-HXT	03186865	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	■
JS754200E2R400.0Z4-HXT	03186866	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	■
JS754200E2R600.0Z4-HXT	03186867	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	■

■ **Lagerstandard.**

JS754

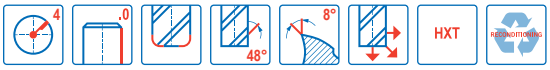
Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

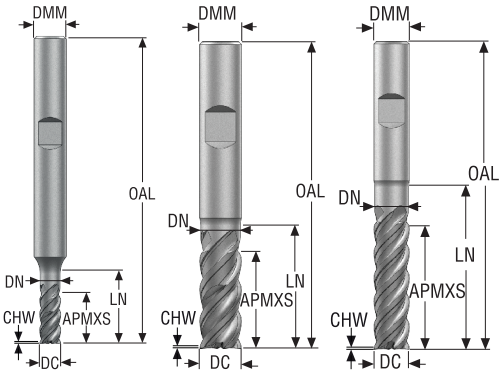


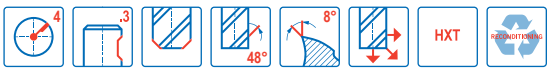
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.0Z4-HXT	03186873	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	■
JS754060E3R050.0Z4-HXT	03186874	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	■
JS754060E3R100.0Z4-HXT	03186875	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	■
JS754080E3R050.0Z4-HXT	03186876	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	■
JS754080E3R100.0Z4-HXT	03186877	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	■
JS754100E3R050.0Z4-HXT	03186878	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	■
JS754100E3R100.0Z4-HXT	03186879	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	■
JS754100E3R200.0Z4-HXT	03186880	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	■
JS754100E3R300.0Z4-HXT	03186881	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	■
JS754120E3R050.0Z4-HXT	03186882	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	■
JS754120E3R100.0Z4-HXT	03186883	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	■
JS754120E3R200.0Z4-HXT	03186884	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	■
JS754120E3R300.0Z4-HXT	03186885	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	■
JS754160E3R050.0Z4-HXT	03186886	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	■
JS754160E3R100.0Z4-HXT	03186887	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	■
JS754160E3R200.0Z4-HXT	03186888	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	■
JS754160E3R300.0Z4-HXT	03186889	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	■
JS754160E3R400.0Z4-HXT	03186890	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	■
JS754160E3R600.0Z4-HXT	03186891	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	■
JS754200E3R050.0Z4-HXT	03186892	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	■
JS754200E3R100.0Z4-HXT	03186893	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	■
JS754200E3R200.0Z4-HXT	03186894	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	■
JS754200E3R300.0Z4-HXT	03186895	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	■
JS754200E3R400.0Z4-HXT	03186896	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	■
JS754200E3R600.0Z4-HXT	03186897	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	■

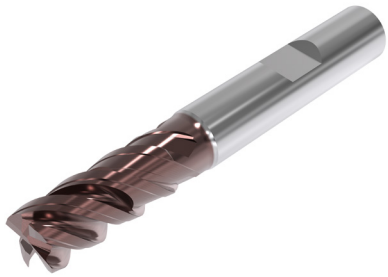
■ **Lagerstandard.**

JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenfase







- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

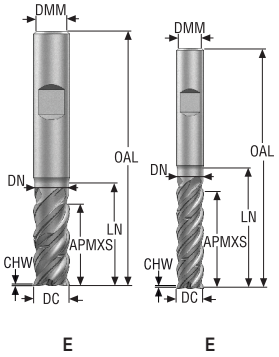
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030G2C.3Z4-HXT	03186975	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	4	□
JS754040G2C.3Z4-HXT	03186976	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4	□
JS754050G2C.3Z4-HXT	03186977	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	4	□
JS754060E2C.3Z4-HXT	03186978	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4-HXT	03186979	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4-HXT	03186980	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4-HXT	03186981	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.3Z4-HXT	03186982	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.3Z4-HXT	03186983	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■
JS754250E2C.3Z4-HXT	03186984	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	■
JS754060E3C.3Z4-HXT	03186990	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.3Z4-HXT	03186991	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.3Z4-HXT	03186992	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.3Z4-HXT	03186993	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.3Z4-HXT	03186994	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.3Z4-HXT	03186995	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■
JS754250E3C.3Z4-HXT	03186996	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

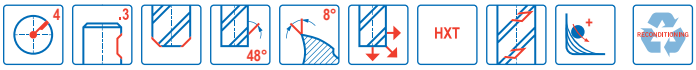
JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenfase – Spanteiler





- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich

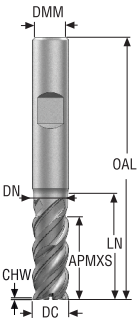


Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754060E3C.3Z4C-HXT	03200562	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	■
JS754080E3C.3Z4C-HXT	03200563	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	■
JS754100E3C.3Z4C-HXT	03186997	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	■
JS754120E3C.3Z4C-HXT	03186998	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	■
JS754160E3C.3Z4C-HXT	03186999	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	■
JS754200E3C.3Z4C-HXT	03187000	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	■

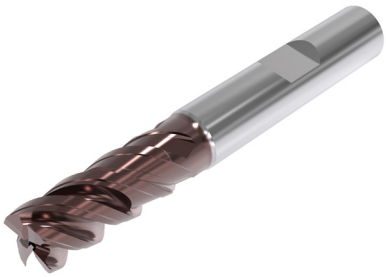
■ **Lagerstandard.**

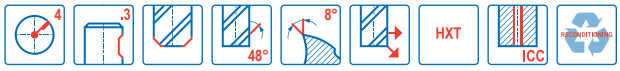
JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenfase – ICC



E





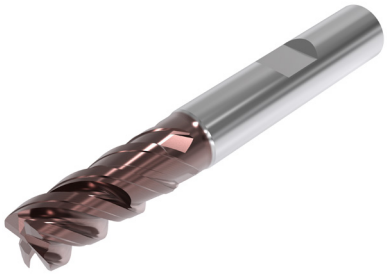
- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

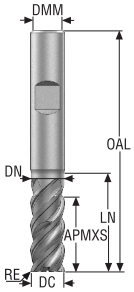
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	■
JS754100E2C.3Z4A-HXT	03187003	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	■
JS754120E2C.3Z4A-HXT	03187004	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	■
JS754160E2C.3Z4A-HXT	03187005	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	■
JS754200E2C.3Z4A-HXT	03187006	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	■

■ **Lagerstandard.**

JS754

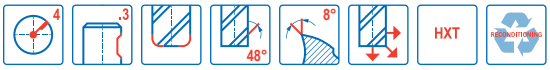
Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenradius





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

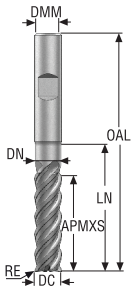


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754030G2R020.3Z4-HXT	03187007	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	4	□
JS754040G2R020.3Z4-HXT	03187008	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4	□
JS754050G2R020.3Z4-HXT	03187009	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	4	□
JS754060E2R020.3Z4-HXT	03187010	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	■
JS754060E2R050.3Z4-HXT	03187011	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	■
JS754060E2R100.3Z4-HXT	03187012	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	■
JS754080E2R050.3Z4-HXT	03187013	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	■
JS754080E2R100.3Z4-HXT	03187014	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	■
JS754100E2R050.3Z4-HXT	03187015	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	■
JS754100E2R100.3Z4-HXT	03187016	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	■
JS754100E2R150.3Z4-HXT	03200564	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	■
JS754100E2R200.3Z4-HXT	03187017	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	■
JS754100E2R300.3Z4-HXT	03187018	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	■
JS754120E2R050.3Z4-HXT	03187019	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	■
JS754120E2R100.3Z4-HXT	03187020	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	■
JS754120E2R150.3Z4-HXT	03200565	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	■
JS754120E2R200.3Z4-HXT	03187021	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	■
JS754120E2R300.3Z4-HXT	03187022	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	■
JS754160E2R050.3Z4-HXT	03187023	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	■
JS754160E2R100.3Z4-HXT	03187024	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	■
JS754160E2R200.3Z4-HXT	03187025	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	■
JS754160E2R300.3Z4-HXT	03187026	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	■
JS754160E2R400.3Z4-HXT	03187027	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	■
JS754160E2R600.3Z4-HXT	03187028	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	■
JS754200E2R050.3Z4-HXT	03187029	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	■
JS754200E2R100.3Z4-HXT	03187030	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	■
JS754200E2R200.3Z4-HXT	03187031	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	■
JS754200E2R300.3Z4-HXT	03187032	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	■
JS754200E2R400.3Z4-HXT	03187033	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	■
JS754200E2R600.3Z4-HXT	03187034	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

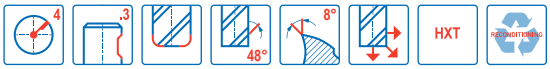
JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenradius



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

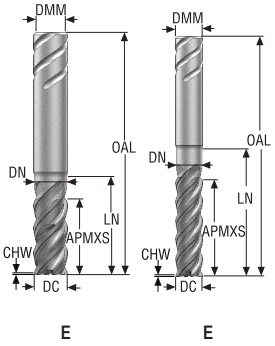
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.3Z4-HXT	03187040	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	☐
JS754060E3R050.3Z4-HXT	03187041	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	☐
JS754060E3R100.3Z4-HXT	03187042	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	☐
JS754080E3R050.3Z4-HXT	03187043	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	☐
JS754080E3R100.3Z4-HXT	03187044	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	☐
JS754100E3R050.3Z4-HXT	03187045	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	☐
JS754100E3R100.3Z4-HXT	03187046	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	☐
JS754100E3R200.3Z4-HXT	03187047	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	☐
JS754100E3R300.3Z4-HXT	03187049	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	☐
JS754120E3R050.3Z4-HXT	03187050	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	☐
JS754120E3R100.3Z4-HXT	03187051	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	☐
JS754120E3R200.3Z4-HXT	03187052	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	☐
JS754120E3R300.3Z4-HXT	03187053	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	☐
JS754160E3R050.3Z4-HXT	03187054	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	☐
JS754160E3R100.3Z4-HXT	03187055	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	☐
JS754160E3R200.3Z4-HXT	03187056	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	☐
JS754160E3R300.3Z4-HXT	03187057	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	☐
JS754160E3R400.3Z4-HXT	03187058	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	☐
JS754160E3R600.3Z4-HXT	03187059	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	☐
JS754200E3R050.3Z4-HXT	03187060	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	☐
JS754200E3R100.3Z4-HXT	03187061	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	☐
JS754200E3R200.3Z4-HXT	03187062	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	☐
JS754200E3R300.3Z4-HXT	03187063	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	☐
JS754200E3R400.3Z4-HXT	03187064	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	☐
JS754200E3R600.3Z4-HXT	03187065	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

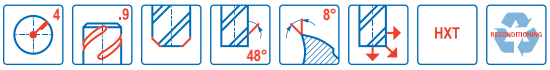
JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Eckenfase





- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

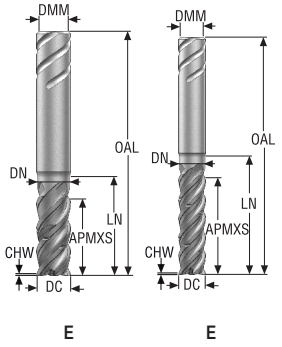


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.9Z4-HXT	03187144	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	☐
JS754080E2C.9Z4-HXT	03187145	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	☐
JS754100E2C.9Z4-HXT	03187146	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4-HXT	03187147	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754160E2C.9Z4-HXT	03187148	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	☐
JS754200E2C.9Z4-HXT	03187149	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	☐
JS754250E2C.9Z4-HXT	03187150	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	☐
JS754060E3C.9Z4-HXT	03187153	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	☐
JS754080E3C.9Z4-HXT	03187154	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	☐
JS754100E3C.9Z4-HXT	03187155	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	☐
JS754120E3C.9Z4-HXT	03187156	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	☐
JS754160E3C.9Z4-HXT	03187157	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	☐
JS754200E3C.9Z4-HXT	03187158	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	☐
JS754250E3C.9Z4-HXT	03187159	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	☐

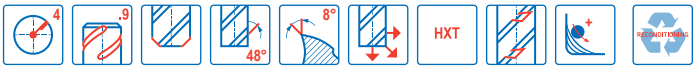
☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Eckenfase – Spanteiler







- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich

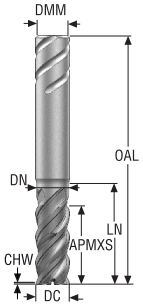
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm	mm	mm		
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4C-HXT	03187152	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754060E3C.9Z4C-HXT	03200571	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	☐
JS754080E3C.9Z4C-HXT	03200572	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	☐
JS754100E3C.9Z4C-HXT	03187160	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	☐
JS754120E3C.9Z4C-HXT	03187161	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	☐
JS754160E3C.9Z4C-HXT	03187162	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	☐
JS754200E3C.9Z4C-HXT	03187163	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS754

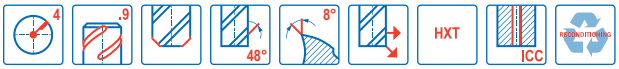
Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Eckenfase – ICC





E

- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

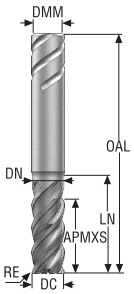


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm	mm	mm		
JS754060E2C.9Z4A-HXT	03187164	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	☐
JS754080E2C.9Z4A-HXT	03187165	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	☐
JS754100E2C.9Z4A-HXT	03187166	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	☐
JS754120E2C.9Z4A-HXT	03187167	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	☐
JS754160E2C.9Z4A-HXT	03187168	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	☐
JS754200E2C.9Z4A-HXT	03187169	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
ICC = mit interner Kühlschmierstoffzufuhr

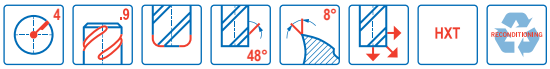
JS754

Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Eckenradius



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

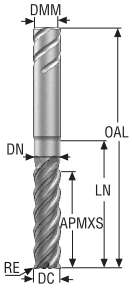
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	☐
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	☐
JS754060E2R100.9Z4-HXT	03187172	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	☐
JS754080E2R050.9Z4-HXT	03187173	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	☐
JS754080E2R100.9Z4-HXT	03187174	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	☐
JS754100E2R050.9Z4-HXT	03187175	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	☐
JS754100E2R100.9Z4-HXT	03187176	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	☐
JS754100E2R150.9Z4-HXT	03200573	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	☐
JS754100E2R200.9Z4-HXT	03187177	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	☐
JS754100E2R300.9Z4-HXT	03187178	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	☐
JS754120E2R050.9Z4-HXT	03187179	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	☐
JS754120E2R100.9Z4-HXT	03187180	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	☐
JS754120E2R150.9Z4-HXT	03200832	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	☐
JS754120E2R200.9Z4-HXT	03187181	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	☐
JS754120E2R300.9Z4-HXT	03187182	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	☐
JS754160E2R050.9Z4-HXT	03187183	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	☐
JS754160E2R100.9Z4-HXT	03187184	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	☐
JS754160E2R200.9Z4-HXT	03187185	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	☐
JS754160E2R300.9Z4-HXT	03187186	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	☐
JS754160E2R400.9Z4-HXT	03187187	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	☐
JS754160E2R600.9Z4-HXT	03187188	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	☐
JS754200E2R050.9Z4-HXT	03187189	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	☐
JS754200E2R100.9Z4-HXT	03187190	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	☐
JS754200E2R200.9Z4-HXT	03187191	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	☐
JS754200E2R300.9Z4-HXT	03187192	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	☐
JS754200E2R400.9Z4-HXT	03187193	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	☐
JS754200E2R600.9Z4-HXT	03187194	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS754

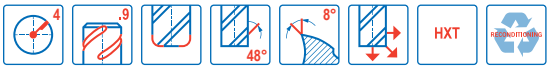
Hochleistung – Schaftfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Eckenradius





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm	mm	mm		
JS754060E3R020.9Z4-HXT	03187197	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	☐
JS754060E3R050.9Z4-HXT	03187198	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	☐
JS754060E3R100.9Z4-HXT	03187199	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	☐
JS754080E3R050.9Z4-HXT	03187200	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	☐
JS754080E3R100.9Z4-HXT	03187201	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	☐
JS754100E3R050.9Z4-HXT	03187202	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	☐
JS754100E3R100.9Z4-HXT	03187203	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	☐
JS754100E3R200.9Z4-HXT	03187204	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	☐
JS754100E3R300.9Z4-HXT	03187205	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	☐
JS754120E3R050.9Z4-HXT	03187206	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	☐
JS754120E3R100.9Z4-HXT	03187207	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	☐
JS754120E3R200.9Z4-HXT	03187208	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	☐
JS754120E3R300.9Z4-HXT	03187209	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	☐
JS754160E3R050.9Z4-HXT	03187210	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	☐
JS754160E3R100.9Z4-HXT	03187211	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	☐
JS754160E3R200.9Z4-HXT	03187212	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	☐
JS754160E3R300.9Z4-HXT	03187213	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	☐
JS754160E3R400.9Z4-HXT	03187214	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	☐
JS754160E3R600.9Z4-HXT	03187215	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	☐
JS754200E3R050.9Z4-HXT	03187216	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	☐
JS754200E3R100.9Z4-HXT	03187217	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	☐
JS754200E3R200.9Z4-HXT	03187218	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	☐
JS754200E3R300.9Z4-HXT	03187219	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	☐
JS754200E3R400.9Z4-HXT	03187220	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	☐
JS754200E3R600.9Z4-HXT	03187221	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS754 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (130–180) *540 (430 — 590)*
P12	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	105 (83–120) *345 (280 — 390)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96–130) *360 (320 — 420)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79–110) *295 (260 — 360)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (44–76) *195 (150 — 240)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	46 (34 — 59) *150 (120–190)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	39 (29 — 49) *130 (96–160)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	50 (26 — 68) *165 (86 — 220)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	41 (21 — 55) *135 (69–180)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	36 (19 — 48) *120 (63–150)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (73–140) *360 (240 — 450)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (56–110) *280 (190 — 360)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (44 — 87) *215 (150 — 280)*

Schnittdaten – JS754 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	150 (120–170) *490 (400 — 550)*
P12	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	90 (69–100) *295 (230 — 320)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85–120) *310 (280 — 390)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 97) *260 (230 — 310)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	55 (39 — 67) *180 (130 — 210)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	40 (29 — 50) *130 (96–160)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (25 — 42) *110 (83–130)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	41 (21 — 54) *135 (69–170)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (17 — 43) *110 (56–140)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	28 (15 — 37) *90 (50–120)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (63–120) *310 (210 — 390)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	70 (48 — 95) *230 (160 — 310)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	55 (38–74) *180 (130 — 240)*

Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren.

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JS754_2C Dynamisches Fräsen a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P11	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.15 *0,0060*	0.17 *0,0065*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150–190) *560 (500 — 620)*
M1	E	0.100 *0,100*	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	205 (180 — 230) *670 (600–750)*
M2	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150–190) *560 (500 — 620)*
M3	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	130 (120–150) *425 (400 — 490)*
M4	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	100 (86–110) *330 (290 — 360)*
M5	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	60 (35 — 80) *195 (120 — 260)*
S3	E	0.0500 *0,0500*	2.0 *2,0*	0.080 *0,0032*	0.095 *0,0038*	50 (31–70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	165 (140–190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	125 (110–150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	2.0 *2,0*	0.060 *0,0024*	0.070 *0,0028*	100 (84–110) *330 (280 — 360)*

Schnittdaten – JS754_3C Dynamisches Fräsen a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140–180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 230) *670 (560–750)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140–190) *560 (460 — 620)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110–150) *425 (370 — 490)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (86–110) *330 (290 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (30–70) *165 (99 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	165 (140–190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110–150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (84–110) *330 (280 — 360)*

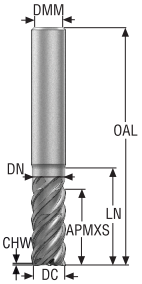
Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren.

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

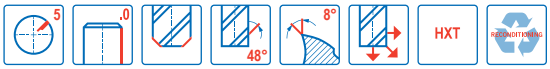
JS755

Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Eckenfase



E





- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

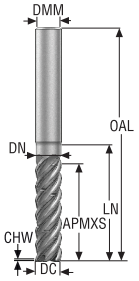
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.0Z5-HXT	03186909	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	■
JS755120E2C.0Z5-HXT	03186910	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	■
JS755160E2C.0Z5-HXT	03186911	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	■
JS755200E2C.0Z5-HXT	03186912	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	■
JS755250E2C.0Z5-HXT	03186913	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	■
JS755060E3C.0Z5-HXT	03186914	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	■
JS755080E3C.0Z5-HXT	03186915	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	■
JS755100E3C.0Z5-HXT	03186916	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.0Z5-HXT	03186917	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.0Z5-HXT	03186918	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.0Z5-HXT	03186919	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■
JS755250E3C.0Z5-HXT	03186920	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	■

■ **Lagerstandard.**

JS755

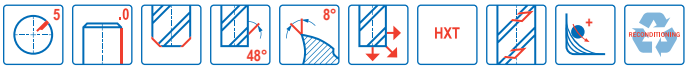
Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Eckenfase – Spanteiler





E

- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich

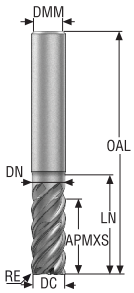


Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.0Z5C-HXT	03186921	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.0Z5C-HXT	03186922	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.0Z5C-HXT	03186923	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.0Z5C-HXT	03186924	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■

■ **Lagerstandard.**

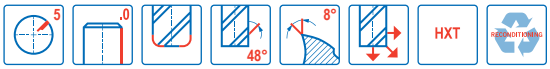
JS755

Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Eckenradius



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

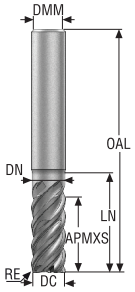
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.0Z5-HXT	03186927	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	■
JS755080E2R050.0Z5-HXT	03186928	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	■
JS755080E2R100.0Z5-HXT	03186929	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	■
JS755100E2R050.0Z5-HXT	03186930	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	■
JS755100E2R100.0Z5-HXT	03186931	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	■
JS755100E2R200.0Z5-HXT	03186932	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	■
JS755100E2R300.0Z5-HXT	03186933	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	■
JS755120E2R050.0Z5-HXT	03186934	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	■
JS755120E2R100.0Z5-HXT	03186935	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	■
JS755120E2R200.0Z5-HXT	03186936	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	■
JS755120E2R300.0Z5-HXT	03186937	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	■
JS755160E2R050.0Z5-HXT	03186938	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	■
JS755160E2R100.0Z5-HXT	03186939	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	■
JS755160E2R600.0Z5-HXT	03186940	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	■
JS755200E2R050.0Z5-HXT	03186941	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	■
JS755200E2R100.0Z5-HXT	03186942	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	■
JS755200E2R600.0Z5-HXT	03186943	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	■

■ **Lagerstandard.**

JS755

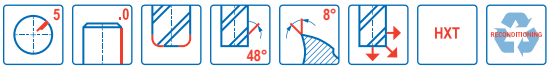
Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

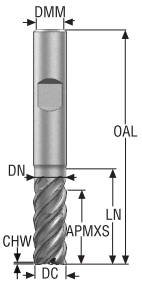


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS755060E3R020.0Z5-HXT	03186946	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	■
JS755060E3R050.0Z5-HXT	03186947	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	■
JS755060E3R100.0Z5-HXT	03186948	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	■
JS755080E3R050.0Z5-HXT	03186949	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	■
JS755080E3R100.0Z5-HXT	03186950	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	■
JS755100E3R050.0Z5-HXT	03186951	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	■
JS755100E3R100.0Z5-HXT	03186952	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	■
JS755100E3R200.0Z5-HXT	03186953	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	■
JS755100E3R300.0Z5-HXT	03186954	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	■
JS755120E3R050.0Z5-HXT	03186955	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	■
JS755120E3R100.0Z5-HXT	03186956	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	■
JS755120E3R200.0Z5-HXT	03186957	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	■
JS755120E3R300.0Z5-HXT	03186958	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	■
JS755160E3R050.0Z5-HXT	03186959	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	■
JS755160E3R600.0Z5-HXT	03186960	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	■
JS755200E3R050.0Z5-HXT	03186961	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	■
JS755200E3R600.0Z5-HXT	03186962	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	■

■ **Lagerstandard.**

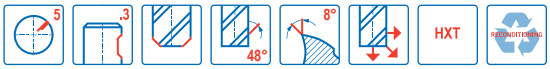
JS755

Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Weldon – Eckenfase



E





- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

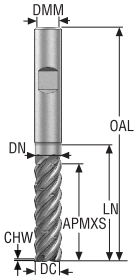
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	■
JS755100E2C.3Z5-HXT	03187085	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	■
JS755120E2C.3Z5-HXT	03187086	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	■
JS755160E2C.3Z5-HXT	03187087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	■
JS755200E2C.3Z5-HXT	03187088	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	■
JS755250E2C.3Z5-HXT	03187089	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	■
JS755060E3C.3Z5-HXT	03187090	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	■
JS755080E3C.3Z5-HXT	03187091	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	■
JS755100E3C.3Z5-HXT	03187092	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.3Z5-HXT	03187093	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.3Z5-HXT	03187094	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.3Z5-HXT	03187095	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■
JS755250E3C.3Z5-HXT	03187096	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	■

■ **Lagerstandard.**

JS755

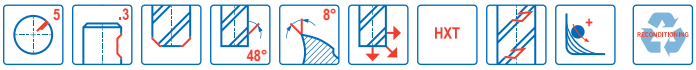
Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Weldon – Eckenfase – Spanteiler





E

- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich

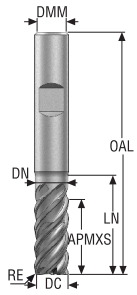


Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.3Z5C-HXT	03187097	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	■
JS755120E3C.3Z5C-HXT	03187098	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	■
JS755160E3C.3Z5C-HXT	03187099	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	■
JS755200E3C.3Z5C-HXT	03187100	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	■

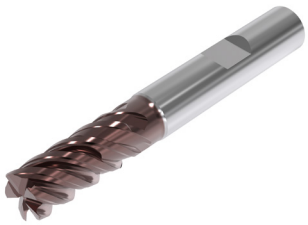
■ **Lagerstandard.**

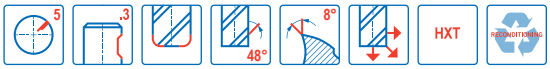
JS755

Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Weldon – Eckenradius



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

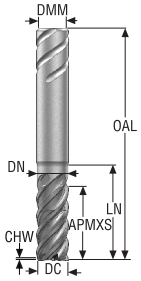
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	■
JS755060E2R100.3Z5-HXT	03187103	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	■
JS755080E2R050.3Z5-HXT	03187104	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	■
JS755080E2R100.3Z5-HXT	03187105	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	■
JS755100E2R050.3Z5-HXT	03187106	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	■
JS755100E2R100.3Z5-HXT	03187107	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	■
JS755100E2R200.3Z5-HXT	03187108	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	■
JS755100E2R300.3Z5-HXT	03187109	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	■
JS755120E2R050.3Z5-HXT	03187110	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	■
JS755120E2R100.3Z5-HXT	03187111	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	■
JS755120E2R200.3Z5-HXT	03187112	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	■
JS755120E2R300.3Z5-HXT	03187113	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	■
JS755160E2R050.3Z5-HXT	03187114	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	■
JS755160E2R100.3Z5-HXT	03187115	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	■
JS755160E2R600.3Z5-HXT	03187116	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	■
JS755200E2R050.3Z5-HXT	03187117	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	■
JS755200E2R100.3Z5-HXT	03187118	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	■
JS755200E2R600.3Z5-HXT	03187119	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	■
JS755060E3R020.3Z5-HXT	03187122	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	□
JS755060E3R050.3Z5-HXT	03187123	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	□
JS755060E3R100.3Z5-HXT	03187124	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	□
JS755080E3R050.3Z5-HXT	03187125	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	□
JS755080E3R100.3Z5-HXT	03187126	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	□
JS755100E3R050.3Z5-HXT	03187127	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	□
JS755100E3R100.3Z5-HXT	03187128	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	□
JS755100E3R200.3Z5-HXT	03187129	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	□
JS755100E3R300.3Z5-HXT	03187130	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	□
JS755120E3R050.3Z5-HXT	03187131	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	□
JS755120E3R100.3Z5-HXT	03187132	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	□
JS755120E3R200.3Z5-HXT	03187133	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	□
JS755120E3R300.3Z5-HXT	03187134	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	□
JS755160E3R050.3Z5-HXT	03187135	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	□
JS755160E3R600.3Z5-HXT	03187136	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	□
JS755200E3R050.3Z5-HXT	03187137	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	□
JS755200E3R600.3Z5-HXT	03187138	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS755

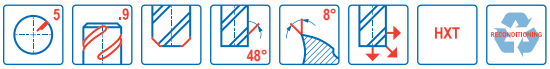
Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Safe-Lock – Eckenfase





E

- Toleranzen:
- DMM = h5
- DC = e7
- Nachschleifen möglich

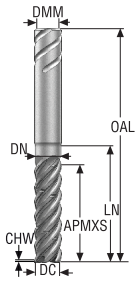


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2C.9Z5-HXT	03187235	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	☐
JS755080E2C.9Z5-HXT	03187236	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	☐
JS755100E2C.9Z5-HXT	03187237	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	☐
JS755120E2C.9Z5-HXT	03187238	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	☐
JS755160E2C.9Z5-HXT	03187239	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	☐
JS755200E2C.9Z5-HXT	03187240	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	☐
JS755250E2C.9Z5-HXT	03187241	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	☐
JS755060E3C.9Z5-HXT	03187242	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	☐
JS755080E3C.9Z5-HXT	03187243	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	☐
JS755100E3C.9Z5-HXT	03187244	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5-HXT	03187245	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5-HXT	03187246	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	☐
JS755200E3C.9Z5-HXT	03187247	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	☐
JS755250E3C.9Z5-HXT	03187248	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

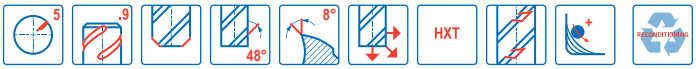
JS755

Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Safe-Lock – Eckenfase – Spanteiler



E





- Toleranzen:
- DMM = h5
- DC = e7
- Spanteiler
- Nachschleifen möglich

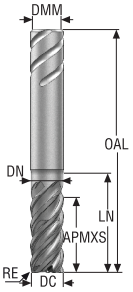
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm	mm	mm		
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	☐
JS755120E3C.9Z5C-HXT	03187250	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	☐
JS755160E3C.9Z5C-HXT	03187252	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	☐
JS755200E3C.9Z5C-HXT	03187253	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS755

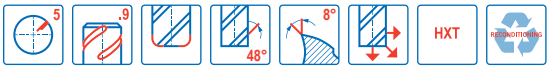
Hochleistung – Schaftfräser – ISO– M und ISO– S – 5 Schneiden – Safe-Lock – Eckenradius





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm	mm	mm		
JS755060E2R020.9Z5-HXT	03187254	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	☐
JS755060E2R050.9Z5-HXT	03187255	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	☐
JS755060E2R100.9Z5-HXT	03187256	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	☐
JS755080E2R050.9Z5-HXT	03187257	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	☐
JS755080E2R100.9Z5-HXT	03187258	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	☐
JS755100E2R050.9Z5-HXT	03187259	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	☐
JS755100E2R100.9Z5-HXT	03187260	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	☐
JS755100E2R200.9Z5-HXT	03187261	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	☐
JS755100E2R300.9Z5-HXT	03187262	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	☐
JS755120E2R050.9Z5-HXT	03187263	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	☐
JS755120E2R100.9Z5-HXT	03187264	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	☐
JS755120E2R200.9Z5-HXT	03187265	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	☐
JS755120E2R300.9Z5-HXT	03187266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	☐
JS755160E2R050.9Z5-HXT	03187267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	☐
JS755160E2R100.9Z5-HXT	03187269	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	☐
JS755160E2R600.9Z5-HXT	03187270	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	☐
JS755200E2R050.9Z5-HXT	03187271	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	☐
JS755200E2R100.9Z5-HXT	03187272	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	☐
JS755200E2R600.9Z5-HXT	03187273	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	☐
JS755060E3R020.9Z5-HXT	03187276	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	☐
JS755060E3R050.9Z5-HXT	03187277	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	☐
JS755060E3R100.9Z5-HXT	03187279	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	☐
JS755080E3R050.9Z5-HXT	03187280	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	☐
JS755080E3R100.9Z5-HXT	03187281	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	☐
JS755100E3R050.9Z5-HXT	03187282	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	☐
JS755100E3R100.9Z5-HXT	03187283	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	☐
JS755100E3R200.9Z5-HXT	03187284	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	☐
JS755100E3R300.9Z5-HXT	03187285	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	☐
JS755120E3R050.9Z5-HXT	03187286	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	☐
JS755120E3R100.9Z5-HXT	03187287	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	☐
JS755120E3R200.9Z5-HXT	03187288	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	☐
JS755120E3R300.9Z5-HXT	03187289	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	☐
JS755160E3R050.9Z5-HXT	03187290	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	☐
JS755160E3R600.9Z5-HXT	03187291	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	☐
JS755200E3R050.9Z5-HXT	03187292	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	☐
JS755200E3R600.9Z5-HXT	03187293	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS755 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	135 (97–150) *445 (320 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	85 (63 — 99) *280 (210 — 320)*
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	170 (150–190) *560 (500 — 620)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120–150) *460 (400 — 490)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (92–120) *360 (310 — 390)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (71 — 95) *280 (240 — 310)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	70 (59–79) *230 (200 — 250)*
S1	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	70 (48–110) *230 (160 — 360)*
S2	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	60 (39 — 89) *195 (130 — 290)*
S3	E	0.0300 *0,0300*	2.0 *2,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (34–78) *165 (120 — 250)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120–160) *460 (400 — 520)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (91–120) *360 (300 — 390)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (73–100) *280 (240 — 320)*

Schnittdaten – JS755_3C Dynamisches Fräsen a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140–180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 220) *670 (560–720)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140–180) *560 (460 — 590)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110–140) *425 (370 — 450)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (85–110) *330 (280 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (31–70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140–190) *520 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110–140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (83–110) *330 (280 — 360)*

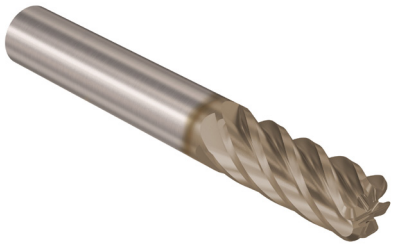
Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren.

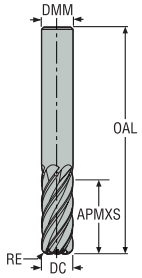
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS720

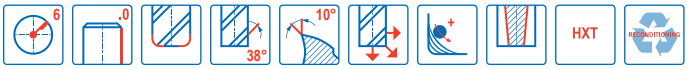
Hochleistung – Titan – Schaftfräser – 6 Schneiden – Zylindrisch – Eckenradius





D

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

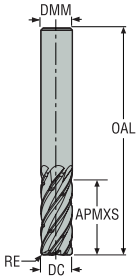


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	■
JS720080D2R050.0Z6-HXT	03060295	2	D	8,0	8,0	23,0	63,0	0,5	6	■
JS720080D2R100.0Z6-HXT	03061294	2	D	8,0	8,0	23,0	63,0	1,0	6	■
JS720100D2R050.0Z6-HXT	03060296	2	D	10,0	10,0	26,0	72,0	0,5	6	■
JS720100D2R100.0Z6-HXT	03060298	2	D	10,0	10,0	26,0	72,0	1,0	6	■
JS720100D2R200.0Z6-HXT	03060299	2	D	10,0	10,0	26,0	72,0	2,0	6	■
JS720100D2R300.0Z6-HXT	03060300	2	D	10,0	10,0	26,0	72,0	3,0	6	■
JS720120D2R050.0Z6-HXT	03060301	2	D	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6-HXT	03060304	2	D	12,0	12,0	30,0	83,0	1,0	6	■
JS720120D2R200.0Z6-HXT	03060305	2	D	12,0	12,0	30,0	83,0	2,0	6	■
JS720120D2R300.0Z6-HXT	03060306	2	D	12,0	12,0	30,0	83,0	3,0	6	■
JS720160D2R050.0Z6-HXT	03060307	2	D	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.0Z6-HXT	03060309	2	D	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.0Z6-HXT	03060310	2	D	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R300.0Z6-HXT	03060311	2	D	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R400.0Z6-HXT	03060312	2	D	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.0Z6-HXT	03060313	2	D	16,0	16,0	44,0	99,0	6,0	6	■
JS720250D2R300.0Z6-HXT	03169498	2	D	25,0	25,0	50,0	125,0	3,0	6	■
JS720160D3R300.0Z6-HXT	03169497	3	D	16,0	16,0	65,0	130,0	3,0	6	■
JS720200D3R050.0Z6-HXT	03060314	3	D	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.0Z6-HXT	03060316	3	D	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.0Z6-HXT	03060317	3	D	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R300.0Z6-HXT	03060318	3	D	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R400.0Z6-HXT	03060319	3	D	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.0Z6-HXT	03060320	3	D	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.0Z6-HXT	03060321	3	D	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.0Z6-HXT	03060322	3	D	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.0Z6-HXT	03060323	3	D	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.0Z6-HXT	03060324	3	D	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.0Z6-HXT	03060325	3	D	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.0Z6-HXT	03060326	3	D	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.0Z6-HXT	03060327	3	D	25,0	25,0	78,0	146,0	6,0	6	■

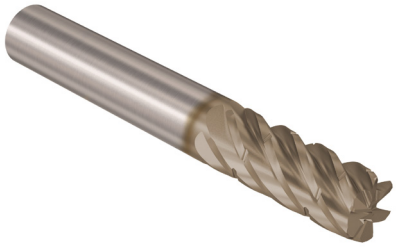
■ **Lagerstandard.**

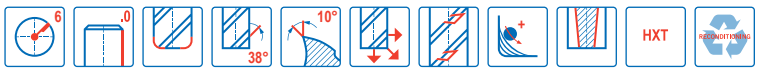
JS720

Hochleistung – Titan – Schaftfräser – 6 Schneiden – Zylindrisch – Eckenradius – Spanteiler



D





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Spanteiler
- Nachschleifen möglich

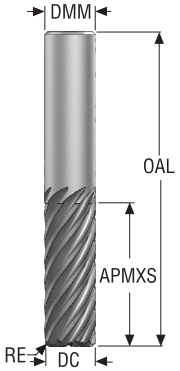
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	12,0	30,0	83,0	1,0	6	■
JS720120D2R200.0Z6C-HXT	03298281	2	D	■	12,0	12,0	30,0	83,0	2,0	6	■
JS720120D2R250.0Z6C-HXT	03298282	2	D	■	12,0	12,0	30,0	83,0	2,5	6	■
JS720120D2R300.0Z6C-HXT	03298283	2	D	■	12,0	12,0	30,0	83,0	3,0	6	■
JS720120D2R310.0Z6C-HXT	03298284	2	D	■	12,0	12,0	30,0	83,0	3,1	6	■
JS720160D2R050.0Z6C-HXT	03060308	2	D	■	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.0Z6C-HXT	03298285	2	D	■	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.0Z6C-HXT	03298286	2	D	■	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R250.0Z6C-HXT	03298287	2	D	■	16,0	16,0	44,0	99,0	2,5	6	■
JS720160D2R300.0Z6C-HXT	03298288	2	D	■	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R310.0Z6C-HXT	03298289	2	D	■	16,0	16,0	44,0	99,0	3,1	6	■
JS720160D2R400.0Z6C-HXT	03298290	2	D	■	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.0Z6C-HXT	03298291	2	D	■	16,0	16,0	44,0	99,0	6,0	6	■
JS720200D3R050.0Z6C-HXT	03060315	3	D	■	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.0Z6C-HXT	03298292	3	D	■	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.0Z6C-HXT	03298293	3	D	■	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R250.0Z6C-HXT	03298294	3	D	■	20,0	20,0	62,0	121,0	2,5	6	■
JS720200D3R300.0Z6C-HXT	03298295	3	D	■	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R310.0Z6C-HXT	03298296	3	D	■	20,0	20,0	62,0	121,0	3,1	6	■
JS720200D3R400.0Z6C-HXT	03298297	3	D	■	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.0Z6C-HXT	03298298	3	D	■	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.0Z6C-HXT	03298299	3	D	■	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.0Z6C-HXT	03066270	3	D	■	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.0Z6C-HXT	03298300	3	D	■	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.0Z6C-HXT	03298301	3	D	■	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.0Z6C-HXT	03298302	3	D	■	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.0Z6C-HXT	03298303	3	D	■	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.0Z6C-HXT	03298304	3	D	■	25,0	25,0	78,0	146,0	6,0	6	■

■ **Lagerstandard.**

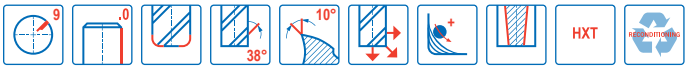
JS720

Hochleistung – Titan – Schaftfräser – 9 Schneiden – Zylindrisch – Eckenradius





D



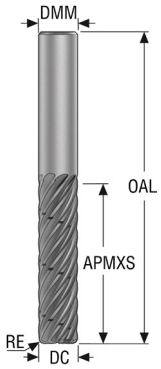
- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JS720100D2R050.0Z9-HXT	10067510	2	D	10,0	10,0	26,0	72,0	0,5	9	■
JS720100D2R100.0Z9-HXT	10067511	2	D	10,0	10,0	26,0	72,0	1,0	9	■
JS720100D2R200.0Z9-HXT	10067512	2	D	10,0	10,0	26,0	72,0	2,0	9	■
JS720120D2R050.0Z9-HXT	10067513	2	D	12,0	12,0	30,0	83,0	0,5	9	■
JS720120D2R100.0Z9-HXT	10067514	2	D	12,0	12,0	30,0	83,0	1,0	9	■
JS720120D2R200.0Z9-HXT	10067515	2	D	12,0	12,0	30,0	83,0	2,0	9	■
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	■
JS720250D2R100.0Z9-HXT	10008155	2	D	25,0	25,0	50,0	125,0	1,0	9	■
JS720250D2R200.0Z9-HXT	10008156	2	D	25,0	25,0	50,0	125,0	2,0	9	■
JS720250D2R300.0Z9-HXT	10008157	2	D	25,0	25,0	50,0	125,0	3,0	9	■
JS720100D3R050.0Z9-HXT	10067516	3	D	10,0	10,0	40,0	89,0	0,5	9	■
JS720100D3R100.0Z9-HXT	10067517	3	D	10,0	10,0	40,0	89,0	1,0	9	■
JS720100D3R200.0Z9-HXT	10067518	3	D	10,0	10,0	40,0	89,0	2,0	9	■
JS720120D3R050.0Z9-HXT	10067519	3	D	12,0	12,0	45,0	100,0	0,5	9	■
JS720120D3R100.0Z9-HXT	10067520	3	D	12,0	12,0	45,0	100,0	1,0	9	■
JS720120D3R200.0Z9-HXT	10067521	3	D	12,0	12,0	45,0	100,0	2,0	9	■
JS720160D3R100.0Z9-HXT	10008158	3	D	16,0	16,0	65,0	130,0	1,0	9	■
JS720160D3R200.0Z9-HXT	10008159	3	D	16,0	16,0	65,0	130,0	2,0	9	■
JS720160D3R300.0Z9-HXT	10008160	3	D	16,0	16,0	65,0	130,0	3,0	9	■
JS720200D3R100.0Z9-HXT	10008161	3	D	20,0	20,0	62,0	121,0	1,0	9	■
JS720200D3R200.0Z9-HXT	10008162	3	D	20,0	20,0	62,0	121,0	2,0	9	■
JS720200D3R300.0Z9-HXT	10008163	3	D	20,0	20,0	62,0	121,0	3,0	9	■
JS720250D3R100.0Z9-HXT	10008164	3	D	25,0	25,0	78,0	146,0	1,0	9	■
JS720250D3R200.0Z9-HXT	10008165	3	D	25,0	25,0	78,0	146,0	2,0	9	■
JS720250D3R300.0Z9-HXT	10008166	3	D	25,0	25,0	78,0	146,0	3,0	9	■

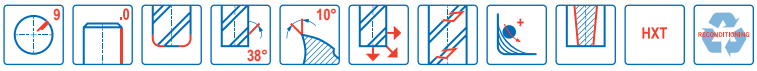
■ **Lagerstandard.**

JS720

Hochleistung – Titan – Schaftfräser – 9 Schneiden – Zylindrisch – Eckenradius



D





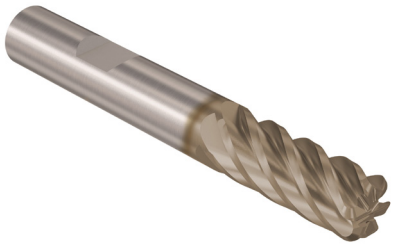
- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

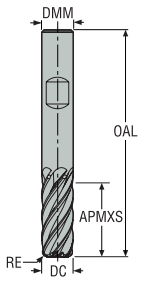
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JS720100D3R050.0Z9C-HXT	10067522	3	D	■	10,0	10,0	40,0	89,0	0,5	9	■
JS720100D3R100.0Z9C-HXT	10067523	3	D	■	10,0	10,0	40,0	89,0	1,0	9	■
JS720100D3R200.0Z9C-HXT	10067524	3	D	■	10,0	10,0	40,0	89,0	2,0	9	■
JS720120D3R050.0Z9C-HXT	10067525	3	D	■	12,0	12,0	45,0	100,0	0,5	9	■
JS720120D3R100.0Z9C-HXT	10067526	3	D	■	12,0	12,0	45,0	100,0	1,0	9	■
JS720120D3R200.0Z9C-HXT	10067527	3	D	■	12,0	12,0	45,0	100,0	2,0	9	■
JS720160D3R100.0Z9C-HXT	10067528	3	D	■	16,0	16,0	65,0	130,0	1,0	9	■
JS720160D3R200.0Z9C-HXT	10067529	3	D	■	16,0	16,0	65,0	130,0	2,0	9	■
JS720160D3R300.0Z9C-HXT	10067530	3	D	■	16,0	16,0	65,0	130,0	3,0	9	■
JS720200D3R100.0Z9C-HXT	10067531	3	D	■	20,0	20,0	62,0	121,0	1,0	9	■
JS720200D3R200.0Z9C-HXT	10067532	3	D	■	20,0	20,0	62,0	121,0	2,0	9	■
JS720200D3R300.0Z9C-HXT	10067533	3	D	■	20,0	20,0	62,0	121,0	3,0	9	■
JS720250D3R100.0Z9C-HXT	10067534	3	D	■	25,0	25,0	78,0	146,0	1,0	9	■
JS720250D3R200.0Z9C-HXT	10067535	3	D	■	25,0	25,0	78,0	146,0	2,0	9	■
JS720250D3R300.0Z9C-HXT	10067536	3	D	■	25,0	25,0	78,0	146,0	3,0	9	■

■ **Lagerstandard.**

JS720

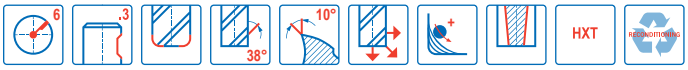
Hochleistung – Titan – Schaftfräser – 6 Schneiden – Weldon – Eckenradius





D

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

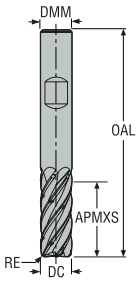


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.3Z6-HXT	03061295	2	D	8,0	8,0	23,0	63,0	1,0	6	☐
JS720100D2R050.3Z6-HXT	03060342	2	D	10,0	10,0	26,0	72,0	0,5	6	☐
JS720100D2R100.3Z6-HXT	03060344	2	D	10,0	10,0	26,0	72,0	1,0	6	☐
JS720100D2R200.3Z6-HXT	03060345	2	D	10,0	10,0	26,0	72,0	2,0	6	☐
JS720100D2R300.3Z6-HXT	03060346	2	D	10,0	10,0	26,0	72,0	3,0	6	☐
JS720120D2R050.3Z6-HXT	03060347	2	D	12,0	12,0	30,0	83,0	0,5	6	☐
JS720120D2R100.3Z6-HXT	03060349	2	D	12,0	12,0	30,0	83,0	1,0	6	☐
JS720120D2R200.3Z6-HXT	03060350	2	D	12,0	12,0	30,0	83,0	2,0	6	☐
JS720120D2R300.3Z6-HXT	03060351	2	D	12,0	12,0	30,0	83,0	3,0	6	☐
JS720160D2R050.3Z6-HXT	03060352	2	D	16,0	16,0	44,0	99,0	0,5	6	☐
JS720160D2R100.3Z6-HXT	03060354	2	D	16,0	16,0	44,0	99,0	1,0	6	☐
JS720160D2R200.3Z6-HXT	03060355	2	D	16,0	16,0	44,0	99,0	2,0	6	☐
JS720160D2R300.3Z6-HXT	03060356	2	D	16,0	16,0	44,0	99,0	3,0	6	☐
JS720160D2R400.3Z6-HXT	03060357	2	D	16,0	16,0	44,0	99,0	4,0	6	☐
JS720160D2R600.3Z6-HXT	03060358	2	D	16,0	16,0	44,0	99,0	6,0	6	☐
JS720200D3R050.3Z6-HXT	03060359	3	D	20,0	20,0	62,0	121,0	0,5	6	☐
JS720200D3R100.3Z6-HXT	03060361	3	D	20,0	20,0	62,0	121,0	1,0	6	☐
JS720200D3R200.3Z6-HXT	03060362	3	D	20,0	20,0	62,0	121,0	2,0	6	☐
JS720200D3R300.3Z6-HXT	03060363	3	D	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R400.3Z6-HXT	03060364	3	D	20,0	20,0	62,0	121,0	4,0	6	☐
JS720200D3R500.3Z6-HXT	03060365	3	D	20,0	20,0	62,0	121,0	5,0	6	☐
JS720200D3R600.3Z6-HXT	03060366	3	D	20,0	20,0	62,0	121,0	6,0	6	☐
JS720250D3R050.3Z6-HXT	03060367	3	D	25,0	25,0	78,0	146,0	0,5	6	☐
JS720250D3R100.3Z6-HXT	03060368	3	D	25,0	25,0	78,0	146,0	1,0	6	☐
JS720250D3R200.3Z6-HXT	03060369	3	D	25,0	25,0	78,0	146,0	2,0	6	☐
JS720250D3R300.3Z6-HXT	03060370	3	D	25,0	25,0	78,0	146,0	3,0	6	☐
JS720250D3R400.3Z6-HXT	03060371	3	D	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.3Z6-HXT	03060372	3	D	25,0	25,0	78,0	146,0	6,0	6	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

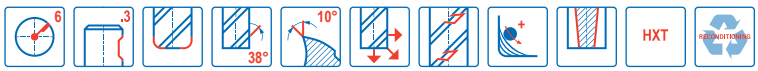
JS720

Hochleistung – Titan – Schaftfräser – 6 Schneiden – Weldon – Eckenradius – Spanteiler



D





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Spanteiler
- Nachschleifen möglich

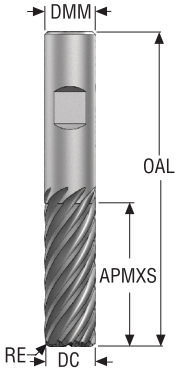
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	6	□
JS720120D2R050.3Z6C-HXT	03060348	2	D	■	12,0	12,0	30,0	83,0	0,5	6	□
JS720120D2R100.3Z6C-HXT	03298308	2	D	■	12,0	12,0	30,0	83,0	1,0	6	□
JS720120D2R200.3Z6C-HXT	03298309	2	D	■	12,0	12,0	30,0	83,0	2,0	6	□
JS720120D2R250.3Z6C-HXT	03298310	2	D	■	12,0	12,0	30,0	83,0	2,5	6	□
JS720120D2R300.3Z6C-HXT	03298311	2	D	■	12,0	12,0	30,0	83,0	3,0	6	□
JS720120D2R310.3Z6C-HXT	03298312	2	D	■	12,0	12,0	30,0	83,0	3,1	6	□
JS720160D2R050.3Z6C-HXT	03060353	2	D	■	16,0	16,0	44,0	99,0	0,5	6	■
JS720160D2R100.3Z6C-HXT	03298313	2	D	■	16,0	16,0	44,0	99,0	1,0	6	■
JS720160D2R200.3Z6C-HXT	03298314	2	D	■	16,0	16,0	44,0	99,0	2,0	6	■
JS720160D2R250.3Z6C-HXT	03298315	2	D	■	16,0	16,0	44,0	99,0	2,5	6	■
JS720160D2R300.3Z6C-HXT	03298316	2	D	■	16,0	16,0	44,0	99,0	3,0	6	■
JS720160D2R310.3Z6C-HXT	03298317	2	D	■	16,0	16,0	44,0	99,0	3,1	6	■
JS720160D2R400.3Z6C-HXT	03298318	2	D	■	16,0	16,0	44,0	99,0	4,0	6	■
JS720160D2R600.3Z6C-HXT	03298319	2	D	■	16,0	16,0	44,0	99,0	6,0	6	■
JS720200D3R050.3Z6C-HXT	03060360	3	D	■	20,0	20,0	62,0	121,0	0,5	6	■
JS720200D3R100.3Z6C-HXT	03298320	3	D	■	20,0	20,0	62,0	121,0	1,0	6	■
JS720200D3R200.3Z6C-HXT	03298321	3	D	■	20,0	20,0	62,0	121,0	2,0	6	■
JS720200D3R250.3Z6C-HXT	03298322	3	D	■	20,0	20,0	62,0	121,0	2,5	6	■
JS720200D3R300.3Z6C-HXT	03298323	3	D	■	20,0	20,0	62,0	121,0	3,0	6	■
JS720200D3R310.3Z6C-HXT	03298324	3	D	■	20,0	20,0	62,0	121,0	3,1	6	■
JS720200D3R400.3Z6C-HXT	03298325	3	D	■	20,0	20,0	62,0	121,0	4,0	6	■
JS720200D3R500.3Z6C-HXT	03298326	3	D	■	20,0	20,0	62,0	121,0	5,0	6	■
JS720200D3R600.3Z6C-HXT	03298327	3	D	■	20,0	20,0	62,0	121,0	6,0	6	■
JS720250D3R050.3Z6C-HXT	03066460	3	D	■	25,0	25,0	78,0	146,0	0,5	6	■
JS720250D3R100.3Z6C-HXT	03298328	3	D	■	25,0	25,0	78,0	146,0	1,0	6	■
JS720250D3R200.3Z6C-HXT	03298329	3	D	■	25,0	25,0	78,0	146,0	2,0	6	■
JS720250D3R300.3Z6C-HXT	03298330	3	D	■	25,0	25,0	78,0	146,0	3,0	6	■
JS720250D3R400.3Z6C-HXT	03298331	3	D	■	25,0	25,0	78,0	146,0	4,0	6	■
JS720250D3R600.3Z6C-HXT	03298332	3	D	■	25,0	25,0	78,0	146,0	6,0	6	■

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

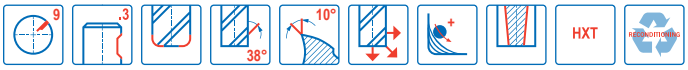
JS720

Hochleistung – Titan – Schaftfräser – 9 Schneiden – Weldon – Eckenradius





D



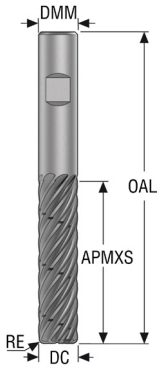
- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JS720100D2R050.3Z9-HXT	10067881	2	D	10,0	10,0	26,0	72,0	0,5	9	☐
JS720100D2R100.3Z9-HXT	10067882	2	D	10,0	10,0	26,0	72,0	1,0	9	☐
JS720100D2R200.3Z9-HXT	10067883	2	D	10,0	10,0	26,0	72,0	2,0	9	☐
JS720120D2R050.3Z9-HXT	10067884	2	D	12,0	12,0	30,0	83,0	0,5	9	☐
JS720120D2R100.3Z9-HXT	10067885	2	D	12,0	12,0	30,0	83,0	1,0	9	☐
JS720120D2R200.3Z9-HXT	10067886	2	D	12,0	12,0	30,0	83,0	2,0	9	☐
JS720160D2R100.3Z9-HXT	10008279	2	D	16,0	16,0	44,0	99,0	1,0	9	☐
JS720160D2R200.3Z9-HXT	10008280	2	D	16,0	16,0	44,0	99,0	2,0	9	☐
JS720160D2R300.3Z9-HXT	10008281	2	D	16,0	16,0	44,0	99,0	3,0	9	☐
JS720250D2R100.3Z9-HXT	10008282	2	D	25,0	25,0	50,0	125,0	1,0	9	☐
JS720250D2R200.3Z9-HXT	10008283	2	D	25,0	25,0	50,0	125,0	2,0	9	☐
JS720250D2R300.3Z9-HXT	10008284	2	D	25,0	25,0	50,0	125,0	3,0	9	☐
JS720100D3R050.3Z9-HXT	10067887	3	D	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.3Z9-HXT	10067888	3	D	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.3Z9-HXT	10067889	3	D	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.3Z9-HXT	10067890	3	D	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.3Z9-HXT	10067891	3	D	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.3Z9-HXT	10067892	3	D	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.3Z9-HXT	10008285	3	D	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.3Z9-HXT	10008286	3	D	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.3Z9-HXT	10008287	3	D	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.3Z9-HXT	10008288	3	D	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.3Z9-HXT	10008289	3	D	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.3Z9-HXT	10008290	3	D	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.3Z9-HXT	10008292	3	D	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.3Z9-HXT	10008293	3	D	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.3Z9-HXT	10008294	3	D	25,0	25,0	78,0	146,0	3,0	9	☐

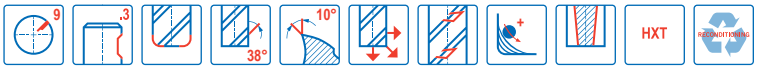
☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS720

Hochleistung – Titan – Schaftfräser – 9 Schneiden – Zylindrisch – Eckenradius



D





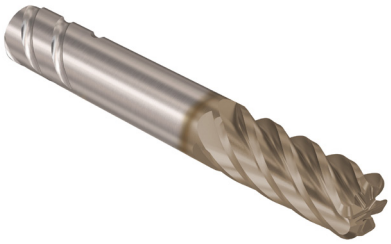
- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

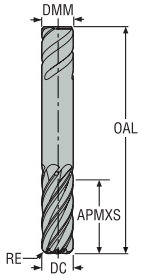
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JS720100D3R050.3Z9C-HXT	10067893	3	D	■	10,0	10,0	40,0	89,0	0,5	9	□
JS720100D3R100.3Z9C-HXT	10067894	3	D	■	10,0	10,0	40,0	89,0	1,0	9	□
JS720100D3R200.3Z9C-HXT	10067895	3	D	■	10,0	10,0	40,0	89,0	2,0	9	□
JS720120D3R050.3Z9C-HXT	10067897	3	D	■	12,0	12,0	45,0	100,0	0,5	9	□
JS720120D3R100.3Z9C-HXT	10067898	3	D	■	12,0	12,0	45,0	100,0	1,0	9	□
JS720120D3R200.3Z9C-HXT	10067899	3	D	■	12,0	12,0	45,0	100,0	2,0	9	□
JS720160D3R100.3Z9C-HXT	10067900	3	D	■	16,0	16,0	65,0	130,0	1,0	9	□
JS720160D3R200.3Z9C-HXT	10067901	3	D	■	16,0	16,0	65,0	130,0	2,0	9	□
JS720160D3R300.3Z9C-HXT	10067902	3	D	■	16,0	16,0	65,0	130,0	3,0	9	□
JS720200D3R100.3Z9C-HXT	10067903	3	D	■	20,0	20,0	62,0	121,0	1,0	9	□
JS720200D3R200.3Z9C-HXT	10067904	3	D	■	20,0	20,0	62,0	121,0	2,0	9	□
JS720200D3R300.3Z9C-HXT	10067905	3	D	■	20,0	20,0	62,0	121,0	3,0	9	□
JS720250D3R100.3Z9C-HXT	10067906	3	D	■	25,0	25,0	78,0	146,0	1,0	9	□
JS720250D3R200.3Z9C-HXT	10067907	3	D	■	25,0	25,0	78,0	146,0	2,0	9	□
JS720250D3R300.3Z9C-HXT	10067908	3	D	■	25,0	25,0	78,0	146,0	3,0	9	□

■ **Lagerstandard.**

JS720

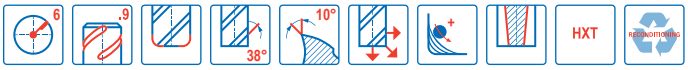
Hochleistung – Titan – Schaftfräser – 6 Schneiden – Safe-Lock – Eckenradius





D

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

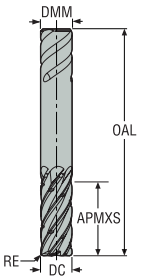


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm		
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	☐
JS720080D2R100.9Z6-HXT	03061296	2	D	8,0	8,0	23,0	63,0	1,0	6	☐
JS720100D2R050.9Z6-HXT	03060377	2	D	10,0	10,0	26,0	72,0	0,5	6	☐
JS720100D2R100.9Z6-HXT	03060379	2	D	10,0	10,0	26,0	72,0	1,0	6	☐
JS720100D2R200.9Z6-HXT	03060380	2	D	10,0	10,0	26,0	72,0	2,0	6	☐
JS720100D2R300.9Z6-HXT	03060381	2	D	10,0	10,0	26,0	72,0	3,0	6	☐
JS720120D2R050.9Z6-HXT	03060382	2	D	12,0	12,0	30,0	83,0	0,5	6	☐
JS720120D2R100.9Z6-HXT	03060384	2	D	12,0	12,0	30,0	83,0	1,0	6	☐
JS720120D2R200.9Z6-HXT	03060385	2	D	12,0	12,0	30,0	83,0	2,0	6	☐
JS720120D2R300.9Z6-HXT	03060386	2	D	12,0	12,0	30,0	83,0	3,0	6	☐
JS720160D2R050.9Z6-HXT	03060387	2	D	16,0	16,0	44,0	99,0	0,5	6	☐
JS720160D2R100.9Z6-HXT	03060389	2	D	16,0	16,0	44,0	99,0	1,0	6	☐
JS720160D2R200.9Z6-HXT	03060390	2	D	16,0	16,0	44,0	99,0	2,0	6	☐
JS720160D2R300.9Z6-HXT	03060391	2	D	16,0	16,0	44,0	99,0	3,0	6	☐
JS720160D2R400.9Z6-HXT	03060392	2	D	16,0	16,0	44,0	99,0	4,0	6	☐
JS720160D2R600.9Z6-HXT	03060393	2	D	16,0	16,0	44,0	99,0	6,0	6	☐
JS720200D3R050.9Z6-HXT	03060394	3	D	20,0	20,0	62,0	121,0	0,5	6	☐
JS720200D3R100.9Z6-HXT	03060396	3	D	20,0	20,0	62,0	121,0	1,0	6	☐
JS720200D3R200.9Z6-HXT	03060397	3	D	20,0	20,0	62,0	121,0	2,0	6	☐
JS720200D3R300.9Z6-HXT	03060398	3	D	20,0	20,0	62,0	121,0	3,0	6	☐
JS720200D3R400.9Z6-HXT	03060399	3	D	20,0	20,0	62,0	121,0	4,0	6	☐
JS720200D3R500.9Z6-HXT	03060400	3	D	20,0	20,0	62,0	121,0	5,0	6	☐
JS720200D3R600.9Z6-HXT	03060401	3	D	20,0	20,0	62,0	121,0	6,0	6	☐
JS720250D3R050.9Z6-HXT	03060402	3	D	25,0	25,0	78,0	146,0	0,5	6	☐
JS720250D3R100.9Z6-HXT	03060403	3	D	25,0	25,0	78,0	146,0	1,0	6	☐
JS720250D3R200.9Z6-HXT	03060404	3	D	25,0	25,0	78,0	146,0	2,0	6	☐
JS720250D3R300.9Z6-HXT	03060405	3	D	25,0	25,0	78,0	146,0	3,0	6	☐
JS720250D3R400.9Z6-HXT	03060406	3	D	25,0	25,0	78,0	146,0	4,0	6	☐
JS720250D3R600.9Z6-HXT	03060407	3	D	25,0	25,0	78,0	146,0	6,0	6	☐

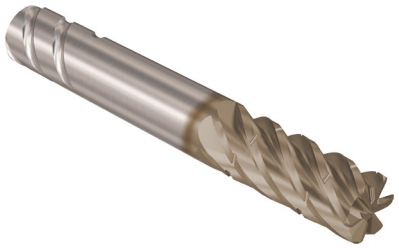
☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

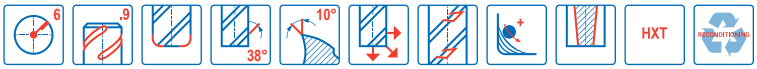
JS720

Hochleistung – Titan – Schaftfräser – 6 Schneiden – Safe-Lock – Eckenradius – Spanteiler



D





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Spanteiler
- Nachschleifen möglich

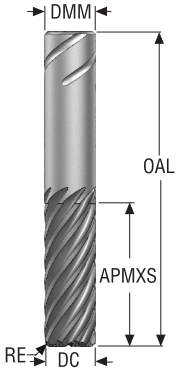
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm		
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	□
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	□
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	30,0	83,0	1,0	6	□
JS720120D2R200.9Z6C-HXT	03298335	2	D	■	12,0	12,0	30,0	83,0	2,0	6	□
JS720120D2R250.9Z6C-HXT	03298336	2	D	■	12,0	12,0	30,0	83,0	2,5	6	□
JS720120D2R300.9Z6C-HXT	03298337	2	D	■	12,0	12,0	30,0	83,0	3,0	6	□
JS720120D2R310.9Z6C-HXT	03298338	2	D	■	12,0	12,0	30,0	83,0	3,1	6	□
JS720160D2R050.9Z6C-HXT	03060388	2	D	■	16,0	16,0	44,0	99,0	0,5	6	□
JS720160D2R100.9Z6C-HXT	03298339	2	D	■	16,0	16,0	44,0	99,0	1,0	6	□
JS720160D2R200.9Z6C-HXT	03298340	2	D	■	16,0	16,0	44,0	99,0	2,0	6	□
JS720160D2R250.9Z6C-HXT	03298341	2	D	■	16,0	16,0	44,0	99,0	2,5	6	□
JS720160D2R300.9Z6C-HXT	03298342	2	D	■	16,0	16,0	44,0	99,0	3,0	6	□
JS720160D2R310.9Z6C-HXT	03298343	2	D	■	16,0	16,0	44,0	99,0	3,1	6	□
JS720160D2R400.9Z6C-HXT	03298344	2	D	■	16,0	16,0	44,0	99,0	4,0	6	□
JS720160D2R600.9Z6C-HXT	03298345	2	D	■	16,0	16,0	44,0	99,0	6,0	6	□
JS720200D3R050.9Z6C-HXT	03060395	3	D	■	20,0	20,0	62,0	121,0	0,5	6	□
JS720200D3R100.9Z6C-HXT	03298346	3	D	■	20,0	20,0	62,0	121,0	1,0	6	□
JS720200D3R200.9Z6C-HXT	03298347	3	D	■	20,0	20,0	62,0	121,0	2,0	6	□
JS720200D3R250.9Z6C-HXT	03298348	3	D	■	20,0	20,0	62,0	121,0	2,5	6	□
JS720200D3R300.9Z6C-HXT	03298349	3	D	■	20,0	20,0	62,0	121,0	3,0	6	□
JS720200D3R310.9Z6C-HXT	03298350	3	D	■	20,0	20,0	62,0	121,0	3,1	6	□
JS720200D3R400.9Z6C-HXT	03298351	3	D	■	20,0	20,0	62,0	121,0	4,0	6	□
JS720200D3R500.9Z6C-HXT	03298352	3	D	■	20,0	20,0	62,0	121,0	5,0	6	□
JS720200D3R600.9Z6C-HXT	03298353	3	D	■	20,0	20,0	62,0	121,0	6,0	6	□
JS720250D3R050.9Z6C-HXT	03066461	3	D	■	25,0	25,0	78,0	146,0	0,5	6	□
JS720250D3R100.9Z6C-HXT	03298354	3	D	■	25,0	25,0	78,0	146,0	1,0	6	□
JS720250D3R200.9Z6C-HXT	03298355	3	D	■	25,0	25,0	78,0	146,0	2,0	6	□
JS720250D3R300.9Z6C-HXT	03298356	3	D	■	25,0	25,0	78,0	146,0	3,0	6	□
JS720250D3R400.9Z6C-HXT	03298357	3	D	■	25,0	25,0	78,0	146,0	4,0	6	□
JS720250D3R600.9Z6C-HXT	03298358	3	D	■	25,0	25,0	78,0	146,0	6,0	6	□

■ **Lagerstandard.**

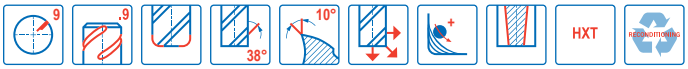
JS720

Hochleistung – Titan – Schaftfräser – 9 Schneiden – Safe-Lock – Eckenradius





D



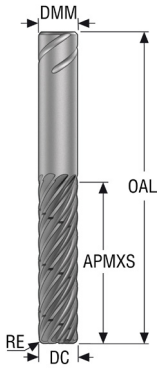
- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Safe-Lock
				mm	mm	mm	mm	mm		
JS720100D2R050.9Z9-HXT	10067909	2	D	10,0	10,0	26,0	72,0	0,5	9	☐
JS720100D2R100.9Z9-HXT	10067910	2	D	10,0	10,0	26,0	72,0	1,0	9	☐
JS720100D2R200.9Z9-HXT	10067911	2	D	10,0	10,0	26,0	72,0	2,0	9	☐
JS720120D2R050.9Z9-HXT	10067912	2	D	12,0	12,0	30,0	83,0	0,5	9	☐
JS720120D2R100.9Z9-HXT	10067913	2	D	12,0	12,0	30,0	83,0	1,0	9	☐
JS720120D2R200.9Z9-HXT	10067914	2	D	12,0	12,0	30,0	83,0	2,0	9	☐
JS720160D2R100.9Z9-HXT	10008295	2	D	16,0	16,0	44,0	99,0	1,0	9	☐
JS720160D2R200.9Z9-HXT	10008296	2	D	16,0	16,0	44,0	99,0	2,0	9	☐
JS720160D2R300.9Z9-HXT	10008297	2	D	16,0	16,0	44,0	99,0	3,0	9	☐
JS720250D2R100.9Z9-HXT	10008298	2	D	25,0	25,0	50,0	125,0	1,0	9	☐
JS720250D2R200.9Z9-HXT	10008299	2	D	25,0	25,0	50,0	125,0	2,0	9	☐
JS720250D2R300.9Z9-HXT	10008300	2	D	25,0	25,0	50,0	125,0	3,0	9	☐
JS720100D3R050.9Z9-HXT	10067915	3	D	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.9Z9-HXT	10067916	3	D	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.9Z9-HXT	10067917	3	D	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.9Z9-HXT	10067918	3	D	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.9Z9-HXT	10067919	3	D	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.9Z9-HXT	10067921	3	D	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.9Z9-HXT	10008301	3	D	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.9Z9-HXT	10008302	3	D	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.9Z9-HXT	10008303	3	D	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.9Z9-HXT	10008304	3	D	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.9Z9-HXT	10008305	3	D	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.9Z9-HXT	10008306	3	D	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.9Z9-HXT	10008307	3	D	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.9Z9-HXT	10008308	3	D	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.9Z9-HXT	10008309	3	D	25,0	25,0	78,0	146,0	3,0	9	☐

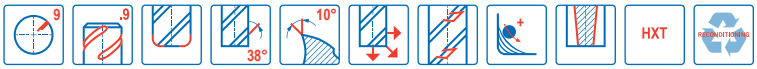
☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS720

Hochleistung – Titan – Schaftfräser – 6 Schneiden – Safe-Lock – Eckenradius







- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm		
JS720100D3R050.9Z9C-HXT	10067922	3	D	■	10,0	10,0	40,0	89,0	0,5	9	☐
JS720100D3R100.9Z9C-HXT	10067923	3	D	■	10,0	10,0	40,0	89,0	1,0	9	☐
JS720100D3R200.9Z9C-HXT	10067924	3	D	■	10,0	10,0	40,0	89,0	2,0	9	☐
JS720120D3R050.9Z9C-HXT	10067925	3	D	■	12,0	12,0	45,0	100,0	0,5	9	☐
JS720120D3R100.9Z9C-HXT	10067926	3	D	■	12,0	12,0	45,0	100,0	1,0	9	☐
JS720120D3R200.9Z9C-HXT	10067927	3	D	■	12,0	12,0	45,0	100,0	2,0	9	☐
JS720160D3R100.9Z9C-HXT	10067928	3	D	■	16,0	16,0	65,0	130,0	1,0	9	☐
JS720160D3R200.9Z9C-HXT	10067929	3	D	■	16,0	16,0	65,0	130,0	2,0	9	☐
JS720160D3R300.9Z9C-HXT	10067930	3	D	■	16,0	16,0	65,0	130,0	3,0	9	☐
JS720200D3R100.9Z9C-HXT	10067931	3	D	■	20,0	20,0	62,0	121,0	1,0	9	☐
JS720200D3R200.9Z9C-HXT	10067932	3	D	■	20,0	20,0	62,0	121,0	2,0	9	☐
JS720200D3R300.9Z9C-HXT	10067933	3	D	■	20,0	20,0	62,0	121,0	3,0	9	☐
JS720250D3R100.9Z9C-HXT	10067934	3	D	■	25,0	25,0	78,0	146,0	1,0	9	☐
JS720250D3R200.9Z9C-HXT	10067935	3	D	■	25,0	25,0	78,0	146,0	2,0	9	☐
JS720250D3R300.9Z9C-HXT	10067936	3	D	■	25,0	25,0	78,0	146,0	3,0	9	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS720 Eckfräsen PCEDC =6

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	140 (110–180) *460 (370 — 590)*
M2	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	115 (91–150) *375 (300 — 490)*
M3	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	90 (72–120) *295 (240 — 390)*
M4	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78–120) *345 (260 — 390)*
M5	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	85 (65–100) *280 (220 — 320)*
S1	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	41 (28 — 68) *135 (92 — 220)*
S2	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	33 (22 — 54) *110 (73–170)*
S3	E	2.6 *2,6*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	29 (20 — 47) *95 (66–150)*
S11	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	135 (110–160) *445 (370 — 520)*
S12	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78–120) *345 (260 — 390)*
S13	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78–120) *345 (260 — 390)*

Schnittdaten – JS720 Eckfräsen dynamisches Fräsen a_e/DC=0,07 PCEDC =6

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	110 (85–140) *360 (280 — 450)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	90 (70–110) *295 (230 — 360)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	70 (55 — 99) *230 (190 — 320)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	65 (50 — 83) *215 (170 — 270)*
S1	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	43 (29–71) *140 (96 — 230)*
S2	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	34 (23 — 57) *110 (76–180)*
S3	E	0.0500 *0,0500*	2.6 *2,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	30 (20 — 49) *100 (66–160)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	105 (78–120) *345 (260 — 390)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*

Schnittdaten – JS720 Eckfräsen dynamisches Fräsen a_e/DC=0,07 PCEDC =9

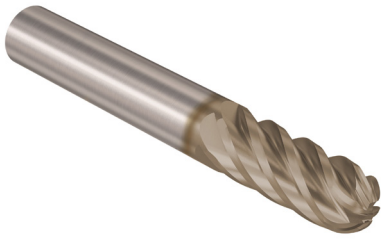
SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
M1	E	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	125 (98–160) *410 (330 — 520)*
M2	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (82–130) *345 (270 — 420)*
M3	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	80 (64–110) *260 (210 — 360)*
M4	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70–110) *310 (230 — 360)*
M5	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	75 (59 — 96) *245 (200 — 310)*
S1	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	37 (25 — 61) *120 (83 — 200)*
S2	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	30 (20 — 49) *100 (66–160)*
S3	E	2.8 *2,8*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	26 (18 — 43) *85 (60–140)*
S11	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	120 (91–150) *395 (300 — 490)*
S12	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70–110) *310 (230 — 360)*
S13	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70–110) *310 (230 — 360)*

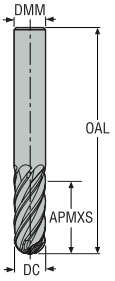
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS730

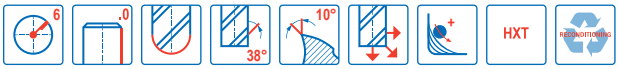
Hochleistung – Titan – Kugelkopf – 6 Schneiden – Zylindrisch





D

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich

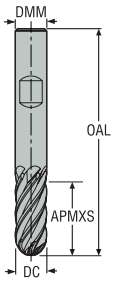


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	6	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	6	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	6	■
JS730120D2B.0Z6-HXT	03067608	2	D	12,0	12,0	30,0	83,0	6	■
JS730160D2B.0Z6-HXT	03067609	2	D	16,0	16,0	44,0	99,0	6	■
JS730200D3B.0Z6-HXT	03067610	3	D	20,0	20,0	62,0	121,0	6	■
JS730250D3B.0Z6-HXT	03067611	3	D	25,0	25,0	78,0	146,0	6	■

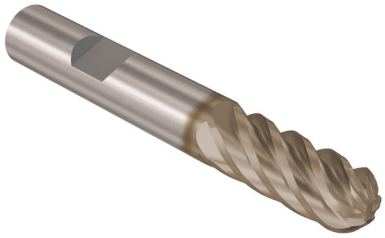
■ **Lagerstandard.**

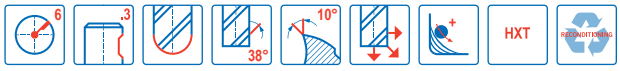
JS730

Hochleistung – Titan – Kugelkopf – 6 Schneiden – Weldon



D





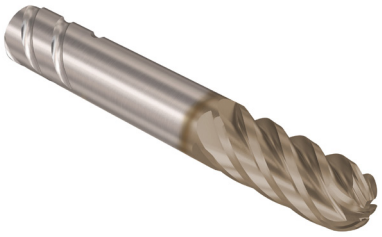
- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich

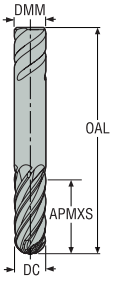
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	12,0	30,0	83,0	6	☐
JS730160D2B.3Z6-HXT	03067782	2	D	16,0	16,0	44,0	99,0	6	☐
JS730200D3B.3Z6-HXT	03067783	3	D	20,0	20,0	62,0	121,0	6	☐
JS730250D3B.3Z6-HXT	03067784	3	D	25,0	25,0	78,0	146,0	6	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS730

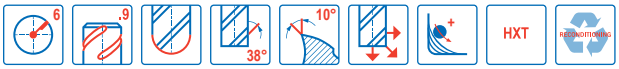
Hochleistung – Titan – Kugelkopf – 6 Schneiden – Safe-Lock





D

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Safe-Lock
				mm	mm	mm	mm		
JS730060D2B.9Z6-HXT	03067785	2	D	6,0	6,0	17,0	57,0	6	☐
JS730080D2B.9Z6-HXT	03067786	2	D	8,0	8,0	23,0	63,0	6	☐
JS730100D2B.9Z6-HXT	03067787	2	D	10,0	10,0	26,0	72,0	6	☐
JS730120D2B.9Z6-HXT	03067788	2	D	12,0	12,0	30,0	83,0	6	☐
JS730160D2B.9Z6-HXT	03067789	2	D	16,0	16,0	44,0	99,0	6	☐
JS730200D3B.9Z6-HXT	03067790	3	D	20,0	20,0	62,0	121,0	6	☐
JS730250D3B.9Z6-HXT	03067791	3	D	25,0	25,0	78,0	146,0	6	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS730 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (87–140) *445 (290 — 450)*
M2	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	110 (70–110) *360 (230 — 360)*
M3	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	85 (55 — 99) *280 (190 — 320)*
M4	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (57–100) *295 (190 — 320)*
M5	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (47 — 85) *245 (160 — 270)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	130 (79–130) *425 (260 — 420)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (61–100) *330 (210 — 320)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	100 (62–100) *330 (210 — 320)*

Schnittdaten – JS730 Eckfräsen dynamisches Fräsen a_e/DC=0,07

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	145 (91–150) *475 (300 — 490)*
M2	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	115 (73–120) *375 (240 — 390)*
M3	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	90 (58–100) *295 (200 — 320)*
M4	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	95 (59–100) *310 (200 — 320)*
M5	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	80 (50 — 89) *260 (170 — 290)*
S11	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (94–150) *490 (310 — 490)*
S12	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	115 (72–110) *375 (240 — 360)*
S13	E	1.9 *1,9*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	120 (74–120) *395 (250 — 390)*

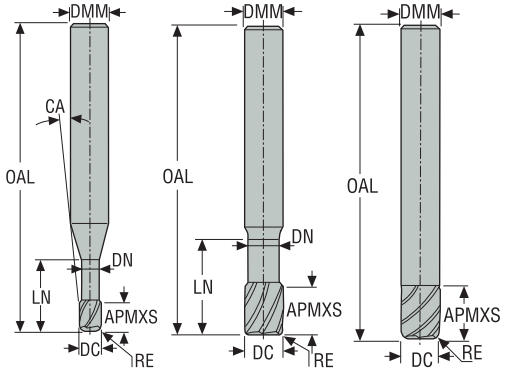
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHP750

Hochleistung – Titan – Schaftfräser – 2-4 Schneiden – Zylindrisch – Eckenradius







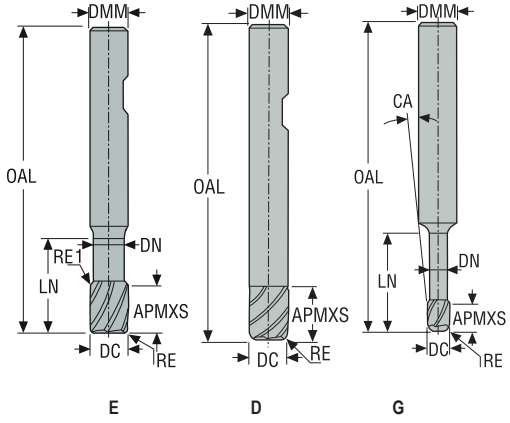
- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	–		
750K080R040.0-TRIBON	02528232	1	D	8,0	8,0	16,0	55,0	–	–	0,4	–	4	■
750K100R040.0-TRIBON	02528234	1	D	10,0	10,0	20,0	65,0	–	–	0,4	–	4	■
750K100R150.0-TRIBON	02528236	1	D	10,0	10,0	20,0	65,0	–	–	1,5	–	4	■
750K120R040.0-TRIBON	02528238	1	D	12,0	12,0	24,0	75,0	–	–	0,4	–	4	■
750K120R150.0-TRIBON	02528242	1	D	12,0	12,0	24,0	75,0	–	–	1,5	–	4	■
750K160R040.0-TRIBON	02528244	1	D	16,0	16,0	32,0	90,0	–	–	0,4	–	4	■
750K160R150.0-TRIBON	02528250	1	D	16,0	16,0	32,0	90,0	–	–	1,5	–	4	■
750K200R080.0-TRIBON	02528253	1	D	20,0	20,0	40,0	100,0	–	–	0,8	–	4	■
750020R020.0-TRIBON	02510010	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	4,0	2	■
750030R020.0-TRIBON	02510012	2	E	3,0	3,0	4,5	40,0	9,0	2,8	0,2	–	2	■
750040R020.0-TRIBON	02510013	2	G	4,0	6,0	6,0	40,0	9,0	3,7	0,2	5,0	2	■
750050R030.0-TRIBON	02510043	2	G	5,0	6,0	7,5	40,0	9,0	4,6	0,3	3,0	2	■
750060R030.0-TRIBON	02510044	2	E	6,0	6,0	9,0	50,0	19,0	5,6	0,3	–	3	■
750080R040.0-TRIBON	02510045	2	E	8,0	8,0	16,0	60,0	24,0	7,4	0,4	–	4	■
750100R040.0-TRIBON	02510046	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,4	–	4	■
750100R080.0-TRIBON	02510049	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,8	–	4	■
750100R200.0-TRIBON	02510053	2	E	10,0	10,0	20,0	70,0	30,0	9,4	2,0	–	4	■
750120R040.0-TRIBON	02510057	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,4	–	4	■
750120R080.0-TRIBON	02510060	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,8	–	4	■
750120R200.0-TRIBON	02510063	2	E	12,0	12,0	24,0	80,0	35,0	11,4	2,0	–	4	■
750120R310.0-TRIBON	02510065	2	E	12,0	12,0	24,0	80,0	35,0	11,4	3,1	–	4	■
750140R080.0-TRIBON	02510067	2	E	14,0	14,0	28,0	90,0	45,0	13,4	0,8	–	4	■
750160R040.0-TRIBON	02510071	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,4	–	4	■
750160R080.0-TRIBON	02510073	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,8	–	4	■
750160R200.0-TRIBON	02510077	2	E	16,0	16,0	32,0	100,0	52,0	15,4	2,0	–	4	■
750200R080.0-TRIBON	02510085	2	E	20,0	20,0	40,0	125,0	75,0	19,4	0,8	–	4	■
750200R200.0-TRIBON	02510087	2	E	20,0	20,0	40,0	125,0	75,0	19,4	2,0	–	4	■

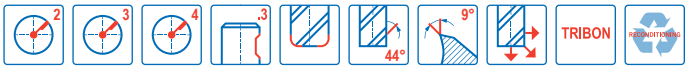
■ **Lagerstandard.**

JHP750

Hochleistung – Titan – Schaftfräser – 2-4 Schneiden – Weldon – Eckenradius







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	–		
750K080R040-TRIBON	02528231	1	D	8,0	8,0	16,0	55,0	–	–	0,4	–	4	■
750K100R040-TRIBON	02528233	1	D	10,0	10,0	20,0	65,0	–	–	0,4	–	4	■
750K100R150-TRIBON	02528235	1	D	10,0	10,0	20,0	65,0	–	–	1,5	–	4	■
750K120R040-TRIBON	02528237	1	D	12,0	12,0	24,0	75,0	–	–	0,4	–	4	■
750K120R150-TRIBON	02528240	1	D	12,0	12,0	24,0	75,0	–	–	1,5	–	4	■
750K160R040-TRIBON	02528243	1	D	16,0	16,0	32,0	90,0	–	–	0,4	–	4	■
750K160R150-TRIBON	02528249	1	D	16,0	16,0	32,0	90,0	–	–	1,5	–	4	■
750K200R080-TRIBON	02528251	1	D	20,0	20,0	40,0	100,0	–	–	0,8	–	4	■
750040R020.0-TRIBONW	02669407	2	G	4,0	6,0	6,0	40,0	9,0	3,7	0,2	5,0	2	□
750050R030.0-TRIBONW	02669408	2	G	5,0	6,0	7,5	40,0	9,0	4,6	0,3	3,0	2	□
750060R030.0-TRIBONW	02669409	2	E	6,0	6,0	9,0	50,0	19,0	5,6	0,3	–	3	□
750080R040-TRIBON	02528258	2	E	8,0	8,0	16,0	60,0	24,0	7,4	0,4	–	4	■
750100R040-TRIBON	02510047	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,4	–	4	■
750100R080-TRIBON	02510048	2	E	10,0	10,0	20,0	70,0	30,0	9,4	0,8	–	4	■
750100R200-TRIBON	02510052	2	E	10,0	10,0	20,0	70,0	30,0	9,4	2,0	–	4	■
750120R040-TRIBON	02510056	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,4	–	4	■
750120R080-TRIBON	02510058	2	E	12,0	12,0	24,0	80,0	35,0	11,4	0,8	–	4	■
750120R200-TRIBON	02510062	2	E	12,0	12,0	24,0	80,0	35,0	11,4	2,0	–	4	■
750120R310-TRIBON	02510064	2	E	12,0	12,0	24,0	80,0	35,0	11,4	3,1	–	4	■
750140R080-TRIBON	02510066	2	E	14,0	14,0	28,0	90,0	45,0	13,4	0,8	–	4	■
750160R040-TRIBON	02510070	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,4	–	4	■
750160R080-TRIBON	02510072	2	E	16,0	16,0	32,0	100,0	52,0	15,4	0,8	–	4	■
750160R200-TRIBON	02510076	2	E	16,0	16,0	32,0	100,0	52,0	15,4	2,0	–	4	■
750200R080-TRIBON	02510084	2	E	20,0	20,0	40,0	125,0	75,0	19,4	0,8	–	4	■
750200R200-TRIBON	02510086	2	E	20,0	20,0	40,0	125,0	75,0	19,4	2,0	–	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC dann a_p=-30%, f_z=-20%

Schnittdaten – JHP750 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	48 (33 — 64) *155 (110 — 200)*
S2	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	39 (26 — 51) *130 (86–160)*
S3	E/M/A	0.0400 *0,0400*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	33 (26 — 50) *110 (86–160)*
S11	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	145 (130–180) *475 (430 — 590)*
S12	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	110 (95–140) *360 (320 — 450)*
S13	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	85 (75–110) *280 (250 — 360)*

Schnittdaten – JHP750 Nutfräsen

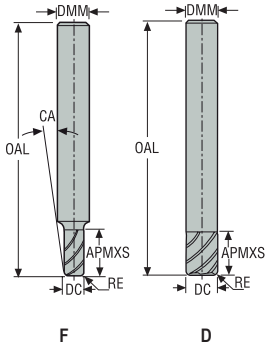
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	30 (20 — 39) *100 (66–120)*
S2	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	24 (17 — 32) *80 (56–100)*
S3	E/M/A	0.36 *0,36*	0.0046 *0,00018*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.034 *0,0013*	0.040 *0,0016*	20 (15 — 29) *65 (50 — 95)*
S11	E/M/A	0.60 *0,60*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	90 (78–110) *295 (260 — 360)*
S12	E/M/A	0.60 *0,60*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (60 — 89) *230 (200 — 290)*
S13	E/M/A	0.60 *0,60*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	55 (48–71) *180 (160 — 230)*

Schnittdaten, siehe Seite 457 - 464

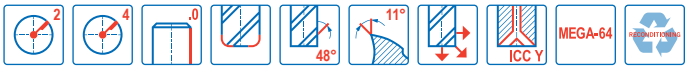
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHP760

Hochleistung – ISO-S – Schaftfräser – 2-4 Schneiden – Zylindrisch – Eckenradius – ICC







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

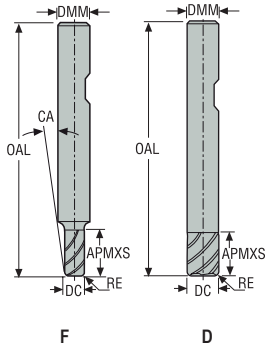
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	RE	CA	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm			
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	■
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0 °	2	■
760050R040Z2.0A-MEGA-64	02623435	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0 °	2	■
760060R020Z4.0A-MEGA-64	02734053	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	■
760060R040Z4.0A-MEGA-64	02623433	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	■
760080R040Z4.0A-MEGA-64	02623436	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	■
760080R100Z4.0A-MEGA-64	02623437	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	■
760100R040Z4.0A-MEGA-64	02623460	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	■
760100R100Z4.0A-MEGA-64	02623463	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	■
760100R150Z4.0A-MEGA-64	02623466	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	■
760120R040Z4.0A-MEGA-64	02623819	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	■
760120R100Z4.0A-MEGA-64	02623825	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	■
760120R150Z4.0A-MEGA-64	02623828	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	■
760120R310Z4.0A-MEGA-64	02623833	2	D	■	12,0	12,0	24,0	75,0	3,1	–	4	■
760200R040Z4.0A-MEGA-64	02734055	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	■
760200R080Z4.0A-MEGA-64	02623852	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	■
760L080R040Z4.0A-MEGA-64	02623438	3	D	■	8,0	8,0	28,0	65,0	0,4	–	4	■
760L100R040Z4.0A-MEGA-64	02623461	3	D	■	10,0	10,0	36,0	75,0	0,4	–	4	■
760L100R100Z4.0A-MEGA-64	02623464	3	D	■	10,0	10,0	36,0	75,0	1,0	–	4	■
760L100R150Z4.0A-MEGA-64	02623467	3	D	■	10,0	10,0	36,0	75,0	1,5	–	4	■
760L100R200Z4.0A-MEGA-64	02623472	3	D	■	10,0	10,0	36,0	75,0	2,0	–	4	■
760L100R310Z4.0A-MEGA-64	02623807	3	D	■	10,0	10,0	36,0	75,0	3,1	–	4	■
760L120R040Z4.0A-MEGA-64	02623821	3	D	■	12,0	12,0	42,0	90,0	0,4	–	4	■
760L120R100Z4.0A-MEGA-64	02623826	3	D	■	12,0	12,0	42,0	90,0	1,0	–	4	■
760L120R150Z4.0A-MEGA-64	02623829	3	D	■	12,0	12,0	42,0	90,0	1,5	–	4	■
760L120R400Z4.0A-MEGA-64	02623838	3	D	■	12,0	12,0	42,0	90,0	4,0	–	4	■
760L160R040Z4.0A-MEGA-64	02623840	3	D	■	16,0	16,0	50,0	100,0	0,4	–	4	■
760L160R100Z4.0A-MEGA-64	02623842	3	D	■	16,0	16,0	50,0	100,0	1,0	–	4	■
760L160R150Z4.0A-MEGA-64	02623844	3	D	■	16,0	16,0	50,0	100,0	1,5	–	4	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmierstoffzufuhr

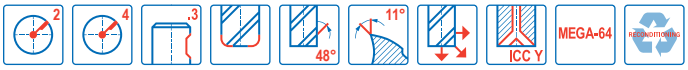
JHP760

Hochleistung – ISO-S – Schaftfräser – 2-4 Schneiden – Weldon – Eckenradius – ICC





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

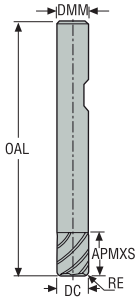


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	RE	CA	PCEDC	Weldon
					mm	mm	mm	mm	mm			
760040R020Z2.0A-MEGA-64W	02734065	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0 °	2	□
760040R040Z2.0A-MEGA-64W	02669339	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0 °	2	□
760050R020Z2.0A-MEGA-64W	02734068	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0 °	2	□
760050R040Z2.0A-MEGA-64W	02669340	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0 °	2	□
760060R020Z4.0A-MEGA-64W	02734069	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	□
760060R040Z4.0A-MEGA-64W	02669341	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	□
760080R040Z4.0A-MEGA-64W	02669343	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	□
760080R100Z4.0A-MEGA-64W	02669344	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	□
760100R040Z4A-MEGA-64	02623442	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	■
760100R100Z4A-MEGA-64	02623462	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	■
760100R150Z4A-MEGA-64	02623465	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	■
760120R040Z4A-MEGA-64	02623817	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	■
760120R100Z4A-MEGA-64	02623824	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	■
760120R150Z4A-MEGA-64	02623827	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	■
760120R400Z4A-MEGA-64	02623835	2	D	■	12,0	12,0	24,0	75,0	4,0	–	4	■
760160R040Z4A-MEGA-64	02623839	2	D	■	16,0	16,0	40,0	90,0	0,4	–	4	■
760160R100Z4A-MEGA-64	02623841	2	D	■	16,0	16,0	40,0	90,0	1,0	–	4	■
760160R150Z4A-MEGA-64	02623843	2	D	■	16,0	16,0	40,0	90,0	1,5	–	4	■
760160R200Z4A-MEGA-64	02623845	2	D	■	16,0	16,0	40,0	90,0	2,0	–	4	■
760200R040Z4A-MEGA-64	02734054	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	■
760200R080Z4A-MEGA-64	02623851	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
ICC = mit interner Kühlschmierstoffzufuhr

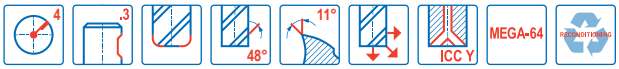
JHP760

Hochleistung – ISO-S – Schaftfräser – 2-4 Schneiden – Weldon – Eckenradius – ICC



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
760L080R040Z4.0A-MEGA-64W	02720459	3	D	■	8,0	8,0	28,0	65,0	0,4	4	☐
760L100R040Z4.0A-MEGA-64W	02669345	3	D	■	10,0	10,0	36,0	75,0	0,4	4	☐
760L100R100Z4.0A-MEGA-64W	02669346	3	D	■	10,0	10,0	36,0	75,0	1,0	4	☐
760L100R150Z4.0A-MEGA-64W	02669347	3	D	■	10,0	10,0	36,0	75,0	1,5	4	☐
760L100R200Z4.0A-MEGA-64W	02669348	3	D	■	10,0	10,0	36,0	75,0	2,0	4	☐
760L120R040Z4.0A-MEGA-64W	02669350	3	D	■	12,0	12,0	42,0	90,0	0,4	4	☐
760L120R100Z4.0A-MEGA-64W	02669351	3	D	■	12,0	12,0	42,0	90,0	1,0	4	☐
760L120R150Z4.0A-MEGA-64W	02669352	3	D	■	12,0	12,0	42,0	90,0	1,5	4	☐
760L160R040Z4.0A-MEGA-64W	02669356	3	D	■	16,0	16,0	50,0	100,0	0,4	4	☐
760L160R100Z4.0A-MEGA-64W	02669357	3	D	■	16,0	16,0	50,0	100,0	1,0	4	☐
760L160R150Z4.0A-MEGA-64W	02669358	3	D	■	16,0	16,0	50,0	100,0	1,5	4	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
ICC = mit interner Kühlschmierstoffzufuhr

Schnittdaten – JHP760 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z									v_c
				4	5	6	8	10	12	16	20	25	
M1	E	0.300 *0,300*	1.5 *1,5*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (97–130) *395 (320 — 420)*
M2	E	0.300 *0,300*	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	100 (81–110) *330 (270 — 360)*
M3	E	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (58 — 91) *245 (200 — 290)*
M4	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	60 (45–70) *195 (150 — 220)*
M5	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	48 (37 — 59) *155 (130–190)*

Schnittdaten – JHP760 Nutfräsen

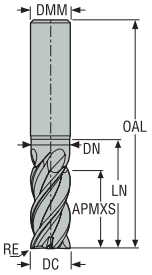
SMG		a_p/DC	f_z									v_c
			4	5	6	8	10	12	16	20	25	
M1	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	110 (92–130) *360 (310 — 420)*
M2	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	90 (74–100) *295 (250 — 320)*
M3	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	70 (54 — 85) *230 (180 — 270)*
M4	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	50 (40 — 63) *165 (140 — 200)*
M5	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	43 (34 — 53) *140 (120–170)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

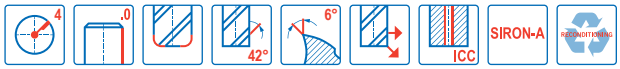
JHP770

Hochleistung – Titan – Schaftfräser – 4-5 Schneiden – Zylindrisch – Eckenradius – ICC



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

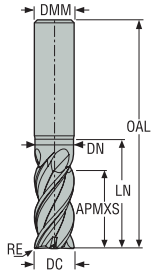
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP770080E2R050.0Z4A-SIRA	02823416	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	■
JHP770100E2R040.0Z4A-SIRA	02760654	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP770100E2R050.0Z4A-SIRA	02823417	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	■
JHP770120E2R040.0Z4A-SIRA	02760656	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP770120E2R050.0Z4A-SIRA	02823419	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	■
JHP770120E2R100.0Z4A-SIRA	02823420	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	■
JHP770120E2R250.0Z4A-SIRA	02760659	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP770140E2R050.0Z4A-SIRA	02823421	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	■
JHP770160E2R040.0Z4A-SIRA	02760661	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP770160E2R050.0Z4A-SIRA	02823422	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	■
JHP770160E2R080.0Z4A-SIRA	02760662	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP770160E2R100.0Z4A-SIRA	02823423	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	■
JHP770160E2R250.0Z4A-SIRA	02760663	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	■
JHP770160E2R310.0Z4A-SIRA	02760664	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	■
JHP770160E2R400.0Z4A-SIRA	02760665	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP770200E2R050.0Z4A-SIRA	02823424	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	■
JHP770200E2R100.0Z4A-SIRA	02823425	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	■
JHP770200E2R250.0Z4A-SIRA	02760668	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	■
JHP770200E2R310.0Z4A-SIRA	02760669	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP770200E2R400.0Z4A-SIRA	02760670	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■

■ **Lagerstandard.**
Anmerkung: bei Eckenradius >15% DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmierstoffzufuhr

JHP770

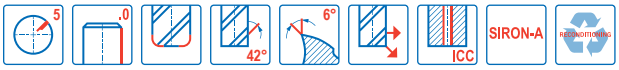
Hochleistung – Titan – Schaftfräser –4-5 Schneiden – Zylindrisch – Eckenradius – ICC





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

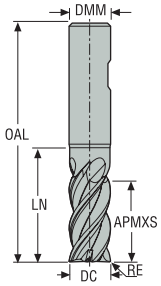


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.0Z5A-SIRA	02810129	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	■
JHP770160E2R100.0Z5A-SIRA	02810130	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	■
JHP770160E2R250.0Z5A-SIRA	02810131	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	■
JHP770160E2R310.0Z5A-SIRA	02810132	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	■
JHP770160E2R400.0Z5A-SIRA	02810133	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	■
JHP770200E2R050.0Z5A-SIRA	02810134	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	■
JHP770200E2R100.0Z5A-SIRA	02810135	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	■
JHP770200E2R250.0Z5A-SIRA	02810136	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	■
JHP770200E2R310.0Z5A-SIRA	02810137	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	■
JHP770200E2R400.0Z5A-SIRA	02810138	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■
JHP770250E2R310.0Z5A-SIRA	02810141	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	3,1	5	■

■ **Lagerstandard.**
Anmerkung: bei Eckenradius >15% DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmierstoffzufuhr

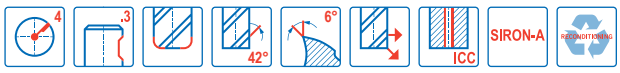
JHP770

Hochleistung – Titan – Schaftfräser – 4-5 Schneiden – Weldon – Eckenradius – ICC



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

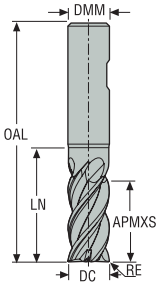
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	□
JHP770080E2R050.3Z4A-SIRA	02823428	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	■
JHP770100E2R040.3Z4A-SIRA	02760801	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	□
JHP770100E2R050.3Z4A-SIRA	02823429	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	■
JHP770120E2R040.3Z4A-SIRA	02760803	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	□
JHP770120E2R050.3Z4A-SIRA	02823431	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	■
JHP770120E2R100.3Z4A-SIRA	02823432	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	■
JHP770120E2R250.3Z4A-SIRA	02760805	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	□
JHP770140E2R050.3Z4A-SIRA	02823433	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	■
JHP770160E2R040.3Z4A-SIRA	02760807	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	□
JHP770160E2R050.3Z4A-SIRA	02823434	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	■
JHP770160E2R080.3Z4A-SIRA	02760809	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	□
JHP770160E2R100.3Z4A-SIRA	02823435	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	■
JHP770160E2R250.3Z4A-SIRA	02760810	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	■
JHP770160E2R310.3Z4A-SIRA	02760811	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	□
JHP770160E2R400.3Z4A-SIRA	02760817	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	□
JHP770200E2R050.3Z4A-SIRA	02823436	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	■
JHP770200E2R100.3Z4A-SIRA	02823437	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	■
JHP770200E2R250.3Z4A-SIRA	02760823	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	□
JHP770200E2R310.3Z4A-SIRA	02760824	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	□
JHP770200E2R400.3Z4A-SIRA	02760825	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmierstoffzufuhr

JHP770

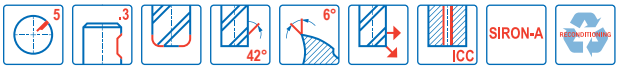
Hochleistung – Titan – Schaftfräser – 4-5 Schneiden – Weldon – Eckenradius – ICC





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

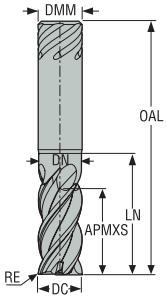


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.3Z5A-SIRA	02810143	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	■
JHP770160E2R100.3Z5A-SIRA	02810144	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	■
JHP770160E2R250.3Z5A-SIRA	02810145	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	□
JHP770160E2R310.3Z5A-SIRA	02810146	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	■
JHP770160E2R400.3Z5A-SIRA	02810147	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	□
JHP770200E2R050.3Z5A-SIRA	02810148	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	■
JHP770200E2R100.3Z5A-SIRA	02810149	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	■
JHP770200E2R250.3Z5A-SIRA	02810150	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	□
JHP770200E2R310.3Z5A-SIRA	02810151	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	■
JHP770200E2R400.3Z5A-SIRA	02810152	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	■
JHP770250E2R050.3Z5A-SIRA	02810153	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	■
JHP770250E2R100.3Z5A-SIRA	02810154	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	1,0	5	■
JHP770250E2R310.3Z5A-SIRA	02810155	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	3,1	5	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmierstoffzufuhr

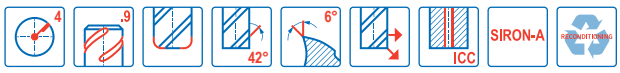
JHP770

Hochleistung – Titan – Schaftfräser – 4-5 Schneiden – Safe-Lock – Eckenradius – ICC



E





- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich

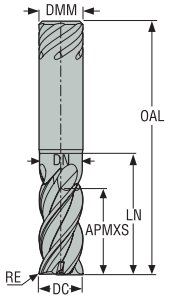
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm	mm	mm		
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	☐
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	☐
JHP770080E2R050.9Z4A-SIRA	02927938	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,5	4	☐
JHP770100E2R040.9Z4A-SIRA	02927939	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,4	4	☐
JHP770100E2R050.9Z4A-SIRA	02927940	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,5	4	☐
JHP770120E2R040.9Z4A-SIRA	02927943	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,4	4	☐
JHP770120E2R050.9Z4A-SIRA	02927944	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,5	4	☐
JHP770120E2R100.9Z4A-SIRA	02927946	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	1,0	4	☐
JHP770120E2R250.9Z4A-SIRA	02927947	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	2,5	4	☐
JHP770140E2R050.9Z4A-SIRA	02927950	2	E	■	14,0	14,0	28,0	95,0	42,0	13,0	0,5	4	☐
JHP770160E2R040.9Z4A-SIRA	02927948	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,4	4	☐
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	4	☐
JHP770160E2R080.9Z4A-SIRA	02927951	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,8	4	☐
JHP770160E2R100.9Z4A-SIRA	02927952	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	4	☐
JHP770160E2R250.9Z4A-SIRA	02927954	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	4	☐
JHP770160E2R310.9Z4A-SIRA	02927956	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	4	☐
JHP770160E2R400.9Z4A-SIRA	02927958	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	4	☐
JHP770200E2R050.9Z4A-SIRA	02927960	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	4	☐
JHP770200E2R100.9Z4A-SIRA	02927962	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	4	☐
JHP770200E2R250.9Z4A-SIRA	02927964	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	4	☐
JHP770200E2R310.9Z4A-SIRA	02927966	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	4	☐
JHP770200E2R400.9Z4A-SIRA	02927968	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	4	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%

JHP770

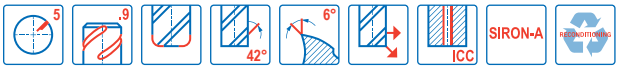
Hochleistung – Titan – Schaftfräser – 4-5 Schneiden – Safe-Lock – Eckenradius – ICC





E

- Toleranzen:
- DMM = h5
- DC = e7
- RE= ±0,02 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm	mm	mm		
JHP770160E2R050.9Z5A-SIRA	02927949	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	5	☐
JHP770160E2R100.9Z5A-SIRA	02927953	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	5	☐
JHP770160E2R250.9Z5A-SIRA	02927955	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	5	☐
JHP770160E2R310.9Z5A-SIRA	02927957	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	5	☐
JHP770160E2R400.9Z5A-SIRA	02927959	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	5	☐
JHP770200E2R050.9Z5A-SIRA	02927961	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	5	☐
JHP770200E2R100.9Z5A-SIRA	02927963	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	5	☐
JHP770200E2R250.9Z5A-SIRA	02927965	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	5	☐
JHP770200E2R310.9Z5A-SIRA	02927967	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	5	☐
JHP770200E2R400.9Z5A-SIRA	02927969	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	5	☐
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	☐
JHP770250E2R310.9Z5A-SIRA	02927974	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	3,1	5	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%

Schnittdaten – JHP770 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S11	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	120 (110–130) *395 (370 — 420)*
S12	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	90 (80–100) *295 (270 — 320)*
S13	E	0.400 *0,400*	1.8 *1,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (64 — 81) *245 (210 — 260)*

Schnittdaten – JHP770 Nutfräsen

SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S11	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (94–120) *345 (310 — 390)*
S12	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (72 — 92) *260 (240 — 300)*
S13	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	65 (56–71) *215 (190 — 230)*

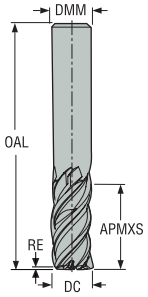
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHP780

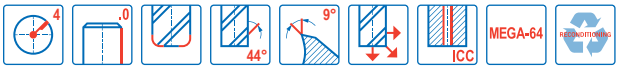
Hochleistung – Superlegierung – Schaftfräser – 4-Schneiden – Zylindrisch – Eckenradius – ICC





D

- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

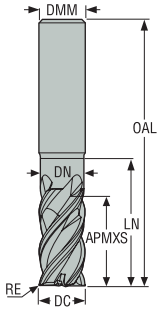


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm		
JHP780060D1R030.0Z4A-M64	03134984	1	D	■	6,0	6,0	7,5	47,0	0,3	4	■
JHP780060D1R080.0Z4A-M64	03134985	1	D	■	6,0	6,0	7,5	47,0	0,8	4	■
JHP780080D1R040.0Z4A-M64	03134986	1	D	■	8,0	8,0	10,0	50,0	0,4	4	■
JHP780080D1R080.0Z4A-M64	03134987	1	D	■	8,0	8,0	10,0	50,0	0,8	4	■
JHP780100D1R040.0Z4A-M64	03134988	1	D	■	10,0	10,0	12,5	57,0	0,4	4	■
JHP780100D1R080.0Z4A-M64	03134989	1	D	■	10,0	10,0	12,5	57,0	0,8	4	■

■ **Lagerstandard.**

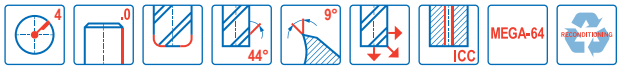
JHP780

Hochleistung – Superlegierung – Schaftfräser – 4-Schneiden – Zylindrisch – Eckenradius – ICC



E





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

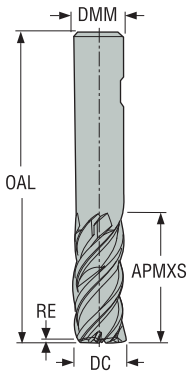
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.0Z4A-M64	03134993	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780080E2R040.0Z4-M64	02760842	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780100E2R040.0Z4A-M64	03134994	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R040.0Z4-M64	02760846	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R080.0Z4A-M64	03134995	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780100E2R080.0Z4-M64	02760847	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780120E2R040.0Z4A-M64	03134996	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R040.0Z4-M64	02760848	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R080.0Z4A-M64	03134997	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R080.0Z4-M64	02760849	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R150.0Z4-M64	02760850	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	■
JHP780120E2R250.0Z4-M64	02760851	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP780140E2R040.0Z4-M64	02760852	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	■
JHP780160E2R040.0Z4A-M64	03135000	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R040.0Z4-M64	02760853	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R080.0Z4A-M64	03135001	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R080.0Z4-M64	02760861	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R310.0Z4-M64	02760862	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	■
JHP780160E2R400.0Z4-M64	02760863	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP780200E2R040.0Z4-M64	02760865	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	■
JHP780200E2R080.0Z4-M64	02760866	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	■
JHP780200E2R310.0Z4-M64	02760867	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP780200E2R400.0Z4-M64	02760868	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■
JHP780250E2R080.0Z4-M64	02760870	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	■

■ Lagerstandard.

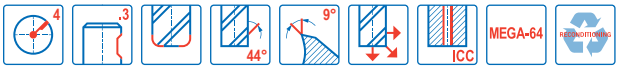
JHP780

Hochleistung – Superlegierung – Schaftfräser – 4-Schneiden – Weldon – Eckenradius – ICC





D



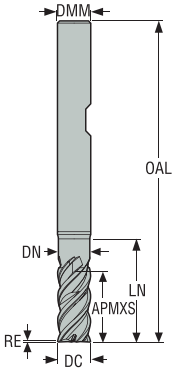
- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm		
JHP780060D1R030.3Z4A-M64	03135445	1	D	■	6,0	6,0	7,5	47,0	0,3	4	■
JHP780060D1R080.3Z4A-M64	03135446	1	D	■	6,0	6,0	7,5	47,0	0,8	4	■
JHP780080D1R040.3Z4A-M64	03135447	1	D	■	8,0	8,0	10,0	50,0	0,4	4	■
JHP780080D1R080.3Z4A-M64	03135449	1	D	■	8,0	8,0	10,0	50,0	0,8	4	■
JHP780100D1R040.3Z4A-M64	03135450	1	D	■	10,0	10,0	12,5	57,0	0,4	4	■
JHP780100D1R080.3Z4A-M64	03135451	1	D	■	10,0	10,0	12,5	57,0	0,8	4	■

■ **Lagerstandard.**

JHP780

Hochleistung – Superlegierung – Schaftfräser – 4-Schneiden – Weldon – Eckenradius – ICC



E





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
JHP780060E2R030.3Z4-M64	02760878	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780060E2R030.3Z4A-M64	03135454	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	■
JHP780080E2R040.3Z4-M64	02760879	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780080E2R040.3Z4A-M64	03135455	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	■
JHP780100E2R040.3Z4-M64	02760880	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R040.3Z4A-M64	03135456	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	■
JHP780100E2R080.3Z4-M64	02760881	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780100E2R080.3Z4A-M64	03135457	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	■
JHP780120E2R040.3Z4-M64	02760883	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R040.3Z4A-M64	03134998	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	■
JHP780120E2R080.3Z4-M64	02760885	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R080.3Z4A-M64	03134999	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	■
JHP780120E2R150.3Z4-M64	02760887	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	■
JHP780120E2R250.3Z4-M64	02766989	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	■
JHP780140E2R040.3Z4-M64	02760888	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	■
JHP780160E2R040.3Z4-M64	02760889	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R040.3Z4A-M64	03135002	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	■
JHP780160E2R080.3Z4-M64	02760890	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R080.3Z4A-M64	03135003	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	■
JHP780160E2R400.3Z4-M64	02760893	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	■
JHP780200E2R040.3Z4-M64	02760894	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	■
JHP780200E2R080.3Z4-M64	02760896	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	■
JHP780200E2R310.3Z4-M64	02760897	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	■
JHP780200E2R400.3Z4-M64	02760898	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	■
JHP780250E2R080.3Z4-M64	02760901	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	■

■ **Lagerstandard.**

Schnittdaten – JHP780 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S1	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	50 (45 — 59) *165 (150–190)*
S2	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	42 (36 — 47) *140 (120–150)*
S3	E	0.300 *0,300*	0.80 *0,80*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	28 (23 — 33) *90 (76–100)*

Schnittdaten – JHP780 Nutfräsen

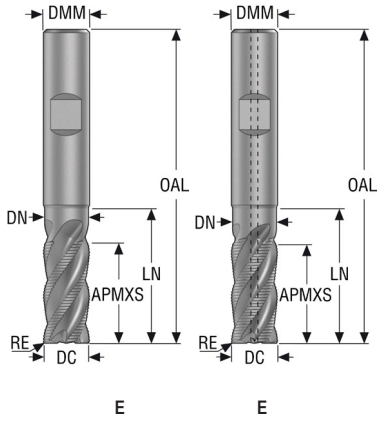
SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S1	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	43 (38 — 49) *140 (130–160)*
S2	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	35 (30 — 40) *115 (99–130)*
S3	E	0.60 *0,60*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	26 (21 — 30) *85 (69 — 98)*

Schnittdaten, siehe Seite 457 - 464

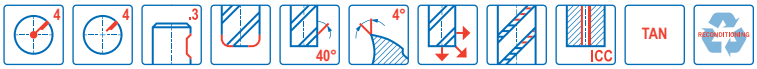
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHP794

Hochleistung – ISO-S – Schaftfräser – 4 Schneiden – Weldon – Eckenradius







- Toleranzen:
- DMM= h6
- DC= h12
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø8 ist

Bezeichnung	Sorte	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
						mm	mm	mm	mm	mm	mm	mm		
JHP794060E2R020.3Z4	TAN	10072338	2	E	–	6,0	6,0	13,0	57,0	18,5	2,0	0,2	4	■
JHP794060E2R020.3Z4A	TAN	10072339	2	E	■	6,0	6,0	13,0	57,0	18,5	5,5	0,2	4	■
JHP794080E2R020.3Z4	TAN	10072340	2	E	–	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	■
JHP794080E2R020.3Z4A	TAN	10072341	2	E	■	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	■
JHP794100E2R035.3Z4	TAN	10072342	2	E	–	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	■
JHP794100E2R035.3Z4A	TAN	10072343	2	E	■	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	■
JHP794120E2R035.3Z4	TAN	10072344	2	E	–	12,0	12,0	26,0	83,0	35,5	11,4	0,35	4	■
JHP794120E2R035.3Z4A	TAN	10072345	2	E	■	12,0	12,0	26,0	92,0	35,5	11,4	0,35	4	■
JHP794160E2R040.3Z4	TAN	10072346	2	E	–	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	■
JHP794160E2R040.3Z4A	TAN	10072347	2	E	■	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	■
JHP794200E2R040.3Z4	TAN	10072348	2	E	–	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	■
JHP794200E2R040.3Z4A	TAN	10072349	2	E	■	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	■
JHP794250E2R040.3Z4	TAN	10072350	2	E	–	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	■
JHP794250E2R040.3Z4A	TAN	10072351	2	E	■	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	■

■ Lagerstandard.

Schnittdaten – JHP760 Eckfräsen

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.3 *1,3*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	90 (61–120) *295 (210 — 390)*
M2	E	1.3 *1,3*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M3	E	1.3 *1,3*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	60 (40–78) *195 (140 — 250)*
M4	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	45 (31 — 60) *150 (110–190)*
M5	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	38 (26 — 50) *125 (86–160)*

Schnittdaten – JHP760 Nutfräsen

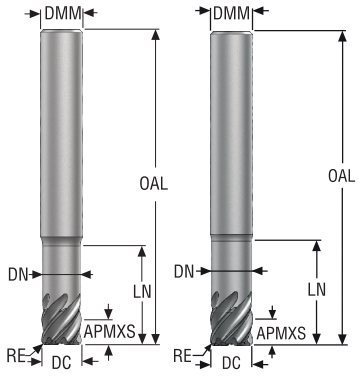
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M2	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	60 (40–79) *195 (140 — 250)*
M3	E	0.60 *0,60*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	47 (32 — 62) *155 (110 — 200)*
M4	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	36 (24 — 47) *120 (79–150)*
M5	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	30 (20 — 39) *100 (66–120)*

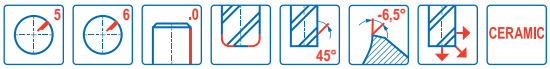
Schnittdaten, siehe Seite 457 - 464

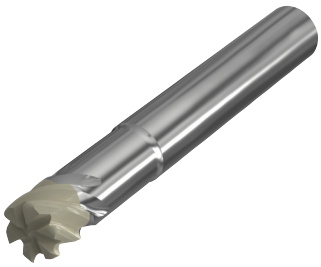
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JCG790

Hochleistung – Schaftfräser – Superlegierung – 5-6 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM = h5
- DC = -0,02/-0,1 mm
- RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	DN	LN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JCG790060E2R050.0Z5	10010512	2	E	6,0	6,0	6,0	59,0	5,7	15,0	0,5	5	■
JCG790080E2R050.0Z5	10010513	2	E	8,0	8,0	6,0	67,0	7,6	20,0	0,5	5	■
JCG790094G2R100.0Z6	10010514	2	G	9,4	10,0	6,0	75,0	9,0	23,5	1,0	6	■
JCG790100E2R100.0Z6	10010515	2	E	10,0	10,0	6,0	75,0	9,5	25,0	1,0	6	■
JCG790114G2R150.0Z6	10010516	2	G	11,4	12,0	6,0	82,0	10,9	28,5	1,5	6	■
JCG790120E2R150.0Z6	10010517	2	E	12,0	12,0	6,0	82,0	11,4	30,0	1,5	6	■
JCG790160E2R200.0Z6	10010518	2	E	16,0	16,0	8,0	93,0	15,2	40,0	2,0	6	■
JCG790200E2R300.0Z6	10010519	2	E	20,0	20,0	8,0	103,0	19,0	50,0	3,0	6	■
JCG790250E2R400.0Z6	10010520	2	E	25,0	25,0	8,0	108,0	23,8	50,0	4,0	6	■

■ **Lagerstandard.**

Schnittdaten – JCG790 Eckfräsen/Schruppen

SMG		a_e/DC	apmxs	f_z							v_c
				6	8	10	12	16	20	25	
S1	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420–1300) *2725 (1400 — 4200)*
S2	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340–1100) *2200 (1200 — 3600)*
S3	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

Schnittdaten – JCG790 Nutfräsen

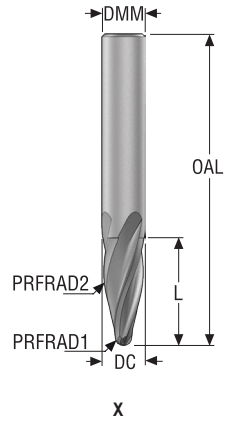
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420–1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340–1100) *2200 (1200 — 3600)*
S3	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

Schnittdaten, siehe Seite 457 - 464

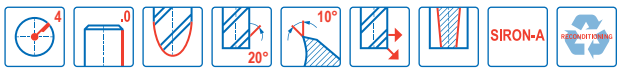
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH734

Hohe Geschwindigkeit – ISO– M und ISO– S - Tropfenform – 4 Schneiden – Zylindrisch







- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Sorte	Produkt-nummer	Längen-index		DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm		
JH734060X2R1R95.0Z4	SIRA	10044783	2	X	6,0	6,0	20,8	62,0	1,0	95,0	4	■
JH734080X2R1R90.0Z4	SIRA	10044784	2	X	8,0	8,0	24,5	68,0	1,0	90,0	4	■
JH734100X2R2R85.0Z4	SIRA	10044785	2	X	10,0	10,0	24,7	72,0	2,0	85,0	4	■
JH734120X2R2R80.0Z4	SIRA	10044786	2	X	12,0	12,0	27,3	83,0	2,0	80,0	4	■
JH734160X2R3R75.0Z4	SIRA	10044787	2	X	16,0	16,0	30,1	92,0	3,0	75,0	4	■

■ **Lagerstandard.**

Schnittdaten – JH734 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P12	E	0.01 *0,01*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.01 *0,01*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.01 *0,01*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.01 *0,01*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

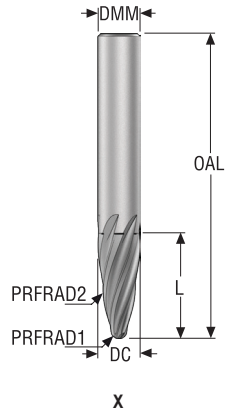
Schnittdaten – JH734 Eckfräsen/Schruppen

SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P12	E	0.025 *0,025*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

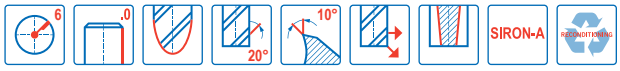
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH736

Hohe Geschwindigkeit – ISO– M und ISO– S - Tropfenform – 6 Schneiden – Zylindrisch







- Toleranzen:
- DMM= h5
- PRFRAD1= ±0.03mm
- Formtoleranz PRFRAD2= 0.02mm
- Nachschleifen möglich

Bezeichnung	Sorte	Produkt-nummer	Längen-index		DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm		
JH736100X2R2R85.0Z6	SIRA	10044834	2	X	10,0	10,0	24,7	72,0	2,0	85,0	6	■
JH736120X2R2R80.0Z6	SIRA	10044835	2	X	12,0	12,0	27,3	83,0	2,0	80,0	6	■
JH736160X2R3R75.0Z6	SIRA	10044836	2	X	16,0	16,0	30,1	92,0	3,0	75,0	6	■

■ **Lagerstandard.**

Schnittdaten – JH736 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

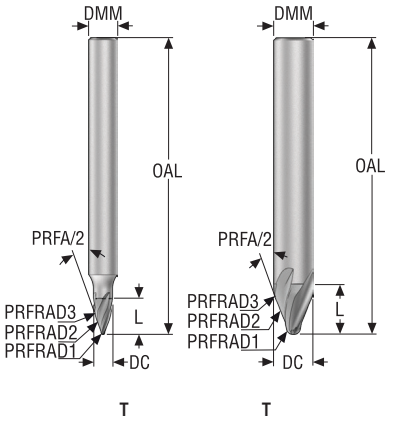
Schnittdaten – JH736 Eckfräsen/Schruppen

SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

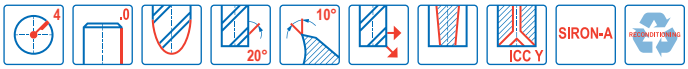
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH744

Hohe Geschwindigkeit – ISO– M und ISO– S - Konische Form – 4 Schneiden – Zylindrisch







- Toleranzen:
- DMM= h5
- PRFRAD1= ±0.03mm
- Formtoleranz PRFRAD2= 0.02mm
- Nachschleifen möglich, wenn PRFRAD1 ≥1,5 ist

Bezeichnung	Sorte	Produkt-nummer	Längen-index		ICC	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFRA	PCEDC	Zylindrisch
						mm	mm	mm	mm	mm	mm	mm			
JH744100T1R1.5R250.0Z4	SIRA	10044920	1	T	–	10,0	10,0	5,4	72,0	1,5	250,0	2,0	65,0	4	■
JH744120T1R3R250.0Z4	SIRA	10044921	1	T	–	12,0	12,0	10,5	89,0	3,0	250,0	6,0	32,5	4	■
JH744160T1R4R500.0Z4	SIRA	10044922	1	T	–	16,0	16,0	14,6	108,0	4,0	500,0	8,0	27,5	4	■
JH744040T2R0.5R250.0Z4	SIRA	10044923	2	T	–	4,0	6,0	7,6	62,0	0,5	250,0	3,0	17,5	4	■
JH744060T2R1R250.0Z4	SIRA	10044924	2	T	–	6,0	6,0	9,6	62,0	1,0	250,0	3,0	17,5	4	■
JH744080T2R1.5R250.0Z4	SIRA	10044925	2	T	–	8,0	8,0	10,7	68,0	1,5	250,0	4,0	20,0	4	■
JH744100T2R2R250.0Z4	SIRA	10044926	2	T	–	10,0	10,0	12,7	75,0	2,0	250,0	5,0	20,0	4	■
JH744120T2R3R250.0Z4	SIRA	10044927	2	T	–	12,0	12,0	13,7	89,0	3,0	250,0	6,0	20,0	4	■
JH744160T2R4R500.0Z4	SIRA	10044928	2	T	–	16,0	16,0	17,6	108,0	4,0	500,0	8,0	20,0	4	■
JH744160T2R2R1000.0Z4	SIRA	10044929	2	T	–	16,0	16,0	31,3	108,0	2,0	1000,0	5,0	12,5	4	■
JH744160T2R4R1000.0Z4	SIRA	10044930	2	T	–	16,0	16,0	24,1	108,0	4,0	1000,0	5,0	12,5	4	■
JH744160T4R4R1000.0Z4A	SIRA	10044931	4	T	■	16,0	16,0	24,1	150,0	4,0	1000,0	5,0	12,5	4	■

Schnittdaten – JH744 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P12	E	0.01 *0,01*	0.02 *0,0008*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.01 *0,01*	0.02 *0,0008*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.01 *0,01*	0.02 *0,0008*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.01 *0,01*	0.02 *0,0008*	0.03 *0,0012*	0.04 *0,0016*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

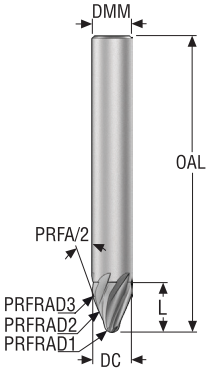
Schnittdaten – JH744 Eckfräsen/Schruppen

SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P12	E	0.025 *0,025*	0.012 *0,00048*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.012 *0,00048*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.012 *0,00048*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.012 *0,00048*	0.018 *0,0007*	0.024 *0,00095*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

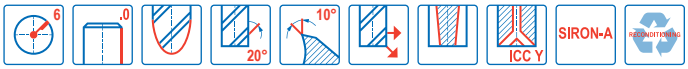
JH746

Hohe Geschwindigkeit – ISO– M und ISO– S - Konische Form – 6 Schneiden – Zylindrisch



T





- Toleranzen:
- DMM= h5
- PRFRAD1= ±0.03mm
- Formtoleranz PRFRAD2= 0.02mm
- Nachschleifen möglich

Bezeichnung	Sorte	Produkt-nummer	Längen-index		ICC	DC	DMM	L	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFRA	PCEDC	Zylindrisch
						mm	mm	mm	mm	mm	mm	mm			
JH746100T2R2R250.0Z6	SIRA	10044958	2	T	–	10,0	10,0	12,7	75,0	2,0	250,0	5,0	20,0	6	■
JH746120T2R3R250.0Z6	SIRA	10044959	2	T	–	12,0	12,0	13,7	89,0	3,0	250,0	6,0	20,0	6	■
JH746160T2R4R500.0Z6	SIRA	10044960	2	T	–	16,0	16,0	17,6	108,0	4,0	500,0	8,0	20,0	6	■
JH746160T4R4R500.0Z6A	SIRA	10044961	4	T	■	16,0	16,0	17,6	150,0	4,0	500,0	8,0	20,0	6	■

■ **Lagerstandard.**

Schnittdaten – JH744 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.01 *0,01*	0.05 *0,0022*	0.06 *0,0024*	0.08 *0,0032*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

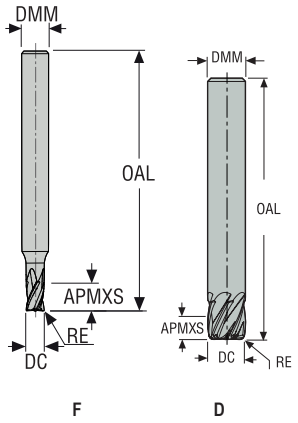
Schnittdaten – JH744 Eckfräsen/Schruppen

SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

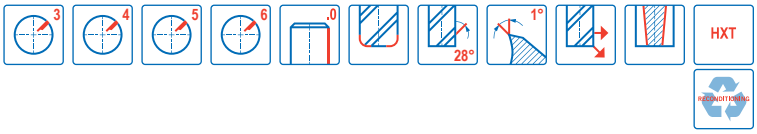
JH770

Hohe Geschwindigkeit – CoCr/Titan – Schaftfräser – 3-4-5-6 Schneiden – Zylindrisch – Eckenradius



F D





- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JH770030F2R020.0Z3-HXT	03320783	2	F	3,0	6,0	5,0	58,0	0,2	3	■
JH770040F2R020.0Z4-HXT	03320784	2	F	4,0	6,0	6,0	58,0	0,2	4	■
JH770050F2R020.0Z4-HXT	10000170	2	F	5,0	6,0	7,0	58,0	0,2	4	■
JH770060D2R050.0Z4-HXT	03127351	2	D	6,0	6,0	8,0	50,0	0,5	4	■
JH770080D2R050.0Z4-HXT	03127352	2	D	8,0	8,0	10,0	58,0	0,5	4	■
JH770080D2R050.0Z5-HXT	03127354	2	D	8,0	8,0	10,0	58,0	0,5	5	■
JH770080D2R100.0Z4-HXT	03127353	2	D	8,0	8,0	10,0	58,0	1,0	4	■
JH770080D2R100.0Z5-HXT	03127355	2	D	8,0	8,0	10,0	58,0	1,0	5	■
JH770080D2R100.0Z6-HXT	03127356	2	D	8,0	8,0	10,0	58,0	1,0	6	■
JH770100D2R100.0Z5-HXT	03127357	2	D	10,0	10,0	12,0	66,0	1,0	5	■
JH770100D2R100.0Z6-HXT	03127358	2	D	10,0	10,0	12,0	66,0	1,0	6	■

■ **Lagerstandard.**

Schnittdaten – JH770 Eckfräsen/Schruppen PCEDC 3 und 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				3	4	6	8	
S2	E	0.750 *0,750*	0.12 *0,12*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	50 (42 — 62) *165 (140 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	65 (53 — 91) *215 (180 — 290)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	50 (41–70) *165 (140 — 220)*

Schnittdaten – JH770 Eckfräsen/Schruppen PCEDC 6

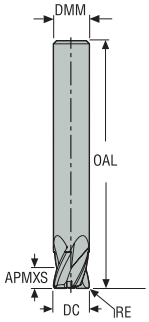
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42–71) *165 (140 — 230)*

Schnittdaten, siehe Seite 457 - 464

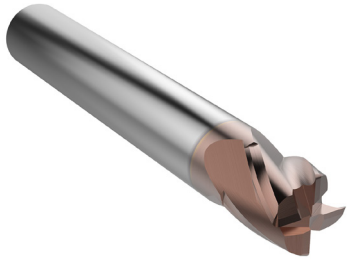
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

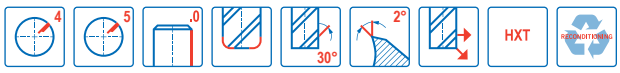
JH740

Hohe Geschwindigkeit – CoCr/Titan – Boden schlichten – 4-5 Schneiden – Zylindrisch – Eckenradius



D





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JH740060D2R025.0Z4-HXT	03127359	2	D	6,0	6,0	6,0	50,0	0,25	4	■
JH740060D2R050.0Z4-HXT	03127360	2	D	6,0	6,0	6,0	50,0	0,5	4	■
JH740080D2R025.0Z4-HXT	03127361	2	D	8,0	8,0	8,0	58,0	0,25	4	■
JH740080D2R050.0Z4-HXT	03127362	2	D	8,0	8,0	8,0	58,0	0,5	4	■
JH740100D2R025.0Z5-HXT	03127363	2	D	10,0	10,0	10,0	66,0	0,25	5	■
JH740100D2R050.0Z5-HXT	03127364	2	D	10,0	10,0	10,0	66,0	0,5	5	■

■ **Lagerstandard.**

Schnittdaten – JH740 Planfräsen/Schlichten PCEDC 4

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140–190)*
S11	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	65 (52–77) *215 (180 — 250)*
S12	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140–190)*

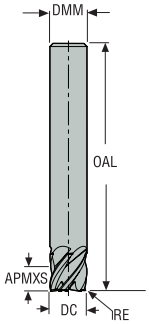
Schnittdaten – JH740 Planfräsen/Schlichten PCEDC 5

SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130–190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51–75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130–190)*

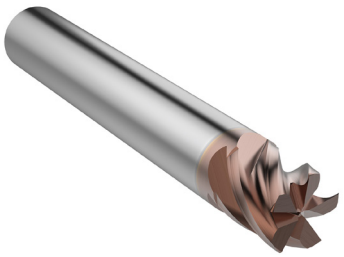
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

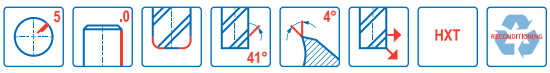
JH710

Hohe Geschwindigkeit – CoCr/Titan – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius



D





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JH710060D2R025.0Z5-HXT	03127365	2	D	6,0	6,0	6,0	57,0	0,25	5	■
JH710060D2R050.0Z5-HXT	03127366	2	D	6,0	6,0	6,0	57,0	0,5	5	■
JH710080D2R025.0Z5-HXT	03127367	2	D	8,0	8,0	8,0	63,0	0,25	5	■
JH710080D2R050.0Z5-HXT	03127368	2	D	8,0	8,0	8,0	63,0	0,5	5	■
JH710080D2R100.0Z5-HXT	03127369	2	D	8,0	8,0	8,0	63,0	1,0	5	■

■ **Lagerstandard.**

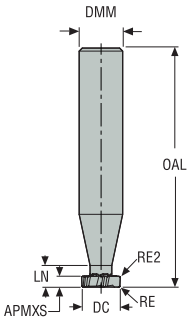
Schnittdaten – JH710 Eckfräsen/Schlichten

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S1	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79–110) *330 (260 — 360)*
S2	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79–110) *330 (260 — 360)*
S3	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79–110) *330 (260 — 360)*
S11	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	180 (160 — 200) *590 (530 — 650)*
S12	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	135 (120–150) *445 (400 — 490)*
S13	E	0.00800 *0,00800*	0.65 *0,65*	0.032 *0,0013*	0.040 *0,0016*	105 (92–120) *345 (310 — 390)*

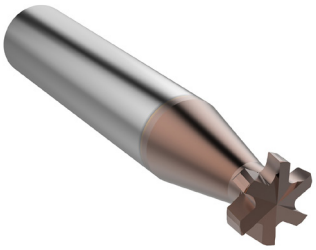
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

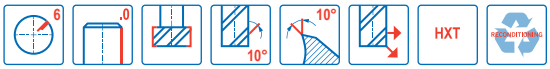
JH790

Hohe Geschwindigkeit – CoCr/Titan – T-Fräser – 6 Schneiden – Zylindrisch



G





- Toleranzen:
- DMM=h5
- DC= ±0,02 mm
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	RE	RE2	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JH790095G2R025.0Z6-HXT	03127370	2	G	9,5	10,0	2,0	66,0	5,0	0,25	0,25	6	■
JH790095G2R050.0Z6-HXT	03127371	2	G	9,5	10,0	2,0	66,0	5,0	0,5	0,5	6	■
JH790095G3R025.0Z6-HXT	03127372	3	G	9,5	10,0	2,54	66,0	5,0	0,25	0,25	6	■
JH790095G3R050.0Z6-HXT	03127373	3	G	9,5	10,0	2,54	66,0	5,0	0,5	0,5	6	■

■ **Lagerstandard.**

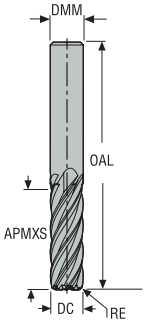
Schnittdaten – JH790 (T) Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110–160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66–100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

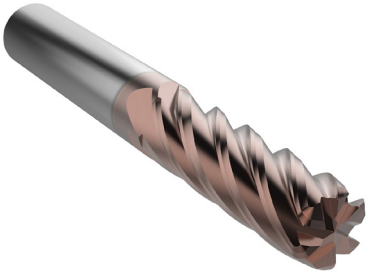
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

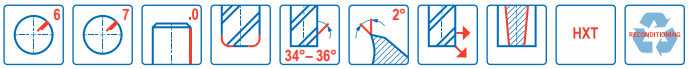
JH730

Hohe Geschwindigkeit – CoCr/Titan – Eckfräser – 6-7 Schneiden – Zylindrisch – Eckenradius



D





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JH730080D2R050.0Z6-HXT	03127375	2	D	8,0	8,0	25,0	63,0	0,5	6	■
JH730080D2R100.0Z6-HXT	03127377	2	D	8,0	8,0	25,0	63,0	1,0	6	■
JH730080D2R150.0Z6-HXT	03127378	2	D	8,0	8,0	25,0	63,0	1,5	6	■
JH730080D2R200.0Z6-HXT	03127379	2	D	8,0	8,0	25,0	63,0	2,0	6	■
JH730100D2R100.0Z7-HXT	03127380	2	D	10,0	10,0	31,0	72,0	1,0	7	■
JH730100D2R250.0Z7-HXT	03127381	2	D	10,0	10,0	31,0	72,0	2,5	7	■

■ **Lagerstandard.**

Schnittdaten – JH730 Eckfräsen/Schlichten

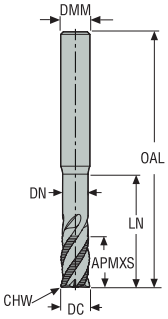
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.0625 *0,0625*	1.8 *1,8*	0.020 *0,00080*	0.025 *0,0010*	80 (63 — 93) *260 (210 — 300)*
S11	E	0.0625 *0,0625*	1.8 *1,8*	0.016 *0,00065*	0.020 *0,00080*	135 (110–160) *445 (370 — 520)*
S12	E	0.0625 *0,0625*	1.8 *1,8*	0.016 *0,00065*	0.020 *0,00080*	105 (83–120) *345 (280 — 390)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

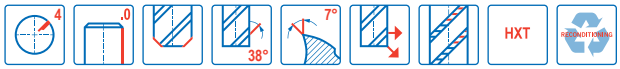
JHP994

Hochleistung – CoCr/Titan – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenfase



E





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW=0/-0,1 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JHP994060E3C.0Z4-HXT	03127382	3	E	6,0	6,0	14,0	63,0	24,0	5,6	0,2	4	■
JHP994080E3C.0Z4-HXT	03127383	3	E	8,0	8,0	18,0	69,0	32,0	7,4	0,2	4	■
JHP994100E3C.0Z4-HXT	03127384	3	E	10,0	10,0	22,0	88,0	40,0	9,4	0,2	4	■

■ **Lagerstandard.**

Schnittdaten – JHP994 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z			v_c
				6	8	10	
S2	E	0.0480 *0,0480*	2.0 *2,0*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	55 (40 — 69) *180 (140 — 220)*
S11	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (39–77) *165 (130 — 250)*
S12	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	40 (30 — 59) *130 (99–190)*

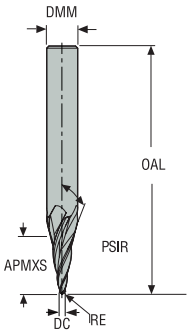
Schnittdaten – JHP994 Nutfräsen

SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79–130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (83–150)*

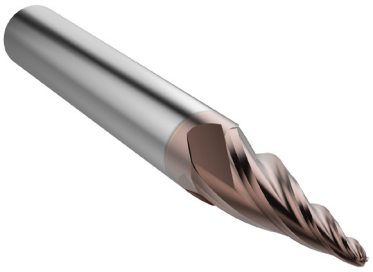
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

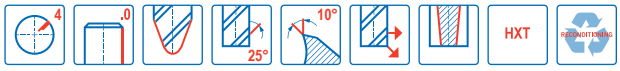
JH780

Hohe Geschwindigkeit – CoCr/Titan – Konischer Kugelkopf – 4 Schneiden – Zylindrisch



N





- Toleranzen:
- DMM=h5
- DC= ±0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PSIR	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
JH780018N2R100.0Z4-HXT	03127386	2	N	1,827	8,0	23,5	63,0	1,0	5,1838	4	■
JH780028N2R150.0Z4-HXT	03127387	2	N	2,803	8,0	23,5	63,0	1,5	3,8915	4	■
JH780038N2R200.0Z4-HXT	03127388	2	N	3,823	8,0	23,5	63,0	2,0	2,5972	4	■
JH780049N2R250.0Z4-HXT	03127389	2	N	4,888	8,0	23,5	63,0	2,5	1,3003	4	■

■ **Lagerstandard.**

Schnittdaten – JH780 Eckfräsen

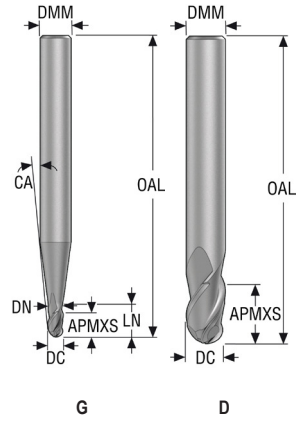
SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76–110) *310 (250 — 360)*

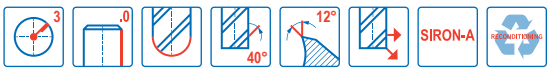
Schnittdaten, siehe Seite 457 - 464

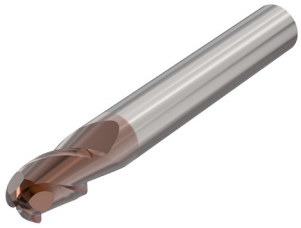
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHB720

Hohe Geschwindigkeit – Titan – Kugelkopf – 3 Schneiden – Zylindrisch







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Sorte	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
					mm	mm	mm	mm	mm	mm									
JHB720020G2B.0Z3	HXT	10072323	2	G	2,0	6,0	3,0	60,0	6,0	1,9	7,0	3	6,5	7,0	7,4	7,7	8,2	9,2	■
JHB720030G2B.0Z3	HXT	10072324	2	G	3,0	6,0	4,5	60,0	6,5	2,8	5,0	3	7,0	8,2	8,7	9,3	10,0	11,9	■
JHB720035G2B.0Z3	HXT	10072325	2	G	3,5	6,0	5,0	65,0	7,0	3,2	3,5	3	7,5	10,0	11,0	12,4	14,1	20,4	■
JHB720040G2B.0Z3	HXT	10072326	2	G	4,0	6,0	6,0	65,0	8,0	3,7	3,0	3	8,5	11,1	12,2	13,7	15,6	–	■
JHB720060D2B.0Z3	HXT	10072327	2	D	6,0	6,0	9,0	75,0	–	–	–	3	–	–	–	–	–	–	■
JHB720080D2B.0Z3	HXT	10072328	2	D	8,0	8,0	12,0	75,0	–	–	–	3	–	–	–	–	–	–	■
JHB720100D2B.0Z3	HXT	10072329	2	D	10,0	10,0	15,0	80,0	–	–	–	3	–	–	–	–	–	–	■
JHB720120D2B.0Z3	HXT	10072330	2	D	12,0	12,0	18,0	90,0	–	–	–	3	–	–	–	–	–	–	■
JHB720160D2B.0Z3	HXT	10072331	2	D	16,0	16,0	24,0	100,0	–	–	–	3	–	–	–	–	–	–	■

■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JHB720 Eckfräsen

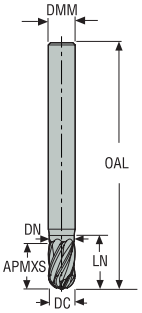
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	3.5	4	6	8	10	12	16	
M1	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62–110) *280 (210 — 360)*
M2	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	70 (51 — 90) *230 (170 — 290)*
M3	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	65 (46 — 84) *215 (160 — 270)*
M4	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	50 (35 — 65) *165 (120 — 210)*
M5	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	42 (29 — 54) *140 (96–170)*
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	500 (400 — 600) *1650 (1400–1900)*
N3	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	335 (270 — 400) *1100 (890–1300)*
N11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	300 (260 — 340) *980 (860–1100)*
S1	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	43 (29 — 57) *140 (96–180)*
S2	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	35 (24 — 46) *115 (79–150)*
S3	E	0.100 *0,100*	1.2 *1,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	30 (21 — 39) *100 (69–120)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79–100) *295 (260 — 320)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.0085 *0,00034*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400–1900)*
TP1	M	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400–1900)*

Schnittdaten, siehe Seite 457 - 464

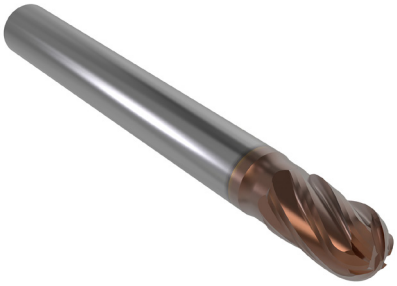
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

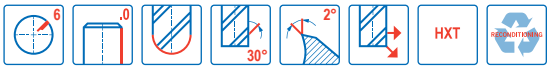
JH721

Hohe Geschwindigkeit – CoCr/Titan – Kugelkopf – 6 Schneiden – Zylindrisch



E





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
JH721060E2B.0Z6-HXT	03127390	2	E	6,0	6,0	10,0	57,0	12,0	5,6	6	■
JH721080E2B.0Z6-HXT	03127391	2	E	8,0	8,0	13,0	58,0	16,0	7,4	6	■

■ **Lagerstandard.**

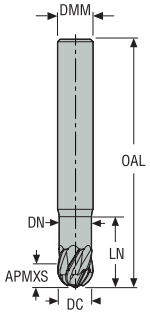
Schnittdaten – JH721 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110–140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460–750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	160 (110–180) *520 (370 — 590)*

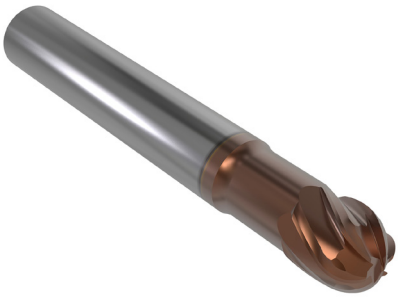
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

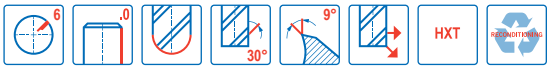
JH722

Hohe Geschwindigkeit – CoCr/Titan – Kugelkopf – 6 Schneiden – Zylindrisch



E





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
JH722100E2B.0Z6-HXT	03127392	2	E	10,0	10,0	10,0	72,0	20,0	9,4	6	■

■ **Lagerstandard.**

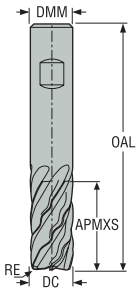
Schnittdaten – JH722 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.0500 *0,0500*	0.15 *0,15*	0.065 *0,0026*	125 (110–150) *410 (370 — 490)*
S11	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	210 (190 — 230) *690 (630–750)*
S12	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	160 (150–180) *520 (500 — 590)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JCO710

Hochleistung – Titan – Schaftfräser – 4-6 Schneiden – Weldon – Eckenradius



D





- Toleranzen:
- DMM = h6
- DC = k10
- RE= ±0,05 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm		
JCO710160D2R100.3Z4	02810493	2	D	16,0	16,0	32,0	92,0	1,0	4	■
JCO710160D2R250.3Z4	02810494	2	D	16,0	16,0	32,0	92,0	2,5	4	■
JCO710160D2R400.3Z4	02810496	2	D	16,0	16,0	32,0	92,0	4,0	4	■
JCO710200D2R100.3Z4	02810497	2	D	20,0	20,0	38,0	114,0	1,0	4	■
JCO710200D2R400.3Z4	02810500	2	D	20,0	20,0	38,0	114,0	4,0	4	■
JCO710250D2R100.3Z6	02810501	2	D	25,0	25,0	45,0	121,0	1,0	6	■
JCO710320D2R100.3Z6	02810504	2	D	32,0	32,0	53,0	132,0	1,0	6	■
JCO710320D2R400.3Z6	02810505	2	D	32,0	32,0	53,0	132,0	4,0	6	■

■ **Lagerstandard.**

Schnittdaten – JCO710 Eckfräsen/Schruppen PCEDC4 LV2

SMG		a_e/DC	a_p/DC	f_z				v_c
				16	20	25	32	
M1	E	0.500 *0,500*	1.2 *1,2*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	21 (15 — 28) *70 (50 — 91)*
M2	E	0.500 *0,500*	1.2 *1,2*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	17 (12 — 23) *55 (40–75)*
S11	E	0.500 *0,500*	1.1 *1,1*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	13 (9.4–18) *43 (31 — 59)*
S12	E	0.500 *0,500*	1.1 *1,1*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	10 (7.3–14) *33 (24 — 45)*
S13	E	0.500 *0,500*	1.1 *1,1*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	7 (5.7–11) *23 (19 — 36)*

Schnittdaten – JCO710 Eckfräsen/Schruppen PCEDC6 LV2

SMG		a_e/DC	a_p/DC	f_z				v_c
				20	25	32	40	
M1	E	0.480 *0,480*	1.2 *1,2*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	18 (13 — 24) *60 (43–78)*
M2	E	0.480 *0,480*	1.2 *1,2*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	15 (11 — 20) *49 (37 — 65)*
S11	E	0.480 *0,480*	1.2 *1,2*	0.075 *0,0030*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	11 (7.9–15) *36 (26 — 49)*
S12	E	0.480 *0,480*	1.2 *1,2*	0.075 *0,0030*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	8 (6.1–12) *26 (21 — 39)*
S13	E	0.480 *0,480*	1.2 *1,2*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	6 (4.9 — 9.6) *20 (17 — 31)*

Schnittdaten – JCO710 Nutfräsen PCEDC4 LV2

SMG		a_p/DC	f_z				v_c
			16	20	25	32	
M1	E	1.0 *1,0*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	19 (13 — 24) *60 (43–78)*
M2	E	1.0 *1,0*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	15 (10 — 20) *49 (33 — 65)*
M3	E	0.50 *0,50*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	10 (7.1–15) *33 (24 — 49)*
M4	E	0.50 *0,50*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	8 (5.4–11) *26 (18 — 36)*
M5	E	0.50 *0,50*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	6 (4.5 — 9.6) *20 (15 — 31)*
S11	E	0.75 *0,75*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	10 (7.8–15) *33 (26 — 49)*
S12	E	0.75 *0,75*	0.0060 *0,00024*	0.0075 *0,00030*	0.0085 *0,00034*	0.010 *0,00040*	8 (6.0–11) *26 (20 — 36)*
S13	E	0.75 *0,75*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	6 (4.7 — 9.3) *20 (16 — 30)*

Bei JCO + SIRA: v_c Tabelle* 1.2

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.



NICHT-EISEN-METALLE

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Nicht-Eisen-Metallen besteht aus Schaft- und Kugelkopffräsern.

- JS412 und JS413 Schaftfräser mit scharfer Ecke
- JS452, JS453, JHP490, JH40, JH421, JM403/404/406, JH410 und JH440 mit Eckenradius
- JH450, JH460 und JM413/416 Kugelkopffräser

Werkzeugauswahl NE-Metalle

						
Werkzeugbezeichnung		JS412	JS413	JS452	JS453	JHP490
Seite(n)		313	316	319	324	329
Produktfamilie		JS²	JS²	JS²	JS²	HPM
Fräserausführung						
Auf-nahmen	Zylindrisch	■	■	■	■	■
	Weldon	■	■	□	□	■
	Safe-Lock					□
Schneidenzahl		2	3	2	3	2-3
ICC						■
	Metrisch	2-20	2-20	2-20	2-20	10-25
	Zoll					
Verfügbare Längen						
		2	2,3	2,3	2,3	2,3,4
Bearbeitung						
						
SMG						
N1		●	●	●	●	●
N2		●	●	●	●	●
N3			●	●	●	●
N11						
TS1		●	●	●	●	
TP1		●	●	●	●	

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl NE-Metalle

					
Werkzeugbezeichnung		JH40	JH421	JH410	JH440
Seite(n)		333	336	340	342
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung					
Aufnahmen	Zylindrisch	■	■	■	■
	Weldon				
	Safe-Lock				
Schneidenzahl		2	2-3	1	2
ICC			■		
	Metrisch	2-20	2-25	2-17	6-8
	Zoll				
Verfügbare Längen					
		1,2	2,3	2,3	2
Bearbeitung					
					
SMG					
N1		•	•	•	•
N2					•
N3					•
N11		•	•	•	•
TS1		•	•	•	•
TP1			•		•

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
• Erste Wahl ○ Alternative

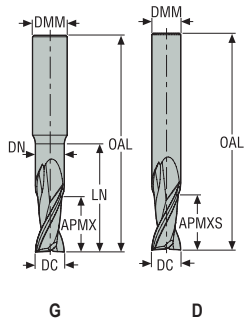
Werkzeugauswahl NE-Metalle

					
Werkzeugbezeichnung		JH450	JH460	JM403/404/406	JM413/416
Seite(n)		344	346	348	350
Produktfamilie		HSM/TORNADO	HSM/TORNADO	MINI	MINI
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
	Safe-Lock				
Schneidenzahl		2	2	1	2
ICC					
	Metrisch	2-20	3-12	0,5-2	0,5-2
	Zoll				
Verfügbare Längen					
		2,3	2	1,2,5	2,3,5
Bearbeitung					
					
					
SMG					
N1		•	•	•	•
N2		•		•	•
N3		•		•	•
N11		•	•		•
TS1		•	•		•
TP1		•	•		•

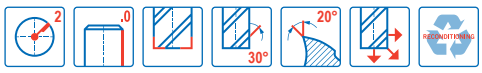
■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JS412

Allgemeine Bearbeitung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide







- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

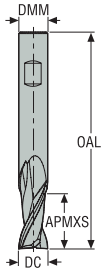
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	DN	LN	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
JS412020G2SZ2.0	02881760	2	G	2,0	6,0	4,0	57,0	1,9	7,0	2	■
JS412030G2SZ2.0	02881761	2	G	3,0	6,0	6,0	57,0	2,8	10,0	2	■
JS412040G2SZ2.0	02881762	2	G	4,0	6,0	8,0	57,0	3,8	14,0	2	■
JS412050G2SZ2.0	02881763	2	G	5,0	6,0	10,0	57,0	4,7	17,0	2	■
JS412060D2SZ2.0	02881764	2	D	6,0	6,0	12,0	57,0	–	–	2	■
JS412080D2SZ2.0	02881765	2	D	8,0	8,0	16,0	63,0	–	–	2	■
JS412100D2SZ2.0	02881766	2	D	10,0	10,0	20,0	75,0	–	–	2	■
JS412120D2SZ2.0	02881767	2	D	12,0	12,0	24,0	88,0	–	–	2	■
JS412160D2SZ2.0	02881769	2	D	16,0	16,0	32,0	100,0	–	–	2	■
JS412200D2SZ2.0	02881770	2	D	20,0	20,0	40,0	124,0	–	–	2	■

■ **Lagerstandard.**

JS412

Allgemeine Bearbeitung – Aluminium – Schaftfräser – 2 Schneiden – Weldon – Scharfe Schneide





D

- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS412060D2SZ2.3	02881771	2	D	6,0	6,0	12,0	57,0	2	■
JS412080D2SZ2.3	02881772	2	D	8,0	8,0	16,0	63,0	2	■
JS412100D2SZ2.3	02881773	2	D	10,0	10,0	20,0	75,0	2	■
JS412120D2SZ2.3	02881774	2	D	12,0	12,0	24,0	88,0	2	■
JS412160D2SZ2.3	02881776	2	D	16,0	16,0	32,0	100,0	2	■
JS412200D2SZ2.3	02881777	2	D	20,0	20,0	40,0	124,0	2	■

■ **Lagerstandard.**

Schnittdaten – JS412 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (470–700) *1925 (1600 — 2200)*
N2	E/M/A	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	475 (360 — 590) *1550 (1200–1900)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480–710) *1975 (1600 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	500 (380 — 630) *1650 (1300 — 2000)*

Schnittdaten – JS412 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
N2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100–1600)*
TS1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
TP1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	420 (320 — 520) *1375 (1100–1700)*

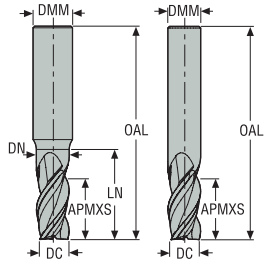
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS413

Allgemeine Bearbeitung – Aluminium – Schaftfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide





- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

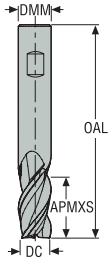


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	DN	LN	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
JS413020G2SZ3.0	02881797	2	G	2,0	6,0	4,0	57,0	1,9	7,0	3	■
JS413030G2SZ3.0	02881798	2	G	3,0	6,0	6,0	57,0	2,8	10,0	3	■
JS413040G2SZ3.0	02881799	2	G	4,0	6,0	8,0	57,0	3,8	14,0	3	■
JS413050G2SZ3.0	02881800	2	G	5,0	6,0	10,0	57,0	4,7	17,0	3	■
JS413060D2SZ3.0	02881801	2	D	6,0	6,0	12,0	57,0	–	–	3	■
JS413080D2SZ3.0	02881802	2	D	8,0	8,0	16,0	63,0	–	–	3	■
JS413100D2SZ3.0	02881803	2	D	10,0	10,0	20,0	72,0	–	–	3	■
JS413120D2SZ3.0	02881804	2	D	12,0	12,0	24,0	88,0	–	–	3	■
JS413160D2SZ3.0	02881806	2	D	16,0	16,0	32,0	100,0	–	–	3	■
JS413200D2SZ3.0	02881807	2	D	20,0	20,0	40,0	124,0	–	–	3	■
JS413060D3SZ3.0	02881815	3	D	6,0	6,0	24,0	70,0	–	–	3	■
JS413080D3SZ3.0	02881816	3	D	8,0	8,0	32,0	85,0	–	–	3	■
JS413100D3SZ3.0	02881817	3	D	10,0	10,0	40,0	100,0	–	–	3	■
JS413120D3SZ3.0	02881818	3	D	12,0	12,0	50,0	115,0	–	–	3	■
JS413160D3SZ3.0	02881820	3	D	16,0	16,0	55,0	125,0	–	–	3	■
JS413200D3SZ3.0	02881821	3	D	20,0	20,0	75,0	150,0	–	–	3	■

■ **Lagerstandard.**

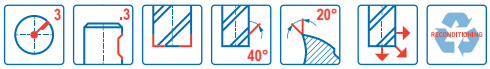
JS413

Allgemeine Bearbeitung – Aluminium – Schaftfräser – 3 Schneiden – Weldon – Scharfe Schneide



D





- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Weldon
				mm	mm	mm	mm		
JS413060D2SZ3.3	02881808	2	D	6,0	6,0	12,0	57,0	3	■
JS413080D2SZ3.3	02881809	2	D	8,0	8,0	16,0	63,0	3	■
JS413100D2SZ3.3	02881810	2	D	10,0	10,0	20,0	72,0	3	■
JS413120D2SZ3.3	02881811	2	D	12,0	12,0	24,0	88,0	3	■
JS413160D2SZ3.3	02881813	2	D	16,0	16,0	32,0	100,0	3	■
JS413200D2SZ3.3	02881814	2	D	20,0	20,0	40,0	124,0	3	■
JS413060D3SZ3.3	02881955	3	D	6,0	6,0	24,0	70,0	3	□
JS413080D3SZ3.3	02881956	3	D	8,0	8,0	32,0	85,0	3	□
JS413100D3SZ3.3	02881957	3	D	10,0	10,0	40,0	100,0	3	□
JS413120D3SZ3.3	02881958	3	D	12,0	12,0	50,0	115,0	3	□
JS413160D3SZ3.3	02881960	3	D	16,0	16,0	55,0	125,0	3	□
JS413200D3SZ3.3	02881961	3	D	20,0	20,0	75,0	150,0	3	□

. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS413 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480–710) *1975 (1600 — 2300)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	470 (360 — 580) *1550 (1200–1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	315 (240 — 390) *1025 (790–1200)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	610 (500–730) *2000 (1700 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	330 (250 — 410) *1075 (830–1300)*

Schnittdaten – JS413 Nutfräsen

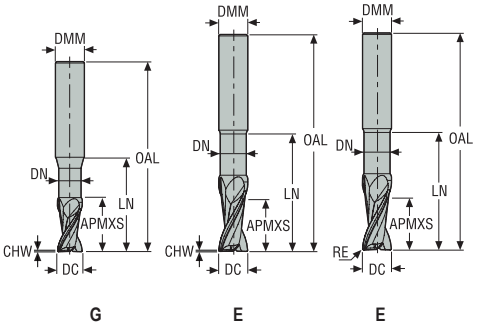
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400–1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	400 (300 — 490) *1300 (990–1600)*
N3	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	265 (200 — 330) *870 (660–1000)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	500 (400 — 600) *1650 (1400–1900)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	270 (210 — 330) *890 (690–1000)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS452

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius oder Fase







- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

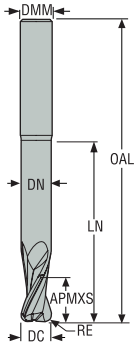
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
JS452020G2CZ2.0-HEMI	02881848	2	G	2,0	6,0	4,0	57,0	8,0	1,9	0,1	–	2	■
JS452030G2CZ2.0-HEMI	02881849	2	G	3,0	6,0	6,0	57,0	10,0	2,8	0,1	–	2	■
JS452040G2CZ2.0-HEMI	02881850	2	G	4,0	6,0	8,0	57,0	14,0	3,8	0,1	–	2	■
JS452050G2CZ2.0-HEMI	02881851	2	G	5,0	6,0	8,0	57,0	17,0	4,7	0,1	–	2	■
JS452060E2CZ2.0-HEMI	02881852	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	–	2	■
JS452060E2R050Z2.0-HEMI	02881853	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	0,5	2	■
JS452060E2R100Z2.0-HEMI	02881854	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	1,0	2	■
JS452080E2CZ2.0-HEMI	02881778	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	–	2	■
JS452080E2R050Z2.0-HEMI	02881855	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	0,5	2	■
JS452080E2R100Z2.0-HEMI	02881779	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	1,0	2	■
JS452100E2CZ2.0-HEMI	02881856	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,1	–	2	■
JS452100E2R050Z2.0-HEMI	02881857	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	0,5	2	■
JS452100E2R100Z2.0-HEMI	02881858	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	1,0	2	■
JS452120E2CZ2.0-HEMI	02881859	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	–	2	■
JS452120E2R050Z2.0-HEMI	02881860	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	0,5	2	■
JS452120E2R100Z2.0-HEMI	02881861	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	1,0	2	■
JS452120E2R200Z2.0-HEMI	02881780	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	2,0	2	■
JS452140E2CZ2.0-HEMI	02881862	2	E	14,0	14,0	28,0	88,0	41,0	13,3	0,1	–	2	■
JS452160E2CZ2.0-HEMI	02881863	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	–	2	■
JS452160E2R050Z2.0-HEMI	02881864	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	0,5	2	■
JS452160E2R100Z2.0-HEMI	02881782	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	2	■
JS452160E2R200Z2.0-HEMI	02881783	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	2	■
JS452160E2R400Z2.0-HEMI	02881785	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	2	■
JS452200E2CZ2.0-HEMI	02881865	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	2	■
JS452200E2R050Z2.0-HEMI	02881866	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	2	■
JS452200E2R100Z2.0-HEMI	02881768	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	2	■

■ Lagerstandard.

JS452

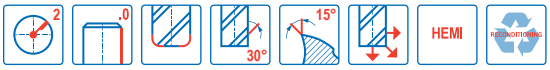
Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

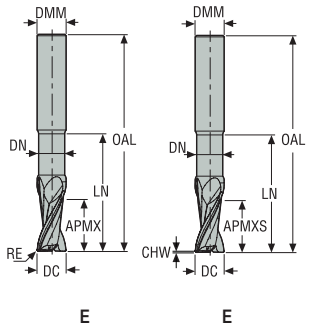


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
JS452080E3R020.0Z2-HEMI	03003413	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	■
JS452100E3R050.0Z2-HEMI	03003415	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	■
JS452120E3R050.0Z2-HEMI	03003419	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	■
JS452160E3R050.0Z2-HEMI	03003426	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	■
JS452200E3R050.0Z2-HEMI	03003433	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	■

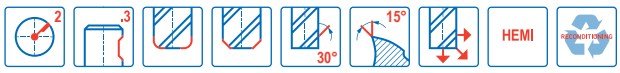
■ **Lagerstandard.**

JS452

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Weldon – Eckenradius oder Fase







- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Nachschleifen möglich

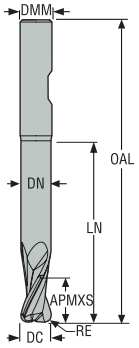
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS452060E2CZ2.3-HEMI	02881867	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	–	2	☐
JS452060E2R050Z2.3-HEMI	02881868	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	0,5	2	☐
JS452060E2R100Z2.3-HEMI	02881869	2	E	6,0	6,0	12,0	57,0	19,0	5,7	–	1,0	2	☐
JS452080E2CZ2.3-HEMI	02881947	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	–	2	☐
JS452080E2R050Z2.3-HEMI	02881870	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	0,5	2	☐
JS452080E2R100Z2.3-HEMI	02922247	2	E	8,0	8,0	16,0	63,0	24,0	7,6	–	1,0	2	☐
JS452100E2CZ2.3-HEMI	02881871	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,1	–	2	☐
JS452100E2R050Z2.3-HEMI	02881872	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	0,5	2	☐
JS452100E2R100Z2.3-HEMI	02881873	2	E	10,0	10,0	20,0	72,0	29,0	9,5	–	1,0	2	☐
JS452120E2CZ2.3-HEMI	02881874	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	–	2	☐
JS452120E2R050Z2.3-HEMI	02881875	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	0,5	2	☐
JS452120E2R100Z2.3-HEMI	02881876	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	1,0	2	☐
JS452120E2R200Z2.3-HEMI	02881948	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	2,0	2	☐
JS452140E2CZ2.3-HEMI	02881877	2	E	14,0	14,0	28,0	88,0	41,0	13,3	0,1	–	2	☐
JS452160E2CZ2.3-HEMI	02881878	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	–	2	☐
JS452160E2R050Z2.3-HEMI	02881879	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	0,5	2	☐
JS452160E2R100Z2.3-HEMI	02881949	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	2	☐
JS452160E2R200Z2.3-HEMI	02881950	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	2	☐
JS452160E2R400Z2.3-HEMI	02881952	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	2	☐
JS452200E2CZ2.3-HEMI	02881880	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	2	☐
JS452200E2R050Z2.3-HEMI	02881881	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	2	☐
JS452200E2R100Z2.3-HEMI	02881953	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	2	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS452

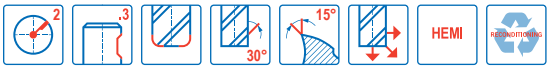
Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Weldon – Eckenradius





E

- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm		
JS452080E3R020.3Z2-HEMI	03003447	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	☐
JS452100E3R050.3Z2-HEMI	03003449	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	☐
JS452120E3R050.3Z2-HEMI	03003453	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	☐
JS452160E3R050.3Z2-HEMI	03003460	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	☐
JS452200E3R050.3Z2-HEMI	03003467	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS452 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	485 (370 — 600) *1600 (1300–1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	325 (250 — 400) *1075 (830–1300)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 670) *1825 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	450 (340 — 560) *1475 (1200–1800)*

Schnittdaten – JS452 Nutfräsen

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100–1600)*
N3	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	265 (210 — 330) *870 (690–1000)*
TS1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
TP1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	400 (310 — 500) *1300 (1100–1600)*

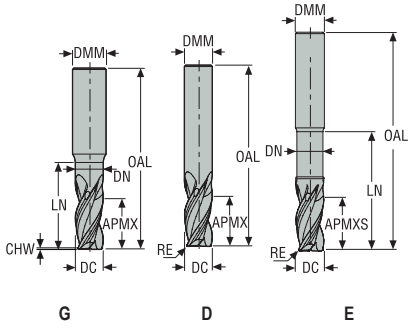
Anmerkung: bei Eckenradius >15% DC dann a_p= -30%, f_z= -20%
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JS453

Hochleistung – Aluminium – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

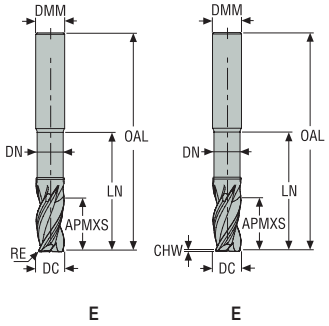


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453020G2CZ3.0-HEMI	02881896	2	G	2,0	6,0	4,0	57,0	7,0	1,9	0,1	–	3	■
JS453030G2CZ3.0-HEMI	02881897	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	–	3	■
JS453040G2CZ3.0-HEMI	02881898	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,1	–	3	■
JS453050G2CZ3.0-HEMI	02881899	2	G	5,0	6,0	10,0	57,0	14,0	4,75	0,1	–	3	■
JS453060D2CZ3.0-HEMI	02881900	2	D	6,0	6,0	12,0	57,0	–	–	0,1	–	3	■
JS453060D2R050Z3.0-HEMI	02881901	2	D	6,0	6,0	12,0	57,0	–	–	–	0,5	3	■
JS453080D2CZ3.0-HEMI	02881812	2	D	8,0	8,0	16,0	63,0	–	–	0,1	–	3	■
JS453080D2R050Z3.0-HEMI	02881902	2	D	8,0	8,0	16,0	63,0	–	–	–	0,5	3	■
JS453100D2CZ3.0-HEMI	02881903	2	D	10,0	10,0	20,0	72,0	–	–	0,1	–	3	■
JS453100D2R050Z3.0-HEMI	02881904	2	D	10,0	10,0	20,0	72,0	–	–	–	0,5	3	■
JS453120D2CZ3.0-HEMI	02881905	2	D	12,0	12,0	24,0	88,0	–	–	0,1	–	3	■
JS453120D2R050Z3.0-HEMI	02881906	2	D	12,0	12,0	24,0	88,0	–	–	–	0,5	3	■
JS453120E2R300.0Z3-HEMI	02905280	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	3,0	3	■
JS453140D2CZ3.0-HEMI	02881907	2	D	14,0	14,0	28,0	88,0	–	–	0,1	–	3	■
JS453160D2CZ3.0-HEMI	02881908	2	D	16,0	16,0	32,0	100,0	–	–	0,1	–	3	■
JS453160D2R050Z3.0-HEMI	02881909	2	D	16,0	16,0	32,0	100,0	–	–	–	0,5	3	■
JS453160E2R100.0Z3-HEMI	02905281	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	3	■
JS453160E2R200.0Z3-HEMI	02905282	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	3	■
JS453160E2R250.0Z3-HEMI	02905283	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,5	3	■
JS453160E2R300.0Z3-HEMI	02905284	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	3,0	3	■
JS453160E2R400.0Z3-HEMI	02905285	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	3	■
JS453200E2C.0Z3-HEMI	02905286	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	3	■
JS453200E2R050.0Z3-HEMI	02905287	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	3	■
JS453200E2R100.0Z3-HEMI	02905288	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	3	■
JS453200E2R200.0Z3-HEMI	02905289	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	2,0	3	■
JS453200E2R300.0Z3-HEMI	02905291	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	3,0	3	■
JS453200E2R400.0Z3-HEMI	02905292	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	4,0	3	■

■ **Lagerstandard.**

JS453

Hochleistung – Aluminium – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase







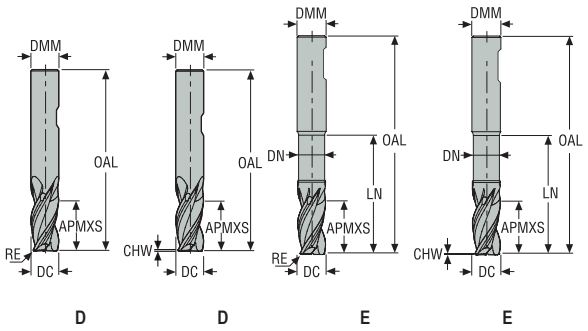
- Toleranzen:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453120E3R300.0Z3-HEMI	02905294	3	E	12,0	12,0	24,0	110,0	54,0	11,4	–	3,0	3	■
JS453160E3R100.0Z3-HEMI	02905295	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	1,0	3	■
JS453160E3R200.0Z3-HEMI	02905296	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	2,0	3	■
JS453160E3R300.0Z3-HEMI	02905298	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	3,0	3	■
JS453160E3R400.0Z3-HEMI	02905299	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	4,0	3	■
JS453200E3C.0Z3-HEMI	02905300	3	E	20,0	20,0	36,0	150,0	90,0	19,0	0,1	–	3	■
JS453200E3R050.0Z3-HEMI	02905301	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	0,5	3	■
JS453200E3R100.0Z3-HEMI	02905302	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	1,0	3	■
JS453200E3R200.0Z3-HEMI	02905303	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	2,0	3	■
JS453200E3R300.0Z3-HEMI	02905305	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	3,0	3	■
JS453200E3R400.0Z3-HEMI	02905306	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	4,0	3	■

JS453

Hochleistung – Aluminium – Schaftfräser – 3 Schneiden – Weldon – Eckenradius oder Fase





- Toleranzen:
- DMM=h5
- DC=e7
- RE=±0,02 mm
- CHW= ±0,02 mm
- Nachschleifen möglich

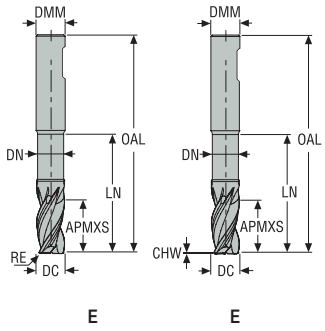


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453060D2CZ3.3-HEMI	02881910	2	D	6,0	6,0	12,0	57,0	–	–	0,1	–	3	☐
JS453060D2R050Z3.3-HEMI	02881911	2	D	6,0	6,0	12,0	57,0	–	–	–	0,5	3	☐
JS453080D2CZ3.3-HEMI	02881964	2	D	8,0	8,0	16,0	63,0	–	–	0,1	–	3	☐
JS453080D2R050Z3.3-HEMI	02881954	2	D	8,0	8,0	16,0	63,0	–	–	–	0,5	3	☐
JS453100D2CZ3.3-HEMI	02881913	2	D	10,0	10,0	20,0	72,0	–	–	0,1	–	3	☐
JS453100D2R050Z3.3-HEMI	02881914	2	D	10,0	10,0	20,0	72,0	–	–	–	0,5	3	☐
JS453120D2CZ3.3-HEMI	02881915	2	D	12,0	12,0	24,0	88,0	–	–	0,1	–	3	☐
JS453120D2R050Z3.3-HEMI	02881916	2	D	12,0	12,0	24,0	88,0	–	–	–	0,5	3	☐
JS453120E2R300.3Z3-HEMI	02905308	2	E	12,0	12,0	24,0	88,0	37,0	11,4	–	3,0	3	☐
JS453140D2CZ3.3-HEMI	02881917	2	D	14,0	14,0	28,0	88,0	–	–	0,1	–	3	☐
JS453160D2CZ3.3-HEMI	02881918	2	D	16,0	16,0	32,0	100,0	–	–	0,1	–	3	☐
JS453160D2R050Z3.3-HEMI	02881919	2	D	16,0	16,0	32,0	100,0	–	–	–	0,5	3	☐
JS453160E2R100.3Z3-HEMI	02905309	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	1,0	3	☐
JS453160E2R200.3Z3-HEMI	02905310	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,0	3	☐
JS453160E2R250.3Z3-HEMI	02905311	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	2,5	3	☐
JS453160E2R300.3Z3-HEMI	02905312	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	3,0	3	☐
JS453160E2R400.3Z3-HEMI	02905313	2	E	16,0	16,0	32,0	100,0	48,0	15,2	–	4,0	3	☐
JS453200E2C.3Z3-HEMI	02905314	2	E	20,0	20,0	36,0	110,0	57,0	19,0	0,1	–	3	☐
JS453200E2R050.3Z3-HEMI	02905315	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	0,5	3	☐
JS453200E2R100.3Z3-HEMI	02905316	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	1,0	3	☐
JS453200E2R200.3Z3-HEMI	02905317	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	2,0	3	☐
JS453200E2R300.3Z3-HEMI	02905319	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	3,0	3	☐
JS453200E2R400.3Z3-HEMI	02905320	2	E	20,0	20,0	36,0	110,0	57,0	19,0	–	4,0	3	☐

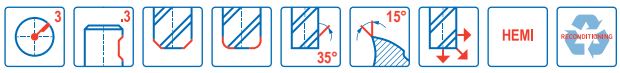
☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS453

Hochleistung – Aluminium – Schaftfräser – 3 Schneiden – Weldon – Eckenradius oder Fase







- Toleranzen:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm		
JS453120E3R300.3Z3-HEMI	02905322	3	E	12,0	12,0	24,0	110,0	54,0	11,4	–	3,0	3	☐
JS453160E3R100.3Z3-HEMI	02905323	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	1,0	3	☐
JS453160E3R200.3Z3-HEMI	02905324	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	2,0	3	☐
JS453160E3R300.3Z3-HEMI	02905326	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	3,0	3	☐
JS453160E3R400.3Z3-HEMI	02905327	3	E	16,0	16,0	32,0	125,0	77,0	15,2	–	4,0	3	☐
JS453200E3C.3Z3-HEMI	02905328	3	E	20,0	20,0	36,0	150,0	90,0	19,0	0,1	–	3	☐
JS453200E3R050.3Z3-HEMI	02905329	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	0,5	3	☐
JS453200E3R100.3Z3-HEMI	02905330	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	1,0	3	☐
JS453200E3R200.3Z3-HEMI	02905331	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	2,0	3	☐
JS453200E3R300.3Z3-HEMI	02905333	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	3,0	3	☐
JS453200E3R400.3Z3-HEMI	02905334	3	E	20,0	20,0	36,0	150,0	90,0	19,0	–	4,0	3	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS453 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	480 (370 — 600) *1575 (1300–1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	320 (250 — 400) *1050 (830–1300)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	445 (340 — 550) *1450 (1200–1800)*

Schnittdaten – JS453 Nutfräsen

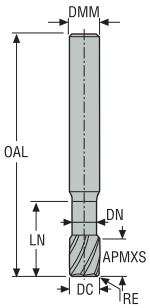
SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
N2	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	400 (300 — 490) *1300 (990–1600)*
N3	E	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	265 (200 — 330) *870 (660–1000)*
TS1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400–1900)*
TP1	A	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.20 *0,0080*	400 (300 — 500) *1300 (990–1600)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

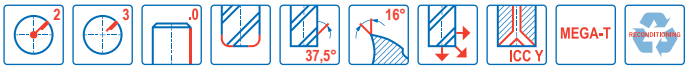
JHP490

Hochleistung – Aluminium – Schaftfräser – 2-3 Schneiden – Zylindrisch – Eckenradius – ICC



E





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich

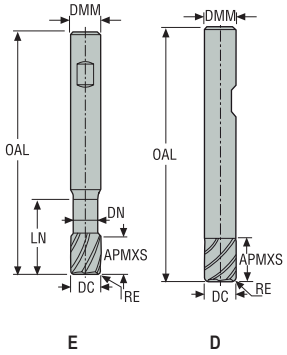
Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.0A-MEGA-T	02623870	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	■
490V120R200Z2.0A-MEGA-T	02623883	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	■
490V160R050Z3.0A-MEGA-T	02623889	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	3	■
490V200R050Z3.0A-MEGA-T	02623908	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	■
490V250R050Z3.0A-MEGA-T	02623926	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	■
490VL100R100Z2.0A-MEGA-T	02623876	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	■
490VL120R050Z3.0A-MEGA-T	02623880	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	■
490VL120R100Z2.0A-MEGA-T	02623886	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	■
490VL160R050Z3.0A-MEGA-T	02623891	3	E	■	16,0	16,0	18,0	95,0	45,0	14,5	0,5	3	■
490VL200R200Z3.0A-MEGA-T	02623916	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	■
490VXL250R050Z3.0A-MEGA-T	02623927	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmierstoffzufuhr

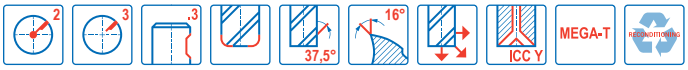
JHP490

Hochleistung – Aluminium – Schaftfräser – 2-3 Schneiden – Weldon – Eckenradius – ICC





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich

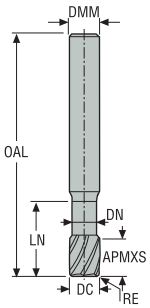


Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Weldon
					mm	mm	mm	mm	mm	mm	mm		
490V120R200Z2.0A-MEGA-TW	02669371	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	□
490V160R050Z3A-MEGA-T	02623888	2	E	■	16,0	16,0	18,0	85,0	32,0	14,5	0,5	3	■
490160R200Z3A-MEGA-T	02623898	2	D	■	16,0	16,0	34,0	95,0	–	–	2,0	3	■
490V200R050Z3A-MEGA-T	02623907	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	■
490V250R050Z3A-MEGA-T	02623925	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	■
490VL100R100Z2.0A-MEGA-TW	02669368	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	□
490VL120R050Z3.0A-MEGA-TW	02669374	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	□
490VL120R100Z2.0A-MEGA-TW	02669375	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	□
490VL160R050Z3.0A-MEGA-TW	02669382	3	E	■	16,0	16,0	18,0	95,0	45,0	14,5	0,5	3	□
490VL200R200Z3.0A-MEGA-TW	02669388	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	□
490VXL250R050Z3.0A-MEGA-TW	02669397	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
ICC = mit interner Kühlschmierstoffzufuhr

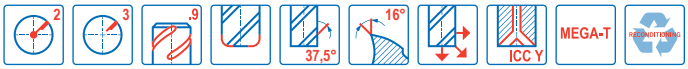
JHP490

Hochleistung – Aluminium – Schaftfräser – 2-3 Schneiden – Safe-Lock – Eckenradius – ICC



E





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Safe-Lock
					mm	mm	mm	mm	mm	mm	mm		
490V100R050Z2.9A-MEGA-T	02927984	2	E	■	10,0	10,0	12,0	65,0	20,0	9,0	0,5	2	☐
490V120R200Z2.9A-MEGA-T	02927988	2	E	■	12,0	12,0	14,0	75,0	24,0	11,0	2,0	2	☐
490V160R050Z3.9A-MEGA-T	02927990	2	E	■	16,0	16,0	18,0	85,0	32,0	14,0	0,5	3	☐
490V200R050Z3.9A-MEGA-T	02927992	2	E	■	20,0	20,0	22,0	100,0	40,0	18,0	0,5	3	☐
490V250R050Z3.9A-MEGA-T	02927993	2	E	■	25,0	25,0	27,0	125,0	50,0	23,0	0,5	3	☐
490VL100R100Z2.9A-MEGA-T	02927994	3	E	■	10,0	10,0	22,0	85,0	42,0	9,0	1,0	2	☐
490VL120R050Z3.9A-MEGA-T	02927995	3	E	■	12,0	12,0	14,0	95,0	40,0	11,0	0,5	3	☐
490VL120R100Z2.9A-MEGA-T	02927996	3	E	■	12,0	12,0	26,0	95,0	50,0	11,0	1,0	2	☐
490VL160R050Z3.9A-MEGA-T	02927997	3	E	■	16,0	16,0	18,0	95,0	32,0	14,0	0,5	3	☐
490VL200R200Z3.9A-MEGA-T	02927998	3	E	■	20,0	20,0	42,0	125,0	65,0	18,0	2,0	3	☐
490VXL250R050Z3.9A-MEGA-T	02927999	4	E	■	25,0	25,0	50,0	125,0	75,0	23,0	0,5	3	☐

☐ Safelock verfügbar. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.
ICC = mit interner Kühlschmierstoffzufuhr

Schnittdaten – JHP490 Eckfräsen/Schruppen

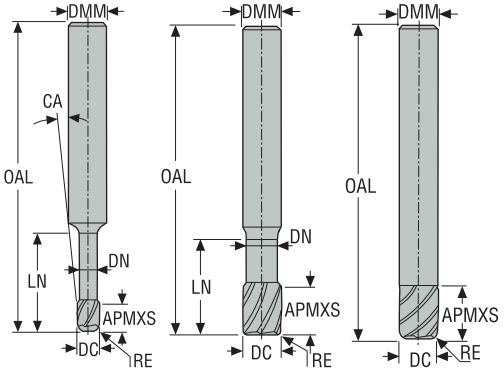
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
N1	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	700 (550 — 860) *2325 (1900 — 2800)*
N2	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	455 (350 — 550) *1500 (1200–1800)*
N3	E/M/A	0.500 *0,500*	1.1 *1,0*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	0.38 *0,015*	540 (440 — 650) *1775 (1500 — 2100)*

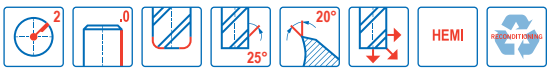
Schnittdaten – JHP490 Nutfräsen

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
N1	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	650 (500–790) *2125 (1700 — 2500)*
N2	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	420 (330 — 510) *1375 (1100–1600)*
N3	E/M/A	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.38 *0,015*	500 (400 — 590) *1650 (1400–1900)*

JH40

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

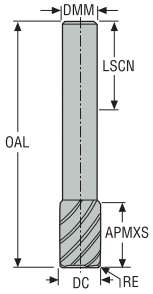
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm			
40K060-HEMI	00022089	1	D	6,0	6,0	13,0	50,0	–	–	0,1	–	2	■
40K080-HEMI	00022090	1	D	8,0	8,0	13,0	50,0	–	–	0,1	–	2	■
40K100-HEMI	00022091	1	D	10,0	10,0	16,0	50,0	–	–	0,1	–	2	■
40K120-HEMI	00022092	1	D	12,0	12,0	16,0	65,0	–	–	0,1	–	2	■
40020-HEMI	00022093	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,1	3,5	2	■
40030-HEMI	00022094	2	E	3,0	3,0	4,0	40,0	8,0	2,9	0,1	–	2	■
40040-HEMI	00022095	2	E	4,0	4,0	5,0	50,0	12,0	3,8	0,1	–	2	■
40050-HEMI	00022120	2	E	5,0	5,0	8,0	50,0	14,0	4,8	0,1	–	2	■
40060-HEMI	00022250	2	E	6,0	6,0	8,0	65,0	18,0	5,7	0,1	–	2	■
40080-HEMI	00022580	2	E	8,0	8,0	10,0	70,0	22,0	7,7	0,1	–	2	■
40100-HEMI	00022663	2	E	10,0	10,0	14,0	80,0	28,0	9,7	0,1	–	2	■
40120-HEMI	00022667	2	E	12,0	12,0	16,0	90,0	35,0	11,5	0,1	–	2	■
40160-HEMI	00022668	2	E	16,0	16,0	20,0	90,0	40,0	15,5	0,1	–	2	■
40200-HEMI	00022701	2	E	20,0	20,0	25,0	100,0	50,0	19,5	0,1	–	2	■

■ Lagerstandard.

JH40

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius





P

- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LSCN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
40020-RS	02479642	2	P	2,0	1,9	3,0	40,0	28,0	0,1	2	■
40030-RS	02479643	2	P	3,0	2,9	4,0	60,0	28,0	0,1	2	■
40040-RS	02479644	2	P	4,0	3,8	5,0	60,0	28,0	0,1	2	■
40050-RS	02479645	2	P	5,0	4,8	8,0	70,0	28,0	0,1	2	■
40060-RS	02479646	2	P	6,0	5,8	8,0	65,0	36,0	0,1	2	■
40080-RS	02479647	2	P	8,0	7,8	10,0	70,0	36,0	0,1	2	■
40100-RS	02479648	2	P	10,0	9,7	14,0	100,0	40,0	0,1	2	■
40120-RS	02479649	2	P	12,0	11,7	16,0	90,0	45,0	0,1	2	■
40L060-RS	02479650	3	P	6,0	5,8	8,0	100,0	36,0	0,1	2	■
40L080-RS	02479651	3	P	8,0	7,8	10,0	100,0	36,0	0,1	2	■
40L120-RS	02479652	3	P	12,0	11,7	16,0	125,0	45,0	0,1	2	■
40L160-RS	02479653	3	P	16,0	15,7	20,0	125,0	48,0	0,1	2	■
40L200-RS	02479654	3	P	20,0	19,7	25,0	125,0	50,0	0,1	2	■

■ **Lagerstandard.**

Schnittdaten – JH40 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	425 (320 — 520) *1400 (1100–1700)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*

Schnittdaten – JH40 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.60 *0,60*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510–700) *1975 (1700 — 2200)*
N11	E/M/A	0.40 *0,40*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100–1600)*
TS1	A	1.0 *1,0*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510–700) *1975 (1700 — 2200)*

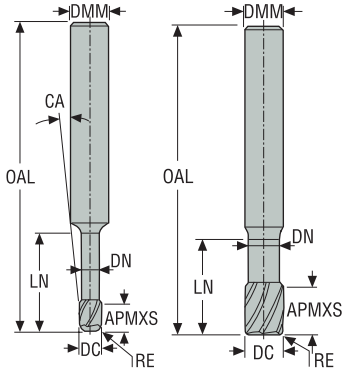
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH421

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius – ICC







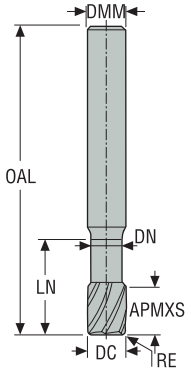
- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm			
421020R020Z2-MEGA-T	02434927	2	G	–	2,0	3,0	3,0	40,0	8,0	1,8	0,2	3,0	2	■
421030R020Z2-MEGA-T	02434939	2	E	–	3,0	3,0	4,0	40,0	12,0	2,7	0,2	–	2	■
421040R020Z2-MEGA-T	02434940	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,2	3,0	2	■
421040R030Z2-MEGA-T	02434941	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,3	3,0	2	■
421050R100Z2-MEGA-T	02434942	2	G	–	5,0	6,0	6,0	50,0	18,0	4,5	1,0	1,5	2	■
421060R025Z2-MEGA-T	02434946	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,25	–	2	■
421060R050Z2-MEGA-T	02434947	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,5	–	2	■
421060R100Z2-MEGA-T	02434958	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	1,0	–	2	■
421080R030Z2-MEGA-T	02434960	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,3	–	2	■
421080R060Z2-MEGA-T	02434964	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,6	–	2	■
421080R100Z2-MEGA-T	02434967	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	1,0	–	2	■
421100R030Z2-MEGA-T	02434968	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,3	–	2	■
421100R080Z2-MEGA-T	02434970	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,8	–	2	■
421100R150Z2-MEGA-T	02434971	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	1,5	–	2	■
421100R250Z2-MEGA-T	02438614	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	2,5	–	2	■
421100R310Z2-MEGA-T	02438683	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	3,1	–	2	■
421120R030Z2-MEGA-T	02434983	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,3	–	2	■
421120R050Z2-MEGA-T	02434986	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,5	–	2	■
421120R100Z2-MEGA-T	02434988	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,0	–	2	■
421120R150Z2-MEGA-T	02434989	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,5	–	2	■
421120R200Z2-MEGA-T	02434990	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,0	–	2	■
421120R250Z2AMEGA-T	02435008	2	E	■	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	■
421120R250Z2-MEGA-T	02435007	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	■
421120R310Z2-MEGA-T	02435009	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	3,1	–	2	■

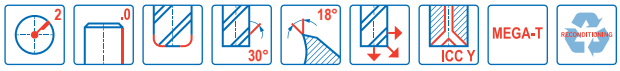
■ **Lagerstandard.**
ICC = mit interner Kühlschmierstoffzufuhr

JH421

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius – ICC



E





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

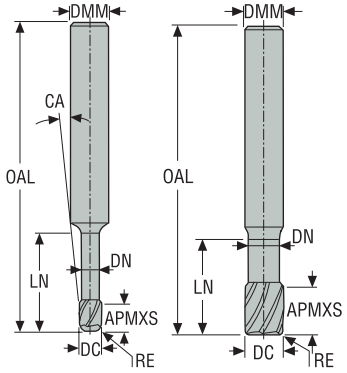
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
421160R050Z2-MEGA-T	02435010	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	0,5	2	■
421160R130Z2-MEGA-T	02435011	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	1,3	2	■
421160R200Z2-MEGA-T	02435014	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,0	2	■
421160R250Z2AMEGA-T	02435020	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	■
421160R250Z2-MEGA-T	02435012	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	■
421160R310Z2-MEGA-T	02435036	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	3,1	2	■
421160R400Z2AMEGA-T	02438684	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	■
421160R400Z2-MEGA-T	02435039	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	■
421200R160Z2-MEGA-T	02435042	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	1,6	2	■
421200R200Z2-MEGA-T	02435044	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,0	2	■
421200R250Z2AMEGA-T	02438685	2	E	■	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	■
421200R250Z2-MEGA-T	02435046	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	■
421200R310Z2-MEGA-T	02435049	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	3,1	2	■
421200R400Z2-MEGA-T	02435051	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	4,0	2	■
421200R500Z2-MEGA-T	02435055	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	5,0	2	■
421200R600Z2-MEGA-T	02435056	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	6,0	2	■
421250R500Z2-MEGA-T	02435065	2	E	–	25,0	25,0	30,0	100,0	45,0	23,0	5,0	2	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmierstoffzufuhr

JH421

Hochleistung – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius – ICC







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm			
421L080R020Z2-MEGA-T	02435068	3	E	–	8,0	8,0	6,0	75,0	40,0	7,2	0,2	–	2	■
421L100R050Z2-MEGA-T	02435070	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	0,5	–	2	■
421L100R250Z2-MEGA-T	02435074	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	2,5	–	2	■
421L100R310Z2-MEGA-T	02438690	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	3,1	–	2	■
421L120R050Z2-MEGA-T	02435340	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	0,5	–	2	■
421L120R100Z2-MEGA-T	02435343	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	1,0	–	2	■
421L120R200Z2-MEGA-T	02435373	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,0	–	2	■
421L120R250Z2-MEGA-T	02435374	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,5	–	2	■
421L120R310Z2-MEGA-T	02438692	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	3,1	–	2	■
421L140R050Z2-MEGA-T	02462710	3	G	–	14,0	16,0	12,0	110,0	70,0	13,0	0,5	1,0	2	■
421L140R310Z2-MEGA-T	02462712	3	G	–	14,0	16,0	12,0	110,0	70,0	13,0	3,1	1,0	2	■
421L160R050Z2-MEGA-T	02435375	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	0,5	–	2	■
421L160R100Z2-MEGA-T	02435380	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	1,0	–	2	■
421L160R200Z2-MEGA-T	02435381	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,0	–	2	■
421L160R250Z2AMEGA-T	02435383	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	2,5	–	2	■
421L160R250Z2-MEGA-T	02435382	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,5	–	2	■
421L160R310Z2-MEGA-T	02435384	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	3,1	–	2	■
421L160R400Z2AMEGA-T	02435386	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	4,0	–	2	■
421L200R050Z2-MEGA-T	02435387	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	0,5	–	2	■
421L200R200Z2-MEGA-T	02435391	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	2,0	–	2	■
421L200R310Z2-MEGA-T	02435398	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	3,1	–	2	■
421L200R500Z2-MEGA-T	02435401	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	5,0	–	2	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmierstoffzufuhr

Schnittdaten – JH421 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	0.28 *0,011*	620 (520–720) *2025 (1800 — 2300)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	410 (310 — 510) *1350 (1100–1600)*
TS1	A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	0.25 *0,010*	0.28 *0,011*	620 (520–720) *2025 (1800 — 2300)*
TP1	M	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	0.24 *0,0095*	410 (310 — 500) *1350 (1100–1600)*

Schnittdaten – JH421 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.50 *0,50*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	610 (510–700) *2000 (1700 — 2200)*
N11	E/M/A	0.50 *0,50*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	405 (310 — 500) *1325 (1100–1600)*
TS1	A	0.50 *0,50*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	610 (510–700) *2000 (1700 — 2200)*
TP1	M	0.50 *0,50*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	405 (310 — 500) *1325 (1100–1600)*

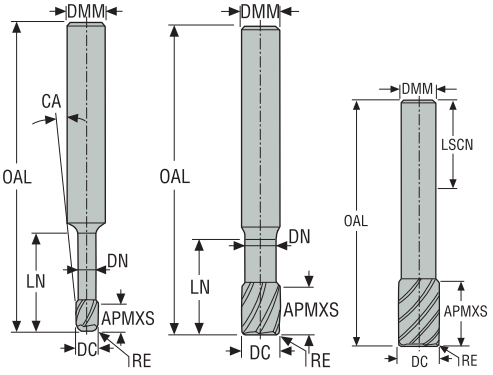
Schnittdaten, siehe Seite 457 - 464

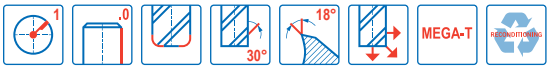
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH410

Hochleistung – Aluminium – Schaftfräser – 1 Schneide – Zylindrisch – Eckenradius







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	LSCN	DN	RE	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm			
410020R050-MEGA-T	02451548	2	G	2,0	6,0	3,0	50,0	6,0	36,0	1,7	0,5	12,0	1	■
410030R050-MEGA-T	02451578	2	G	3,0	6,0	4,0	50,0	8,0	36,0	2,7	0,5	7,5	1	■
410ML030R050-MEGA-T	02451580	2	G	3,0	6,0	4,0	60,0	15,0	36,0	2,7	0,5	5,0	1	■
410040R050-MEGA-T	02451581	2	G	4,0	6,0	5,0	60,0	8,0	36,0	3,6	0,5	5,5	1	■
410ML040R050-MEGA-T	02451585	2	G	4,0	6,0	5,0	60,0	15,0	36,0	3,6	0,5	3,5	1	■
410050R050-MEGA-T	02451586	2	G	5,0	6,0	7,0	65,0	11,0	36,0	4,5	0,5	2,5	1	■
410ML050R050-MEGA-T	02451589	2	G	5,0	6,0	7,0	65,0	18,0	36,0	4,5	0,5	1,5	1	■
410TL050R050-MEGA-T	02451587	2	G	5,0	6,0	7,0	65,0	26,0	36,0	4,5	0,5	1,5	1	■
410060R050-MEGA-T	02451591	2	E	6,0	6,0	8,0	70,0	11,0	36,0	5,3	0,5	–	1	■
410ML060R050-MEGA-T	02451593	2	E	6,0	6,0	8,0	70,0	18,0	36,0	5,3	0,5	–	1	■
410TL060R050-MEGA-T	02451592	2	E	6,0	6,0	8,0	70,0	31,0	36,0	5,3	0,5	–	1	■
410070RSR050-MEGA-T	02451594	2	P	7,0	6,0	9,0	65,0	–	36,0	–	0,5	–	1	■
410090RSR050-MEGA-T	02451596	2	P	9,0	8,0	11,0	65,0	–	36,0	–	0,5	–	1	■
410110RSR050-MEGA-T	02451598	2	P	11,0	10,0	13,0	70,0	–	40,0	–	0,5	–	1	■
410130RSR100-MEGA-T	02451600	2	P	13,0	12,0	15,0	70,0	–	45,0	–	1,0	–	1	■
410150RSR100-MEGA-T	02451603	2	P	15,0	14,0	17,0	80,0	–	45,0	–	1,0	–	1	■
410170RSR100-MEGA-T	02451605	2	P	17,0	16,0	19,0	80,0	–	48,0	–	1,0	–	1	■
410L070RSR200-MEGA-T	02451595	3	P	7,0	6,0	9,0	85,0	–	36,0	–	2,0	–	1	■
410L090RSR200-MEGA-T	02451597	3	P	9,0	8,0	11,0	85,0	–	36,0	–	2,0	–	1	■
410L110RSR200-MEGA-T	02451599	3	P	11,0	10,0	13,0	90,0	–	40,0	–	2,0	–	1	■
410L130RSR200-MEGA-T	02451601	3	P	13,0	12,0	15,0	90,0	–	45,0	–	2,0	–	1	■
410L150RSR200-MEGA-T	02451604	3	P	15,0	14,0	17,0	110,0	–	45,0	–	2,0	–	1	■
410L170RSR200-MEGA-T	02451606	3	P	17,0	16,0	19,0	110,0	–	48,0	–	2,0	–	1	■

■ **Lagerstandard.**

Schnittdaten – JH410 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*
N11	E/M/A	0.318 *0,318*	0.65 *0,65*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	495 (380 — 610) *1625 (1300 — 2000)*
TS1	A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*

Schnittdaten – JH410 Nutfräsen

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.75 *0,75*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530–730) *2075 (1800 — 2300)*
N11	E/M/A	0.36 *0,36*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	420 (320 — 520) *1375 (1100–1700)*
TS1	A	1.0 *1,0*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530–730) *2075 (1800 — 2300)*

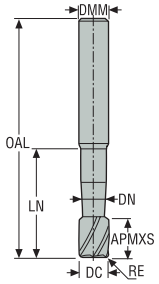
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH440

Hohe Geschwindigkeit – Aluminium – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
440060-MEGA-T	00022702	2	E	6,0	6,0	8,0	60,0	30,0	5,4	1,5	2	■
440080-MEGA-T	00022865	2	E	8,0	8,0	10,0	60,0	30,0	7,2	2,0	2	■

Schnittdaten – JH440 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	340 (260 — 420) *1125 (860–1300)*
N11	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	255 (130 — 370) *840 (430–1200)*
TS1	A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
TP1	A	0.300 *0,300*	0.60 *0,60*	0.060 *0,0024*	0.080 *0,0032*	510 (380 — 630) *1675 (1300 — 2000)*

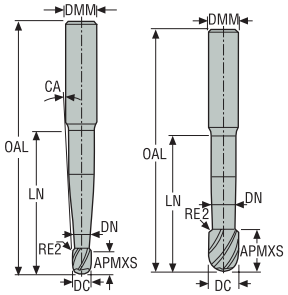
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH450

Hohe Geschwindigkeit – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch





- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE2	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm			
450020-MEGA-T	00022977	2	G	2,0	3,0	1,75	40,0	10,0	1,8	1,0	3,0	2	■
450030-MEGA-T	00022978	2	E	3,0	3,0	2,5	40,0	12,0	2,7	2,0	–	2	■
450040-MEGA-T	00022979	2	G	4,0	6,0	3,5	50,0	21,0	3,6	2,0	3,0	2	■
450050-MEGA-T	00022980	2	G	5,0	6,0	4,5	50,0	22,5	4,5	2,0	2,0	2	■
450060-MEGA-T	00023020	2	E	6,0	6,0	5,5	55,0	25,0	5,4	2,0	–	2	■
450080-MEGA-T	00023032	2	E	8,0	8,0	7,0	65,0	30,0	7,2	2,0	–	2	■
450100-MEGA-T	00023040	2	E	10,0	10,0	8,5	75,0	35,0	9,0	3,0	–	2	■
450120-MEGA-T	00029842	2	E	12,0	12,0	10,5	75,0	40,0	11,0	3,0	–	2	■
450160-MEGA-T	00023050	2	E	16,0	16,0	14,0	90,0	50,0	14,5	4,0	–	2	■
450200-MEGA-T	00023053	2	E	20,0	20,0	17,0	100,0	50,0	18,0	4,0	–	2	■
450L100-MEGA-T	00023056	3	G	10,0	12,0	8,5	125,0	50,0	9,0	3,0	1,5	2	■
450L120-MEGA-T	00023091	3	E	12,0	12,0	10,5	150,0	60,0	11,0	3,0	–	2	■
450L160-MEGA-T	00023095	3	E	16,0	16,0	14,0	150,0	70,0	14,5	4,0	–	2	■

■ **Lagerstandard.**

Schnittdaten – JH450 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	690 (670 — 930) *2275 (2200 — 3000)*
N2	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	470 (410 — 680) *1550 (1400 — 2200)*
N3	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	315 (280 — 450) *1025 (920–1400)*
N11	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (420 — 680) *1550 (1400 — 2200)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	700 (630 — 860) *2300 (2100 — 2800)*
TP1	M	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (410 — 680) *1550 (1400 — 2200)*

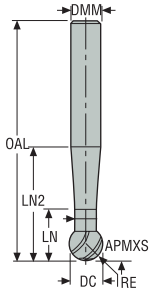
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH460

Hohe Geschwindigkeit – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch





E

- Toleranzen:
- DMM=h5
- DC=-0,02/-0,06 mm
- RE= ±0.02 mm
- SA=250°



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
460030-HEMI	00040372	2	E	3,0	3,0	2,3	60,0	4,8	9,9	1,5	1,5	2	■
460040-HEMI	00040373	2	E	4,0	4,0	3,1	60,0	5,6	12,1	2,0	2,0	2	■
460050-HEMI	00040376	2	E	5,0	5,0	3,9	70,0	6,4	14,4	2,5	2,5	2	■
460060-HEMI	00040377	2	E	6,0	6,0	4,7	80,0	9,7	19,1	3,0	3,0	2	■
460080-HEMI	00040378	2	E	8,0	8,0	6,2	85,0	11,2	23,6	4,0	4,0	2	■
460100-HEMI	00040379	2	E	10,0	10,0	7,8	100,0	15,6	30,8	5,0	5,0	2	■
460120-HEMI	00040380	2	E	12,0	12,0	9,4	125,0	17,2	35,3	6,0	6,0	2	■

■ **Lagerstandard.**

Schnittdaten – JH460 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
N1	E/M/A	0.500 *0,500*	0.20 *0,20*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (500 — 680) *1925 (1700 — 2200)*
N11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	610 (510–700) *2000 (1700 — 2200)*
S11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	120 (110–130) *395 (370 — 420)*
S12	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	90 (82–100) *295 (270 — 320)*
S13	E/M/A	0.300 *0,300*	0.20 *0,20*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	75 (65 — 81) *245 (220 — 260)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.13 *0,0050*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	620 (520–720) *2025 (1800 — 2300)*
TP1	M	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	405 (360 — 450) *1325 (1200–1400)*

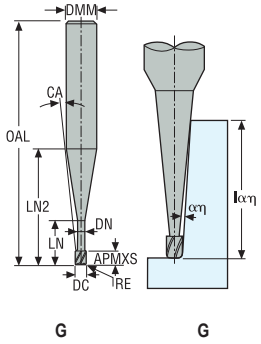
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

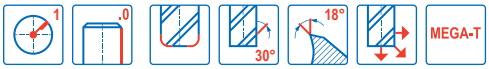
JM403/JM404/JM406

Mini – Aluminium – Schaftfräser – 1 Schneide – Zylindrisch – Eckenradius





- Toleranzen:
- Rundlaufabweichung =<0,005 mm
- DMM= h5
- DC= < Ø0,6= -0,005/-0,013 mm
- DC= ≥ Ø0,6= -0,005/-0,015 mm
- RE= ±0,01 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm									
403ML005R005-MEGA-T	02568434	2	G	0,5	3,0	0,5	40,0	1,5	6,7	0,45	0,05	1	11,0	1,5	1,6	1,7	1,7	1,8	1,9	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	7,1	0,75	0,05	1	9,0	2,5	2,6	2,7	2,8	2,9	3,2	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	8,3	0,95	0,1	1	7,5	4,0	4,2	4,3	4,5	4,6	5,0	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	14,0	1,4	0,1	1	9,5	5,1	5,3	5,5	5,7	5,9	6,4	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	10,4	1,9	0,1	1	6,0	6,1	6,3	6,6	6,8	7,0	7,6	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf αη (lαη, ref)*

Schnittdaten – JM403/JM404/406 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	0.8	1	1.5	2	
N1	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	365 (310 — 420) *1200 (1100–1300)*
N2	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	235 (200 — 270) *770 (660 — 880)*
N3	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	155 (140–180) *510 (460 — 590)*

Schnittdaten – JM403/JM404/406 Nutfräsen

SMG		a_p/DC	f_z					v_c
			0.5	0.8	1	1.5	2	
N1	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	315 (270 — 360) *1025 (890–1100)*
N2	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	200 (170 — 230) *660 (560–750)*
N3	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	135 (120–150) *445 (400 — 490)*

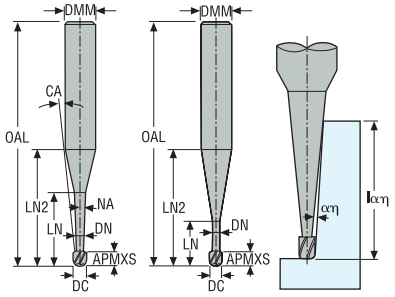
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JM413/JM416

Mini – Aluminium – Kugelkopf – 2 Schneide – Zylindrisch





- Toleranzen:
- Rundlaufabweichung =<0,005 mm
- DMM=h5
- DC= < Ø 0,6= -0,005/-0,013 mm
- DC= ≥ Ø 0,6= -0,005/-0,015 mm
- RE= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm									
413ML005TN-MEGA-T	02568709	2	J	0,5	3,0	0,375	40,0	1,5	6,6	0,45	0,25	2	11,5	1,5	1,5	1,6	1,6	1,7	1,8	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	7,7	0,45	0,25	2	10,0	2,5	2,6	2,7	2,8	2,9	3,1	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	8,6	0,75	0,4	2	8,0	4,0	4,2	4,3	4,4	4,6	4,9	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	9,3	0,95	0,5	2	7,0	5,0	5,2	5,4	5,5	5,7	6,2	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	16,5	1,4	0,75	2	8,5	7,6	7,9	8,1	8,4	8,7	9,3	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	18,1	1,9	1,0	2	7,0	10,1	10,4	10,8	11,1	11,5	12,4	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JM413/416 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0,5	0.8	1	1.5	2	
N1	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300–1600)*
N2	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	245 (240 — 320) *800 (790–1000)*
N3	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	165 (160 — 210) *540 (530 — 680)*
N11	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	320 (300 — 430) *1050 (990–1400)*
TS1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300–1600)*
TP1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300–1600)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.



HARTE WERKSTOFFE

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in harten Werkstoffen besteht aus Schaft-, Kugelkopf- und Kreissegmentfräsern.

- JHP170, JHF181, JH120, JH130, JH930, JH142, JME142 und JME144 mit Eckenradius
- JH112, JH150, JH160 und JMB112 Kugelkopffräser

Werkzeugauswahl Harte Werkstoffe

							
Werkzeugbezeichnung		JHP170	JHF181	JH120	JH130	JH930	JH142
Seite(n)		355	358	361	363	132, 132, 365	192, 192, 368
Produktfamilie		HPM	HFM	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung							
Aufnahmen	Zylindrisch	■	■	■	■	■	■
	Weldon	■					
Schneidenzahl		3-4	3-4-5	4	5-6, 8	5-6, 8	2-4-5-6
ICC			■				
	Metrisch	2-20	1-10	2-16	6-20	6-20	2-12
	Zoll						
Verfügbare Längen							
		2	1,2,3,4	2	2	2	2,3,6
Bearbeitung							
							
							
SMG							
H3		•	•	•	•	•	•
H5		•	•	•	•	•	•
H7		•	•	•	•	•	•
H8		•	•	•	•	•	•
H11		•	•	•	•	•	
H12		•	•	•	•	•	
H21		•	•	•	•	•	•
H31		•	•	•	•	•	•

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
• Erste Wahl ○ Alternative

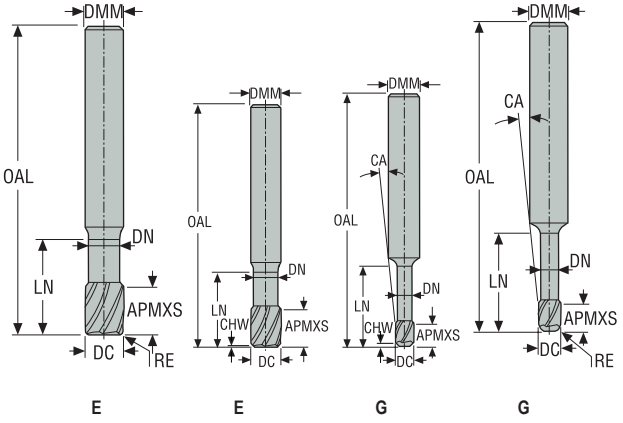
Werkzeugauswahl Harte Werkstoffe

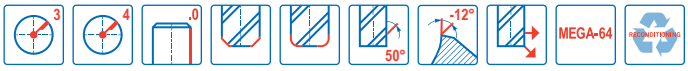
							
Werkzeugbezeichnung		JH112	JH150	JH160	JME142	JME144	JMB112
Seite(n)		197, 197, 371	374	376	378	383	385
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Fräserausführung							
Auf-nahmen	Zylindrisch	■	■	■	■	■	■
	Weldon						
Schneidenzahl		2	4	4	2	4	2
ICC							
	Metrisch	2-12	6-12	3-12	0,2-3,0	1,0-3,0	0,2-3,0
	Zoll						
Verfügbare Längen							
		1,2,3,4,5,6	2	2	1,2,3,4,5,6	2,3,4	1,2,3,4,5,6
Bearbeitung							
							
							
SMG							
H3		•	•	•	•	•	•
H5		•	•	•	•	•	•
H7		•	•	•	•	•	•
H8		•	•	•	•	•	•
H11			•	•	•	•	•
H12			•	•	•	•	•
H21		•	•	•	•	•	•
H31		•	•	•	•	•	•

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JHP170

Hochleistung – Gehärteter Stahl – Schaftfräser – 3-4 Schneiden – Zylindrisch – Eckenradius oder Fase







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2- Ø4=+0,05 mm
- CHW= Ø5-Ø16=+0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

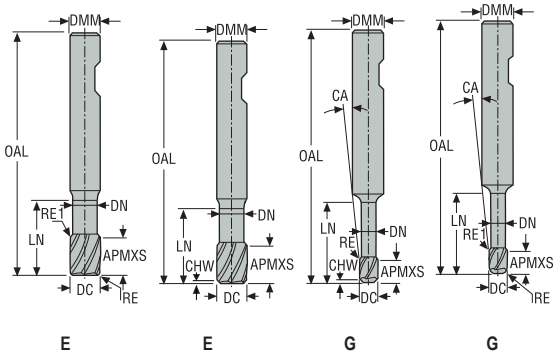
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm			
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	■
170020R050.0-MEGA-64	02587617	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	15,0	3	■
170030.0-MEGA-64	02462686	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	■
170030R020.0-MEGA-64	02587618	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	9,5	3	■
170030R050.0-MEGA-64	02587619	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	9,5	3	■
170040.0-MEGA-64	02462687	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	■
170040R020.0-MEGA-64	02587620	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	5,5	4	■
170040R050.0-MEGA-64	02587621	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	5,5	4	■
170050.0-MEGA-64	02462688	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	■
170050R020.0-MEGA-64	02587622	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	2,5	4	■
170050R050.0-MEGA-64	02587623	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	2,5	4	■
170060.0-MEGA-64	02462689	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	■
170060R020.0-MEGA-64	02587624	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	■
170060R050.0-MEGA-64	02587625	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	■
170080.0-MEGA-64	02462690	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	■
170080R020.0-MEGA-64	02587626	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	■
170080R050.0-MEGA-64	02587627	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	■
170080R100.0-MEGA-64	02587628	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	■
170100.0-MEGA-64	02462691	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	■
170100R050.0-MEGA-64	02587629	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	■
170100R100.0-MEGA-64	02587630	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	■
170120.0-MEGA-64	02462692	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	■
170120R050.0-MEGA-64	02587631	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	■
170120R100.0-MEGA-64	02587632	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	■
170160.0-MEGA-64	02462693	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	■
170160R050.0-MEGA-64	02587633	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	■

■ Lagerstandard.

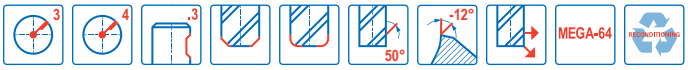
JHP170

Hochleistung – Gehärteter Stahl – Schaftfräser – 3-4 Schneiden – Weldon – Eckenradius oder Fase





- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2-Ø4=+0,05 mm
- CHW= Ø5-Ø16= +0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA	PCEDC	Weldon
				mm	mm	mm	mm	mm	mm	mm	mm			
170020-MEGA-64	02452924	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	■
170020R020.0-MEGA-64W	02669319	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	–	3	□
170020R050.0-MEGA-64W	02669320	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	–	3	□
170030-MEGA-64	02452925	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	■
170030R020.0-MEGA-64W	02669321	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	–	3	□
170030R050.0-MEGA-64W	02669322	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	–	3	□
170040-MEGA-64	02452927	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	■
170040R020.0-MEGA-64W	02669323	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	–	4	□
170040R050.0-MEGA-64W	02669324	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	–	4	□
170050-MEGA-64	02452928	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	■
170050R020.0-MEGA-64W	02669325	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	–	4	□
170050R050.0-MEGA-64W	02669326	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	–	4	□
170060-MEGA-64	02452929	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	■
170060R020.0-MEGA-64W	02669327	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	□
170060R050.0-MEGA-64W	02669328	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	□
170080-MEGA-64	02452930	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	■
170080R020.0-MEGA-64W	02669329	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	□
170080R050.0-MEGA-64W	02669331	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	□
170080R100.0-MEGA-64W	02669332	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	□
170100-MEGA-64	02452931	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	■
170100R050.0-MEGA-64W	02669333	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	□
170100R100.0-MEGA-64W	02669334	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	□
170120-MEGA-64	02452932	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	■
170120R050.0-MEGA-64W	02669335	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	□
170120R100.0-MEGA-64W	02669336	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	□
170160-MEGA-64	02452933	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	■
170160R050.0-MEGA-64W	02669337	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	□
170200R050-MEGA-64	02611637	2	E	20,0	20,0	20,0	100,0	40,0	19,2	–	0,5	–	4	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP170 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
H3	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73–110)*
H5	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*
H7	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73–110)*
H8	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59–71) *215 (200 — 230)*
H11	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (71 — 86) *260 (240 — 280)*
H12	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	75 (69 — 83) *245 (230 — 270)*
H21	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59–71) *215 (200 — 230)*
H31	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*

Schnittdaten – JHP170 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
H3	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H5	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160–180)*
H7	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H8	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160–180)*
H11	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	65 (58–70) *215 (200 — 220)*
H12	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	60 (53 — 64) *195 (180 — 200)*
H21	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160–180)*
H31	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160–180)*

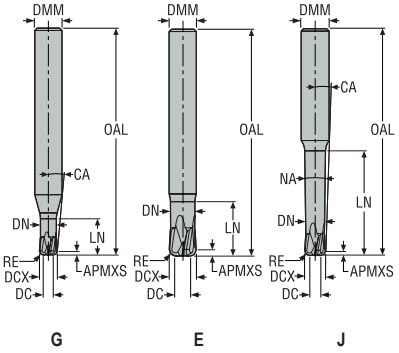
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JHF181

Hohe Vorschübe – Gehärteter Stahl – Eckfräser – 3-5 Schneiden – Zylindrisch – Eckenradius – ICC





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index		ICC	DCX	DC	DMM	APMXS	OAL	LN	DN	NA	RE	CA	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm	mm	mm			
JHF181020G1R050.0Z4-HXT	03067297	1	G	–	2,0	1,0	6,0	0,5	50,0	4,0	1,8	15,0	0,5	10,0	4	■
JHF181030G1R075.0Z4-HXT	03067298	1	G	–	3,0	1,5	6,0	0,75	50,0	6,0	2,7	15,0	0,75	7,5	4	■
JHF181040G1R100.0Z4-HXT	03067299	1	G	–	4,0	2,0	6,0	1,0	50,0	8,0	3,6	15,0	1,0	5,0	4	■
JHF181060E1R150.0Z4-HXT	03067300	1	E	–	6,0	3,0	6,0	1,5	50,0	12,0	5,4	0,0	1,5	–	4	■
JHF181080E1R200.0Z4-HXT	03067301	1	E	–	8,0	4,0	8,0	2,0	55,0	16,0	7,3	0,0	2,0	–	4	■
JHF181100E1R200.0Z4-HXT	03067302	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	0,0	2,0	–	4	■
JHF181100E1R200.0Z5-HXT	03067303	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	0,0	2,0	–	5	■
JHF181120E1R300.0Z4-HXT	03067304	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	0,0	3,0	–	4	■
JHF181120E1R300.0Z5-HXT	03067305	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	0,0	3,0	–	5	■
JHF181160E1R300.0Z4-HXT	03067306	1	E	–	16,0	10,0	16,0	3,0	80,0	32,0	14,8	0,0	3,0	–	4	■
JHF181020G2R050.0Z4-HXT	03067307	2	G	–	2,0	1,0	6,0	0,5	50,0	8,0	1,8	15,0	0,5	7,5	4	■
JHF181030G2R075.0Z4-HXT	03067308	2	G	–	3,0	1,5	6,0	0,75	50,0	12,0	2,7	15,0	0,75	5,0	4	■
JHF181040G2R100.0Z4-HXT	03067309	2	G	–	4,0	2,0	6,0	1,0	50,0	16,0	3,6	15,0	1,0	3,0	4	■
JHF181060E2R150.0Z4A-HXT	03067311	2	E	■	6,0	3,0	6,0	1,5	65,0	24,0	5,4	0,0	1,5	–	4	■
JHF181060E2R150.0Z4-HXT	03067310	2	E	–	6,0	3,0	6,0	1,5	65,0	24,0	5,4	0,0	1,5	–	4	■
JHF181080E2R200.0Z4A-HXT	03067313	2	E	■	8,0	4,0	8,0	2,0	70,0	32,0	7,3	0,0	2,0	–	4	■
JHF181080E2R200.0Z4-HXT	03067312	2	E	–	8,0	4,0	8,0	2,0	70,0	32,0	7,3	0,0	2,0	–	4	■
JHF181100E2R200.0Z4A-HXT	03067315	2	E	■	10,0	6,0	10,0	2,0	85,0	40,0	9,2	0,0	2,0	–	4	■
JHF181100E2R200.0Z4-HXT	03067314	2	E	–	10,0	6,0	10,0	2,0	85,0	40,0	9,2	0,0	2,0	–	4	■
JHF181120E2R300.0Z4A-HXT	03067317	2	E	■	12,0	6,0	12,0	3,0	100,0	48,0	11,0	0,0	3,0	–	4	■
JHF181120E2R300.0Z4-HXT	03067316	2	E	–	12,0	6,0	12,0	3,0	100,0	48,0	11,0	0,0	3,0	–	4	■
JHF181020J3R050.0Z4-HXT	03067318	3	J	–	2,0	1,0	6,0	0,5	50,0	10,0	1,8	0,9	0,5	6,8	4	■
JHF181030J3R075.0Z4-HXT	03067319	3	J	–	3,0	1,5	6,0	0,75	50,0	15,0	2,7	0,9	0,75	4,4	4	■
JHF181040J3R100.0Z4-HXT	03067320	3	J	–	4,0	2,0	6,0	1,0	60,0	20,0	3,6	0,9	1,0	2,6	4	■
JHF181060J3R150.0Z4-HXT	03067321	3	J	–	6,0	3,0	8,0	1,5	65,0	30,0	5,4	0,9	1,5	1,9	4	■
JHF181080J3R200.0Z4-HXT	03067325	3	J	–	8,0	4,0	10,0	2,0	85,0	40,0	7,3	0,9	2,0	1,5	4	■
JHF181100J3R200.0Z4-HXT	03067327	3	J	–	10,0	6,0	12,0	2,0	100,0	50,0	9,2	0,9	2,0	1,2	4	■
JHF181020J4R050.0Z3-HXT	03067329	4	J	–	2,0	1,0	6,0	0,5	50,0	14,0	1,8	0,9	0,5	5,6	3	■
JHF181030J4R075.0Z3-HXT	03067330	4	J	–	3,0	1,5	6,0	0,75	60,0	21,0	2,7	0,9	0,75	3,4	3	■
JHF181040J4R100.0Z3-HXT	03067331	4	J	–	4,0	2,0	6,0	1,0	65,0	28,0	3,6	0,9	1,0	2,0	3	■
JHF181060J4R150.0Z3-HXT	03067332	4	J	–	6,0	3,0	8,0	1,5	80,0	42,0	5,4	0,9	1,5	1,4	3	■
JHF181080J4R200.0Z3-HXT	03067333	4	J	–	8,0	4,0	10,0	2,0	100,0	56,0	7,3	0,9	2,0	1,1	3	■
JHF181100J4R200.0Z3-HXT	03067334	4	J	–	10,0	6,0	12,0	2,0	125,0	70,0	9,2	0,9	2,0	0,9	3	■

■ **Lagerstandard.**

Schnittdaten – JHF181 Eckfräsen/Schruppen

SMG		a_e/DCX	a_p/DCX	f_z								v_c
				2	3	4	6	8	10	12	16	
P6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	305 (290 — 320) *1000 (960–1000)*
P7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	290 (270 — 300) *950 (890 — 980)*
P8	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	270 (260 — 290) *890 (860 — 950)*
P11	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	280 (270 — 290) *920 (890 — 950)*
K1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 240) *690 (630–780)*
K2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	185 (160 — 200) *610 (530 — 650)*
K3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	155 (140–170) *510 (460 — 550)*
K4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	150 (130–160) *490 (430 — 520)*
K5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	150 (120–170) *490 (400 — 550)*
K6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	220 (180 — 260) *720 (600 — 850)*
K7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	190 (160 — 220) *620 (530–720)*
S1	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	60 (40–79) *195 (140 — 250)*
S2	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	48 (33 — 64) *155 (110 — 200)*
S3	E	0.18 *0,18*	0.014 *0,014*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	42 (28 — 55) *140 (92–180)*
S11	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	200 (180 — 220) *660 (600–720)*
S12	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	155 (140–170) *510 (460 — 550)*
S13	E	0.18 *0,18*	0.034 *0,034*	0.032 *0,0013*	0.046 *0,0018*	0.065 *0,0026*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.24 *0,0095*	125 (110–130) *410 (370 — 420)*
H3	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H5	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150–180) *540 (500 — 590)*
H7	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H8	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150–180) *540 (500 — 590)*
H11	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 230) *690 (630–750)*
H12	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	190 (180 — 210) *620 (600 — 680)*
H21	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150–180) *540 (500 — 590)*
H31	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	125 (120–130) *410 (400 — 420)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JHF181 Nutfräsen

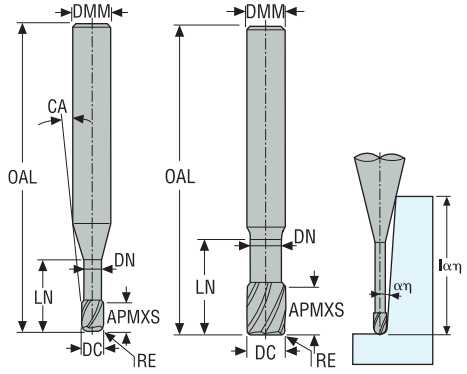
SMG		a_p/DCX	f_z								v_c
			2	3	4	6	8	10	12	16	
P6	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	270 (260 — 280) *890 (860 — 910)*
P7	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	255 (240 — 270) *840 (790 — 880)*
P8	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	240 (230 — 250) *790 (760 — 820)*
P11	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	250 (240 — 260) *820 (790 — 850)*
K1	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 210) *610 (560 — 680)*
K2	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	160 (140–180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	135 (120–150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	130 (120–140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	130 (110–150) *425 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	195 (160 — 230) *640 (530–750)*
K7	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	48 (33 — 64) *155 (110 — 200)*
S2	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	39 (26 — 51) *130 (86–160)*
S3	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	33 (23 — 44) *110 (76–140)*
S11	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	170 (150–190) *560 (500 — 620)*
S12	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	130 (120–140) *425 (400 — 450)*
S13	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	100 (89–110) *330 (300 — 360)*
H3	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H5	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130–160) *475 (430 — 520)*
H7	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H8	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130–160) *475 (430 — 520)*
H11	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 200) *610 (560 — 650)*
H12	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	170 (160–180) *560 (530 — 590)*
H21	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130–160) *475 (430 — 520)*
H31	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	110 (98–120) *360 (330 — 390)*

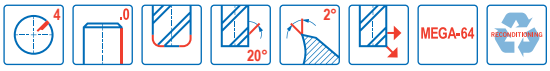
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH120

Hohe Geschwindigkeit – Gehärteter Stahl – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,03 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
120020-MEGA-64	00019437	2	G	2,0	6,0	2,5	50,0	5,0	1,9	0,2	10,5	4	5,0	5,4	5,6	5,7	5,9	6,2	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	6,0	6,4	6,6	6,8	7,0	7,5	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	7,0	7,7	8,0	8,2	8,5	9,2	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	8,0	9,0	9,3	9,7	10,0	10,9	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	9,0	10,0	10,4	10,8	11,2	12,2	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	12,0	13,0	13,4	13,7	14,1	14,9	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	14,0	–	–	–	–	–	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	18,0	–	–	–	–	–	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	25,0	–	–	–	–	–	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	30,0	–	–	–	–	–	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	35,0	–	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf αη (lαη, ref)*

Schnittdaten – JH120 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57–130) *295 (190 — 420)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H7	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57–130) *295 (190 — 420)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	275 (230 — 320) *900 (760–1000)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	250 (210 — 290) *820 (690 — 950)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	135 (120–150) *445 (400 — 490)*

Schnittdaten – JH120 Nutfräsen

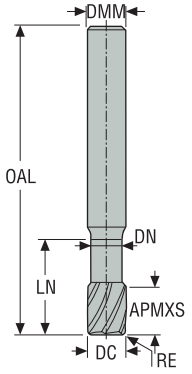
SMG		a_p/DC	f_z											v_c
			2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34–78) *180 (120 — 250)*
H5	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	120 (98–140) *395 (330 — 450)*
H7	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34–78) *180 (120 — 250)*
H8	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110–140) *410 (370 — 450)*
H11	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	150 (130–170) *490 (430 — 550)*
H12	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	145 (120–170) *475 (400 — 550)*
H21	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110–140) *410 (370 — 450)*
H31	M	0.18 *0,18*	0.0055 *0,00022*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (70 — 92) *260 (230 — 300)*

Schnittdaten, siehe Seite 457 - 464

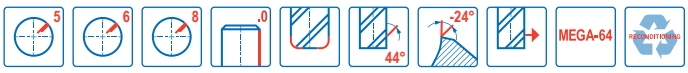
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH130

Hohe Geschwindigkeit – Gehärteter Stahl – Schaftfräser – 5-8 Schneiden – Zylindrisch – Eckenradius



E





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
130060-MEGA-64	00019504	2	E	6,0	6,0	6,0	55,0	12,0	5,6	0,2	5	■
130080-MEGA-64	00019507	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,2	5	■
130100-MEGA-64	00019511	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,3	6	■
130120-MEGA-64	00019512	2	E	12,0	12,0	12,0	80,0	24,0	11,4	0,5	6	■
130160-MEGA-64	00019514	2	E	16,0	16,0	16,0	90,0	30,0	15,4	0,5	8	■
130200-MEGA-64	00019542	2	E	20,0	20,0	20,0	100,0	35,0	19,2	0,5	8	■

■ **Lagerstandard.**

Schnittdaten – JH130 Eckfräsen/Schlichten

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990–1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920–1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140–170) *510 (460 — 550)*

Schnittdaten – JH130 Eckfräsen/Schruppen

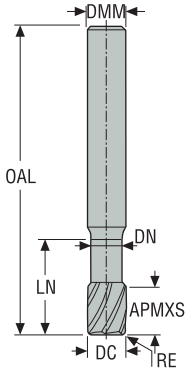
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990–1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920–1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140–170) *510 (460 — 550)*

Schnittdaten, siehe Seite 457 - 464

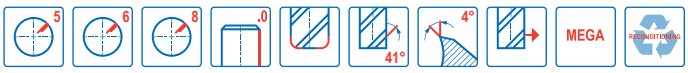
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH930

Hohe Geschwindigkeit – Universal – Schaftfräser – 5-8 Schneiden – Zylindrisch – Eckenradius



E





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	■

■ **Lagerstandard.**

Schnittdaten – JH930 Eckfräsen

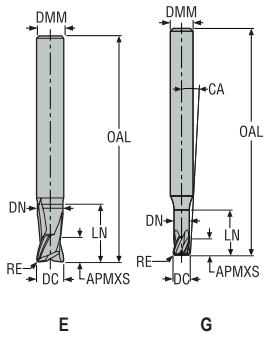
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300–1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200–1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100–1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920–1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890–1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990–1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920–1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890–1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920–1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560–720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530–720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760–1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660–1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62–100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110–160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140–180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110–140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81–110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41–71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41–71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860–1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730–1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130–180) *510 (430 — 590)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH142

Hohe Geschwindigkeit – Hochpräzise – Torisch – Gehärteter Stahl – 2-6 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	6,63	6,96	7,21	7,43	7,62	7,96	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	6,63	6,95	7,2	7,41	7,6	7,93	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	8,92	9,23	9,48	9,71	9,91	10,26	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	8,92	9,21	9,46	9,67	9,87	10,21	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	9,13	9,4	9,64	9,84	10,03	10,37	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	9,13	9,4	9,63	9,83	10,02	10,35	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	9,13	9,38	9,6	9,8	9,98	10,3	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	12,0	–	–	–	–	–	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	12,0	–	–	–	–	–	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	12,0	–	–	–	–	–	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	12,0	–	–	–	–	–	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	16,0	–	–	–	–	–	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	16,0	–	–	–	–	–	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	16,0	–	–	–	–	–	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	20,0	–	–	–	–	–	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	20,0	–	–	–	–	–	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	20,0	–	–	–	–	–	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	24,0	–	–	–	–	–	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	24,0	–	–	–	–	–	■

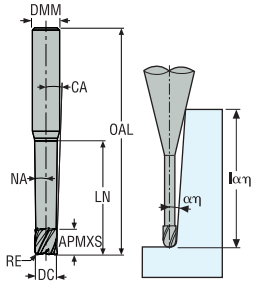
■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf a_{η} ($l a_{\eta}$, ref)*

JH142

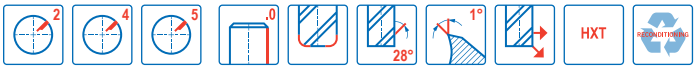
Hohe Geschwindigkeit – Hochpräzise – Torisch – Gehärteter Stahl – 2-5 Schneiden – Zylindrisch – Eckenradius





J

- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	2	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	4	5,23	10,27	10,95	11,31	11,69	12,54	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	2	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	4	5,23	10,24	10,94	11,29	11,66	12,5	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	2	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	4	9,57	15,58	16,22	16,75	17,32	18,57	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	2	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	4	9,57	15,54	16,19	16,7	17,25	18,46	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	2	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	4	13,87	20,79	21,52	22,23	22,99	–	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	2	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	4	13,87	20,78	21,51	22,21	22,97	–	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	2	13,87	20,76	21,48	22,16	22,9	–	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	4	13,87	20,76	21,48	22,16	22,9	–	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	4	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	5	19,15	30,85	31,88	32,93	–	–	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	4	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	5	19,15	30,83	31,85	32,88	–	–	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	5	19,15	30,8	31,82	32,83	–	–	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	5	19,15	30,78	31,78	32,78	–	–	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	5	27,67	41,12	42,44	–	–	–	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	5	27,67	41,11	42,41	–	–	–	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	5	27,67	41,09	42,38	–	–	–	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	5	27,67	41,08	42,35	–	–	–	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	5	29,67	50,97	52,62	–	–	–	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	5	29,67	50,95	52,59	–	–	–	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	5	29,67	50,91	52,53	–	–	–	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	4	5,23	11,4	21,0	21,71	22,45	24,11	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	4	5,23	11,14	20,99	21,69	22,43	24,06	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	4	9,57	20,92	31,32	32,35	33,46	–	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	4	9,57	20,3	31,29	32,31	33,39	–	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	4	13,87	30,85	41,65	–	–	–	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	4	13,87	30,6	41,65	–	–	–	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	4	13,87	29,98	41,6	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf αη (lαη, ref)*

Schnittdaten – JH142 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600–1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500–1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300–1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200–1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100–1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300–1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200–1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100–1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200–1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100–1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960–1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100–1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600–1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400–1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72–110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960–1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72–110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960–1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200–1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100–1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960–1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120–160) *460 (400 — 520)*

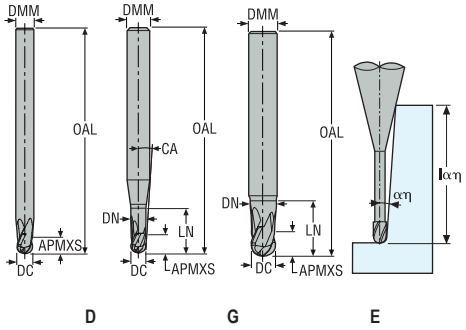
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

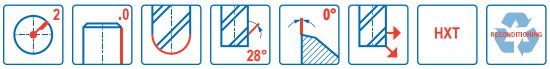
JH112

Hohe Geschwindigkeit – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

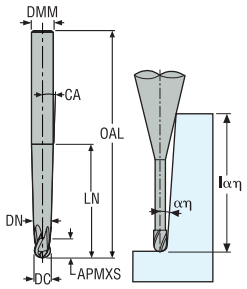


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm									
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	6,45	2	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	3,3	2	6,96	7,29	7,66	8,08	8,56	9,78	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	–	2	–	–	–	–	–	–	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	–	2	–	–	–	–	–	–	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	–	2	–	–	–	–	–	–	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	–	2	–	–	–	–	–	–	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	2,5	2	10,79	11,1	11,42	11,77	–	–	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	–	2	–	–	–	–	–	–	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	–	2	–	–	–	–	–	–	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	–	2	–	–	–	–	–	–	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	–	2	–	–	–	–	–	–	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	8,12	2	4,66	4,84	5,03	5,24	5,47	6,03	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	7,39	2	5,66	5,87	6,1	6,36	6,64	7,31	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	5,5	2	6,97	7,31	7,7	8,14	8,65	9,95	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	3,81	2	8,62	9,24	9,99	10,9	12,05	15,49	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	3,34	2	9,62	10,31	11,14	12,15	13,42	17,25	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,0	2	12,09	12,96	14,01	15,29	16,89	–	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	2,78	2	14,09	15,1	16,31	17,79	19,64	25,2	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	–	2	16,0	–	–	–	–	–	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	–	2	20,0	–	–	–	–	–	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	–	2	24,0	–	–	–	–	–	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	3,82	2	20,66	21,59	22,61	23,73	24,98	27,94	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	2,91	2	20,97	22,18	23,55	25,11	26,92	31,51	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	1,97	2	21,62	23,39	25,53	28,13	–	–	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	0,53	2	52,09	56,58	–	–	–	–	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	–	2	–	–	–	–	–	–	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	–	2	–	–	–	–	–	–	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	–	2	–	–	–	–	–	–	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	–	2	–	–	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

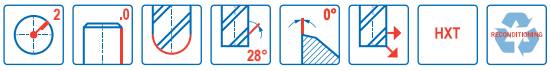
JH112

Hohe Geschwindigkeit – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



J





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	DN	NA	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm										
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	1,9	3,55	3,3	2	3,09	3,43	3,91	4,63	5,81	14,63	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	2,8	2,5	2,2	2	5,7	6,75	8,51	12,03	22,61	–	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	3,7	1,4	1,2	2	10,58	15,35	32,07	–	–	–	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	4,6	1,95	1,6	2	11,47	14,56	20,93	41,46	–	–	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	5,6	1,4	1,1	2	14,72	21,24	44,08	–	–	–	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	7,4	1,43	1,0	2	20,71	29,7	59,65	–	–	–	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	9,4	1,5	1,0	2	22,16	30,75	56,56	–	–	–	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	5,6	2,3	2,0	2	11,59	13,99	18,22	27,78	69,22	–	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	7,4	2,3	1,8	2	16,24	19,64	25,68	39,27	98,24	–	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	9,4	1,1	0,8	2	26,26	43,99	–	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf αη (lαη, ref)*

Schnittdaten – JH112 Kopierfräsen/ Feinbearbeitung

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500–730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200–1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200–1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560–790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500–750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790–1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500–750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790–1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990–1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920–1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790–1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960–1400)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JH112 Eckfräsen/Schruppen

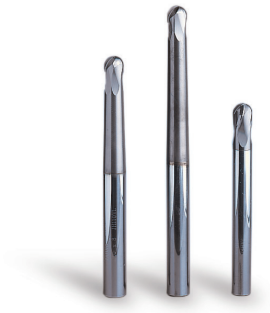
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100–1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890–1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760–1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730–1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830–1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200–1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100–160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100–160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560–780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

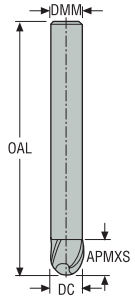
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH150

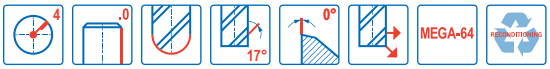
Hohe Geschwindigkeit – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





D

- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	4	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	4	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	4	■

■ **Lagerstandard.**

Schnittdaten – JH150 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100–1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890–1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890–1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300–1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200–1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88–120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88–120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630–750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130–180) *410 (430 — 590)*

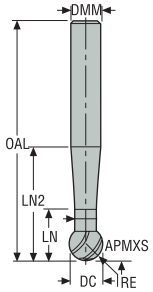
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JH160

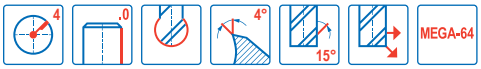
Hohe Geschwindigkeit – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





E

- Toleranzen:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	LN2	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm	mm		
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	9,0	1,8	1,5	4	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	11,0	2,4	2,0	4	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	13,0	3,0	2,5	4	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	17,3	3,6	3,0	4	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	21,3	4,8	4,0	4	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	27,9	6,0	5,0	4	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	31,8	7,2	6,0	4	■

■ **Lagerstandard.**

Schnittdaten – JH160 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450–700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300–1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200–1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100–1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200–1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200–1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100–1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100–1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91–110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100–1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91–110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100–1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400–1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200–1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100–1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

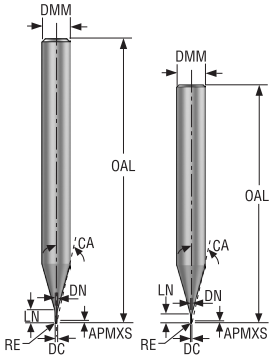
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JME142

Mini – Gehärteter Stahl – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

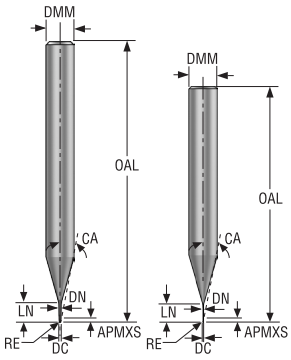


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA	PCEDC	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME142002G1R005Z2.0-HXT	03205080	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,05	15,12	2	0,48	0,5	0,51	0,53	0,55	0,58	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	14,77	2	0,68	0,7	0,73	0,75	0,77	0,81	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	14,39	2	0,9	0,93	0,95	0,98	1,01	1,07	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	14,01	2	1,13	1,15	1,18	1,21	1,25	1,32	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	13,67	2	1,32	1,35	1,39	1,43	1,47	1,55	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	13,98	2	1,72	1,76	1,81	1,86	1,91	2,02	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	13,49	2	2,14	2,19	2,25	2,31	2,37	2,51	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	13,02	2	2,54	2,6	2,67	2,74	2,81	2,98	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	12,3	2	3,14	3,22	3,3	3,38	3,47	3,68	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	14,23	2	0,54	0,72	0,81	0,89	0,95	1,07	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	13,67	2	0,61	1,0	1,13	1,23	1,31	1,44	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	13,1	2	1,01	1,37	1,5	1,59	1,68	1,83	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	12,54	2	1,41	1,72	1,85	1,95	2,04	2,2	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	12,61	2	1,41	1,72	1,84	1,95	2,03	2,19	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	13,5	2	1,78	1,9	2,0	2,09	2,16	2,32	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	13,55	2	1,78	1,9	1,99	2,08	2,16	2,31	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	11,76	2	1,42	2,18	2,36	2,48	2,59	2,78	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	11,83	2	1,42	2,18	2,35	2,48	2,58	2,77	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	9,48	2	2,27	2,42	2,54	2,67	2,82	3,16	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	9,51	2	2,27	2,42	2,54	2,66	2,81	3,14	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	10,92	2	1,56	2,67	2,88	3,02	3,14	3,37	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	10,98	2	1,57	2,66	2,87	3,01	3,13	3,36	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	11,1	2	1,57	2,65	2,86	3,0	3,12	3,34	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	9,15	2	2,77	2,95	3,09	3,25	3,43	3,84	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	9,17	2	2,77	2,94	3,09	3,24	3,41	3,82	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	9,22	2	2,77	2,94	3,08	3,23	3,39	3,79	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	8,29	2	4,32	4,55	4,77	5,01	5,29	5,93	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	8,31	2	4,32	4,54	4,76	5,01	5,27	5,91	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	8,36	2	4,32	4,54	4,75	4,99	5,25	5,88	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	7,97	2	4,82	5,07	5,32	5,59	5,89	6,62	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	7,99	2	4,82	5,07	5,31	5,58	5,88	6,6	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	8,04	2	4,82	5,06	5,3	5,57	5,86	6,56	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	7,6	2	5,32	5,59	5,87	6,17	6,5	7,3	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	9,7	2	5,32	5,58	5,77	5,96	6,16	6,61	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	9,76	2	5,32	5,57	5,76	5,95	6,15	6,59	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf a_{η} (la_{η}, ref)*

JME142

Mini – Gehärteter Stahl – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius



J G





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME142018G2R005Z2.0-HXT	03205174	2	G	1,8	6,0	1,35	50,0	5,0	1,75	0,05	2	9,4	5,32	5,58	5,77	5,96	6,17	6,62	■
JME142018G2R010Z2.0-HXT	03205177	2	G	1,8	6,0	1,35	50,0	5,0	1,75	0,1	2	9,43	5,32	5,58	5,77	5,96	6,16	6,61	■
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	2	8,52	6,35	6,64	6,85	7,08	7,33	7,87	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	2	8,55	6,35	6,64	6,85	7,08	7,32	7,86	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	2	8,6	6,35	6,63	6,84	7,07	7,3	7,84	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	2	8,66	6,35	6,63	6,84	7,06	7,29	7,81	■
JME142025G2R005Z2.0-HXT	03205192	2	G	2,5	6,0	1,875	50,0	7,5	2,4	0,05	2	7,1	7,97	8,26	8,52	8,81	9,11	9,79	■
JME142025G2R010Z2.0-HXT	03205195	2	G	2,5	6,0	1,875	50,0	7,5	2,4	0,1	2	7,13	7,97	8,26	8,52	8,8	9,11	9,78	■
JME142025G2R020Z2.0-HXT	03205198	2	G	2,5	6,0	1,875	50,0	7,5	2,4	0,2	2	7,17	7,97	8,25	8,51	8,79	9,09	9,76	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	2	5,81	9,59	9,9	10,21	10,56	10,92	11,73	■
JME142030G2R010Z2.0-HXT	03205205	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,1	2	5,82	9,59	9,89	10,21	10,55	10,91	11,72	■
JME142030G2R020Z2.0-HXT	03205208	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,2	2	5,86	9,59	9,89	10,2	10,54	10,9	11,7	■
JME142030G2R030Z2.0-HXT	03205211	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,3	2	5,9	9,59	9,89	10,2	10,53	10,89	11,68	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	2	11,24	1,41	2,63	2,86	3,01	3,13	3,36	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	2	11,29	1,41	2,62	2,86	3,0	3,12	3,35	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	2	11,55	3,78	4,0	4,16	4,3	4,44	4,77	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	2	11,59	3,78	4,0	4,15	4,29	4,44	4,76	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	2	10,58	1,42	3,05	3,37	3,54	3,67	3,94	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	2	10,63	1,42	3,04	3,36	3,53	3,66	3,93	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	2	8,46	4,27	4,52	4,74	4,98	5,25	5,9	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	2	8,48	4,27	4,52	4,73	4,98	5,24	5,88	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	2	9,36	1,56	3,46	4,39	4,59	4,75	5,1	■
JME142008J3R010Z2.0-HXT	03205131	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,1	2	9,4	1,57	3,4	4,39	4,59	4,75	5,09	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	2	9,89	5,77	6,08	6,28	6,49	6,72	7,21	■
JME142008G3R010Z2.0-HXT	03205132	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,1	2	9,92	5,77	6,08	6,28	6,49	6,71	7,2	■
JME142008G3R020Z2.0-HXT	03205137	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,2	2	9,98	5,77	6,07	6,27	6,48	6,7	7,18	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	2	8,84	7,32	7,65	7,9	8,16	8,44	9,07	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	2	8,86	7,32	7,65	7,9	8,16	8,44	9,06	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	2	8,91	7,32	7,65	7,89	8,15	8,42	9,04	■
JME142012G3R005Z2.0-HXT	03205153	3	G	1,2	6,0	0,9	50,0	8,0	1,15	0,05	2	8,16	8,32	8,68	8,96	9,26	9,58	10,29	■
JME142012G3R010Z2.0-HXT	03205156	3	G	1,2	6,0	0,9	50,0	8,0	1,15	0,1	2	8,19	8,32	8,68	8,96	9,26	9,58	10,28	■
JME142012G3R020Z2.0-HXT	03205159	3	G	1,2	6,0	0,9	50,0	8,0	1,15	0,2	2	8,23	8,32	8,68	8,95	9,25	9,56	10,26	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	2	7,05	10,32	10,75	11,09	11,46	11,86	12,74	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	2	7,06	10,32	10,75	11,09	11,46	11,85	12,73	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	2	7,1	10,32	10,74	11,08	11,45	11,84	12,71	■

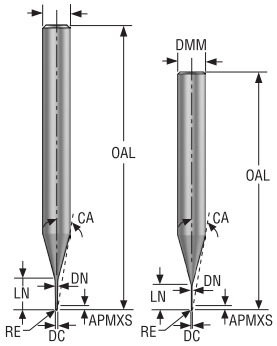
■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

JME142

Mini – Gehärteter Stahl – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

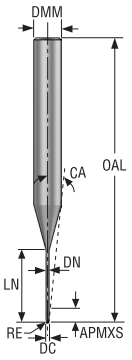


Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME142018G3R005Z2.0-HXT	03205175	3	G	1,8	6,0	1,35	50,0	10,0	1,75	0,05	2	6,77	10,32	10,75	11,09	11,46	11,86	12,74	■
JME142018G3R010Z2.0-HXT	03205178	3	G	1,8	6,0	1,35	50,0	10,0	1,75	0,1	2	6,79	10,32	10,75	11,09	11,46	11,85	12,73	■
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	2	5,9	12,35	12,83	13,24	13,68	14,16	15,21	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	2	5,92	12,35	12,83	13,24	13,68	14,15	15,2	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	2	5,95	12,35	12,82	13,23	13,67	14,14	15,18	■
JME142025G3R005Z2.0-HXT	03205193	3	G	2,5	6,0	1,875	50,0	12,5	2,4	0,05	2	5,25	12,97	13,42	13,85	14,31	14,81	15,91	■
JME142025G3R010Z2.0-HXT	03205196	3	G	2,5	6,0	1,875	50,0	12,5	2,4	0,1	2	5,27	12,97	13,41	13,85	14,31	14,8	15,9	■
JME142025G3R020Z2.0-HXT	03205199	3	G	2,5	6,0	1,875	50,0	12,5	2,4	0,2	2	5,29	12,97	13,41	13,84	14,3	14,79	15,88	■
JME142030G3R005Z2.0-HXT	03205202	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,05	2	4,14	15,59	16,08	16,6	17,16	17,75	19,07	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	2	4,15	15,59	16,08	16,6	17,15	17,75	19,06	■
JME142030G3R020Z2.0-HXT	03205209	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,2	2	4,17	15,59	16,08	16,59	17,14	17,73	19,04	■
JME142030G3R030Z2.0-HXT	03205212	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,3	2	4,19	15,59	16,08	16,59	17,13	17,72	19,02	■
JME142005J4R005Z2.0-HXT	03205091	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,05	2	9,71	1,41	3,12	4,38	4,58	4,74	5,09	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	2	9,76	1,41	3,06	4,37	4,58	4,74	5,08	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	2	10,42	5,28	5,56	5,75	5,95	6,15	6,61	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	2	10,45	5,28	5,56	5,75	5,94	6,14	6,6	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	2	8,79	1,42	3,13	5,39	5,63	5,82	6,26	■
JME142006J4R010Z2.0-HXT	03205118	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,1	2	8,83	1,42	3,08	5,39	5,62	5,81	6,24	■
JME142006G4R005Z2.0-HXT	03205106	4	G	0,6	6,0	0,45	50,0	6,0	0,56	0,05	2	9,72	6,27	6,6	6,82	7,04	7,29	7,83	■
JME142006G4R010Z2.0-HXT	03205120	4	G	0,6	6,0	0,45	50,0	6,0	0,56	0,1	2	9,75	6,27	6,59	6,81	7,04	7,28	7,82	■
JME142008J4R005Z2.0-HXT	03205127	4	J	0,8	4,0	0,6	40,0	7,0	0,76	0,05	2	7,28	1,56	3,46	7,43	7,72	7,98	8,57	■
JME142008J4R010Z2.0-HXT	03205133	4	J	0,8	4,0	0,6	40,0	7,0	0,76	0,1	2	7,3	1,57	3,4	7,42	7,71	7,98	8,56	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	2	8,49	8,27	8,67	8,95	9,24	9,56	10,27	■
JME142008G4R010Z2.0-HXT	03205134	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,1	2	8,51	8,27	8,66	8,94	9,24	9,56	10,26	■
JME142008G4R020Z2.0-HXT	03205138	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,2	2	8,56	8,27	8,66	8,94	9,23	9,54	10,24	■
JME142010G4R005Z2.0-HXT	03205142	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,05	2	7,47	10,32	10,75	11,09	11,46	11,86	12,74	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	2	7,48	10,32	10,75	11,09	11,46	11,85	12,73	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	2	7,52	10,32	10,74	11,08	11,45	11,84	12,71	■
JME142012G4R005Z2.0-HXT	03205154	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,05	2	6,61	12,32	12,81	13,22	13,66	14,14	15,19	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	2	6,62	12,32	12,81	13,22	13,66	14,13	15,18	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	2	6,65	12,32	12,8	13,21	13,65	14,12	15,16	■
JME142015G4R005Z2.0-HXT	03205164	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,05	2	5,54	15,32	15,9	16,42	16,97	17,55	18,86	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	2	5,55	15,32	15,9	16,41	16,96	17,55	18,85	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	2	5,58	15,32	15,9	16,41	16,95	17,53	18,83	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf a_p (l_{ap}, ref)*

JME142

Mini – Gehärteter Stahl – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius



G





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME142018G4R005Z2.0-HXT	03205176	4	G	1,8	6,0	1,35	60,0	18,0	1,75	0,05	2	4,68	18,32	19,0	19,61	20,27	20,97	22,53	■
JME142018G4R010Z2.0-HXT	03205179	4	G	1,8	6,0	1,35	60,0	18,0	1,75	0,1	2	4,69	18,32	19,0	19,61	20,26	20,96	22,52	■
JME142020G4R005Z2.0-HXT	03205182	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,05	2	4,19	20,35	21,08	21,76	22,49	23,27	25,0	■
JME142020G4R010Z2.0-HXT	03205187	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,1	2	4,19	20,35	21,08	21,76	22,48	23,26	24,99	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	2	4,21	20,35	21,07	21,75	22,47	23,25	24,97	■
JME142025G4R005Z2.0-HXT	03205194	4	G	2,5	6,0	1,875	65,0	25,0	2,4	0,05	2	3,18	25,47	26,31	27,16	28,07	29,04	31,2	■
JME142025G4R010Z2.0-HXT	03205197	4	G	2,5	6,0	1,875	65,0	25,0	2,4	0,1	2	3,19	25,47	26,31	27,16	28,06	29,03	31,19	■
JME142025G4R020Z2.0-HXT	03205200	4	G	2,5	6,0	1,875	65,0	25,0	2,4	0,2	2	3,2	25,47	26,3	27,15	28,05	29,02	31,17	■
JME142030G4R010Z2.0-HXT	03205207	4	G	3,0	6,0	2,25	80,0	30,0	2,85	0,1	2	2,41	30,59	31,55	32,57	33,66	34,83	–	■
JME142030G4R020Z2.0-HXT	03205210	4	G	3,0	6,0	2,25	80,0	30,0	2,85	0,2	2	2,42	30,59	31,55	32,57	33,65	34,81	–	■
JME142030G4R030Z2.0-HXT	03205213	4	G	3,0	6,0	2,25	80,0	30,0	2,85	0,3	2	2,42	30,59	31,55	32,56	33,64	34,8	–	■
JME142010G5R005Z2.0-HXT	03205143	5	G	1,0	6,0	0,75	60,0	15,0	0,95	0,05	2	5,93	15,32	15,9	16,42	16,97	17,55	18,86	■
JME142015G5R005Z2.0-HXT	03205165	5	G	1,5	6,0	1,125	80,0	22,5	1,45	0,05	2	4,2	22,82	23,64	24,4	25,22	26,09	28,04	■
JME142020G5R005Z2.0-HXT	03205183	5	G	2,0	6,0	1,5	80,0	30,0	1,94	0,05	2	3,07	30,35	31,39	32,41	33,49	34,65	37,24	■
JME142030G5R005Z2.0-HXT	03205203	5	G	3,0	6,0	2,25	90,0	45,0	2,85	0,05	2	1,7	45,59	47,03	48,55	50,17	–	–	■
JME142010G6R005Z2.0-HXT	03205144	6	G	1,0	6,0	0,75	60,0	20,0	0,95	0,05	2	4,92	20,32	21,06	21,74	22,47	23,25	24,98	■
JME142015G6R005Z2.0-HXT	03205166	6	G	1,5	6,0	1,125	80,0	30,0	1,45	0,05	2	3,37	30,32	31,37	32,39	33,47	34,63	37,21	■
JME142020G6R005Z2.0-HXT	03205184	6	G	2,0	6,0	1,5	80,0	40,0	1,94	0,05	2	2,42	40,35	41,71	43,06	44,5	46,04	–	■
JME142030G6R005Z2.0-HXT	03205204	6	G	3,0	6,0	2,25	90,0	60,0	2,85	0,05	2	1,31	60,59	62,5	64,52	–	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JME142 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1,5	1,8	2	2,5	3	
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59–110) *295 (200 — 360)*
H5	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140–190) *520 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	90 (59–110) *295 (200 — 360)*
H8	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140–190) *520 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (170 — 240) *670 (560–780)*
H12	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530–720)*
H21	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	160 (140–190) *520 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.46 *0,46*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (110–140) *395 (370 — 450)*

Schnittdaten – JME142 Nutfräsen

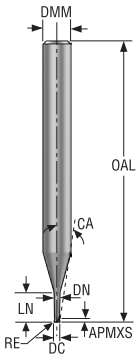
SMG		a_p/DC	f_z													v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H5	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97–130) *395 (320 — 420)*
H7	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	65 (43 — 85) *215 (150 — 270)*
H8	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (97–130) *395 (320 — 420)*
H11	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	150 (130–170) *490 (430 — 550)*
H12	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120–160) *445 (400 — 520)*
H21	M/A	0.012 *0,012*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (98–140) *395 (330 — 450)*
H31	M/A	0.020 *0,020*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	90 (73–100) *295 (240 — 320)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JME144

Mini – Gehärteter Stahl – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius



J





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM=h5
- DC = 0-0,01 mm
- RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME144010J2R005Z4.0-HXT	03205214	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,05	4	9,08	2,04	4,12	4,44	4,62	4,78	5,14	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	4	9,13	2,04	4,11	4,43	4,62	4,78	5,13	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	4	9,22	2,04	4,09	4,42	4,61	4,76	5,1	■
JME144012J2R005Z4.0-HXT	03205221	2	J	1,2	4,0	0,9	50,0	4,5	1,15	0,05	4	8,37	2,18	4,59	4,96	5,15	5,33	5,72	■
JME144012J2R010Z4.0-HXT	03205224	2	J	1,2	4,0	0,9	50,0	4,5	1,15	0,1	4	8,41	2,18	4,59	4,95	5,15	5,33	5,71	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	4	7,52	2,4	5,09	5,48	5,69	5,88	6,32	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	4	7,56	2,4	5,08	5,47	5,68	5,87	6,31	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	4	7,63	2,4	5,06	5,47	5,67	5,86	6,28	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	4	5,97	3,09	6,16	6,54	6,77	7,0	7,52	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	4	6,0	3,09	6,15	6,54	6,76	6,99	7,51	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	4	6,06	3,1	6,14	6,53	6,75	6,98	7,49	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	4	6,12	3,1	6,13	6,52	6,74	6,97	7,47	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	4	2,66	6,76	9,44	9,78	10,1	10,45	–	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	4	2,69	6,76	9,44	9,77	10,09	10,44	–	■
JME144010J3R005Z4.0-HXT	03205215	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,05	4	8,27	2,04	4,52	5,45	5,66	5,86	6,29	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	4	8,3	2,04	4,47	5,44	5,66	5,85	6,28	■
JME144012J3R005Z4.0-HXT	03205222	3	J	1,2	4,0	0,9	50,0	6,0	1,15	0,05	4	7,3	2,18	4,85	6,47	6,71	6,94	7,46	■
JME144012J3R010Z4.0-HXT	03205225	3	J	1,2	4,0	0,9	50,0	6,0	1,15	0,1	4	7,33	2,18	4,79	6,47	6,71	6,94	7,45	■
JME144015J3R005Z4.0-HXT	03205228	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,05	4	6,04	2,4	5,34	8,0	8,29	8,57	9,21	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	4	6,06	2,4	5,28	8,0	8,28	8,57	9,2	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	4	4,29	3,09	6,9	10,57	10,93	11,31	12,15	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	4	4,31	3,09	6,84	10,57	10,92	11,3	12,14	■
JME144030J3R005Z4.0-HXT	03205242	3	J	3,0	4,0	2,25	50,0	15,0	2,85	0,05	4	1,74	6,76	15,06	15,82	16,35	–	–	■
JME144030J3R010Z4.0-HXT	03205244	3	J	3,0	4,0	2,25	50,0	15,0	2,85	0,1	4	1,75	6,76	15,04	15,82	16,35	–	–	■
JME144010J4R005Z4.0-HXT	03205216	4	J	1,0	4,0	0,75	40,0	8,5	0,95	0,05	4	6,28	2,04	4,52	8,98	9,3	9,63	10,34	■
JME144010J4R010Z4.0-HXT	03205219	4	J	1,0	4,0	0,75	40,0	8,5	0,95	0,1	4	6,31	2,04	4,47	8,98	9,3	9,62	10,33	■
JME144012J4R005Z4.0-HXT	03205223	4	J	1,2	4,0	0,9	50,0	10,0	1,15	0,05	4	5,44	2,18	4,85	10,51	10,87	11,25	12,09	■
JME144012J4R010Z4.0-HXT	03205226	4	J	1,2	4,0	0,9	50,0	10,0	1,15	0,1	4	5,46	2,18	4,79	10,5	10,87	11,24	12,07	■
JME144015J4R010Z4.0-HXT	03205231	4	J	1,5	4,0	1,125	60,0	12,0	1,45	0,1	4	4,46	2,4	5,28	12,53	12,96	13,41	14,4	■
JME144015J4R020Z4.0-HXT	03205233	4	J	1,5	4,0	1,125	60,0	12,0	1,45	0,2	4	4,49	2,4	5,17	12,53	12,95	13,4	14,38	■
JME144020J4R010Z4.0-HXT	03205238	4	J	2,0	4,0	1,5	60,0	16,0	1,94	0,1	4	3,02	3,09	6,84	16,61	17,16	17,76	19,08	■
JME144020J4R020Z4.0-HXT	03205240	4	J	2,0	4,0	1,5	60,0	16,0	1,94	0,2	4	3,04	3,1	6,72	16,6	17,16	17,74	19,05	■
JME144030J4R010Z4.0-HXT	03205245	4	J	3,0	4,0	2,25	60,0	24,0	2,85	0,1	4	1,16	6,76	15,09	24,88	–	–	–	■
JME144030J4R020Z4.0-HXT	03205248	4	J	3,0	4,0	2,25	60,0	24,0	2,85	0,2	4	1,16	6,76	14,97	24,87	–	–	–	■

■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JME144 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				1.0	1.2	1.5	2.0	3	
H3	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65–120) *310 (220 — 390)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140–190) *540 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65–120) *310 (220 — 390)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140–190) *540 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	210 (180 — 240) *690 (600–780)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	190 (160 — 220) *620 (530–720)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140–190) *540 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	125 (110–140) *410 (370 — 450)*

Schnittdaten – JME144 Nutfräsen

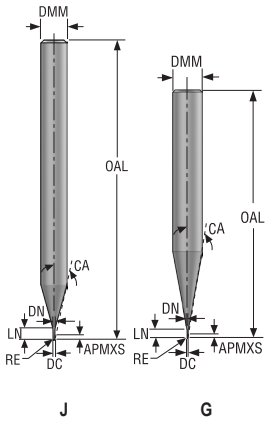
SMG		a_p/DC	f_z					v_c
			1.0	1.2	1.5	2.0	3,0	
H3	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H5	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96–130) *375 (320 — 420)*
H7	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H8	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96–130) *375 (320 — 420)*
H11	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	150 (130–170) *490 (430 — 550)*
H12	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	135 (120–160) *445 (400 — 520)*
H21	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96–130) *375 (320 — 420)*
H31	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	90 (73–100) *295 (240 — 320)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = <Ø0,6= 0/-0,008 mm
- DC = ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB112002G1BZ2.0-HXT	03204964	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,1	2	15,11	0,49	0,5	0,52	0,54	0,55	0,59	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	2	14,77	0,69	0,71	0,73	0,75	0,77	0,82	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	2	14,32	0,95	0,97	1,0	1,02	1,05	1,12	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	2	13,97	1,15	1,18	1,21	1,24	1,27	1,35	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	2	13,64	1,34	1,37	1,41	1,45	1,49	1,58	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	2	13,96	1,74	1,78	1,83	1,88	1,93	2,04	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	2	13,49	2,14	2,19	2,25	2,31	2,37	2,51	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	2	13,02	2,54	2,6	2,67	2,74	2,81	2,98	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	2	12,2	3,23	3,31	3,39	3,48	3,57	3,79	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	2	14,33	0,51	0,72	0,8	0,87	0,94	1,06	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	2	13,85	0,61	0,99	1,11	1,2	12,7	1,42	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	2	13,3	1,02	1,35	1,47	1,57	1,65	1,79	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	2	12,85	1,53	1,72	1,84	1,93	2,02	2,17	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	2	9,91	1,78	1,89	1,98	2,07	2,17	2,41	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	2	12,09	1,57	2,19	2,35	2,46	2,56	2,74	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	2	9,62	2,27	2,41	2,52	2,63	2,76	3,07	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	2	11,34	1,77	2,67	2,86	2,99	3,1	3,31	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	2	9,33	2,77	2,93	3,06	3,2	3,35	3,72	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	2	9,49	2,29	4,13	4,42	4,59	4,74	5,06	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	2	8,49	4,32	4,52	4,72	4,94	5,19	5,77	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	2	8,83	2,49	4,6	4,93	5,12	5,28	5,63	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	2	8,21	4,82	5,04	5,26	5,51	5,78	6,42	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	2	8,1	2,78	5,09	5,45	5,64	5,81	6,19	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	2	10,14	5,32	5,55	5,72	5,89	6,07	6,47	■
JMB112018J2BZ2.0-HXT	03205019	2	J	1,8	4,0	1,8	50,0	5,0	1,75	0,9	2	7,71	3,08	5,15	5,46	5,64	5,81	6,17	■
JMB112018G2BZ2.0-HXT	03205018	2	G	1,8	6,0	1,8	50,0	5,0	1,75	0,9	2	9,99	5,32	5,55	5,71	5,88	6,05	6,44	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	2	6,6	3,6	6,16	6,5	6,7	6,9	7,34	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	2	9,1	6,35	6,6	6,79	6,99	7,2	7,66	■
JMB112025J2BZ2.0-HXT	03205032	2	J	2,5	4,0	2,5	50,0	7,5	2,4	1,25	2	4,75	5,4	7,81	8,12	8,35	8,59	9,14	■
JMB112025G2BZ2.0-HXT	03205033	2	G	2,5	6,0	2,5	50,0	7,5	2,4	1,25	2	7,71	7,97	8,22	8,45	8,69	8,95	9,53	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	2	3,04	7,53	9,44	9,73	10,01	10,31	10,96	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	2	6,35	9,59	9,85	10,12	10,41	10,72	11,42	■

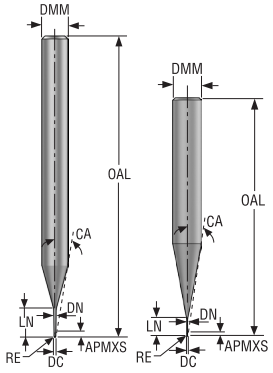
■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch





J G



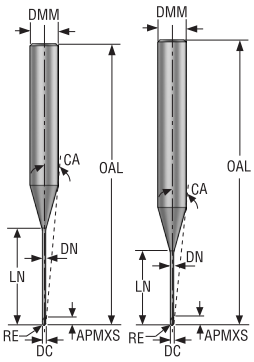
- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = <Ø0,6= 0/-0,008 mm
- DC = ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB112005J3BZ2.0-HXT	03204973	3	J	0,5	4,0	0,5	40,0	2,5	0,46	0,25	2	11,49	1,54	2,63	2,85	2,99	3,11	3,32	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	2	8,81	3,78	3,99	4,18	4,38	4,61	5,15	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	2	10,83	1,57	3,07	3,36	3,52	3,65	3,9	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	2	8,56	4,27	4,51	4,72	4,94	5,2	5,81	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	2	9,67	1,77	3,52	4,38	4,57	4,72	5,05	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	2	10,1	5,77	6,06	6,26	6,46	6,67	7,14	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	2	8,6	2,29	4,57	5,43	5,64	5,82	6,22	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	2	9,06	7,32	7,64	7,87	8,12	8,38	8,97	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	2	7,65	2,49	4,9	6,45	6,68	6,89	7,36	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	2	8,42	8,32	8,67	8,93	9,21	9,51	10,17	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	2	6,4	2,78	5,33	7,97	8,24	8,5	9,08	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	2	7,31	10,32	10,72	11,05	11,39	11,76	12,59	■
JMB112018J3BZ2.0-HXT	03205020	3	J	1,8	4,0	1,8	50,0	9,0	1,75	0,9	2	5,28	3,08	5,81	9,49	9,8	10,11	10,8	■
JMB112018G3BZ2.0-HXT	03205021	3	G	1,8	6,0	1,8	50,0	12,0	1,75	0,9	2	6,35	12,32	12,78	13,17	13,58	14,02	15,0	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	2	4,61	3,6	6,86	10,53	10,86	11,21	11,97	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	2	6,19	12,35	12,8	13,18	13,59	14,03	15,0	■
JMB112025J3BZ2.0-HXT	03205034	3	J	2,5	4,0	2,5	50,0	12,5	2,4	1,25	2	3,13	5,4	10,6	13,15	13,55	13,97	14,92	■
JMB112025G3BZ2.0-HXT	03205035	3	G	2,5	6,0	2,5	50,0	15,0	2,4	1,25	2	4,91	15,47	15,96	16,43	16,94	17,49	18,71	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	2	1,91	7,53	15,03	15,77	16,25	–	–	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	2	4,41	15,59	16,04	16,51	17,01	17,55	18,76	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = <Ø0,6= 0/-0,008 mm
- DC = ≥Ø0,6= 0/-0,01 mm
- RE= <Ø0,5= ±0,004 mm
- RE= ≥Ø1,5= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB112005J4BZ2.0-HXT	03204975	4	J	0,5	4,0	0,5	40,0	4,0	0,46	0,25	2	9,9	1,54	3,15	4,37	4,57	4,72	5,06	■
JMB112005G4BZ2.0-HXT	03204976	4	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	2	10,55	5,28	5,55	5,74	5,93	6,12	6,56	■
JMB112006J4BZ2.0-HXT	03204982	4	J	0,6	4,0	0,6	40,0	5,0	0,56	0,3	2	8,97	1,57	3,19	5,38	5,61	5,8	6,21	■
JMB112006G4BZ2.0-HXT	03204983	4	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	2	9,86	6,27	6,59	6,8	7,02	7,25	7,77	■
JMB112008J4BZ2.0-HXT	03204989	4	J	0,8	4,0	0,8	40,0	7,0	0,76	0,4	2	7,46	1,77	3,52	7,41	7,7	7,95	8,52	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	2	8,65	8,27	8,65	8,92	9,21	9,52	10,2	■
JMB112010J4BZ2.0-HXT	03204996	4	J	1,0	4,0	1,0	40,0	8,5	0,95	0,5	2	6,48	2,29	4,57	8,96	9,28	9,58	10,26	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	2	7,63	10,32	10,73	11,06	11,42	11,8	12,64	■
JMB112012J4BZ2.0-HXT	03205005	4	J	1,2	4,0	1,2	50,0	10,0	1,15	0,6	2	5,63	2,49	4,9	10,48	10,84	11,2	11,99	■
JMB112012G4BZ2.0-HXT	03205006	4	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	2	8,77	12,32	12,79	13,19	13,61	14,06	15,07	■
JMB112015J4BZ2.0-HXT	03205014	4	J	1,5	4,0	1,5	60,0	12,0	1,45	0,75	2	4,65	2,78	5,33	12,51	12,92	13,34	14,28	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	2	5,7	15,32	15,88	16,37	16,9	17,46	18,71	■
JMB112018J4BZ2.0-HXT	03205022	4	J	1,8	4,0	1,8	60,0	15,0	1,75	0,9	2	3,57	3,08	5,81	15,54	16,04	16,57	17,74	■
JMB112018G4BZ2.0-HXT	03205023	4	G	1,8	6,0	1,8	60,0	18,0	1,75	0,9	2	4,83	18,32	18,97	19,56	20,18	20,85	22,35	■
JMB112020J4BZ2.0-HXT	03205028	4	J	2,0	4,0	2,0	60,0	16,0	1,94	1,0	2	3,17	3,6	6,86	16,58	17,11	17,66	18,91	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	2	4,68	18,35	18,99	19,57	20,19	20,86	22,35	■
JMB112025G4BZ2.0-HXT	03205036	4	G	2,5	6,0	2,5	65,0	25,0	2,4	1,25	2	3,3	25,47	26,27	27,08	27,95	28,88	30,94	■
JMB112030J4BZ2.0-HXT	03205041	4	J	3,0	4,0	3,0	60,0	24,0	2,85	1,5	2	1,22	7,53	15,07	24,83	–	–	–	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	2	2,51	30,59	31,51	32,48	33,52	34,63	–	■
JMB112010G5BZ2.0-HXT	03204999	5	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	2	6,04	15,32	15,89	16,39	16,92	17,49	18,76	■
JMB112012G5BZ2.0-HXT	03205007	5	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	2	5,24	18,32	18,98	19,58	20,21	20,89	22,41	■
JMB112015G5BZ2.0-HXT	03205016	5	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	2	4,29	22,82	23,62	24,36	25,15	26,0	27,88	■
JMB112020G5BZ2.0-HXT	03205030	5	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	2	3,15	30,35	31,36	32,35	33,4	34,52	37,03	■
JMB112030G5BZ2.0-HXT	03205043	5	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	2	1,75	45,59	46,98	48,45	50,03	–	–	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	2	4,99	20,32	21,05	21,71	22,42	23,19	24,92	■
JMB112012G6BZ2.0-HXT	03205008	6	G	1,2	6,0	1,2	70,0	24,0	1,15	0,6	2	4,27	24,32	25,17	25,97	26,82	27,73	29,75	■
JMB112015G6BZ2.0-HXT	03205017	6	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	2	3,44	30,32	31,35	32,35	33,4	34,49	37,06	■
JMB112020G6BZ2.0-HXT	03205031	6	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2	2,47	40,35	41,68	43,0	44,4	45,91	–	■
JMB112030G6BZ2.0-HXT	03205045	6	G	3,0	6,0	3,0	90,0	60,0	2,85	1,5	2	1,34	60,59	62,45	64,43	–	–	–	■

■ **Lagerstandard.**

Für WDX-Werte: Max. Schnitttiefe bezogen auf a_{η} ($l_{a\eta}$, ref)*

Schnittdaten – JMB112 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130–170) *490 (430 — 550)*
H5	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (200 — 240) *720 (660–780)*
H7	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130–170) *490 (430 — 550)*
H8	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660–780)*
H11	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 310) *920 (830–1000)*
H12	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	255 (230 — 280) *840 (760 — 910)*
H21	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660–780)*
H31	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.036 *0,0014*	0.042 *0,0017*	0.044 *0,0017*	165 (150–180) *540 (500 — 590)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.



KUNSTSTOFFE UND COMPOSITE

Seco bietet ein vollständiges Programm an Vollhartmetallfräsern für die Bearbeitung von glas- und carbonfaserverstärkten Kunststoffen. Es besteht aus diamantbeschichteten, unbeschichteten und PKD-Fräsern mit verschiedenen Geometrien sowie Fräser mit eingelöteter PKD-Spitze. Die Werkzeuge sind speziell für schwierige Zerspanungsbedingungen in anspruchsvollen Werkstoffen optimiert.

- JC860, JC870, JC871, JC899, JPD890, J93F und J28 Schaftfräser mit scharfer Ecke
- JC845, JC880, JC885 und JC898 mit Eckenradius
- JC875, JC876, JC877 und JPD880 mit 45° Fase
- JC850 und JPD850 Kugelkopffräser

Werkzeugauswahl Kunststoffe und Composite

						
Werkzeugbezeichnung		JC845	JC850	JC860	JC870	JC871
Seite(n)		393	395	397	399	405
Produktfamilie		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Fräserausführung						
Auf-nahmen	Zylindrisch	■	■	■	■	■
	Weldon					
Schneidenzahl		3	4	5,6,8,9		
ICC						
	Metrisch	6-8	3-12	6-12	3-12	3-12
	Zoll				1/4 -1/2	1/4 -1/2
Verfügbare Längen						
		2	2	2	2	2
Bearbeitung						
						
						
SMG						
TS1						
TS2		●	●	●	●	●
TS3		●	●	●	●	●
TP1						
TP2		●	●	●	●	●
TP3		●	●	●	●	●
Honeycomb*				●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Kunststoffe und Composite

								
Werkzeugbezeichnung		JC875	JC876	JC877	JC880	JC885	JC898	JC899
Seite(n)		411	415	419	423	425	427	429
Produktfamilie		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Fräserausführung								
Aufnahmen	Zylindrisch	■	■	■	■	■	■	■
	Weldon							
Schneidenzahl		5,6,10	6,8,10,12,14	6,8,10,12,14	4	4	4	4
ICC							■	
	Metrisch	3-10	3-12	3-12	4-20	4-10	8-15	8,5-14,8
	Zoll	1/4 -1/2	1/4-1/2	1/4-1/2				
Verfügbare Längen								
		2	2	2	2	2	2	2
Bearbeitung								
								
SMG								
TS1								
TS2		●	●	●	●	●		
TS3		●	●	●	●	●		
TP1								
TP2		●	●	●	●	●		
TP3		●	●	●	●	●		
Honeycomb*								

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

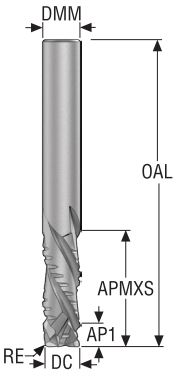
Werkzeugauswahl Kunststoffe und Composite

						
Werkzeugbezeichnung		JPD850	JPD880	JPD890	J93F	J28
Seite(n)		432	434	436	438	440
Produktfamilie		PCD	PCD	PCD	VHM	VHM
Fräserausführung						
Auf-nahmen	Zylindrisch	■	■	■	■	■
	Weldon					
Schneidenzahl		2	3	2	2	1
ICC		■	■	■		
	Metrisch	4-10	6-16	6-12	1,5-20	3-12
	Zoll					
Verfügbare Längen						
		2	2,3	2,3	1,2,3,4	2
Bearbeitung						
						
						
SMG						
TS1					•	•
TS2		•	•	•		
TS3		•	•	•		
TP1					•	
TP2		•	•	•		
TP3		•	•	•		
Honeycomb*						

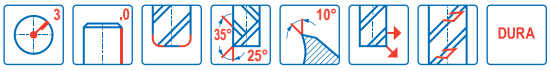
■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JC845

Composite – Kompression – 3 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	AP1	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm		
JC845060D2R050.0Z3-DURA	02843006	2	D	6,0	6,0	18,0	4,2	65,0	0,5	3	■
JC845080D2R050.0Z3-DURA	02843007	2	D	8,0	8,0	24,0	5,2	75,0	0,5	3	■
JC845100D2R050.0Z3-DURA	02843008	2	D	10,0	10,0	30,0	6,3	85,0	0,5	3	■
JC845120D2R050.0Z5-DURA	02843009	2	D	12,0	12,0	36,0	8,3	100,0	0,5	5	■

■ **Lagerstandard.**

Schnittdaten – JC845 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	185 (130 — 240) *610 (430–780)*
TS3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87–160) *410 (290 — 520)*
TP2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87–180) *410 (290 — 590)*
TP3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	85 (62–110) *280 (210 — 360)*

Schnittdaten – JC845 Nutfräsen

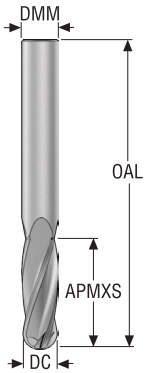
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	160 (110 — 210) *520 (370 — 680)*
TS3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (76–130) *345 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (75–160) *345 (250 — 520)*
TP3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (54 — 96) *245 (180 — 310)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC850

Composite – Kugelkopf – 4 Schneiden – Zylindrisch



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
850030Z4.0-DURA	02719949	2	D	3,0	3,0	9,0	50,0	4	■
850040Z4.0-DURA	02719952	2	D	4,0	4,0	12,0	50,0	4	■
850060Z4.0-DURA	02719953	2	D	6,0	6,0	18,0	65,0	4	■
850080Z4.0-DURA	02719954	2	D	8,0	8,0	24,0	70,0	4	■
850100Z4.0-DURA	02719955	2	D	10,0	10,0	30,0	85,0	4	■
850120Z4.0-DURA	02719956	2	D	12,0	12,0	36,0	100,0	4	■

■ **Lagerstandard.**

Schnittdaten – JC850 Kopierfräser

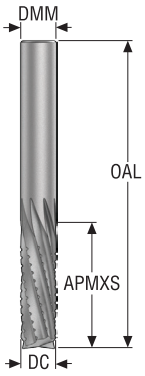
SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	265 (220 — 320) *870 (730–1000)*
TS3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	160 (110 — 210) *520 (370 — 680)*
TP2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	215 (110 — 320) *710 (370–1000)*
TP3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	105 (54–150) *345 (180 — 490)*

Schnittdaten, siehe Seite 457 - 464

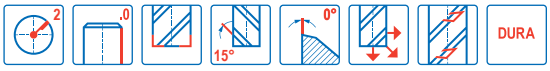
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC860

Honeycomb – Schaftfräser – 5-9 Schneiden – Zylindrisch – Scharfe Schneide



D





- Toleranzen:
- DMM=h5
- DC= -0.02-0.08 mm
- FCEDC=Stirnverzahnung

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Zylindrisch
				mm	mm	mm	mm			
860060Z5.0-DURA	02720211	2	D	6,0	6,0	18,0	70,0	2	5	■
860080Z6.0-DURA	02720212	2	D	8,0	8,0	24,0	80,0	2	6	■
860100Z8.0-DURA	02720216	2	D	10,0	10,0	30,0	90,0	2	8	■
860120Z9.0-DURA	02720217	2	D	12,0	12,0	36,0	110,0	2	9	■

■ **Lagerstandard.**

Schnittdaten – JC860 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	235 (200 — 270) *770 (660 — 880)*
TS3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	160 (130–180) *520 (430 — 590)*
TP2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	165 (130 — 200) *540 (430 — 650)*
TP3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	65 (50–110) *215 (170 — 360)*

Schnittdaten – JC860 Nutfräsen

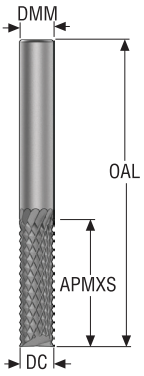
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (85–120) *345 (280 — 390)*
TP2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	110 (84–130) *360 (280 — 420)*
TP3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	44 (34–78) *145 (120 — 250)*

Schnittdaten, siehe Seite 457 - 464

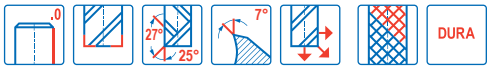
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC870

Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Zylindrisch
				mm	mm	mm	mm			
870030.0-DURA	02720219	2	D	3,0	3,0	9,0	50,0	2	8	■
870040.0-DURA	02720226	2	D	4,0	4,0	12,0	50,0	2	8	■
870060.0-DURA	02720228	2	D	6,0	6,0	18,0	65,0	2	10	■
870080.0-DURA	02720229	2	D	8,0	8,0	24,0	75,0	2	12	■
870100.0-DURA	02720231	2	D	10,0	10,0	30,0	85,0	2	12	■
870120.0-DURA	02720232	2	D	12,0	12,0	36,0	100,0	2	14	■

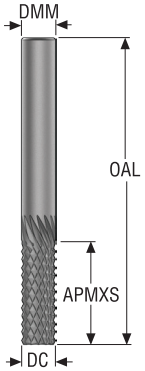
■ **Lagerstandard.**

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC870

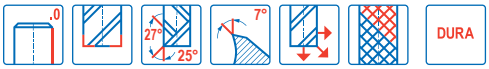
Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide – Zoll





D

- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*



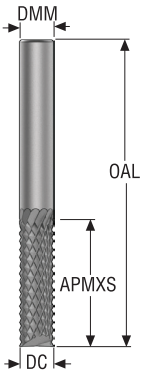
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll			
8700250.0-DURA	02720784	2	D	0.250	0.250	0.750	2.250	2	10	■
8700375.0-DURA	02720785	2	D	0.375	0.375	1.250	3.500	2	12	■

■ **Lagerstandard.**

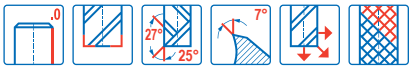
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC870

Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Zylindrisch
				mm	mm	mm	mm			
870030.0	02742789	2	D	3,0	3,0	9,0	50,0	2	8	■
870040.0	02742792	2	D	4,0	4,0	12,0	50,0	2	8	■
870050.0	02742793	2	D	5,0	5,0	15,0	50,0	2	10	■
870060.0	02742794	2	D	6,0	6,0	18,0	65,0	2	10	■
870080.0	02742795	2	D	8,0	8,0	24,0	75,0	2	12	■
870100.0	02742796	2	D	10,0	10,0	30,0	85,0	2	12	■
870120.0	02742797	2	D	12,0	12,0	36,0	100,0	2	14	■

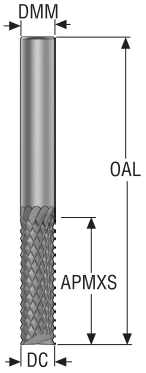
■ **Lagerstandard.**

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC870

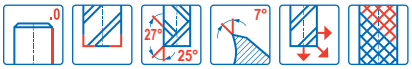
Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide – Zoll





D

- Toleranzen:
- DMM=h5
- DC=-.0008 / -.0015 *Zoll*
- Fräser (Linksdrall)*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll			
8700250.0	02742798	2	D	0.250	0.250	0.750	2.250	2	10	■
8700500.0	02742800	2	D	0.500	0.500	1.500	4.250	2	14	■

■ **Lagerstandard.**

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

Schnittdaten – JC870 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94–130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88–140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC870 Nutfräsen

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	145 (130–170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (79–110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (74–120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	39 (30 — 68) *130 (99 — 220)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JC870 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94–130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88–140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC870 Nutfräsen – Zoll

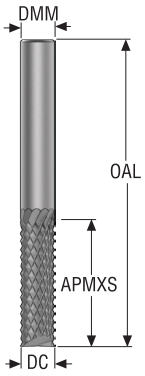
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130–170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79–110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74–120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

Schnittdaten, siehe Seite 457 - 464

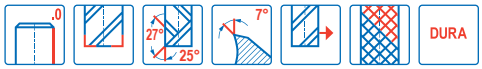
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC871

Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
871030.0-DURA	02720249	2	D	3,0	3,0	9,0	50,0	8	■
871040.0-DURA	02720250	2	D	4,0	4,0	12,0	50,0	8	■
871060.0-DURA	02720252	2	D	6,0	6,0	18,0	65,0	10	■
871080.0-DURA	02720253	2	D	8,0	8,0	24,0	75,0	12	■
871100.0-DURA	02720254	2	D	10,0	10,0	30,0	85,0	12	■
871120.0-DURA	02720257	2	D	12,0	12,0	36,0	100,0	14	■

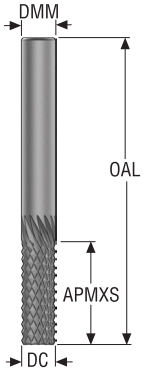
■ **Lagerstandard.**

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC871

Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide – Zoll





D

- Toleranzen:
- DMM=h5
- DC=-.0008 / -.0015 *Zoll*
- Fräser (Linksdrall)*



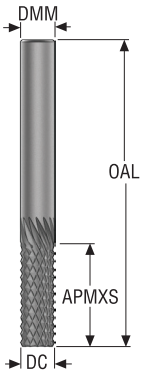
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll		
8710250.0-DURA	02720788	2	D	0.250	0.250	0.750	2.250	10	■
8710375.0-DURA	02720789	2	D	0.375	0.375	1.250	3.500	12	■
8710500.0-DURA	02720790	2	D	0.500	0.500	1.500	4.250	14	■

■ **Lagerstandard.**

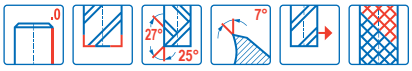
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC871

Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide



D





- Toleranzen:
- DMM=h5
- DC=-0.02/-0.04
- Fräser (Linksdrall)*

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				mm	mm	mm	mm		
871030.0	02742801	2	D	3,0	3,0	9,0	50,0	8	■
871040.0	02742803	2	D	4,0	4,0	12,0	50,0	8	■
871060.0	02742806	2	D	6,0	6,0	18,0	65,0	10	■
871080.0	02742807	2	D	8,0	8,0	24,0	75,0	12	■
871100.0	02742808	2	D	10,0	10,0	30,0	85,0	12	■
871120.0	02742809	2	D	12,0	12,0	36,0	100,0	14	■

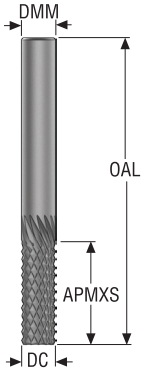
■ **Lagerstandard.**

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC871

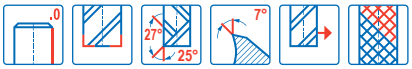
Composite – Fräser – Schaftfräser – Zylindrisch – Scharfe Schneide – Zoll





D

- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll		
8710500.0	02742814	2	D	0.500	0.500	1.500	4.250	14	■

■ **Lagerstandard.**

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

Schnittdaten – JC871 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94–130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88–140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC871 Nutfräsen

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	155 (140–180) *510 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (84–120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (79–130) *345 (260 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	40 (31–70) *130 (110 — 220)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JC871 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94–130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88–140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC871 Nutfräsen – Zoll

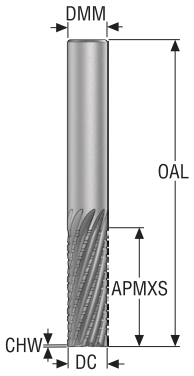
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130–170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79–110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74–120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

Schnittdaten, siehe Seite 457 - 464

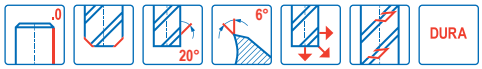
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC875

Composite – Schaftfräser – 5-10 Schneiden – Zylindrisch – Eckenfase



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm

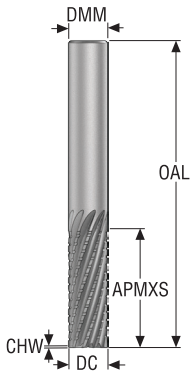
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JC875030D2.0-DURA	02968155	2	D	3,0	3,0	9,0	50,0	0,05	5	■
JC875050D2.0-DURA	02968157	2	D	5,0	5,0	15,0	50,0	0,05	6	■
JC875060D2.0-DURA	02968158	2	D	6,0	6,0	18,0	65,0	0,06	6	■
JC875080D2.0-DURA	02968159	2	D	8,0	8,0	24,0	70,0	0,08	10	■
JC875100D2.0-DURA	02968160	2	D	10,0	10,0	30,0	80,0	0,1	10	■

■ **Lagerstandard.**

JC875

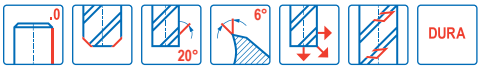
Composite – Schaftfräser – 6-10 Schneiden – Zylindrisch – Eckenfase – Zoll





D

- Toleranzen:
- DMM=h5
- DC= -.0008/-.0030 *Zoll*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll	Zoll		
JC875.250D2.0-DURA	02968162	2	D	0.250	0.250	0.750	3.000	0.002	6	■

■ **Lagerstandard.**

Schnittdaten – JC875 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	5	6	8	10	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	190 (160 — 220) *620 (530–720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (110–150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (96–150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	50 (39 — 89) *165 (130 — 290)*

Schnittdaten – JC875 Nutfräsen

SMG		a_p/DC	f_z					v_c
			3	5	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (86–120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (81–130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	42 (33–74) *140 (110 — 240)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JC875 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	190 (160 — 220) *620 (530–720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (110–150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (96–150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	50 (39 — 89) *165 (130 — 290)*

Schnittdaten – JC875 Nutfräsen – Zoll

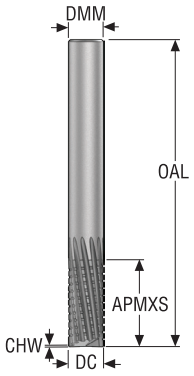
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (86–120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (81–130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	42 (33–74) *140 (110 — 240)*

Schnittdaten, siehe Seite 457 - 464

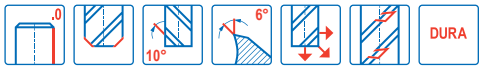
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC876

Composite – Schaftfräser – 6-14 Schneiden – Zylindrisch – Eckenfase



D





- Toleranzen:
- DMM=h5
- DC=-0,02 -0,08 mm
- Linksdrall

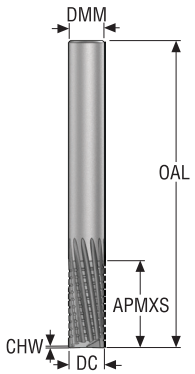
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JC876030D2C.0Z6-DURA	03135004	2	D	3,0	3,0	7,5	50,0	0,035	6	■
JC876040D2C.0Z6-DURA	03135005	2	D	4,0	4,0	10,0	54,0	0,045	6	■
JC876060D2C.0Z8-DURA	03135006	2	D	6,0	6,0	15,0	62,0	0,075	8	■
JC876060D2C.0Z10-DURA	03135007	2	D	6,0	6,0	15,0	62,0	0,075	10	■
JC876080D2C.0Z10-DURA	03135009	2	D	8,0	8,0	20,0	70,0	0,1	10	■
JC876100D2C.0Z12-DURA	03135011	2	D	10,0	10,0	25,0	82,0	0,125	12	■
JC876120D2C.0Z14-DURA	03135012	2	D	12,0	12,0	30,0	95,0	0,15	14	■

■ **Lagerstandard.**

JC876

Composite – Schaftfräser – 8-14 Schneiden – Zylindrisch – Eckenfase – Zoll





D

- Toleranzen:
- DMM=h5
- DC= -.0008/-.0030 *Zoll*
- Linksdrall



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll	Zoll		
JC876.250D2C.0Z8-DURA	03135125	2	D	0.250	0.250	0.625	2.500	0.003	8	■
JC876.375D2C.0Z12-DURA	03135127	2	D	0.375	0.375	1.000	3.000	0.005	12	■

■ **Lagerstandard.**

Schnittdaten – JC876 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (120–170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (110–180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	75 (44–100) *245 (150 — 320)*

Schnittdaten – JC876 Nutfräsen

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (94–140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (88–140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	60 (36 — 81) *195 (120 — 260)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JC876 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (120–170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (110–180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	75 (44–100) *245 (150 — 320)*

Schnittdaten – JC876 Nutfräsen – Zoll

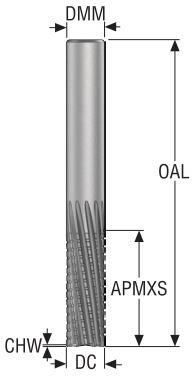
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (94–140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (88–140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	60 (36 — 81) *195 (120 — 260)*

Schnittdaten, siehe Seite 457 - 464

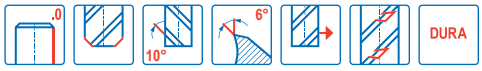
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC877

Composite – Schaftfräser – 6-14 Schneiden – Zylindrisch – Eckenfase



D





- Toleranzen:
- DMM=h5
- DC=-0,02, -0,08 mm
- Linksdrall

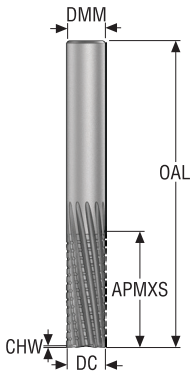
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JC877030D2C.0Z6-DURA	03135013	2	D	3,0	3,0	9,0	50,0	0,035	6	■
JC877040D2C.0Z6-DURA	03135014	2	D	4,0	4,0	12,0	54,0	0,045	6	■
JC877060D2C.0Z8-DURA	03135015	2	D	6,0	6,0	18,0	62,0	0,075	8	■
JC877060D2C.0Z10-DURA	03135016	2	D	6,0	6,0	18,0	62,0	0,075	10	■
JC877080D2C.0Z10-DURA	03135018	2	D	8,0	8,0	24,0	70,0	0,1	10	■
JC877100D2C.0Z12-DURA	03135020	2	D	10,0	10,0	30,0	82,0	0,125	12	■
JC877120D2C.0Z14-DURA	03135021	2	D	12,0	12,0	36,0	95,0	0,15	14	■

■ **Lagerstandard.**

JC877

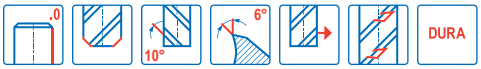
Composite – Schaftfräser – 8-14 Schneiden – Zylindrisch – Eckenfase – Zoll





D

- Toleranzen:
- DMM=h5
- DC= -.0008/-.0030 *Zoll*
- Linksdrall



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Zylindrisch
				Zoll	Zoll	Zoll	Zoll	Zoll		
JC877.250D2C.0Z8-DURA	03135129	2	D	0.250	0.250	0.750	2.500	0.003	8	■

■ **Lagerstandard.**

Schnittdaten – JC877 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	195 (170 — 220) *640 (560–720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (110–150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (98–160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (40 — 91) *215 (140 — 290)*

Schnittdaten – JC877 Nutfräsen

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	170 (150 — 200) *115 (92–130)*
TP2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	115 (86–140) *55 (35 — 80)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Schnittdaten – JC877 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	195 (170 — 220) *640 (560–720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (110–150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (98–160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	65 (40 — 91) *215 (140 — 290)*

Schnittdaten – JC877 Nutfräsen – Zoll

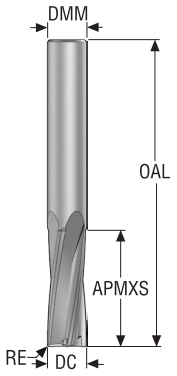
SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140–180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (85–120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (80–130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	55 (32–74) *180 (110 — 240)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC880

Composite – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
880040R020Z4.0-DURA	02843012	2	D	4,0	4,0	12,0	50,0	0,2	4	■
880050R020Z4.0-DURA	02843013	2	D	5,0	5,0	15,0	50,0	0,2	4	■
880060R020Z4.0-DURA	02720258	2	D	6,0	6,0	18,0	65,0	0,2	4	■
880080R020Z4.0-DURA	02720259	2	D	8,0	8,0	24,0	70,0	0,2	4	■
880100R020Z4.0-DURA	02720260	2	D	10,0	10,0	30,0	80,0	0,2	4	■
880120R020Z4.0-DURA	02720261	2	D	12,0	12,0	36,0	100,0	0,2	4	■
880160R020Z4.0-DURA	02720262	2	D	16,0	16,0	48,0	110,0	0,2	4	■
880200R020Z4.0-DURA	02720263	2	D	20,0	20,0	60,0	130,0	0,2	4	■

■ **Lagerstandard.**

Schnittdaten – JC880 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				4	6	8	10	12	16	20	
TS2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	130 (93–170) *425 (310 — 550)*
TP2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	125 (95–150) *410 (320 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (40 — 92) *165 (140 — 300)*

Schnittdaten – JC880 Nutfräsen

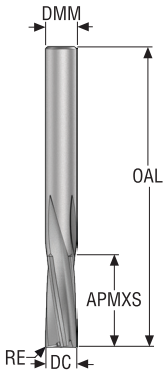
SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130–170) *490 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	100 (71–130) *330 (240 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (76–120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	40 (31–70) *130 (110 — 220)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC885

Composite – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius



D





- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm
- Linksdrall

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
JC885040D2R020.0Z4-DURA	02843014	2	D	4,0	4,0	12,0	50,0	0,2	4	■
JC885060D2R020.0Z4-DURA	02843016	2	D	6,0	6,0	18,0	70,0	0,2	4	■
JC885080D2R020.0Z4-DURA	02843017	2	D	8,0	8,0	24,0	80,0	0,2	4	■

■ **Lagerstandard.**

Schnittdaten – JC885 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				4	6	8	10	
TS2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	130 (99–170) *425 (330 — 550)*
TP2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	125 (94–150) *410 (310 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (33 — 92) *165 (110 — 300)*

Schnittdaten – JC885 Nutfräsen

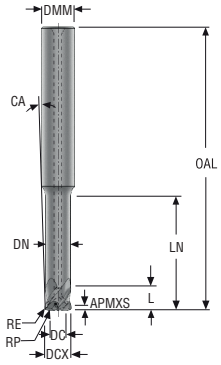
SMG		a_p/DC	f_z				v_c
			4	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	150 (130–170) *490 (430 — 550)*
TS3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	100 (76–130) *330 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	100 (75–120) *330 (250 — 390)*
TP3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	40 (26–70) *130 (86 — 220)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

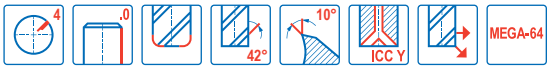
JC898

Hohe Vorschübe – Plattenpakete – Eckenradius – 4 Schneiden – Zylindrisch – Eckenradius



G





- Toleranzen:
- DMM=h5
- DC= e7
- RE= ±0,1 mm

Bezeichnung	Produkt-nummer	Längen-index		ICC	DC	DCX	DMM	APMXS	L	OAL	LN	DN	RE	RP	CA	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm	mm	mm	mm			
JC898080G3HZ4A.0-M64	03245308	3	G	■	4,0	8,0	10,0	0,43	6,0	88,0	35,0	7,6	0,5	0,87	1,5 °	4	■
JC898150G3HZ4A.0-M64	03245309	3	G	■	7,5	15,0	16,0	0,796	12,0	125,0	70,0	14,3	0,94	1,63	0,4 °	4	■

■ **Lagerstandard.**

Schnittdaten – JC898 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z		v_c
				8	15	
S12+TS2/TP2	D	0,30 *0,30*	0,020 *0,020*	0,1 *0,0040*	0,15 *0,0060*	90 (80-120) *300 (270-400)*
TP2+TS2/TP2	D	0,30 *0,30*	0,034 *0,034*	0,12 *0,0048*	0,25 *0,0100*	120 (90-150) *400 (300-490)*

Schnittdaten – JC898 Nutfräsen

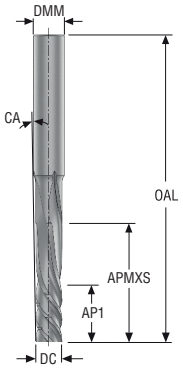
SMG		a_p/DCX	f_z		v_c
			8	15	
S12+TP2/TS2	D	0.020 *0.020*	0.08 *0,0032*	0.10 *0,0040*	90 (80-120) *300 (270-400)*
N1+TP2/TS2	D	0.034 *0.034*	0.1 *0,0040*	0.10 *0,0040*	120 (90-150) *400 (300-490)*

Schnittdaten, siehe Seite 457 - 464

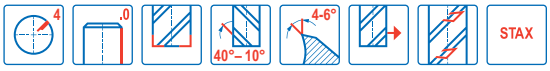
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JC899

Hochleistung – Plattenpakete – Schaftfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide



F





- Toleranzen:
- DMM=h5
- DC= ±0,02 mm

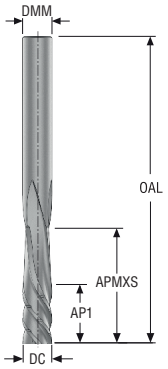
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	AP1	OAL	CA	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm			
JC899085F3S.0Z4-STAX	03245482	3	F	■	8,5	10,0	38,0	19,0	100,0	0,8 °	4	■
JC899148F3S.0Z4-STAX	03245480	3	F	■	14,8	16,0	55,0	30,0	150,0	0,53 °	4	■
JC899148F4S.0Z4-STAX	03245481	4	F	■	14,8	16,0	62,0	37,0	150,0	0,48 °	4	■

■ **Lagerstandard.**

JC899

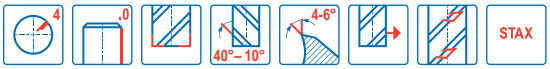
Hochleistung – Plattenpakete – Schaftfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





D

- Toleranzen:
- DMM=h5
- DC= ±0,0008 *Zoll*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	AP1	OAL	PCEDC	Zylindrisch
					Zoll	Zoll	Zoll	Zoll	Zoll		
JC8990375D4S.0Z4-STAX	03245483	4	D	■	0.373	0.375	1.500	0.625	4.000	4	■

■ **Lagerstandard.**

Schnittdaten – JC899 Schlichten

SMG		a_e/DC	a_p/DC	f_z		v_c
				8.5	14.8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,04 *0,0016*	0,075 *0,0030*	40 (30 — 50) *140 (100–170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,06 *0,0032*	0,09 *0,0036*	60 (50–75) *200 (170 — 250)*

Schnittdaten – JC899 Schlichten – Zoll

SMG		a_e/DC	a_p/DC	f_z	v_c
				3/8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,05 *0,0022*	40 (30 — 50) *140 (100–170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,07 *0,0028*	60 (50–75) *200 (170 — 250)*

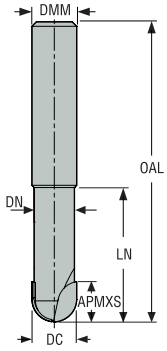
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JPD850

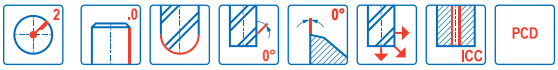
Composite – Kugelkopf – 2 Schneiden – Zylindrisch – ICC





E

- Toleranzen:
- DMM=h5
- DC= h10
- ICC= 2 gerade Kanäle



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm		
JPD850040G2B.0Z2A	02968182	2	G	■	4,0	6,0	6,0	58,0	12,0	3,8	2	■
JPD850050G2B.0Z2A	02968183	2	G	■	5,0	6,0	6,0	58,0	15,0	4,8	2	■
JPD850060E2B.0Z2A	02968184	2	E	■	6,0	6,0	7,0	58,0	18,0	5,4	2	■
JPD850080E2B.0Z2A	02968185	2	E	■	8,0	8,0	8,0	64,0	24,0	7,2	2	■
JPD850100E2B.0Z2A	02968186	2	E	■	10,0	10,0	10,0	73,0	30,0	9,0	2	■

■ **Lagerstandard.**

Schnittdaten – JPD850 Kopierfräser

SMG		a_e/DC	a_p/DC	f_z					v_c
				4	5	6	8	10	
TS2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	550 (470 — 820) *1800 (1600 — 2600)*
TS3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	310 (270 — 460) *1025 (890–1500)*
TP2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	890 (750–1300) *2925 (2500 — 4200)*
TP3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	580 (500 — 870) *1900 (1700 — 2800)*

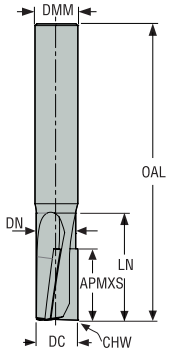
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JPD880

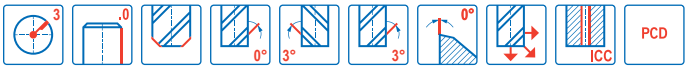
Composite – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenfase – ICC





E

- Toleranzen:
- DMM=h5
- DC=h10
- ICC=Y



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JPD880060G2C.0Z3A	02968190	2	G	■	6,0	8,0	13,0	64,0	20,0	5,3	0,1	3	■
JPD880080E2C.0Z3A	02968191	2	E	■	8,0	8,0	15,0	64,0	20,0	7,3	0,1	3	■
JPD880100E2C.0Z3A	02968192	2	E	■	10,0	10,0	13,0	73,0	30,0	9,2	0,1	3	■
JPD880120E2C.0Z3A	02968194	2	E	■	12,0	12,0	13,0	83,0	30,0	11,0	0,1	3	■
JPD880160E2C.0Z3A	02968196	2	E	■	16,0	16,0	13,0	90,0	35,0	14,8	0,1	3	■
JPD880100E3C.0Z3A	02968193	3	E	■	10,0	10,0	20,0	73,0	30,0	9,2	0,1	3	■
JPD880160E3C.0Z3A	02968197	3	E	■	16,0	16,0	20,0	90,0	35,0	14,8	0,1	3	■

■ **Lagerstandard.**

Schnittdaten – JPD880 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				6	8	10	12	16	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	510 (430–750) *1675 (1500 — 2400)*
TS3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	275 (230 — 410) *900 (760–1300)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	810 (680 — 940) *2650 (2300 — 3000)*
TP3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	520 (440–780) *1700 (1500 — 2500)*

Schnittdaten – JPD880 Nutfräsen

SMG		a_p/DC	f_z					v_c
			6	8	10	12	16	
TS2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	385 (330 — 570) *1275 (1100–1800)*
TS3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	210 (180 — 310) *690 (600–1000)*
TP2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	620 (520–710) *2025 (1800 — 2300)*
TP3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	395 (340 — 590) *1300 (1200–1900)*

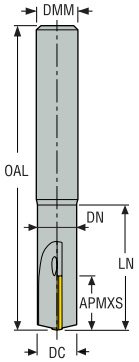
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JPD890

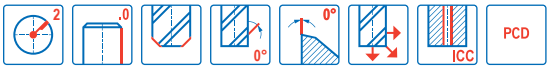
Composite – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenfase – ICC





E

- Toleranzen:
- DMM=h5
- DC=h10
- ICC=2 gerade Kanäle



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	ICC	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Zylindrisch
					mm	mm	mm	mm	mm	mm	mm		
JPD890060G2S.0Z2A	02791382	2	G	■	6,0	8,0	13,0	64,0	20,0	5,4	0,1	2	■
JPD890080E2S.0Z2A	02791383	2	E	■	8,0	8,0	15,0	64,0	20,0	7,4	0,1	2	■
JPD890100E2S.0Z2A	02791384	2	E	■	10,0	10,0	13,0	73,0	30,0	9,4	0,1	2	■
JPD890120E2S.0Z2A	02791386	2	E	■	12,0	12,0	13,0	83,0	30,0	11,4	0,1	2	■
JPD890100E3S.0Z2A	02791385	3	E	■	10,0	10,0	20,0	73,0	30,0	9,4	0,1	2	■
JPD890120E3S.0Z2A	02791387	3	E	■	12,0	12,0	20,0	83,0	30,0	11,4	0,1	2	■

■ **Lagerstandard.**

Schnittdaten – JPD890 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	415 (360 — 620) *1350 (1200 — 2000)*
TS3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (260 — 450) *1000 (860–1400)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	670 (560–770) *2200 (1900 — 2500)*
TP3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	580 (490 — 860) *1900 (1700 — 2800)*

Schnittdaten – JPD890 Nutfräsen

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	375 (320 — 550) *1225 (1100–1800)*
TS3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	225 (190 — 330) *740 (630–1000)*
TP2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	600 (500 — 690) *1975 (1700 — 2200)*
TP3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	420 (360 — 630) *1375 (1200 — 2000)*

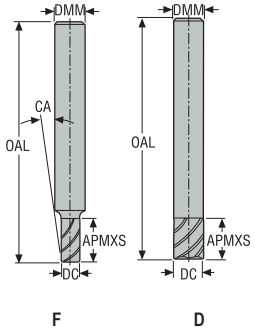
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

J93F

Allgemeine Bearbeitung – Kunststoff – Schaftfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide





- Toleranzen:
- DMM= h5
- DC= Ø1-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
93015-F	02605874	2	F	1,5	3,0	6,0	40,0	4,0	2	■
93020-F	02605888	2	F	2,0	3,0	9,0	40,0	2,5	2	■
93030-F	02606060	2	D	3,0	3,0	12,0	40,0	–	2	■
93040-F	02606061	2	D	4,0	4,0	14,0	50,0	–	2	■
93060-F	02606063	2	D	6,0	6,0	20,0	65,0	–	2	■
93080-F	02606064	2	D	8,0	8,0	20,0	70,0	–	2	■
93100-F	02606065	2	D	10,0	10,0	25,0	80,0	–	2	■
93120-F	02606066	2	D	12,0	12,0	25,0	90,0	–	2	■
93160-F	02606068	2	D	16,0	16,0	30,0	90,0	–	2	■
93L060-F	02606071	3	D	6,0	6,0	40,0	100,0	–	2	■
93L080-F	02606072	3	D	8,0	8,0	40,0	100,0	–	2	■
93L100-F	02606073	3	D	10,0	10,0	40,0	100,0	–	2	■
93L120-F	02606074	3	D	12,0	12,0	45,0	100,0	–	2	■
93L160-F	02606077	3	D	16,0	16,0	45,0	100,0	–	2	■
93L200-F	02606078	3	D	20,0	20,0	55,0	125,0	–	2	■
93XL120-F	02606079	4	D	12,0	12,0	30,0	150,0	–	2	■
93XL160-F	02606080	4	D	16,0	16,0	65,0	150,0	–	2	■
93XL200-F	02606081	4	D	20,0	20,0	65,0	150,0	–	2	■

■ **Lagerstandard.**

Schnittdaten – J93F Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	590 (480–710) *1925 (1600 — 2300)*
TP1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	570 (460 — 680) *1875 (1600 — 2200)*

Schnittdaten – J93F Nutfräsen

SMG		a_p/DC	f_z										v_c
			1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	500 (400 — 590) *1650 (1400–1900)*
TP1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	485 (390 — 580) *1600 (1300–1900)*

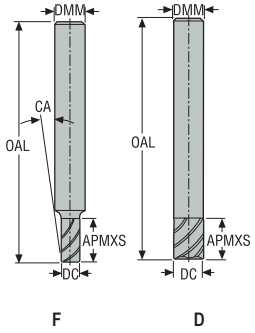
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

J28

Allgemeine Bearbeitung – Kunststoff – Schaftfräser – 1 Schneide – Zylindrisch – Scharfe Schneide





- Toleranzen:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø12= -0,02/-0,044 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CA	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm		
28030	00029353	2	D	3,0	3,0	10,0	40,0	–	1	■
28040	00029361	2	D	4,0	4,0	14,0	50,0	–	1	■
28050	00029363	2	D	5,0	5,0	16,0	60,0	–	1	■
28060	00029366	2	D	6,0	6,0	20,0	65,0	–	1	■
28080	00029369	2	D	8,0	8,0	25,0	75,0	–	1	■
28100	00029370	2	D	10,0	10,0	25,0	75,0	–	1	■
28120	00029372	2	D	12,0	12,0	25,0	75,0	–	1	■

■ **Lagerstandard.**

Schnittdaten – J28 Eckfräsen a_e/DC=0,4

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS1	A/D	0.300 *0,300*	1.5 *1,5*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	490 (370 — 610) *1600 (1300 — 2000)*

Schnittdaten – J28 Nutfräsen

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS1	A/D	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	400 (310 — 490) *1300 (1100–1600)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.



GRAPHIT

Die diamantbeschichteten Vollhartmetallfräser von Seco eignen sich speziell für die Bearbeitung von Graphit. Sie bieten eine deutlich längere Standzeit als herkömmliche Beschichtungen. Diese Werkzeuge mit optimiertem Substrat für perfekte Adhäsion der Beschichtung sind in einer Vielzahl an Geometrien in einem großen Durchmesserbereich verfügbar.

- JD620, JD630, JD640 und JME642 Schaftfräser mit Eckenradius
- JD660 und JMB642 Kugelkopffräser

Werkzeugauswahl Graphit

					
Werkzeugbezeichnung		JD620	JD630	JD640	JD660
Seite(n)		445	447	449	451
Produktfamilie		DIAMOND	DIAMOND	DIAMOND	DIAMOND
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
Schneidenzahl		2	3	4	2
ICC					
	Metrisch	3-12	3-8	6-12	3-6
	Zoll				
Verfügbare Längen					
		2,3,4	2,3,4	2,3,4	1,2,3,4,5
Bearbeitung					
					
					
SMG					
GR		●	●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

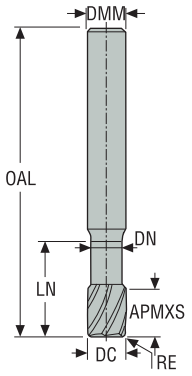
Werkzeugauswahl Graphit

			
Werkzeugbezeichnung		JME642	JMB642/JMB662
Seite(n)		453	455
Produktfamilie		MINI DIAMOND	MINI DIAMOND
Fräserausführung			
Auf-nahmen	Zylindrisch	■	■
	Weldon		
Schneidenzahl		2	2
ICC			
	Metrisch	0,2-2,0	0,2-3,0
	Zoll		
Verfügbare Längen			
		1,3,5,6,7	
Bearbeitung			
			
			
SMG			
GR		●	●

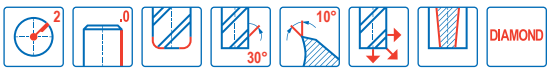
■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JD620

Diamond – Graphit – Schaftfräser – 2 Schneiden – Zylindrisch – Eckenradius



E





- Toleranzen:
- Rundlaufabweichung = <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
620V030R050-DIAMOND	00023425	2	E	3,0	3,0	5,0	60,0	30,0	2,85	0,5	2	■
620V040R050-DIAMOND	00023427	2	E	4,0	4,0	5,0	60,0	30,0	3,85	0,5	2	■
620V060R050-DIAMOND	00023429	2	E	6,0	6,0	10,0	80,0	40,0	5,8	0,5	2	■
620V080R050-DIAMOND	00023431	2	E	8,0	8,0	10,0	80,0	40,0	7,7	0,5	2	■
620V100R050-DIAMOND	00023435	2	E	10,0	10,0	10,0	80,0	40,0	9,7	0,5	2	■
620V120R050-DIAMOND	00023437	2	E	12,0	12,0	10,0	80,0	40,0	11,7	0,5	2	■
620VL060R050-DIAMOND	00023444	3	E	6,0	6,0	10,0	100,0	70,0	5,8	0,5	2	■
620VL080R050-DIAMOND	00023446	3	E	8,0	8,0	10,0	100,0	70,0	7,8	0,5	2	■
620VL080R100-DIAMOND	00023447	3	E	8,0	8,0	10,0	100,0	70,0	7,8	1,0	2	■
620VL100R050-DIAMOND	00023448	3	E	10,0	10,0	10,0	100,0	70,0	9,8	0,5	2	■
620VL100R100-DIAMOND	00023449	3	E	10,0	10,0	10,0	100,0	70,0	9,8	1,0	2	■
620VL120R050-DIAMOND	00023450	3	E	12,0	12,0	10,0	100,0	70,0	11,8	0,5	2	■
620VL120R100-DIAMOND	00023451	3	E	12,0	12,0	10,0	100,0	70,0	11,7	1,0	2	■
620VSL100R100-DIAMOND	00023452	4	E	10,0	10,0	10,0	150,0	100,0	9,8	1,0	2	■
620VSL120R100-DIAMOND	00023453	4	E	12,0	12,0	10,0	150,0	100,0	11,8	1,0	2	■

■ **Lagerstandard.**

Schnittdaten – JD620 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
GR1	D	0.500 *0,500*	0.50 *0,50*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	690 (580 — 800) *2275 (2000 — 2600)*

Schnittdaten – JD620 Nutfräsen

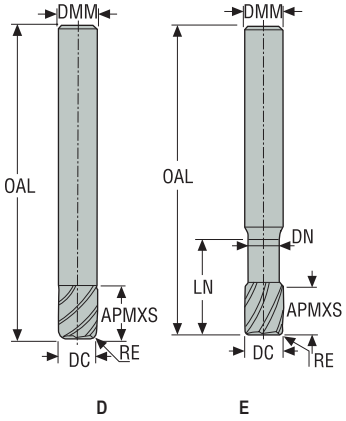
SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520–710) *2000 (1800 — 2300)*

Schnittdaten, siehe Seite 457 - 464

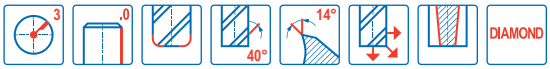
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JD630

Diamond – Graphit – Schaftfräser – 3 Schneiden – Zylindrisch – Eckenradius



D E





- Toleranzen:
- Rundlaufabweichung = <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
630030R015-DIAMOND	00023454	2	D	3,0	3,0	12,0	40,0	–	–	0,15	3	■
630040R020-DIAMOND	00023456	2	D	4,0	4,0	14,0	50,0	–	–	0,2	3	■
630050R030-DIAMOND	00023457	2	D	5,0	5,0	16,0	50,0	–	–	0,3	3	■
630060R030-DIAMOND	00023458	2	D	6,0	6,0	20,0	65,0	–	–	0,3	3	■
630080R050-DIAMOND	00023459	2	D	8,0	8,0	20,0	65,0	–	–	0,5	3	■
630V030R030-DIAMOND	00023464	3	E	3,0	3,0	5,0	40,0	15,0	2,9	0,3	3	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	3	■
630VL030R020-DIAMOND	00023467	4	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	■
630VL040R020-DIAMOND	00023470	4	E	4,0	4,0	5,0	60,0	30,0	3,9	0,2	3	■
630VL050R020-DIAMOND	00023471	4	E	5,0	5,0	6,0	70,0	40,0	4,9	0,2	3	■
630VL060R050-DIAMOND	00023472	4	E	6,0	6,0	10,0	100,0	60,0	5,9	0,5	3	■

■ **Lagerstandard.**

Schnittdaten – JD630 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	4	5	6	8	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	680 (580–790) *2225 (2000 — 2500)*

Schnittdaten – JD630 Nutfräsen

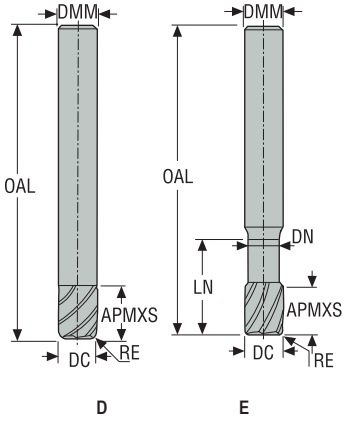
SMG		a_p/DC	f_z					v_c
			3	4	5	6	8	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	620 (520–720) *2025 (1800 — 2300)*

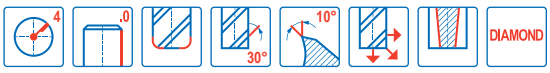
Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JD640

Diamond – Graphit – Schaftfräser – 4 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- Rundlaufabweichung = <0,01 mm
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
640100R050-DIAMOND	00023474	2	D	10,0	10,0	25,0	75,0	–	–	0,5	4	■
640120R050-DIAMOND	00023475	2	D	12,0	12,0	25,0	80,0	–	–	0,5	4	■
640V060R050-DIAMOND	00023479	3	E	6,0	6,0	10,0	80,0	40,0	5,9	0,5	4	■
640V080R050-DIAMOND	00023480	3	E	8,0	8,0	10,0	80,0	40,0	7,8	0,5	4	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	■
640V100R100-DIAMOND	00039781	3	E	10,0	10,0	12,0	80,0	40,0	9,8	1,0	4	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	■
640V120R100-DIAMOND	00023484	3	E	12,0	12,0	15,0	80,0	40,0	11,8	1,0	4	■
640VL080R100-DIAMOND	00023485	4	E	8,0	8,0	10,0	100,0	60,0	7,8	1,0	4	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	■
640VL100R100-DIAMOND	02462696	4	E	10,0	10,0	12,0	125,0	80,0	9,7	1,0	4	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	■
640VL120R100-DIAMOND	00023487	4	E	12,0	12,0	15,0	125,0	80,0	11,8	1,0	4	■

■ **Lagerstandard.**

Schnittdaten – JD640 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	680 (570–780) *2225 (1900 — 2500)*

Schnittdaten – JD640 Nutfräsen

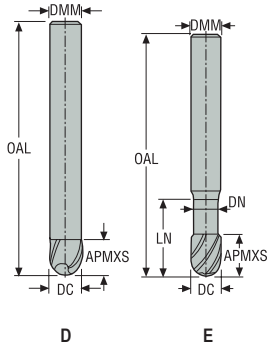
SMG		a_p/DC	f_z				v_c
			6	8	10	12	
GR1	D	0.50 *0,50*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520–710) *2000 (1800 — 2300)*

Schnittdaten, siehe Seite 457 - 464

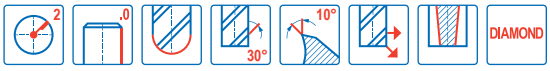
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

JD660

Diamond – Graphit – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- Rundlaufabweichung =<0,01 mm
- DMM=h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- B=0,9°

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm		
660030-DIAMOND	00023488	1	D	3,0	3,0	8,0	40,0	–	–	1,5	2	■
660040-DIAMOND	00023489	1	D	4,0	4,0	14,0	50,0	–	–	2,0	2	■
660060-DIAMOND	00023491	1	D	6,0	6,0	20,0	65,0	–	–	3,0	2	■
660V030-DIAMOND	00023501	2	E	3,0	3,0	6,0	40,0	15,0	2,9	1,5	2	■
660V040-DIAMOND	00023502	2	E	4,0	4,0	6,0	40,0	15,0	3,9	2,0	2	■
660V060-DIAMOND	00023505	2	E	6,0	6,0	10,0	65,0	35,0	5,9	3,0	2	■
660L030-DIAMOND	00023494	3	D	3,0	3,0	20,0	60,0	–	–	1,5	2	■
660L040-DIAMOND	00023496	3	D	4,0	4,0	30,0	60,0	–	–	2,0	2	■
660L060-DIAMOND	00023498	3	D	6,0	6,0	40,0	100,0	–	–	3,0	2	■
660VL030-DIAMOND	00023511	4	E	3,0	3,0	6,0	60,0	30,0	2,9	1,5	2	■
660VL040-DIAMOND	00023512	4	E	4,0	4,0	6,0	60,0	30,0	3,9	2,0	2	■
660VL060-DIAMOND	00023516	4	E	6,0	6,0	10,0	100,0	70,0	5,8	3,0	2	■

■ **Lagerstandard.**

Schnittdaten – JD660 Eckfräsen/Schruppen

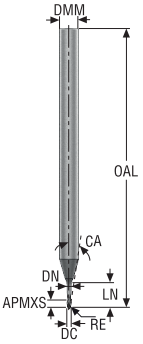
SMG		a_e/DC	a_p/DC	f_z			v_c
				3	4	6	
GR1	D	0.400 *0,400*	2.4 *2,4*	0.024 *0,00095*	0.032 *0,0013*	0.046 *0,0018*	920 (780–1000) *3025 (2600 — 3200)*

Schnittdaten, siehe Seite 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

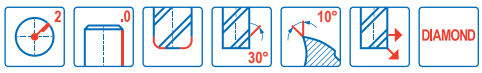
JME642

Mini – Graphit – Schaftfräser – Diamond – 2 Schneiden – DMM 4 – Zylindrisch – Eckenradius



G





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM= h5
- DC= 0/-0,015 mm
- RE= ±0,007 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JME642002G1R002.0Z2-DIA	03215524	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,02	2	14,32	0,59	0,65	0,72	0,78	0,84	0,95	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	2	14,1	0,74	0,81	0,87	0,94	1,0	1,11	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	2	11,67	2,29	2,44	2,57	2,68	2,78	2,96	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	2	10,97	2,83	3,0	3,13	3,25	3,36	3,56	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	2	10,31	3,33	3,52	3,67	3,8	3,92	4,13	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	2	9,31	4,33	4,57	4,74	4,89	5,02	5,25	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	2	8,04	5,33	5,61	5,81	5,97	6,12	6,37	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	2	7,09	6,33	6,65	6,87	7,05	7,2	7,46	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	2	5,8	7,99	8,29	8,52	8,71	8,87	9,36	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	2	4,11	10,53	10,88	11,22	11,55	11,99	12,87	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	2	4,11	10,49	10,87	11,13	11,35	11,53	12,48	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	2	9,43	4,33	4,57	4,74	4,89	5,03	5,26	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	2	8,5	5,33	5,61	5,81	5,98	6,12	6,37	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	2	7,02	7,33	7,68	7,92	8,12	8,28	8,72	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	2	6,06	8,33	9,23	9,5	9,71	9,89	10,59	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	2	5,23	10,33	10,78	11,07	11,3	11,5	12,46	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	2	4,25	12,49	12,92	13,22	13,32	13,84	14,99	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2	2,87	16,53	17,06	17,61	18,91	18,82	–	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2	2,87	16,49	17,02	17,36	17,77	18,45	–	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	2	4,86	12,33	12,84	13,16	13,4	13,81	14,96	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	2	3,13	18,49	19,07	19,43	19,99	20,76	22,49	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	2	1,97	25,49	26,21	26,78	27,77	28,83	–	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	2	1,68	30,49	31,03	32,13	33,32	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JME642/JME662 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.80 *0,80*	0.024 *0,00095*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	175 (130 — 370) *570 (430–1200)*

Schnittdaten – JME642 Nutfräsen

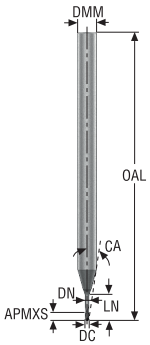
SMG		a_p/DC	f_z										v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.30 *0,30*	0.022 *0,00085*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	140 (110 — 300) *460 (370 — 980)*

Tabelle basierend auf LV3, auf Basis der gewählten Version neu berechnen. Siehe Seite(n). 457 - 464

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

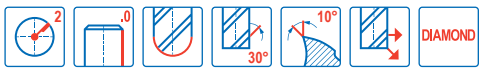
JMB642/JMB662

Mini – Graphit – Kugelkopf – Diamond – 2 Schneiden – DMM 4-6 – Zylindrisch



G





- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM= h5
- DC= 0/-0,015 mm
- RE= ±0,007 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	CA	WDX0	WDX05	WDX1	WDX15	WDX2	WDX3	Zylindrisch
				mm	mm	mm	mm	mm	mm	mm									
JMB642002G1B.0Z2-DIA	03215373	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,1	2	14,5	0,59	0,65	0,7	0,76	0,81	0,92	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	2	14,17	0,74	0,8	0,86	0,91	0,97	1,07	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	2	13,8	2,29	2,43	2,55	2,66	2,76	2,93	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	2	11,19	2,83	2,99	3,12	3,23	3,34	3,52	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	2	10,55	3,33	3,51	3,65	3,78	3,89	4,09	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	2	9,38	4,33	4,55	4,72	4,86	4,99	5,21	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	2	8,33	5,33	5,59	5,78	5,94	6,08	6,32	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	2	7,38	6,33	6,63	6,84	7,01	7,16	7,41	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	2	6,08	7,99	8,28	8,49	8,67	8,83	9,33	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	2	4,35	10,49	10,84	11,1	11,3	11,5	12,44	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	2	4,38	15,71	16,1	16,39	16,67	17,3	18,72	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	2	9,6	4,33	4,56	4,73	4,88	5,01	5,23	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	2	8,68	5,33	5,6	5,79	5,96	6,1	6,34	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	2	7,18	7,33	7,67	7,91	8,09	8,26	8,7	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	2	6,22	8,83	9,22	9,48	9,68	9,86	10,57	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	2	5,4	10,33	10,77	11,05	11,27	11,49	12,44	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	2	4,4	12,49	12,91	13,19	13,42	13,81	14,96	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2	2,99	16,49	17,0	17,33	17,75	18,42	19,94	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	2	3,0	24,71	25,28	25,73	26,67	27,68	29,97	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	2	4,96	12,33	12,83	13,14	13,38	13,8	14,94	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	2	3,21	18,49	19,05	19,41	19,97	20,74	22,45	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2	2,03	25,49	26,2	26,76	27,75	28,81	–	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	2	1,72	30,49	31,29	32,12	33,3	–	–	■

■ **Lagerstandard.**
Für WDX-Werte: Max. Schnitttiefe bezogen auf $\alpha\eta$ ($l\alpha\eta$, ref)*

Schnittdaten – JMB642/662 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

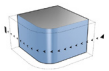
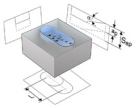
Schnittdaten – JMB642/662 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Tabelle basierend auf LV3, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 457 - 464

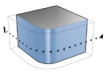
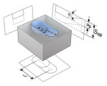
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (*sf/min*)
f_z = mm/Zahn (*Zoll/Zahn*)
a_p = mm/DC (*Zoll/DC*) = Faktor
a_e = mm/DC (*Zoll/DC*) = Faktor
Alle Schnittdaten sind Richtwerte.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Bohrzirkularfräsen			Bohren	
Zentral																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% von DC)	Bohrung Ø (≥ % von DC)	f_z	a_p (% von DC)
										≤ 30° *						
JS412																
LV2	100	100	100	100	100	140	3	40	120	80	100	50	10	130	50	100
										≤ 10° *						
JS413																
LV2	100	100	100	100	100	150	3	40	120	70	50	50	10	130	X	X
LV3	X	X	25	60	240	120	3	40	230	70	50	50	10	130	X	X
										≤ 30° *						
JS452																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 10° *						
JS453																
LV2	100	100	100	100	100	140	3	35	120	70	50	50	10	130	20	10
LV3	X	X	25	60	240	120	3	40	230	70	70	50	10	130	20	10
										≤ 30° *						
JSE512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	5	130	40	40
										≤ 5° *						
JSE513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	5	130	50	40
LV3	30	100	30	50	200	110	3	85	250	X	X	X	X	X	X	X
										≤ 5° *						
JSE514																
LV2	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV3	X	X	25	50	200	110	3	60	250	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
LV1	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV2	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV3	40	60	40	105	200	110	3	55	250	50	15	35	3	130	35	50
										≤ 5° *						
JS554																
LV1	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV2	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	53	250	50	50	60	3	130	X	X
JS564																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X

* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

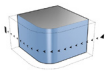
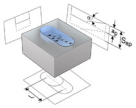
Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Bohrzirkularfräsen			Bohren	
Zentral																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% von DC)	Bohrung Ø (≥ % von DC)	f_z	a_p (% von DC)
										≤ 45° *						
J28 LV2	100	100	100	100	100	140	3	100	135	40	25	100	10	130	25	60
										≤ X° *						
J36 LV2	X	X	100	100	100	120	3	85	150	X	X	X	X	X	X	X
										≤ 20° *						
J93F LV2	100	100	100	100	100	133	3	40	100	100	100	100	3	130	25	30
										≤ 1°						
JH120 LV2	100	100	100	100	100	120	3	120	80	17	100	100	2	130	X	X
										≤ X° *						
JH130 LV2	X	X	100	100	100	120	3	120	80	X	X	X	X	X	X	X
										≤ X° *						
JH142 LV2	X	X	100	100	100	110	3	80	70	X	X	30	2	130	X	X
LV3	X	X	100	100	100	110	3	80	70	X	X	20	1	130	X	X
LV6	X	X	100	100	100	110	3	80	70	X	X	10	1	130	X	X
										≤ 45° *						
JH830 LV2	100	100	100	100	100	110	3	110	80	9	135	135	3	130	X	X
										≤ X° *						
JH910 LV2	100	100	100	100	100	125	4	100	80	15	140	140	3	130	X	X
LV3	80	80	100	80	80	125	4	80	65	10	110	110	3	130	X	X
										≤ X° *						
JH930 LV2	X	X	100	100	100	125	2	30	100	X	X	X	X	X	X	X

* Max. Einwärtskopierwinkel

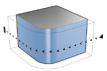
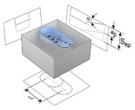
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
Zentral	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Bohrzirkularfräsen			Bohren	
																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% von DC)	Bohrung Ø (≥ % von DC)	f_z	a_p (% von DC)
										≤ 5° *						
JH40																
LV2	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
LV3	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
										≤ 45° *						
JH410																
LV2	100	100	100	100	100	125	2	25	100	100	67	67	40	130	67	80
LV2 (ML)	75	60	80	60	100	125	2	25	100	60	40	40	40	130	40	50
LV2 (TL)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV2 (RS)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV3 (RS)	95	95	80	100	100	100	2	100	100	50	50	50	40	130	75	40
										≤ 45° *						
JH421																
LV2	100	100	100	100	100	100	4	35	100	100	100	100	25	130	45	80
										≤ 30° *						
JH440																
LV2	100	100	100	100	100	125	3	40	100	100	100	100	5	130	X	X
										≤ 5° *						
JHP750																
LV1	115	120	115	115	100	100	2	145	100	100	120	120	3	130	10	70
LV2	100	100	100	100	100	100	2	145	100	100	100	100	3	130	10	60
										≤ 5° *						
JHP951																
LV2	100	100	100	100	100	158	2	50	113	20	100	125	3	130	6	20
										≤ 10° *						
JHP993																
LV2	100	100	100	100	100	X	X	X	X	30	100	100	3	130	4	40
LV3	80	80	80	80	80	X	X	X	X	20	80	80	3	130	3	30
										≤ X° *						
JS520																
LV2	X	X	100	100	100	133	2	65	100	X	X	X	X	X	X	X
LV3	X	X	X	X	X	133	2	65	175	X	X	X	X	X	X	X
										≤ X° *						
JS522																
LV4	X	X	100	100	100	129	2	140	100	X	X	X	X	X	X	X
JS720																
LV2	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
LV3	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
JS754																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	55	250	50	50	60	3	130		
JS755																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	100	110	3	55	250	50	50	60	3	130		

* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

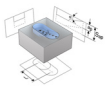
Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Eckfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Bohrzirkularfräsen			Bohren	
Zentral																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% von DC)	Bohrung Ø (≥ % von DC)	f_z	a_p (% von DC)
										≤ X°						
JME542-JME562-JME564																
LV1	100	100	100	100	100	125	2	150	5	X	X	X	X	X	X	X
LV2	63	100	100	100	65	125	2	150	3	X	X	X	X	X	X	X
LV3	25	100	100	100	25	125	2	150	1	X	X	X	X	X	X	X
LV4 (TL)	18	100	100	100	20	125	2	150	1	X	X	X	X	X	X	X
LV4 (XL)	12	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV5	10	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV6	4	100	100	100	5	125	2	150	1	X	X	X	X	X	X	X
LV7	2	100	100	100	2	125	2	150	1	X	X	X	X	X	X	X
										≤ X°						
JME142-JME144																
LV1	100	100	100	100	100	100	2	150	5	X	X	X	X	X	X	X
LV2	85	85	100	100	63	100	2	150	3	X	X	X	X	X	X	X
LV3	75	75	100	100	25	100	2	150	1	X	X	X	X	X	X	X
LV4	60	60	100	100	20	100	2	150	1	X	X	X	X	X	X	X
LV5	50	50	100	100	10	100	2	150	1	X	X	X	X	X	X	X
LV6	40	40	100	100	5	100	2	150	1	X	X	X	X	X	X	X
										≤ X° *						
JM403-JM404-JM406																
LV1	100	100	100	100	100	X	X	X	X	X	X	X	X	X	X	X
LV2	100	75	100	75	100	X	X	X	X	X	X	X	X	X	X	X
LV3 (L)	100	75	100	75	90	X	X	X	X	X	X	X	X	X	X	X
LV3 (TL)	90	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (XL)	75	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (SL)	75	75	100	75	45	X	X	X	X	X	X	X	X	X	X	X
LV5	50	50	100	50	30	X	X	X	X	X	X	X	X	X	X	X
JME642																
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
										≤2						
JC898																
LV3	X	X	100	100	100	X	X	X	X	X	50	80	3	130-160	X	X
										≤5°						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

* Max. Einwärtskopierwinkel

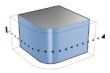
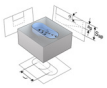
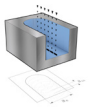
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
Zentral	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Bohrzirkularfräsen			Bohren	
																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% von DC)	Bohrung Ø (≥ % von DC)	f_z	a_p (% von DC)
										≤ 1°						
JHP170																
LV2	100	100	100	100	100	130	3	175	80	100	100	100	2	130	X	X
										≤ 30°						
JHP490																
LV2	100	100	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV2 (E-Form)	100	75	100	100	100	X	X	X	X	50	50	35	5	130	30	50
LV3	100	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
LV4	150	75	80	100	100	X	X	X	X	50	50	35	5	130	30	50
										≤ 5°						
JHP760																
LV2	100	100	100	100	100	140	2	125	15	30	100	100	3	130	10	50
LV3	50	50	100	50	50	140	2	125	15	15	50	50	3	130	5	25
										≤ 15°						
JHP770																
LV2	100	100	100	100	100	170	3	125	100	100	40	40	3	130	X	X
										≤ 5°						
JHP780																
LV1	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
LV2	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
JD620																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	20	100	60	100	60	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD630																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD640																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X

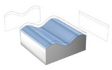
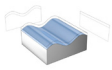
* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.								
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Bohrzirkularfräsen			Eintauchen			
Zentral																		
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% von DC)	Bohrung Ø (≥ % von DC)	v_c	a_e (% von DC)	f_z	a_e-sd (% von DC)
JHF181																		
LV1	100	100	100	100	100	X	X	X	X	X	X	100	3,4	130	X	X	X	X
LV2	80	85	100	85	80	X	X	X	X	X	X	85	3,0	130	X	X	X	X
LV3	60	70	100	70	60	X	X	X	X	X	X	70	2,5	130	X	X	X	X
										≤ 1,5° *								
JHF980																		
LV1	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV2	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV3	80	85	80	85	80	X	X	X	X	80	85	85	3	130	70	30	33	200
LV4	50	70	50	70	60	X	X	X	X	60	70	70	3	130	70	30	33	200

* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

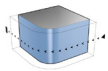
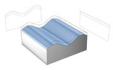
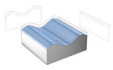
Berechnungen

Original-Schnittdaten einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.									
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Eckfräsen/Schruppen			Kopierfräsen/ Feinbearbeitung				Bohrzirkularfräsen		
KUGELKOPF																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	f_z	$a_p/360°$ (% von DC)	
JSB512																			
LV2	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	100	5	130
JS532																			
LV1	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV2	X	X	70	100	70	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV3	X	X	X	X	X	125	3	125	10	X	X	X	X	X	X	X	X	X	X
JS533																			
LV1	X	X	100	100	100	125	3	125	15	X	X	X	X	X	X	X	75	5	130
LV2	X	X	75	75	75	125	3	125	15	X	X	X	X	X	X	X	75	5	130
JS534																			
LV1	X	X	100	100	100	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV2	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV3	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
JHB970																			
LV1	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV3	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JHB720																			
LV2	X	X	100	100	100	125	2	90	75	X	X	X	X	X	X	X	40	3	130
JH112																			
LV1	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV2	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV3	X	X	100	100	100	110	1,6	55	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	130	1,4	55	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	130	1,4	50	100	X	X	X	X	X	X	X	X	X	X
LV6	X	X	100	100	100	130	1	35	100	X	X	X	X	X	X	X	X	X	X
JH150																			
LV2	X	X	100	100	100	165	1	90	35	X	X	X	X	X	X	X	30	2	130

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.									
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Eckfräsen/Schruppen			Kopierfräsen/ Feinbearbeitung				Bohrzirkularfräsen		
KUGELKOPF																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% von DC)	f_z	a_p	f_z	a_p/360° (% von DC)	
JH160																			
Standard (2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
JH450																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	45	5	130
JH460																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	X	X	X
JMB542-JMB562-JMB563																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	125	2	150	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	100	100	63	125	2	150	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	100	100	25	125	2	150	1	X	X	X
LV4 (TL)	20	100	X	X	X	X	X	X	X	100	100	19	125	2	150	1	X	X	X
LV4 (XL)	12	100	X	X	X	X	X	X	X	100	100	12	125	2	150	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	100	100	10	125	2	150	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	100	100	4	125	2	150	1	X	X	X
LV7	2	100	X	X	X	X	X	X	X	100	100	2	125	2	150	1	X	X	X
JMB112																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	118	2	120	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	64	85	85	118	2	120	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	56	75	75	118	2	120	1	X	X	X
LV4	20	100	X	X	X	X	X	X	X	45	60	60	118	2	120	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	38	50	50	118	2	120	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	30	40	40	118	2	120	1	X	X	X
JM413-JM416																			
LV1	X	X	100	100	100	100	5	40	35	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	60	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	80	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	60	75	100	5	40	10	X	X	X	X	X	X	X	X	X	X
JMB642																			
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
										≤2									
JD660																			
LV1	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Nomenklatur und Formeln

Drehzahl

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c} \quad (U/min)$$

Schnittgeschwindigkeit

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000} \quad (m/min)$$

Vorschub-geschwindigkeit

$$v_f = n \cdot z_n \cdot f_z \quad (mm/min)$$

Vorschub pro Umdrehung

$$f = z_n \cdot f_z \quad (mm/U)$$

Zeitspanvolumen

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000} \quad (cm^3/min)$$

Schnittgeschwindigkeit und Drehzahl für Kopierfräsen

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad (m/min)$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad (Drehzahl)$$

$$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad (mm)$$

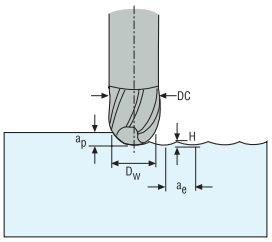
Berechnung von a_p abhängig von Auskraglänge:
Bei Auskraglänge länger als 4 x DC und Einsatz zylindrischer Schäfte muss die Schnitttiefe (a_p) neu berechnet werden.
Die neue Schnitttiefe ist nach folgender Formel zu berechnen: a_p (neu)

$a_p neu = a_p \times (4 \times DC/XS)^2$

Profilhöhe

$$H = \frac{D_c}{2} - \frac{\sqrt{D_c^2 - a_e^2}}{2}$$

$$D_W = 2 \cdot \sqrt{a_p (D_c - a_p)} \quad (mm)$$



Profilhöhe H (um)

DC	a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	1,90	4,20

a_p = Axiale Schnitttiefe (mm)
a_e = Radiale Schnitttiefe (Eingriffsbreite) (mm)
DC = Fräserdurchmesser
f = Vorschub/U (mm/U)
f_z = Vorschub/Zahn (mm/Zahn)
z_n = Zähnezahl
n = Drehzahl (U/min)
Q = Zeitspanvolumen (cm^3/min)
v_c = Schnittgeschwindigkeit (m/min)
v_f = Vorschubgeschwindigkeit (mm/min)
D_w = Wirkdurchmesser

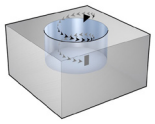
Zerspanungsempfehlungen

Einwärtskopieren

In nachstehender Tabelle finden Sie die Vorschubraten zu den entsprechenden Winkeln.

Empfohlene Bohrungsdurchmesser zum Bohrzirkularfräsen

Werkzeugdurchmesser DC	Bohrungsdurchmesser
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC

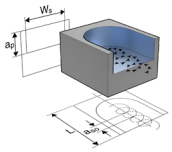


Trochoides Verfahren

Nachstehende Abbildung zeigt das sogenannte Trochoide Verfahren

Empfohlene Nutbreite

Werkzeugdurchmesser DC	Nutbreite
1-2,5	1,8 x DC
3-6	1,6 x DC
8-12	1,4 x DC
16-32	1,2 x DC





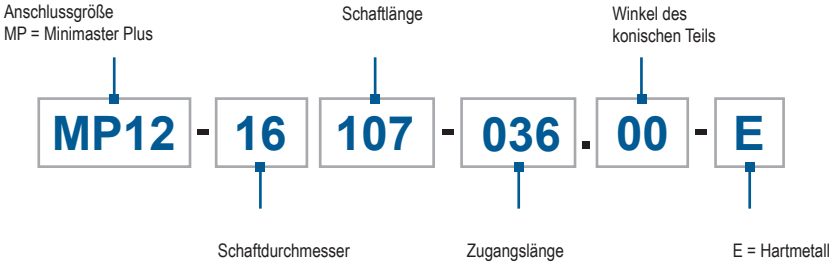
MINIMASTER™ PLUS

Minimaster Plus ist die nächste Generation des Wechselkopfsystems zum Fräsen. Der Schneidkopfwechsel erfolgt rasch, ohne dass der Schaft aus dem Halter bzw. aus der Maschine genommen oder die gesamte Anordnung neu eingemessen werden muss. Nach dem Wechsel des Schneidkopfes bleibt die axiale und radiale Position unverändert – für maximale Präzision.

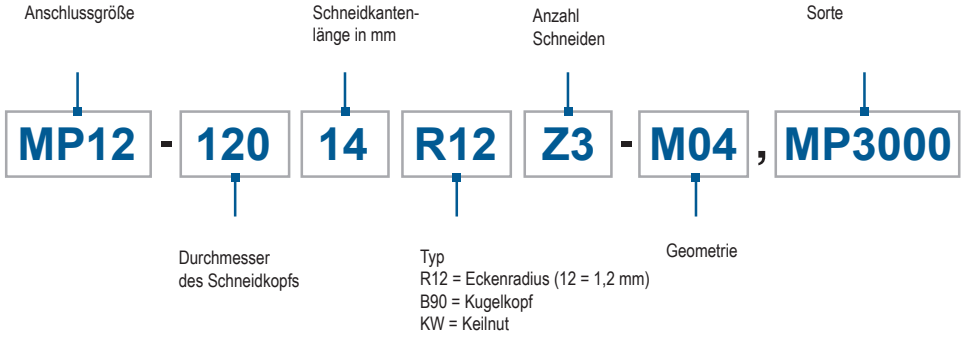
- Schaftfräser: 10 bis 16 mm (.375 - .625”)
- Kugelkopffräser: 10 bis 16 mm (.375 - .625”)
- Zentrier-/Anfasfräser: 10 bis 16 mm (.375 - .625”)
- Hochvorschubfräser: 10 bis 16 mm (.375 - .625”)

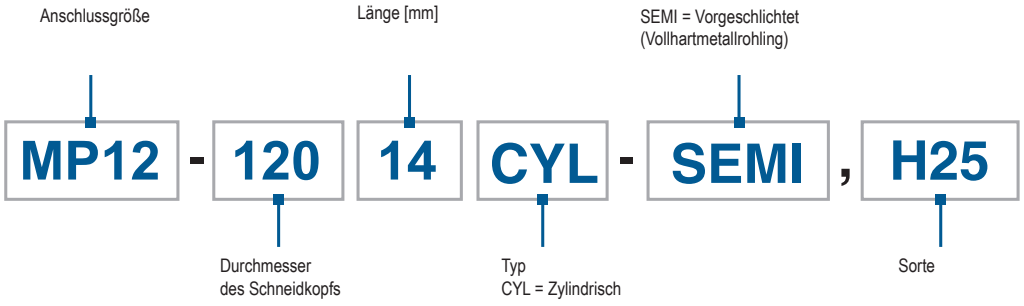
Code-Schlüssel

Code-Schlüssel – Aufnahmen



Code-Schlüssel – Schneidköpfe





Mit interner Kühlschmierstoffzufuhr



Auswahl

1. Anschlussgröße wählen
Die Ausführung des Werkstückes und die Bearbeitung entscheiden über die Anschlussgröße. Je größer der Anschlussdurchmesser, desto höher ist die Stabilität.

2. Schneidkopf wählen
a. Werkstoff anhand der Seco Werkstoff-Gruppen ab Seite 626 klassifizieren
b. Die gewählte Anschlussgröße den Katalogseiten entnehmen und den geeigneten Schneidkopf in der Auswahltabelle wählen.

3. Aufnahme wählen
a. Auf den Katalogseiten die geeignete Aufnahme auswählen.
b. Schneidkopf und Aufnahme müssen die gleiche Anschlussgröße haben. Je kürzer die Aufnahme, desto größer ist die Stabilität.

Achtung! Hartmetallschäfte eignen sich nur zum Schlichten und Vorschlichten.

4. Schnittdaten wählen
a. Die maximale axiale Schnitttiefe ist in der Tabelle Abmessungen angegeben. Die Schnittdatenempfehlungen basieren auf stabilen Arbeitsbedingungen und müssen daher je nach Stabilität der Bearbeitung (Werkzeugsystem, Maschine und Aufspannung) angepasst werden. Eine allgemeine Regel für die max. Schnitttiefe beim Nutfräsen ist DC*0.3= Max APMXS. (Siehe Abb. 1).
b. Empfehlungen zu Vorschub und Schnittgeschwindigkeit finden Sie ebenfalls in der Tabelle Abmessungen.
c. Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nie überschritten werden darf, ist auf Seite [XXX] angegeben
d. Wenn die radiale Schnitttiefe (Eingriffsbreite) geringer ist als der volle Schneiddurchmesser, müssen Vorschub/Zahn und Schnittgeschwindigkeit erhöht werden, um die Mittenspandicke und die Arbeitstemperatur konstant zu halten.
e. Den Prozentsatz für das Eingriffsverhältnis ermitteln: radiale Schnitttiefe durch den Durchmesser dividieren (bei Kopierfräsern ae/DC%), bei Kugelkopffräsern den effektiven Wirkdurchmesser Dw anstatt DC (siehe Abb. 2 & 6) verwenden
f. Die Tabelle Schnittdaten enthält Richtwerte für Vorschub/Zahn sowie den Korrekturfaktor für die Schnittgeschwindigkeit.

5. Allgemein
- Beim Fräsen an Ecken und Taschenboden vergrößert sich die Eingriffsbreite dramatisch. Der Vorschub muss reduziert werden, weil sonst die Mittenspandicke enorm zunimmt. Setzen Sie deshalb die Vorschubwerte für volle Eingriffsbreite ein
- Beim Bohrfräsen mit einem Kopierwinkel von 40° oder beim Ziehfräsen mit einem Kopierwinkel von 30° in Kombination mit einer geringen Schnitttiefe wird der Wirkdurchmesser Dw immer größer sein als die genannten Werte in der Tabelle. In diesem Falle für die Vorschubberechnung den Fräserdurchmesser DC als Wirkdurchmesser Dw einsetzen.
- Der ZEFP-Faktor ist die effektive Zähnezahl zur Berechnung von Vorschub und Vorschubgeschwindigkeit. Den ZEFP-Faktor finden Schnittdatenberechnung finden in der Tabelle Abmessungen.

Achtung! Beachten, dass bei höheren Vorschubwerten die Qualität der Werkstück-Oberfläche abnimmt. (Abb. 3& 5)

Minimaster Plus

Abb. 1

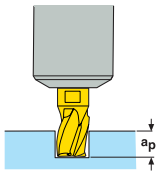


Abb. 2

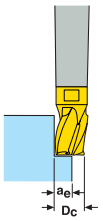


Abb. 3

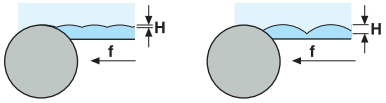


Abb. 4

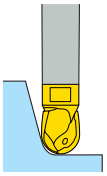


Abb. 5

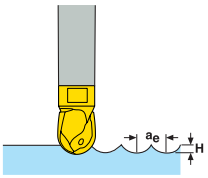
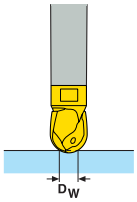
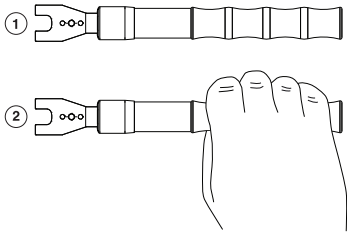
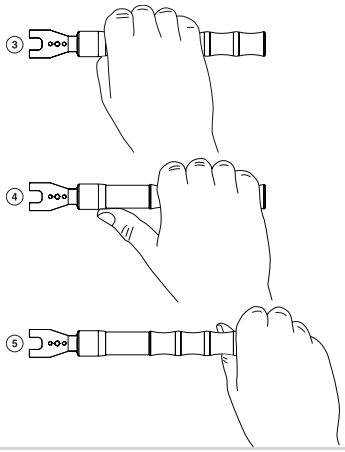


Abb. 6



Informationen zum Drehmomentschlüssel und Bedienungsanweisung

Drehmomentschlüssel	
	Zum Spannen des Schneidkopfes empfehlen wir einen Drehmomentschlüssel für höchste Präzision und höhere Lebensdauer. Unterschiedliche Drehmomente für Aufspannung: – MP10: 11 Nm – MP12: 15 Nm – MP16: 19 Nm Keine verschlissenen Schlüssel verwenden. Beachten Sie Folgendes: Drehmoment- und Standard-Schlüssel bitte separat bestellen.
	Nehmen Sie den Schlüsselgriff wie dargestellt (Abb. 1) in die Hand (Abb. 2).
	Beachten Sie den korrekten Ansatz des Schlüssels. Verwenden Sie den Schlüssel nicht wie auf Abb. 3-5, da ein falsches Drehmoment einen nicht ordnungsgemäßen Einsatz des Schneidkopfes verursachen kann.

MP10 Schaft – Metrisch



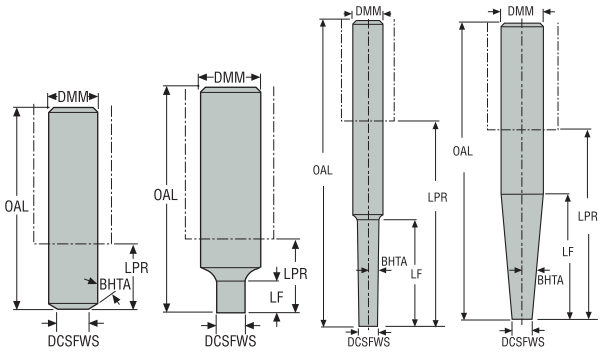
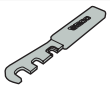
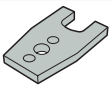


Abb. 1 **Abb. 2** **Abb. 3** **Abb. 4**

- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen.

Bezeichnung	Aufnahme	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Abb.		Gewicht
		mm	mm	mm	mm	mm					kg
MP10-10055-010.00	Zylindrisch	9,8	10,0	55,0	15,0	10,0	80000	0,0	2	✓	0,1
MP10-16068-000.60	Zylindrisch	9,5	16,0	68,0	20,0	0,0	80000	60,0	1	✓	0,2
MP10-16073-015.00	Zylindrisch	9,8	16,0	73,0	25,0	15,0	80000	0,0	2	✓	0,1
MP10-16118-035.01	Zylindrisch	9,5	16,0	118,0	70,0	35,0	80000	1,0	3	✓	0,2
MP10-16158-060.01	Zylindrisch	9,5	16,0	158,0	110,0	60,0	80000	1,0	3	✓	0,2
MP10-20100-045.03	Zylindrisch	9,5	20,0	100,0	50,0	45,0	80000	3,0	3	✓	0,2
MP10-20140-085.03	Zylindrisch	9,5	20,0	140,0	90,0	85,0	80000	3,0	3	✓	0,3
MP10-20140-090.05	Zylindrisch	9,5	20,0	140,0	90,0	60,0	80000	5,0	4	✓	0,3
MP10-12095-030.00-E	Zylindrisch	9,8	12,0	95,0	50,0	30,0	80000	0,0	2	✓	0,2
MP10-12105-040.00-E	Zylindrisch	9,8	12,0	105,0	60,0	40,0	80000	0,0	2	✓	0,2
MP10-12125-060.00-E	Zylindrisch	9,8	12,0	125,0	80,0	60,0	80000	0,0	2	✓	0,2
MP10-16120-050.01-E	Zylindrisch	9,5	16,0	120,0	72,0	50,0	80000	1,0	3	✓	0,3
MP10-16150-080.01-E	Zylindrisch	9,5	16,0	150,0	102,0	80,0	80000	1,0	3	✓	0,3
MP10-16170-100.01-E	Zylindrisch	9,5	16,0	170,0	122,0	100,0	80000	1,0	3	✓	0,4
MP10-16140-092.03-E	Zylindrisch	9,5	16,0	140,0	92,0	62,0	80000	3,0	4	✓	0,4
MP10-16170-122.03-E	Zylindrisch	9,5	16,0	170,0	122,0	62,0	80000	3,0	4	✓	0,4

Zubehör

Schlüssel	Ersatzklinge	Drehmoment-schlüssel
		
MP1016	MP00-10M	MP00-10.110

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten.

MP10 Schaft – Zoll

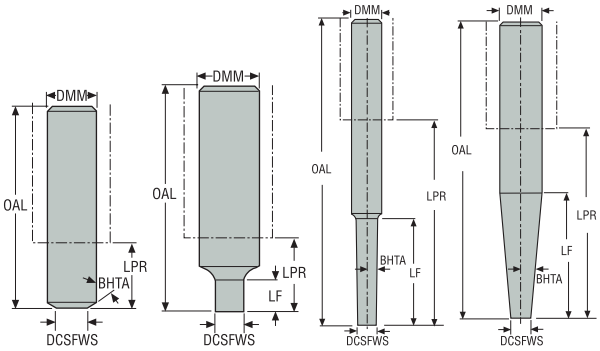


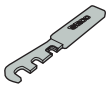
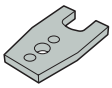
Abb. 1 **Abb. 2** **Abb. 3** **Abb. 4**



- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen.

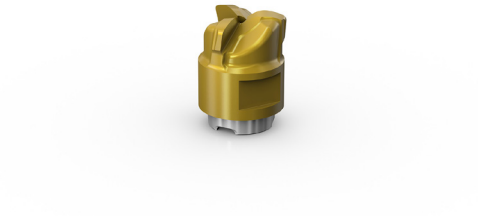
Bezeichnung	Aufnahme	DCSFMS	DMM	OAL	LPR	LF	RPMX	BHTA°	Abb.		Gewicht
		Zoll	Zoll	Zoll	Zoll	Zoll					lbs
MP10-0372.1-0.39.00	Zylindrisch	0.370	0.375	2.122	0.591	0.394	80000	0,0	2	✓	0.220
MP10-0622.6-0.00.60	Zylindrisch	0.374	0.625	2.662	0.787	0	80000	60,0	1	✓	0.220
MP10-0622.8-0.59.00	Zylindrisch	0.370	0.625	2.859	0.984	0.591	80000	0,0	2	✓	0.220
MP10-0624.6-1.37.01	Zylindrisch	0.374	0.625	4.631	2.756	1.378	80000	1,0	3	✓	0.440
MP10-0626.2-2.36.01	Zylindrisch	0.374	0.625	6.206	4.331	2.362	80000	1,0	3	✓	0.440
MP10-0753.9-1.80.03	Zylindrisch	0.374	0.750	3.969	1.969	1.799	80000	3,0	3	✓	0.440
MP10-0755.5-3.40.03	Zylindrisch	0.374	0.750	5.543	3.543	3.402	80000	3,0	4	✓	0.660
MP10-0755.5-3.54.05	Zylindrisch	0.374	0.750	5.543	3.543	2.150	80000	5,0	4	✓	0.660
MP10-0504.8-2.36.00-E	Zylindrisch	0.370	0.500	4.900	3.150	2.362	80000	0,0	2	✓	0.440

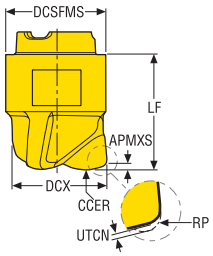
Zubehör

Schlüssel	Ersatzklinge	Drehmoment-schlüssel
		
MP1016	MP00-10M	MP00-10.110

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten.

MP10 Hochvorschubfräser





• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 482-483

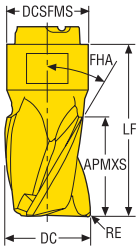
Z3



Bezeichnung	DCX	DC	APMXS	DCSFMS	CCER	RP	LF	UTCN	RMPX°	C min	C max	ZEFP		Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						MP3000	F40M
MP10-1000.6HFZ3-MD08	10,0 *0.394*	5,0 *0.197*	0,6 *0.024*	9,6 *0.378*	6,2 *0.244*	1,13 *0.044*	11,0 *0.433*	0,32 *0.013*	5,0	10,9	14,8	3	✓	■	
MP10-0950.6HFZ3-MD08	9,525 *0.375*	4,55 *0.179*	0,6 *0.024*	9,4 *0.370*	6,2 *0.244*	1,13 *0.044*	11,0 *0.433*	0,32 *0.013*	5,0	10,4	13,4	3	✓	■	

MP10 Eckfräser

Nut- und Konturfräsen





• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 484-485

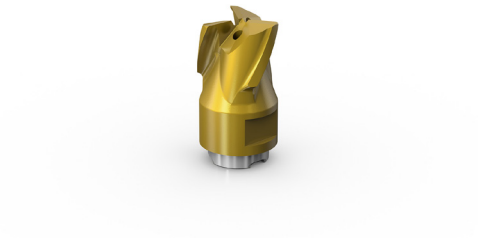
Z3

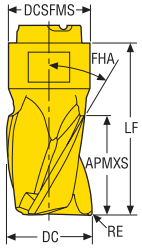


Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	RMPX°	C min	C max	ZEFP		Sorten	
												Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							MP3000	F40M
MP10-09807KWZ3-E03	9,8 *0.386*	7,0 *0.276*	0,3 *0.012*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,0	18,8	3	✓		■
MP10-10007R04Z3-E03	10,0 *0.394*	7,0 *0.276*	0,4 *0.016*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	19,0	3	✓		■
MP10-10007R04Z3-M03	10,0 *0.394*	7,0 *0.276*	0,4 *0.016*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	19,0	3	✓	■	
MP10-10007R05Z3-E03	10,0 *0.394*	7,0 *0.276*	0,5 *0.020*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	18,8	3	✓		■
MP10-10007R08Z3-E03	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	18,2	3	✓		■
MP10-10007R08Z3-M03	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	18,2	3	✓	■	
MP10-10007R20Z3-E03	10,0 *0.394*	7,0 *0.276*	2,0 *0.079*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	15,8	3	✓		■
MP10-10007R31Z3-E03	10,0 *0.394*	7,0 *0.276*	3,1 *0.122*	9,6 *0.378*	16,0 *0.630*	30	15,0	12,2	13,6	3	✓		■

MP10 Eckfräser

Nut- und Konturfräsen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 484-485

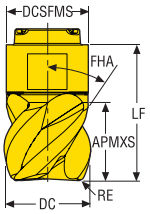
Z3



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	RMPX°	C min	C max	ZEFP		Sorten	
												Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							MP3000	F40M
MP10-09812KWZ3-E03	9,8 *0.386*	12,0 *0.472*	0,3 *0.012*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,0	18,8	3	✓		■
MP10-10012R04Z3-E03	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	19,0	3	✓		■
MP10-10012R04Z3-M03	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	19,0	3	✓	■	
MP10-10012R05Z3-E03	10,0 *0.394*	12,0 *0.472*	0,5 *0.020*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	18,8	3	✓		■
MP10-10012R08Z3-E03	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	18,2	3	✓		■
MP10-10012R08Z3-M03	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	18,2	3	✓	■	
MP10-10012R20Z3-E03	10,0 *0.394*	12,0 *0.472*	2,0 *0.079*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	15,8	3	✓		■
MP10-10012R31Z3-E03	10,0 *0.394*	12,0 *0.472*	3,1 *0.122*	9,6 *0.378*	21,0 *0.827*	30	15,0	12,2	13,6	3	✓		■
MP10-09512R04Z3-E03	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	18,0	3	✓		■
MP10-09512R04Z3-M03	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	18,0	3	✓	■	
MP10-09512R08Z3-E03	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	17,2	3	✓		■
MP10-09512R08Z3-M03	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	17,2	3	✓	■	
MP10-09512R16Z3-E03	9,525 *0.375*	12,0 *0.472*	1,6 *0.063*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	15,6	3	✓		■
MP10-09512R31Z3-E03	9,525 *0.375*	12,0 *0.472*	3,1 *0.122*	9,6 *0.378*	21,0 *0.827*	30	15,0	11,6	12,6	3	✓		■

MP10 Eckfräser

Nut- und Konturfräsen





• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 484-485

Z4

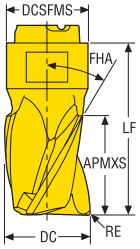


Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	RMPX°	ZEFP	Sorten	
									Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP10-10007R04Z4-M02	10,0 *0.394*	7,0 *0.276*	0,4 *0.016*	9,6 *0.378*	16,0 *0.630*	50	15,0	4	■	
MP10-10007R05Z4-E02	10,0 *0.394*	7,0 *0.276*	0,5 *0.020*	9,6 *0.378*	16,0 *0.630*	50	15,0	4		■
MP10-10007R08Z4-E02	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	50	15,0	4		■
MP10-10007R08Z4-M02	10,0 *0.394*	7,0 *0.276*	0,8 *0.031*	9,6 *0.378*	16,0 *0.630*	50	15,0	4	■	
MP10-10007R16Z4-E02	10,0 *0.394*	7,0 *0.276*	1,6 *0.063*	9,6 *0.378*	16,0 *0.630*	50	15,0	4		■
MP10-10012R04Z4-E02	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-10012R04Z4-M02	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	
MP10-10012R05Z4-E02	10,0 *0.394*	12,0 *0.472*	0,5 *0.020*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-10012R08Z4-E02	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-10012R08Z4-M02	10,0 *0.394*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	
MP10-10012R16Z4-E02	10,0 *0.394*	12,0 *0.472*	1,6 *0.063*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-09512R04Z4-E02	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-09512R04Z4-M02	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	
MP10-09512R08Z4-E02	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4		■
MP10-09512R08Z4-M02	9,525 *0.375*	12,0 *0.472*	0,8 *0.031*	9,6 *0.378*	21,0 *0.827*	50	15,0	4	■	

MP10 Eckfräser

Nur Konturfräsen





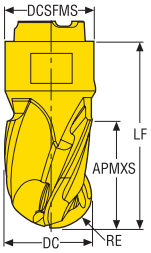
- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 484-485

Z5



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	ZEFP		Sorten	
									Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP10-10012R04Z5-M02	10,0 *0.394*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	40	5		■	
MP10-09512R04Z5-M02	9,525 *0.375*	12,0 *0.472*	0,4 *0.016*	9,6 *0.378*	21,0 *0.827*	40	5		■	

MP10 Kugelkopffräser





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 486-487

Z3



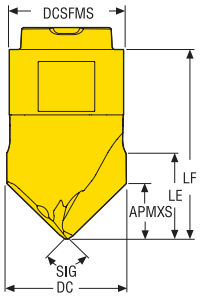
Z4



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	RMPX°	ZEFP		Sorten	
										Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					MP3000	F40M
MP10-10007B90Z3-E03	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	30	15,0	3	✓		■
MP10-10007B90Z3-M03	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	30	15,0	3	✓	■	
MP10-10012B90Z3-E03	10,0 *0.394*	12,0 *0.472*	5,0 *0.197*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓		■
MP10-10012B90Z3-M03	10,0 *0.394*	12,0 *0.472*	5,0 *0.197*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓	■	
MP10-10007B90Z4-E02	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	20	15,0	4			■
MP10-10007B90Z4-M02	10,0 *0.394*	7,0 *0.276*	5,0 *0.197*	9,6 *0.378*	16,0 *0.630*	20	15,0	4		■	
MP10-09507B90Z3-E03	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	30	15,0	3	✓		■
MP10-09507B90Z3-M03	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	30	15,0	3	✓	■	
MP10-09512B90Z3-E03	9,525 *0.375*	12,0 *0.472*	4,7625 *0.188*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓		■
MP10-09512B90Z3-M03	9,525 *0.375*	12,0 *0.472*	4,7625 *0.188*	9,6 *0.378*	21,0 *0.827*	30	15,0	3	✓	■	
MP10-09507B90Z4-E02	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	20	15,0	4			■
MP10-09507B90Z4-M02	9,525 *0.375*	7,0 *0.276*	4,7625 *0.188*	9,4 *0.370*	16,0 *0.630*	20	15,0	4		■	

MP10 Zentrierbohren/Anfasen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 488-489

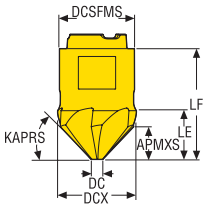
Z2



Bezeichnung	DC	APMXS	DCSFMS	LE	LF	SIG°	ZEFP		Sorten	
									Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP10-10006C90Z2-M03	10,0 *0.394*	4,6 *0.181*	9,6 *0.378*	7,1 *0.280*	16,0 *0.630*	90,0	2	✓		■

MP10 Anfasen





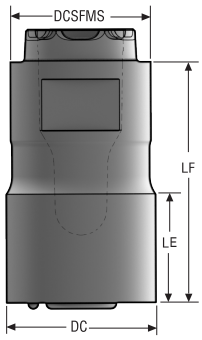
- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 490-491

Z6



Bezeichnung	DCX	DC	APMXS	DCSFMS	LE	LF	KAPRS°	ZEFP		Sorten	
										Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP10-10006C90Z6-M03	10,1 *0.398*	1,95 *0.077*	4,0 *0.157*	9,6 *0.378*	5,9 *0.232*	14,5 *0.571*	45,0	6			■

MP10 Zylindrische Rohlinge





- Zylindrische Hartmetall-Rohlinge zur Herstellung eigener Geometrien





Bezeichnung	DC	DCSFMS	LE	LF	Sorten
					Unbeschichtet
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	H25
MP10-10007CYL-SEMI	10,15 *0.400*	9,6 *0.378*	7,3 *0.287*	16,3 *0.642*	■
MP10-10012CYL-SEMI	10,15 *0.400*	9,6 *0.378*	12,4 *0.488*	21,3 *0.839*	■

MP10 Hochvorschubfräsen – Auswahl der Wendeschneidplatten – mm/*Zoll*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
P3	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,70 *0.028*
P4	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,44 *0.017*	0,44 *0.017*	0,55 *0.022*	0,70 *0.028*
P5	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P6	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P7	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P8	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,70 *0.028*
P11	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
P12	MP10-0950.6HFZ3-MD08 MP3000	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
M2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
M3	MP10-1000.6HFZ3-MD08 MP3000	0,34 *0.013*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
M4	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M5	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,46 *0.018*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
K2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K3	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K4	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K5	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,38 *0.015*	0,38 *0.015*	0,50 *0.020*	0,60 *0.024*
K6	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,70 *0.028*
K7	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,38 *0.015*	0,38 *0.015*	0,50 *0.020*	0,60 *0.024*
N1	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
N2	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
N3	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
N11	MP10-1000.6HFZ3-MD08 MP3000	0,42 *0.017*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
S1	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S2	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S3	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,30 *0.012*	0,28 *0.011*	0,36 *0.014*	0,44 *0.017*
S11	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S12	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S13	MP10-1000.6HFZ3-MD08 MP3000	0,25 *0.010*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
H5	MP10-1000.6HFZ3-MD08 MP3000	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
H8	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*	0,34 *0.013*
H11	MP10-1000.6HFZ3-MD08 MP3000	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
H12	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*	0,34 *0.013*
H21	MP10-1000.6HFZ3-MD08 MP3000	0,30 *0.012*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*	0,34 *0.013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP10 Hochvorschubfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	MP3000			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	355 *1175*	370 *1225*
P2	245 *800*	295 *970*	345 *1125*	360 *1175*
P3	215 *710*	260 *850*	295 *970*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	245 *800*	285 *940*	295 *970*
P7	190 *620*	235 *770*	270 *890*	280 *920*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	225 *740*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	185 *610*	220 *720*	255 *840*	270 *890*
M2	150 *490*	185 *610*	210 *690*	220 *720*
M3	120 *395*	145 *475*	170 *560*	180 *590*
M4	95 *310*	115 *375*	130 *425*	140 *460*
M5	80 *260*	95 *310*	110 *360*	115 *375*
K1	195 *640*	235 *770*	275 *900*	285 *940*
K2	170 *560*	210 *690*	240 *790*	250 *820*
K3	145 *475*	175 *570*	205 *670*	215 *710*
K4	140 *460*	170 *560*	195 *640*	205 *670*
K5	85 *280*	105 *345*	120 *395*	125 *410*
K6	120 *395*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1450 *4750*	1750 *5750*	2025 *6650*	2100 *6900*
N2	580 *1900*	710 *2325*	810 *2650*	850 *2800*
N3	390 *1275*	470 *1550*	540 *1775*	570 *1875*
N11	445 *1450*	540 *1775*	620 *2025*	650 *2125*
S1	45 *150*	55 *180*	60 *195*	65 *215*
S2	36 *120*	42 *140*	49 *160*	50 *165*
S3	31 *100*	37 *120*	43 *140*	45 *150*
S11	60 *195*	75 *245*	85 *280*	90 *295*
S12	43 *140*	50 *165*	60 *195*	60 *195*
S13	25 *80*	30 *100*	34 *110*	36 *120*
H5	37 *120*	45 *150*	50 *165*	55 *180*
H8	39 *130*	47 *155*	55 *180*	60 *195*
H11	48 *155*	55 *180*	65 *215*	70 *230*
H12	75 *245*	90 *295*	105 *345*	110 *360*
H21	39 *130*	47 *155*	55 *180*	60 *195*

MP10 Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	30%	10%	5%
P1	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,10 *0.0040*
P2	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*
P3	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 *0.0038*
P4	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,044 *0.0017*	0,065 *0.0026*	0,095 *0.0038*
P5	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P6	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,038 *0.0015*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P7	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,038 *0.0015*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P8	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 *0.0038*
P11	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,038 *0.0015*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
P12	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,026 *0.0010*	0,030 *0.0012*	0,044 *0.0017*	0,060 *0.0024*
M1	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*
M2	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
M3	MP10-10007R04Z3-E03 F40M	2,5 *0.10*	0,032 *0.0013*	0,034 *0.0013*	0,055 *0.0022*	0,075 *0.0030*
M4	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
M5	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
K1	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*
K2	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K3	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K4	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K5	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
K6	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,065 *0.0026*	0,090 *0.0036*
K7	MP10-10007R04Z3-M03 MP3000	3,5 *0.14*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
N1	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
N2	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
N3	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
N11	MP10-10007R04Z3-E03 F40M	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
S1	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
S2	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
S3	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,026 *0.0010*	0,028 *0.0011*	0,042 *0.0017*	0,060 *0.0024*
S11	MP10-10007R04Z3-E03 F40M	2,5 *0.10*	0,032 *0.0013*	0,034 *0.0013*	0,055 *0.0022*	0,075 *0.0030*
S12	MP10-10007R04Z3-E03 F40M	2,5 *0.10*	0,032 *0.0013*	0,034 *0.0013*	0,055 *0.0022*	0,075 *0.0030*
S13	MP10-10007R04Z3-E03 F40M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
H5	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,026 *0.0010*	0,030 *0.0012*	0,044 *0.0017*	0,060 *0.0024*
H8	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00085*	0,034 *0.0013*	0,048 *0.0019*
H11	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,026 *0.0010*	0,030 *0.0012*	0,044 *0.0017*	0,060 *0.0024*
H12	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00085*	0,034 *0.0013*	0,048 *0.0019*
H21	MP10-10007R04Z3-M03 MP3000	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00085*	0,034 *0.0013*	0,048 *0.0019*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP10 Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M			
	100%	30%	10%	5%	100%	30%	10%	5%
P1	265 *870*	345 *1125*	405 *1325*	435 *1425*	250 *820*	325 *1075*	380 *1250*	410 *1350*
P2	255 *840*	335 *1100*	395 *1300*	425 *1400*	240 *790*	315 *1025*	370 *1225*	400 *1300*
P3	225 *740*	290 *950*	340 *1125*	365 *1200*	210 *690*	275 *900*	320 *1050*	345 *1125*
P4	195 *640*	255 *840*	300 *980*	325 *1075*	185 *610*	240 *790*	285 *940*	305 *1000*
P5	190 *620*	245 *800*	290 *950*	310 *1025*	175 *570*	235 *770*	270 *890*	295 *970*
P6	215 *710*	275 *900*	325 *1075*	350 *1150*	200 *660*	260 *850*	305 *1000*	330 *1075*
P7	200 *660*	260 *850*	305 *1000*	330 *1075*	190 *620*	245 *800*	290 *950*	310 *1025*
P8	190 *620*	245 *800*	285 *940*	310 *1025*	175 *570*	230 *750*	270 *890*	290 *950*
P11	195 *640*	255 *840*	295 *970*	320 *1050*	185 *610*	240 *790*	280 *920*	305 *1000*
P12	125 *410*	160 *520*	185 *610*	200 *660*	115 *375*	150 *490*	175 *570*	190 *620*
M1	190 *620*	250 *820*	295 *970*	315 *1025*	195 *640*	255 *840*	300 *980*	320 *1050*
M2	155 *510*	205 *670*	240 *790*	260 *850*	160 *520*	210 *690*	245 *800*	265 *870*
M3	125 *410*	165 *540*	190 *620*	205 *670*	125 *410*	165 *540*	195 *640*	210 *690*
M4	95 *310*	125 *410*	145 *475*	155 *510*	100 *330*	125 *410*	145 *475*	160 *520*
M5	80 *260*	105 *345*	120 *395*	130 *425*	80 *260*	105 *345*	125 *410*	135 *445*
K1	200 *660*	265 *870*	310 *1025*	335 *1100*	190 *620*	250 *820*	295 *970*	315 *1025*
K2	180 *590*	235 *770*	275 *900*	295 *970*	170 *560*	220 *720*	260 *850*	280 *920*
K3	150 *490*	200 *660*	230 *750*	250 *820*	140 *460*	185 *610*	220 *720*	235 *770*
K4	145 *475*	190 *620*	220 *720*	240 *790*	135 *445*	180 *590*	210 *690*	225 *740*
K5	85 *280*	115 *375*	135 *445*	145 *475*	80 *260*	110 *360*	125 *410*	135 *445*
K6	125 *410*	165 *540*	195 *640*	210 *690*	120 *395*	155 *510*	185 *610*	200 *660*
K7	110 *360*	145 *475*	170 *560*	185 *610*	105 *345*	140 *460*	160 *520*	175 *570*
N1	1525 *5000*	2000 *6550*	2350 *7700*	2525 *8275*	1450 *4750*	1875 *6150*	2225 *7300*	2375 *7800*
N2	620 *2025*	810 *2650*	950 *3125*	1025 *3375*	580 *1900*	760 *2500*	900 *2950*	960 *3150*
N3	410 *1350*	540 *1775*	630 *2075*	680 *2225*	390 *1275*	510 *1675*	600 *1975*	640 *2100*
N11	470 *1550*	610 *2000*	720 *2350*	780 *2550*	445 *1450*	580 *1900*	680 *2225*	730 *2400*
S1	45 *150*	60 *195*	70 *230*	75 *245*	46 *150*	60 *195*	70 *230*	75 *245*
S2	36 *120*	47 *155*	55 *180*	60 *195*	37 *120*	48 *155*	55 *180*	60 *195*
S3	31 *100*	41 *135*	47 *155*	50 *165*	32 *105*	42 *140*	48 *155*	50 *165*
S11	65 *215*	80 *260*	95 *310*	105 *345*	65 *215*	85 *280*	100 *330*	105 *345*
S12	44 *145*	55 *180*	65 *215*	70 *230*	45 *150*	60 *195*	70 *230*	75 *245*
S13	25 *80*	33 *110*	38 *125*	41 *135*	26 *85*	33 *110*	39 *130*	42 *140*
H5	38 *125*	49 *160*	60 *195*	60 *195*	39 *130*	50 *165*	60 *195*	65 *215*
H8	40 *130*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	60 *195*	65 *215*
H11	49 *160*	65 *215*	75 *245*	80 *260*	49 *160*	65 *215*	75 *245*	80 *260*
H12	75 *245*	100 *330*	115 *375*	125 *410*	70 *230*	95 *310*	110 *360*	115 *375*
H21	40 *130*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	60 *195*	65 *215*

MP10 Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z				
			100%	30%	10%	5%	2%
P1	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,17 *0.0065*
P2	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*	0,17 *0.0065*
P3	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,046 *0.0018*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P4	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,046 *0.0018*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P5	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P6	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P7	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P8	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,046 *0.0018*	0,048 *0.0019*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P11	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P12	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
M1	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*	0,17 *0.0065*
M2	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
M3	MP10-10007B90Z3-E03 F40M	2,5 *0.10*	0,038 *0.0015*	0,038 *0.0015*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
M5	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
K1	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*	0,17 *0.0065*
K2	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K3	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K4	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K5	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
K6	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,044 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
K7	MP10-10007B90Z3-M03 MP3000	3,5 *0.14*	0,040 *0.0016*	0,042 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N1	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N2	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N3	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N11	MP10-10007B90Z3-E03 F40M	3,5 *0.14*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
S1	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
S2	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
S3	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,032 *0.0013*	0,032 *0.0013*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
S11	MP10-10007B90Z3-E03 F40M	2,5 *0.10*	0,038 *0.0015*	0,038 *0.0015*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MP10-10007B90Z3-E03 F40M	2,5 *0.10*	0,038 *0.0015*	0,038 *0.0015*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MP10-10007B90Z3-E03 F40M	2,0 *0.080*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
H5	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H8	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,025 *0.0010*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,080 *0.0032*
H11	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H12	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,025 *0.0010*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,080 *0.0032*
H21	MP10-10007B90Z3-M03 MP3000	2,5 *0.10*	0,025 *0.0010*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,080 *0.0032*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP10 Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	MP3000					F40M				
	100%	30%	10%	5%	2%	100%	30%	10%	5%	2%
P1	275 *900*	330 *1075*	360 *1175*	385 *1275*	385 *1275*	260 *850*	310 *1025*	340 *1125*	365 *1200*	365 *1200*
P2	265 *870*	320 *1050*	345 *1125*	375 *1225*	375 *1225*	250 *820*	300 *980*	325 *1075*	355 *1175*	355 *1175*
P3	230 *750*	280 *920*	300 *980*	325 *1075*	325 *1075*	220 *720*	265 *870*	285 *940*	310 *1025*	305 *1000*
P4	205 *670*	245 *800*	265 *870*	290 *950*	290 *950*	195 *640*	230 *750*	250 *820*	270 *890*	270 *890*
P5	195 *640*	235 *770*	255 *840*	275 *900*	275 *900*	185 *610*	220 *720*	240 *790*	260 *850*	260 *850*
P6	220 *720*	265 *870*	285 *940*	310 *1025*	310 *1025*	205 *670*	250 *820*	270 *890*	295 *970*	290 *950*
P7	205 *670*	250 *820*	270 *890*	295 *970*	290 *950*	195 *640*	235 *770*	255 *840*	275 *900*	275 *900*
P8	195 *640*	235 *770*	255 *840*	275 *900*	270 *890*	185 *610*	220 *720*	240 *790*	260 *850*	255 *840*
P11	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	190 *620*	230 *750*	250 *820*	270 *890*	265 *870*
P12	125 *410*	155 *510*	160 *520*	175 *570*	175 *570*	120 *395*	145 *475*	155 *510*	165 *540*	165 *540*
M1	200 *660*	240 *790*	260 *850*	280 *920*	280 *920*	205 *670*	245 *800*	265 *870*	285 *940*	285 *940*
M2	165 *540*	195 *640*	215 *710*	230 *750*	230 *750*	165 *540*	200 *660*	215 *710*	235 *770*	235 *770*
M3	130 *425*	160 *520*	165 *540*	180 *590*	180 *590*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
M4	100 *330*	125 *410*	125 *410*	140 *460*	140 *460*	105 *345*	125 *410*	130 *425*	140 *460*	140 *460*
M5	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*	85 *280*	105 *345*	110 *360*	115 *375*	115 *375*
K1	210 *690*	255 *840*	275 *900*	300 *980*	300 *980*	200 *660*	240 *790*	260 *850*	280 *920*	280 *920*
K2	185 *610*	220 *720*	245 *800*	260 *850*	260 *850*	175 *570*	210 *690*	230 *750*	245 *800*	245 *800*
K3	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*	150 *490*	180 *590*	195 *640*	210 *690*	210 *690*
K4	150 *490*	180 *590*	195 *640*	210 *690*	210 *690*	140 *460*	170 *560*	185 *610*	200 *660*	200 *660*
K5	90 *295*	110 *360*	120 *395*	125 *410*	130 *425*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*
K6	130 *425*	160 *520*	175 *570*	185 *610*	185 *610*	125 *410*	150 *490*	165 *540*	175 *570*	175 *570*
K7	115 *375*	140 *460*	150 *490*	165 *540*	165 *540*	110 *360*	130 *425*	145 *475*	155 *510*	155 *510*
N1	1600 *5250*	1925 *6325*	2100 *6900*	2275 *7475*	2250 *7375*	1500 *4925*	1825 *6000*	1975 *6475*	2150 *7050*	2125 *6975*
N2	650 *2125*	780 *2550*	840 *2750*	920 *3025*	900 *2950*	610 *2000*	730 *2400*	800 *2625*	860 *2825*	850 *2800*
N3	430 *1400*	520 *1700*	560 *1825*	610 *2000*	600 *1975*	405 *1325*	490 *1600*	530 *1750*	580 *1900*	570 *1875*
N11	490 *1600*	590 *1925*	640 *2100*	700 *2300*	690 *2275*	465 *1525*	560 *1825*	610 *2000*	660 *2175*	650 *2125*
S1	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S2	38 *125*	46 *150*	48 *155*	50 *165*	50 *165*	39 *130*	47 *155*	49 *160*	55 *180*	55 *180*
S3	33 *110*	40 *130*	41 *135*	45 *150*	45 *150*	34 *110*	41 *135*	42 *140*	46 *150*	46 *150*
S11	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*	70 *230*	85 *280*	85 *280*	95 *310*	95 *310*
S12	46 *150*	55 *180*	60 *195*	65 *215*	65 *215*	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*
S13	27 *90*	32 *105*	33 *110*	36 *120*	36 *120*	27 *90*	33 *110*	34 *110*	37 *120*	37 *120*
H5	39 *130*	48 *155*	50 *165*	55 *180*	55 *180*	40 *130*	48 *155*	50 *165*	55 *180*	55 *180*
H8	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H11	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	80 *260*	95 *310*	100 *330*	110 *360*	110 *360*	75 *245*	90 *295*	95 *310*	100 *330*	100 *330*
H21	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*

MP10 Zentrierbohren – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		f_z	a_{so}
			100%
P1	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
P2	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
P3	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P4	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P5	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P6	MP10-10006C90Z2-M03 F40M	0,038 *0.0015*	3,0 *0.12*
P7	MP10-10006C90Z2-M03 F40M	0,038 *0.0015*	3,0 *0.12*
P8	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
P11	MP10-10006C90Z2-M03 F40M	0,038 *0.0015*	3,0 *0.12*
P12	MP10-10006C90Z2-M03 F40M	0,026 *0.0010*	2,0 *0.080*
M1	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
M2	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
M3	MP10-10006C90Z2-M03 F40M	0,032 *0.0013*	2,0 *0.080*
M4	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
M5	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
K1	MP10-10006C90Z2-M03 F40M	0,042 *0.0017*	3,0 *0.12*
K2	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K3	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K4	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K5	MP10-10006C90Z2-M03 F40M	0,036 *0.0014*	3,0 *0.12*
K6	MP10-10006C90Z2-M03 F40M	0,040 *0.0016*	3,0 *0.12*
K7	MP10-10006C90Z2-M03 F40M	0,036 *0.0014*	3,0 *0.12*
N1	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
N2	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
N3	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
N11	MP10-10006C90Z2-M03 F40M	0,055 *0.0022*	3,0 *0.12*
S1	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
S2	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
S3	MP10-10006C90Z2-M03 F40M	0,025 *0.0010*	1,7 *0.065*
S11	MP10-10006C90Z2-M03 F40M	0,032 *0.0013*	1,9 *0.075*
S12	MP10-10006C90Z2-M03 F40M	0,032 *0.0013*	1,9 *0.075*
S13	MP10-10006C90Z2-M03 F40M	0,028 *0.0011*	1,7 *0.065*
H5	MP10-10006C90Z2-M03 F40M	0,026 *0.0010*	2,0 *0.080*
H8	MP10-10006C90Z2-M03 F40M	0,020 *0.00080*	1,9 *0.075*
H11	MP10-10006C90Z2-M03 F40M	0,026 *0.0010*	2,0 *0.080*
H12	MP10-10006C90Z2-M03 F40M	0,020 *0.00080*	1,9 *0.075*
H21	MP10-10006C90Z2-M03 F40M	0,020 *0.00080*	1,9 *0.075*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP10 Zentrierbohren – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F40M
	100%
P1	305 *1000*
P2	295 *970*
P3	260 *850*
P4	225 *740*
P5	215 *710*
P6	245 *800*
P7	230 *750*
P8	215 *710*
P11	225 *740*
P12	135 *445*
M1	240 *790*
M2	195 *640*
M3	150 *490*
M4	110 *360*
M5	95 *310*
K1	235 *770*
K2	205 *670*
K3	175 *570*
K4	165 *540*
K5	100 *330*
K6	145 *475*
K7	130 *425*
N1	1775 *5825*
N2	710 *2325*
N3	475 *1550*
N11	540 *1775*
S1	50 *165*
S2	42 *140*
S3	36 *120*
S11	75 *245*
S12	50 *165*
S13	29 *95*
H5	45 *150*
H8	46 *150*
H11	55 *180*
H12	85 *280*
H21	46 *150*

MP10 Anfasen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z				
			100%	50%	30%	20%	10%
P1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
P2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
P3	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
P4	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
P5	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P6	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P7	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P8	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
P11	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
P12	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*
M1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
M2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
M3	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*
M4	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
M5	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
K1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
K2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K3	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K4	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K5	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
K6	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
K7	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
N1	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
N2	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
N3	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
N11	MP10-10006C90Z2-M03 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
S1	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
S2	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
S3	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,044 *0.0017*
S11	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*
S12	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*
S13	MP10-10006C90Z2-M03 F40M	1,3 *0.050*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
H5	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*
H8	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*
H11	MP10-10006C90Z2-M03 F40M	1,8 *0.070*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*
H12	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*
H21	MP10-10006C90Z2-M03 F40M	1,5 *0.060*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP10 Anfasen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	50%	30%	20%	10%
P1	330 *1075*	300 *980*	360 *1175*	395 *1300*	465 *1525*
P2	320 *1050*	290 *950*	350 *1150*	385 *1275*	455 *1500*
P3	285 *940*	255 *840*	305 *1000*	340 *1125*	395 *1300*
P4	250 *820*	225 *740*	270 *890*	300 *980*	350 *1150*
P5	240 *790*	215 *710*	260 *850*	285 *940*	335 *1100*
P6	265 *870*	240 *790*	290 *950*	320 *1050*	380 *1250*
P7	250 *820*	230 *750*	275 *900*	300 *980*	355 *1175*
P8	240 *790*	215 *710*	260 *850*	285 *940*	330 *1075*
P11	245 *800*	220 *720*	265 *870*	295 *970*	345 *1125*
P12	155 *510*	140 *460*	160 *520*	175 *570*	220 *720*
M1	260 *850*	235 *770*	280 *920*	310 *1025*	365 *1200*
M2	215 *710*	195 *640*	230 *750*	255 *840*	305 *1000*
M3	170 *560*	150 *490*	175 *570*	195 *640*	240 *790*
M4	130 *425*	110 *360*	125 *410*	140 *460*	185 *610*
M5	105 *345*	90 *295*	105 *345*	120 *395*	155 *510*
K1	255 *840*	230 *750*	275 *900*	305 *1000*	360 *1175*
K2	225 *740*	205 *670*	245 *800*	270 *890*	320 *1050*
K3	190 *620*	175 *570*	205 *670*	230 *750*	270 *890*
K4	180 *590*	165 *540*	200 *660*	220 *720*	260 *850*
K5	110 *360*	100 *330*	120 *395*	135 *445*	155 *510*
K6	160 *520*	145 *475*	175 *570*	190 *620*	230 *750*
K7	140 *460*	130 *425*	155 *510*	170 *560*	200 *660*
N1	1925 *6325*	1725 *5650*	2075 *6800*	2300 *7550*	2700 *8850*
N2	770 *2525*	690 *2275*	840 *2750*	930 *3050*	1100 *3600*
N3	520 *1700*	465 *1525*	560 *1825*	620 *2025*	730 *2400*
N11	590 *1925*	530 *1750*	640 *2100*	710 *2325*	830 *2725*
S1	60 *195*	50 *165*	60 *195*	65 *215*	85 *280*
S2	48 *155*	41 *135*	47 *155*	55 *180*	70 *230*
S3	42 *140*	36 *120*	41 *135*	46 *150*	60 *195*
S11	85 *280*	75 *245*	85 *280*	95 *310*	120 *395*
S12	60 *195*	50 *165*	60 *195*	65 *215*	85 *280*
S13	34 *110*	29 *95*	33 *110*	37 *120*	48 *155*
H5	50 *165*	46 *150*	50 *165*	60 *195*	75 *245*
H8	55 *180*	47 *155*	55 *180*	60 *195*	75 *245*
H11	65 *215*	60 *195*	65 *215*	75 *245*	90 *295*
H12	95 *310*	85 *280*	95 *310*	110 *360*	135 *445*
H21	55 *180*	47 *155*	55 *180*	60 *195*	75 *245*

MP12 Schaft



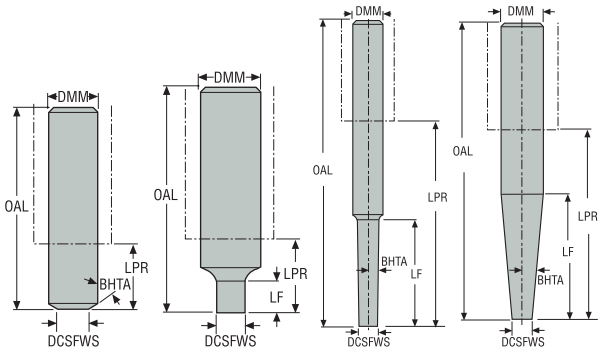
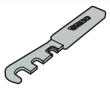
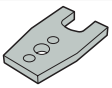


Abb. 1 Abb. 2 Abb. 3 Abb. 4

- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen.

Bezeichnung	Aufnahme	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Abb.		Gewicht
		mm	mm	mm	mm	mm					kg
MP12-12060-012.00	Zylindrisch	11,5	12,0	60,0	15,0	12,0	72700	0,0	2	✓	0,1
MP12-16068-000.60	Zylindrisch	11,5	16,0	68,0	20,0	0,0	72700	60,0	1	✓	0,2
MP12-16078-018.00	Zylindrisch	11,5	16,0	78,0	30,0	18,0	72700	0,0	2	✓	0,1
MP12-16153-042.01	Zylindrisch	11,5	16,0	153,0	105,0	42,0	72700	1,0	3	✓	0,2
MP12-20170-072.01	Zylindrisch	11,5	20,0	170,0	120,0	72,0	72700	1,0	3	✓	0,3
MP12-20110-055.03	Zylindrisch	11,5	20,0	110,0	60,0	55,0	72700	3,0	3	✓	0,2
MP12-20150-100.03	Zylindrisch	11,5	20,0	150,0	100,0	81,1	72700	3,0	3	✓	0,3
MP12-20155-105.05	Zylindrisch	11,5	20,0	155,0	105,0	48,6	72700	5,0	4	✓	0,4
MP12-16107-036.00-E	Zylindrisch	11,5	16,0	107,0	59,0	36,0	72700	0,0	2	✓	0,3
MP12-16120-048.00-E	Zylindrisch	11,5	16,0	120,0	72,0	48,0	72700	0,0	2	✓	0,3
MP12-16150-072.00-E	Zylindrisch	11,5	16,0	150,0	102,0	72,0	72700	0,0	2	✓	0,3
MP12-16120-060.01-E	Zylindrisch	11,5	16,0	120,0	72,0	60,0	72700	1,0	3	✓	0,3
MP12-16150-096.01-E	Zylindrisch	11,5	16,0	150,0	102,0	96,0	72700	1,0	3	✓	0,4
MP12-16175-120.01-E	Zylindrisch	11,5	16,0	175,0	127,0	120,0	72700	1,0	3	✓	0,4
MP12-16155-107.03-E	Zylindrisch	11,5	16,0	155,0	107,0	42,9	72700	3,0	4	✓	0,4
MP12-16180-132.03-E	Zylindrisch	11,5	16,0	180,0	132,0	42,9	72700	3,0	4	✓	0,5

Zubehör

Schlüssel	Ersatzklinge	Drehmoment-schlüssel
		
MP1016	MP00-12M	MP00-12.150

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten.

MP12 Schaft – Zoll

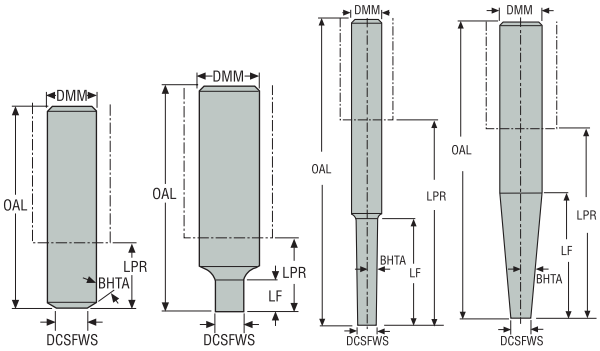


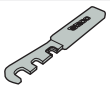
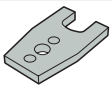
Abb. 1 Abb. 2 Abb. 3 Abb. 4



- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen.

Bezeichnung	Aufnahme	DCSFMS	DMM	OAL	LPR	LF	RPMX	BHTA°	Abb.		Gewicht
		Zoll	Zoll	Zoll	Zoll	Zoll					lbs
MP12-0502.3-0.47.00	Zylindrisch	0.453	0.500	2.341	0.591	0.472	72700	0,0	2	✓	0.220
MP12-0622.6-0.00.60	Zylindrisch	0.453	0.625	2.662	0.787	0	72700	60,0	1	✓	0.220
MP12-0623.0-0.70.00	Zylindrisch	0.453	0.625	3.056	1.181	0.709	72700	0,0	2	✓	0.220
MP12-0626.0-1.65.01	Zylindrisch	0.453	0.625	6.009	4.134	1.654	72700	1,0	3	✓	0.440
MP12-0754.3-2.20.03	Zylindrisch	0.453	0.750	4.362	2.362	2.201	72700	3,0	3	✓	0.440
MP12-0755.9-3.93.03	Zylindrisch	0.453	0.750	5.937	3.937	2.835	72700	3,0	3	✓	0.660
MP12-0756.1-4.13.05	Zylindrisch	0.453	0.750	6.134	4.134	1.697	72700	5,0	4	✓	0.660
MP12-0756.7-2.83.01	Zylindrisch	0.453	0.750	6.724	4.724	2.835	72700	1,0	4	✓	0.660
MP12-0627.0-5.19.03-E	Zylindrisch	0.453	0.625	7.072	5.197	1.654	72700	3,0	4	✓	1.100
MP12-0625.8-2.83.00-E	Zylindrisch	0.453	0.625	5.891	4.016	2.835	72700	0,0	2	✓	0.660

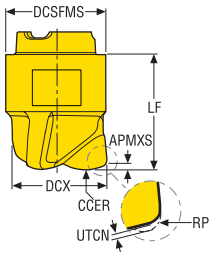
Zubehör

Schlüssel	Ersatzklinge	Drehmoment-schlüssel
		
MP1016	MP00-12M	MP00-12.150

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten.

MP12 Hochvorschubfräser





• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 502-503

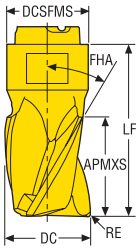
Z3



Bezeichnung	DCX	DC	APMXS	DCSFMS	CCER	RP	LF	UTCN	RMPX°	C min	C max	ZEFP		Sorten	
														Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						MP3000	F40M
MP12-1200.7HFZ3-MD10	12,0 *0.472*	6,0 *0.236*	0,7 *0.028*	11,52 *0.454*	7,5 *0.295*	1,66 *0.065*	13,3 *0.524*	0,33 *0.013*	5,0	13,1	17,8	3	✓	■	
MP12-1270.7HFZ3-MD10	12,7 *0.500*	6,7 *0.264*	0,7 *0.028*	11,52 *0.454*	7,5 *0.295*	1,66 *0.065*	13,3 *0.524*	0,32 *0.013*	5,0	13,8	19,2	3	✓	■	

MP12 Eckfräser

Nut- und Konturfräsen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 504-505

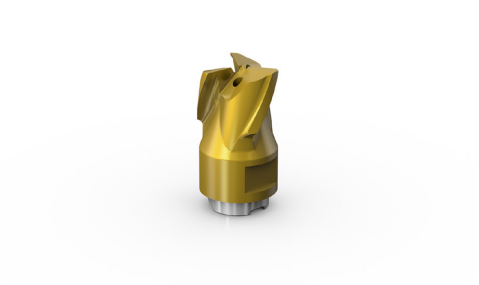
Z3

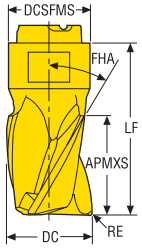


Bezeichnung	DC	APMXS	RE	DCSFMS	FHA	LF	RMPX°	C min	C max	ZEFP		Sorten	
												Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						MP3000	F40M
MP12-12008R04Z3-E04	12,0 *0.472*	8,0 *0.315*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	23,0	3	✓		■
MP12-12008R04Z3-M04	12,0 *0.472*	8,0 *0.315*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	23,0	3	✓	■	
MP12-12008R05Z3-E04	12,0 *0.472*	8,0 *0.315*	0,5 *0.020*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	22,8	3	✓		■
MP12-12008R08Z3-E04	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	22,2	3	✓		■
MP12-12008R08Z3-M04	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	22,2	3	✓	■	
MP12-12008R16Z3-E04	12,0 *0.472*	8,0 *0.315*	1,6 *0.063*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	20,6	3	✓		■
MP12-12008R31Z3-E04	12,0 *0.472*	8,0 *0.315*	3,1 *0.122*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	14,6	17,6	3	✓		■
MP12-12708R08Z3-M04	12,7 *0.500*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	18,8 *0.740*	15,0	15,4	23,6	3	✓	■	

MP12 Eckfräser

Nut- und Konturfräsen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 504-505

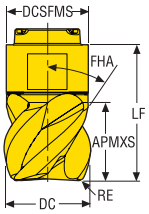
Z3



Bezeichnung	DC	APMXS	RE	DCSFMS	FHA	LF	RMPX°	C min	C max	ZEFP		Sorten	
												Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						MP3000	F40M
MP12-11714KWZ3-E04	11,7 *0.461*	14,0 *0.551*	0,3 *0.012*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,2	22,6	3	✓		■
MP12-12014R04Z3-E04	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	23,0	3	✓		■
MP12-12014R04Z3-M04	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	23,0	3	✓	■	
MP12-12014R05Z3-E04	12,0 *0.472*	14,0 *0.551*	0,5 *0.020*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	22,8	3	✓		■
MP12-12014R08Z3-M04	12,0 *0.472*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	22,2	3	✓	■	
MP12-12014R12Z3-E04	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	21,4	3	✓		■
MP12-12014R12Z3-M04	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	21,4	3	✓	■	
MP12-12014R20Z3-E04	12,0 *0.472*	14,0 *0.551*	2,0 *0.079*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	19,8	3	✓		■
MP12-12014R31Z3-E04	12,0 *0.472*	14,0 *0.551*	3,1 *0.122*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	14,6	17,6	3	✓		■
MP12-12714R04Z3-E04	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	24,4	3	✓		■
MP12-12714R04Z3-M04	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	24,4	3	✓	■	
MP12-12714R08Z3-E04	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	23,6	3	✓		■
MP12-12714R08Z3-M04	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	23,6	3	✓	■	
MP12-12714R16Z3-E04	12,7 *0.500*	14,0 *0.551*	1,6 *0.063*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	23,9	3	✓		■
MP12-12714R31Z3-E04	12,7 *0.500*	14,0 *0.551*	3,1 *0.122*	11,5 *0.453*	30 *1.181*	24,0 *0.945*	15,0	15,4	22,0	3	✓		■

MP12 Eckfräser

Nut- und Konturfräsen





• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 504-505

Z4

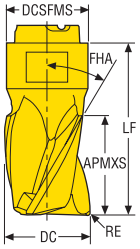


Bezeichnung	DC	APMXS	RE	DCSFMS	FHA	LF	RMPX°	C min	C max	ZEFP	Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					MP3000	F40M
MP12-12008R04Z4-M03	12,0 *0.472*	8,0 *0.315*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	23,0	4	■	
MP12-12008R05Z4-E03	12,0 *0.472*	8,0 *0.315*	0,5 *0.020*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	22,8	4		■
MP12-12008R08Z4-E03	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	22,2	4		■
MP12-12008R08Z4-M03	12,0 *0.472*	8,0 *0.315*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	22,2	4	■	
MP12-12008R12Z4-M03	12,0 *0.472*	8,0 *0.315*	1,2 *0.047*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	21,4	4	■	
MP12-12008R24Z4-E03	12,0 *0.472*	8,0 *0.315*	2,4 *0.094*	11,5 *0.453*	50 *1.969*	18,8 *0.740*	15,0	14,6	19,0	4		■
MP12-12014R04Z4-M03	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	23,0	4	■	
MP12-12014R05Z4-E03	12,0 *0.472*	14,0 *0.551*	0,5 *0.020*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	22,8	4		■
MP12-12014R08Z4-E03	12,0 *0.472*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	22,2	4		■
MP12-12014R08Z4-M03	12,0 *0.472*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	22,2	4	■	
MP12-12014R12Z4-E03	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	21,4	4		■
MP12-12014R12Z4-M03	12,0 *0.472*	14,0 *0.551*	1,2 *0.047*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	21,4	4	■	
MP12-12014R16Z4-E03	12,0 *0.472*	14,0 *0.551*	1,6 *0.063*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	14,6	20,6	4		■
MP12-12714R04Z4-E03	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	24,4	4		■
MP12-12714R04Z4-M03	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	24,4	4	■	
MP12-12714R08Z4-E03	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	23,9	4		■
MP12-12714R08Z4-M03	12,7 *0.500*	14,0 *0.551*	0,8 *0.031*	11,5 *0.453*	50 *1.969*	24,0 *0.945*	15,0	15,4	23,6	4	■	

MP12 Eckfräser

Nur Konturfräsen





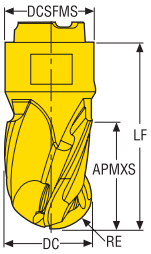
- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 504-505

Z6



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	ZEFP		Sorten	
									Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP12-12014R04Z6-M03	12,0 *0.472*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	24,0 *0.945*	40	6		■	
MP12-12714R04Z6-M03	12,7 *0.500*	14,0 *0.551*	0,4 *0.016*	11,5 *0.453*	24,0 *0.945*	40	6		■	

MP12 Kugelkopffräser





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 506-507

Z3



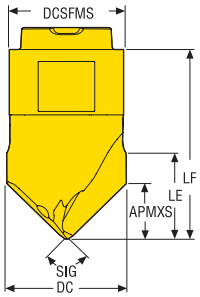
Z4



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	RMPX°	ZEFP		Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					MP3000	F40M
MP12-12008B90Z3-E04	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓		■
MP12-12008B90Z3-M04	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓	■	
MP12-12014B90Z3-E04	12,0 *0.472*	14,0 *0.551*	6,0 *0.236*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓		■
MP12-12014B90Z3-M04	12,0 *0.472*	14,0 *0.551*	6,0 *0.236*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓	■	
MP12-12008B90Z4-E03	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,7 *0.736*	20	15,0	4			■
MP12-12008B90Z4-M03	12,0 *0.472*	8,0 *0.315*	6,0 *0.236*	11,5 *0.453*	18,7 *0.736*	20	15,0	4		■	
MP12-12708B90Z3-E04	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓		■
MP12-12708B90Z3-M04	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,8 *0.740*	30	15,0	3	✓	■	
MP12-12714B90Z3-E04	12,7 *0.500*	14,0 *0.551*	6,35 *0.250*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓		■
MP12-12714B90Z3-M04	12,7 *0.500*	14,0 *0.551*	6,35 *0.250*	11,5 *0.453*	24,0 *0.945*	30	15,0	3	✓	■	
MP12-12708B90Z4-E03	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,7 *0.736*	20	15,0	4			■
MP12-12708B90Z4-M03	12,7 *0.500*	8,0 *0.315*	6,35 *0.250*	11,5 *0.453*	18,7 *0.736*	20	15,0	4		■	

MP12 Zentrierbohren





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 508-509

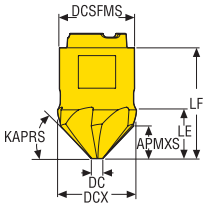
Z2



Bezeichnung	DC	APMXS	DCSFMS	LE	LF	SIG°	ZEFP		Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP12-12007C90Z2-M04	12,0 *0.472*	5,6 *0.220*	11,5 *0.453*	8,7 *0.343*	19,0 *0.748*	90,0	2	✓		■

MP12 Anfasen





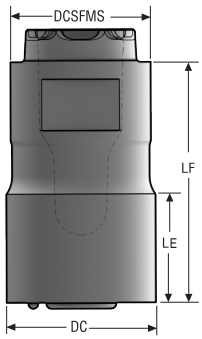
- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 510-511

Z6



Bezeichnung	DCX	DC	APMXS	DCSFMS	LE	LF	KAPRS°	ZEFP		Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP12-12007C90Z6-M04	12,1 *0.476*	2,95 *0.116*	4,4 *0.173*	11,5 *0.453*	7,5 *0.295*	18,0 *0.709*	45,0	6			■

MP12 Zylindrische Rohlinge





- Zylindrische Hartmetall-Rohlinge zur Herstellung eigener Geometrien





Bezeichnung	DC	DCSFMS	LE	LF	Sorten
					Unbeschichtet
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	H25
MP12-12008CYL-SEMI	12,95 *0.510*	11,5 *0.453*	9,4 *0.370*	19,35 *0.762*	■
MP12-12014CYL-SEMI	12,95 *0.510*	11,5 *0.453*	14,3 *0.563*	24,15 *0.951*	■

MP12 Hochvorschubfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,90 *0.036*
P3	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P4	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P5	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P6	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P7	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P8	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P11	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P12	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
M1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,90 *0.036*
M2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
M3	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
M4	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M5	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
K1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,90 *0.036*
K2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K3	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K4	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K5	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K6	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K7	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
N1	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
N2	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
N3	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
N11	MP12-1200.7HFZ3-MD10 MP3000	0,48 *0.019*	0,70 *0.028*	0,70 *0.028*	0,95 *0.038*	1,2 *0.048*
S1	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S2	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S3	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*	0,50 *0.020*
S11	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S12	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S13	MP12-1200.7HFZ3-MD10 MP3000	0,30 *0.012*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H5	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
H8	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,28 *0.011*	0,26 *0.010*	0,34 *0.013*	0,40 *0.016*
H11	MP12-1200.7HFZ3-MD10 MP3000	0,40 *0.016*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
H12	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,28 *0.011*	0,26 *0.010*	0,34 *0.013*	0,40 *0.016*
H21	MP12-1200.7HFZ3-MD10 MP3000	0,34 *0.013*	0,28 *0.011*	0,26 *0.010*	0,34 *0.013*	0,40 *0.016*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP12 Hochvorschubfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	MP3000			
	100%	70%	30%	20%
P1	240 *790*	295 *970*	340 *1125*	355 *1175*
P2	235 *770*	285 *940*	325 *1075*	345 *1125*
P3	205 *670*	245 *800*	285 *940*	300 *980*
P4	185 *610*	220 *720*	250 *820*	265 *870*
P5	175 *570*	210 *690*	245 *800*	255 *840*
P6	195 *640*	240 *790*	275 *900*	290 *950*
P7	185 *610*	225 *740*	260 *850*	275 *900*
P8	170 *560*	205 *670*	240 *790*	255 *840*
P11	180 *590*	220 *720*	250 *820*	265 *870*
P12	115 *375*	140 *460*	160 *520*	170 *560*
M1	175 *570*	215 *710*	245 *800*	260 *850*
M2	145 *475*	175 *570*	205 *670*	215 *710*
M3	120 *395*	140 *460*	160 *520*	170 *560*
M4	95 *310*	110 *360*	125 *410*	135 *445*
M5	80 *260*	90 *295*	105 *345*	110 *360*
K1	185 *610*	225 *740*	260 *850*	275 *900*
K2	165 *540*	200 *660*	230 *750*	245 *800*
K3	140 *460*	170 *560*	195 *640*	205 *670*
K4	135 *445*	160 *520*	190 *620*	195 *640*
K5	80 *260*	100 *330*	115 *375*	120 *395*
K6	120 *395*	145 *475*	165 *540*	175 *570*
K7	105 *345*	125 *410*	145 *475*	150 *490*
N1	1400 *4600*	1700 *5575*	1925 *6325*	2025 *6650*
N2	560 *1825*	680 *2225*	780 *2550*	820 *2700*
N3	375 *1225*	455 *1500*	520 *1700*	540 *1775*
N11	430 *1400*	520 *1700*	600 *1975*	620 *2025*
S1	44 *145*	50 *165*	60 *195*	60 *195*
S2	35 *115*	41 *135*	47 *155*	50 *165*
S3	31 *100*	36 *120*	42 *140*	44 *145*
S11	60 *195*	70 *230*	80 *260*	85 *280*
S12	42 *140*	49 *160*	55 *180*	60 *195*
S13	25 *80*	29 *95*	33 *110*	35 *115*
H5	36 *120*	44 *145*	50 *165*	55 *180*
H8	39 *130*	46 *150*	55 *180*	55 *180*
H11	46 *150*	55 *180*	65 *215*	65 *215*
H12	75 *245*	90 *295*	100 *330*	110 *360*
H21	39 *130*	46 *150*	55 *180*	55 *180*

MP12 Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	30%	10%	5%
P1	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*	0,13 *0.0050*
P2	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*
P3	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
P4	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,12 *0.0048*
P5	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
P6	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
P7	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
P8	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*
P11	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
P12	MP12-12008R08Z3-M04 MP3000	3,0 *0.12*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
M1	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*
M2	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
M3	MP12-12008R04Z3-E04 F40M	3,0 *0.12*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*
M4	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
M5	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
K1	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*
K2	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K3	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K4	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K5	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,048 *0.0019*	0,050 *0.0020*	0,080 *0.0032*	0,11 *0.0044*
K6	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,090 *0.0036*	0,12 *0.0048*
K7	MP12-12008R04Z3-M04 MP3000	4,0 *0.16*	0,048 *0.0019*	0,050 *0.0020*	0,080 *0.0032*	0,11 *0.0044*
N1	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
N2	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
N3	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
N11	MP12-12008R04Z3-E04 F40M	4,0 *0.16*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
S1	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
S2	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
S3	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*
S11	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*
S12	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,095 *0.0038*
S13	MP12-12008R04Z3-E04 F40M	2,5 *0.10*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 *0.0034*
H5	MP12-12008R04Z3-M04 MP3000	3,0 *0.12*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
H8	MP12-12008R04Z3-M04 MP3000	2,5 *0.10*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
H11	MP12-12008R04Z3-M04 MP3000	3,0 *0.12*	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*	0,080 *0.0032*
H12	MP12-12008R04Z3-M04 MP3000	2,5 *0.10*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*
H21	MP12-12008R04Z3-M04 MP3000	2,5 *0.10*	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*	0,065 *0.0026*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP12 Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M			
	100%	30%	10%	5%	100%	30%	10%	5%
P1	250 *820*	325 *1075*	380 *1250*	415 *1350*	235 *770*	310 *1025*	360 *1175*	390 *1275*
P2	240 *790*	315 *1025*	370 *1225*	405 *1325*	225 *740*	295 *970*	350 *1150*	380 *1250*
P3	210 *690*	275 *900*	320 *1050*	345 *1125*	200 *660*	260 *850*	305 *1000*	325 *1075*
P4	185 *610*	240 *790*	285 *940*	310 *1025*	175 *570*	230 *750*	270 *890*	295 *970*
P5	180 *590*	235 *770*	275 *900*	295 *970*	170 *560*	220 *720*	260 *850*	280 *920*
P6	200 *660*	265 *870*	310 *1025*	330 *1075*	190 *620*	250 *820*	290 *950*	315 *1025*
P7	190 *620*	250 *820*	290 *950*	315 *1025*	180 *590*	235 *770*	275 *900*	295 *970*
P8	175 *570*	230 *750*	270 *890*	290 *950*	165 *540*	215 *710*	255 *840*	275 *900*
P11	185 *610*	240 *790*	280 *920*	305 *1000*	175 *570*	230 *750*	265 *870*	290 *950*
P12	115 *375*	150 *490*	175 *570*	195 *640*	110 *360*	145 *475*	165 *540*	180 *590*
M1	180 *590*	235 *770*	275 *900*	300 *980*	180 *590*	240 *790*	280 *920*	305 *1000*
M2	150 *490*	195 *640*	230 *750*	245 *800*	150 *490*	200 *660*	235 *770*	250 *820*
M3	120 *395*	155 *510*	180 *590*	195 *640*	120 *395*	155 *510*	185 *610*	200 *660*
M4	90 *295*	120 *395*	140 *460*	150 *490*	95 *310*	120 *395*	140 *460*	155 *510*
M5	75 *245*	100 *330*	115 *375*	125 *410*	75 *245*	100 *330*	120 *395*	125 *410*
K1	190 *620*	250 *820*	295 *970*	320 *1050*	180 *590*	235 *770*	275 *900*	300 *980*
K2	170 *560*	220 *720*	260 *850*	280 *920*	160 *520*	210 *690*	245 *800*	265 *870*
K3	145 *475*	190 *620*	220 *720*	240 *790*	135 *445*	180 *590*	210 *690*	225 *740*
K4	140 *460*	180 *590*	210 *690*	225 *740*	130 *425*	170 *560*	200 *660*	215 *710*
K5	85 *280*	110 *360*	125 *410*	135 *445*	80 *260*	105 *345*	120 *395*	130 *425*
K6	120 *395*	160 *520*	185 *610*	200 *660*	115 *375*	150 *490*	175 *570*	190 *620*
K7	105 *345*	140 *460*	160 *520*	175 *570*	100 *330*	130 *425*	155 *510*	165 *540*
N1	1425 *4675*	1875 *6150*	2200 *7225*	2375 *7800*	1350 *4425*	1775 *5825*	2100 *6900*	2250 *7375*
N2	570 *1875*	760 *2500*	890 *2925*	960 *3150*	540 *1775*	720 *2350*	840 *2750*	910 *2975*
N3	385 *1275*	500 *1650*	600 *1975*	640 *2100*	360 *1175*	475 *1550*	560 *1825*	610 *2000*
N11	440 *1450*	580 *1900*	680 *2225*	730 *2400*	415 *1350*	540 *1775*	640 *2100*	690 *2275*
S1	43 *140*	55 *180*	65 *215*	70 *230*	43 *140*	55 *180*	65 *215*	70 *230*
S2	34 *110*	45 *150*	50 *165*	55 *180*	35 *115*	46 *150*	55 *180*	55 *180*
S3	30 *100*	39 *130*	46 *150*	49 *160*	31 *100*	40 *130*	46 *150*	50 *165*
S11	60 *195*	80 *260*	90 *295*	100 *330*	60 *195*	80 *260*	95 *310*	100 *330*
S12	42 *140*	55 *180*	65 *215*	70 *230*	42 *140*	55 *180*	65 *215*	70 *230*
S13	24 *80*	31 *100*	36 *120*	39 *130*	24 *80*	32 *105*	37 *120*	40 *130*
H5	36 *120*	47 *155*	55 *180*	60 *195*	36 *120*	48 *155*	55 *180*	60 *195*
H8	38 *125*	49 *160*	55 *180*	60 *195*	38 *125*	50 *165*	60 *195*	60 *195*
H11	46 *150*	60 *195*	70 *230*	75 *245*	46 *150*	60 *195*	70 *230*	75 *245*
H12	70 *230*	95 *310*	110 *360*	120 *395*	70 *230*	90 *295*	105 *345*	110 *360*
H21	38 *125*	49 *160*	55 *180*	60 *195*	38 *125*	50 *165*	60 *195*	60 *195*

MP12 Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z				
			100%	30%	10%	5%	2%
P1	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
P2	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
P3	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P4	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P5	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P6	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P7	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P8	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P11	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P12	MP12-12008B90Z3-M04 MP3000	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
M1	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
M2	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
M3	MP12-12008B90Z3-E04 F40M	3,0 *0.12*	0,050 *0.0020*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M4	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
M5	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
K1	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,22 *0.0085*
K2	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K3	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K4	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K5	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,11 *0.0044*	0,18 *0.0070*
K6	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
K7	MP12-12008B90Z3-M04 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,11 *0.0044*	0,18 *0.0070*
N1	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
N2	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
N3	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
N11	MP12-12008B90Z3-E04 F40M	4,0 *0.16*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
S1	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
S2	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
S3	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,042 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
S11	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
S12	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
S13	MP12-12008B90Z3-E04 F40M	2,5 *0.10*	0,046 *0.0018*	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
H5	MP12-12008B90Z3-M04 MP3000	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
H8	MP12-12008B90Z3-M04 MP3000	2,5 *0.10*	0,034 *0.0013*	0,034 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H11	MP12-12008B90Z3-M04 MP3000	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
H12	MP12-12008B90Z3-M04 MP3000	2,5 *0.10*	0,034 *0.0013*	0,034 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H21	MP12-12008B90Z3-M04 MP3000	2,5 *0.10*	0,034 *0.0013*	0,034 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,10 *0.0040*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP12 Kopierfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	MP3000					F40M				
	100%	30%	10%	5%	2%	100%	30%	10%	5%	2%
P1	265 *870*	320 *1050*	345 *1125*	375 *1225*	370 *1225*	250 *820*	300 *980*	325 *1075*	355 *1175*	350 *1150*
P2	255 *840*	310 *1025*	330 *1075*	360 *1175*	360 *1175*	240 *790*	295 *970*	315 *1025*	340 *1125*	340 *1125*
P3	220 *720*	265 *870*	290 *950*	315 *1025*	315 *1025*	210 *690*	255 *840*	270 *890*	295 *970*	295 *970*
P4	195 *640*	240 *790*	255 *840*	275 *900*	275 *900*	185 *610*	225 *740*	240 *790*	260 *850*	260 *850*
P5	190 *620*	230 *750*	245 *800*	265 *870*	265 *870*	175 *570*	215 *710*	230 *750*	250 *820*	250 *820*
P6	210 *690*	255 *840*	275 *900*	300 *980*	295 *970*	200 *660*	240 *790*	260 *850*	285 *940*	280 *920*
P7	200 *660*	240 *790*	260 *850*	285 *940*	280 *920*	190 *620*	230 *750*	245 *800*	265 *870*	265 *870*
P8	185 *610*	225 *740*	240 *790*	265 *870*	265 *870*	175 *570*	210 *690*	230 *750*	250 *820*	250 *820*
P11	195 *640*	235 *770*	250 *820*	275 *900*	270 *890*	185 *610*	220 *720*	240 *790*	260 *850*	255 *840*
P12	120 *395*	150 *490*	160 *520*	170 *560*	170 *560*	115 *375*	140 *460*	150 *490*	160 *520*	160 *520*
M1	190 *620*	230 *750*	250 *820*	270 *890*	270 *890*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*
M2	155 *510*	190 *620*	205 *670*	225 *740*	220 *720*	160 *520*	195 *640*	210 *690*	225 *740*	225 *740*
M3	125 *410*	155 *510*	160 *520*	175 *570*	175 *570*	130 *425*	155 *510*	165 *540*	180 *590*	175 *570*
M4	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*
M5	85 *280*	100 *330*	105 *345*	110 *360*	110 *360*	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*
K1	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	190 *620*	235 *770*	250 *820*	270 *890*	270 *890*
K2	180 *590*	215 *710*	230 *750*	255 *840*	250 *820*	170 *560*	205 *670*	220 *720*	240 *790*	235 *770*
K3	150 *490*	185 *610*	195 *640*	215 *710*	210 *690*	140 *460*	175 *570*	185 *610*	200 *660*	200 *660*
K4	145 *475*	175 *570*	185 *610*	205 *670*	205 *670*	135 *445*	165 *540*	175 *570*	195 *640*	190 *620*
K5	85 *280*	105 *345*	115 *375*	125 *410*	125 *410*	80 *260*	100 *330*	105 *345*	115 *375*	115 *375*
K6	125 *410*	155 *510*	165 *540*	180 *590*	180 *590*	120 *395*	145 *475*	155 *510*	170 *560*	170 *560*
K7	110 *360*	135 *445*	145 *475*	160 *520*	155 *510*	105 *345*	130 *425*	135 *445*	150 *490*	150 *490*
N1	1525 *5000*	1850 *6075*	1975 *6475*	2150 *7050*	2150 *7050*	1450 *4750*	1750 *5750*	1875 *6150*	2025 *6650*	2025 *6650*
N2	620 *2025*	750 *2450*	800 *2625*	870 *2850*	870 *2850*	580 *1900*	710 *2325*	760 *2500*	820 *2700*	820 *2700*
N3	410 *1350*	500 *1650*	530 *1750*	580 *1900*	580 *1900*	390 *1275*	470 *1550*	500 *1650*	550 *1800*	550 *1800*
N11	470 *1550*	570 *1875*	610 *2000*	660 *2175*	660 *2175*	445 *1450*	540 *1775*	580 *1900*	620 *2025*	630 *2075*
S1	46 *150*	55 *180*	60 *195*	65 *215*	60 *195*	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*
S2	37 *120*	45 *150*	47 *155*	50 *165*	50 *165*	38 *125*	45 *150*	47 *155*	50 *165*	50 *165*
S3	32 *105*	39 *130*	40 *130*	44 *145*	44 *145*	33 *110*	40 *130*	41 *135*	45 *150*	44 *145*
S11	65 *215*	80 *260*	80 *260*	90 *295*	90 *295*	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*
S12	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	45 *150*	55 *180*	60 *195*	60 *195*	60 *195*
S13	26 *85*	31 *100*	33 *110*	35 *115*	35 *115*	27 *90*	32 *105*	33 *110*	36 *120*	36 *120*
H5	38 *125*	47 *155*	49 *160*	55 *180*	55 *180*	38 *125*	47 *155*	49 *160*	55 *180*	55 *180*
H8	40 *130*	48 *155*	50 *165*	55 *180*	55 *180*	40 *130*	49 *160*	50 *165*	55 *180*	55 *180*
H11	48 *155*	60 *195*	60 *195*	65 *215*	70 *230*	49 *160*	60 *195*	65 *215*	70 *230*	70 *230*
H12	75 *245*	95 *310*	95 *310*	105 *345*	105 *345*	70 *230*	85 *280*	90 *295*	100 *330*	100 *330*
H21	40 *130*	48 *155*	50 *165*	55 *180*	55 *180*	40 *130*	49 *160*	50 *165*	55 *180*	55 *180*

MP12 Zentrierbohren – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		f_z	a_{so}
			100%
P1	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P2	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P3	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P4	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P5	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P6	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P7	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P8	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
P11	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
P12	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,5 *0.10*
M1	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
M2	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
M3	MP12-12007C90Z2-M04 F40M	0,042 *0.0017*	2,5 *0.10*
M4	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
M5	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
K1	MP12-12007C90Z2-M04 F40M	0,055 *0.0022*	3,5 *0.14*
K2	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K3	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K4	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K5	MP12-12007C90Z2-M04 F40M	0,046 *0.0018*	3,5 *0.14*
K6	MP12-12007C90Z2-M04 F40M	0,050 *0.0020*	3,5 *0.14*
K7	MP12-12007C90Z2-M04 F40M	0,046 *0.0018*	3,5 *0.14*
N1	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
N2	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
N3	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
N11	MP12-12007C90Z2-M04 F40M	0,075 *0.0030*	3,5 *0.14*
S1	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
S2	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
S3	MP12-12007C90Z2-M04 F40M	0,034 *0.0013*	2,0 *0.080*
S11	MP12-12007C90Z2-M04 F40M	0,042 *0.0017*	2,5 *0.10*
S12	MP12-12007C90Z2-M04 F40M	0,042 *0.0017*	2,5 *0.10*
S13	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,0 *0.080*
H5	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,5 *0.10*
H8	MP12-12007C90Z2-M04 F40M	0,028 *0.0011*	2,5 *0.10*
H11	MP12-12007C90Z2-M04 F40M	0,036 *0.0014*	2,5 *0.10*
H12	MP12-12007C90Z2-M04 F40M	0,028 *0.0011*	2,5 *0.10*
H21	MP12-12007C90Z2-M04 F40M	0,028 *0.0011*	2,5 *0.10*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP12 Zentrierbohren – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F40M
	100%
P1	275 *900*
P2	265 *870*
P3	235 *770*
P4	205 *670*
P5	195 *640*
P6	220 *720*
P7	205 *670*
P8	195 *640*
P11	200 *660*
P12	125 *410*
M1	215 *710*
M2	175 *570*
M3	140 *460*
M4	105 *345*
M5	85 *280*
K1	210 *690*
K2	185 *610*
K3	155 *510*
K4	150 *490*
K5	90 *295*
K6	130 *425*
K7	120 *395*
N1	1575 *5175*
N2	640 *2100*
N3	425 *1400*
N11	490 *1600*
S1	49 *160*
S2	39 *130*
S3	34 *110*
S11	70 *230*
S12	48 *155*
S13	27 *90*
H5	42 *140*
H8	43 *140*
H11	55 *180*
H12	80 *260*
H21	43 *140*

MP12 Anfasen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z				
			100%	50%	30%	20%	10%
P1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
P2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
P3	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
P4	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
P5	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P6	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P7	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P8	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
P11	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
P12	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
M1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
M2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
M3	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
M4	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
M5	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
K1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
K2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K3	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K4	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K5	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
K6	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
K7	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
N1	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N2	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N3	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N11	MP12-12007C90Z2-M04 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
S1	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
S2	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
S3	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*
S11	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
S12	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,075 *0.0030*
S13	MP12-12007C90Z2-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,065 *0.0026*
H5	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
H8	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
H11	MP12-12007C90Z2-M04 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*
H12	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*
H21	MP12-12007C90Z2-M04 F40M	1,9 *0.075*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,038 *0.0015*	0,048 *0.0019*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP12 Anfasen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	50%	30%	20%	10%
P1	300 *980*	275 *900*	330 *1075*	365 *1200*	430 *1400*
P2	290 *950*	270 *890*	320 *1050*	355 *1175*	415 *1350*
P3	255 *840*	235 *770*	280 *920*	310 *1025*	360 *1175*
P4	225 *740*	210 *690*	250 *820*	275 *900*	320 *1050*
P5	215 *710*	200 *660*	235 *770*	260 *850*	310 *1025*
P6	240 *790*	225 *740*	265 *870*	295 *970*	345 *1125*
P7	225 *740*	210 *690*	250 *820*	275 *900*	325 *1075*
P8	215 *710*	200 *660*	235 *770*	260 *850*	305 *1000*
P11	220 *720*	205 *670*	245 *800*	270 *890*	320 *1050*
P12	140 *460*	125 *410*	150 *490*	165 *540*	205 *670*
M1	235 *770*	220 *720*	260 *850*	285 *940*	335 *1100*
M2	190 *620*	180 *590*	215 *710*	235 *770*	280 *920*
M3	150 *490*	135 *445*	165 *540*	180 *590*	220 *720*
M4	115 *375*	100 *330*	115 *375*	130 *425*	170 *560*
M5	95 *310*	85 *280*	95 *310*	110 *360*	140 *460*
K1	230 *750*	215 *710*	255 *840*	280 *920*	330 *1075*
K2	200 *660*	190 *620*	225 *740*	250 *820*	295 *970*
K3	170 *560*	160 *520*	190 *620*	210 *690*	250 *820*
K4	165 *540*	150 *490*	180 *590*	200 *660*	235 *770*
K5	100 *330*	95 *310*	110 *360*	125 *410*	145 *475*
K6	145 *475*	135 *445*	160 *520*	175 *570*	210 *690*
K7	130 *425*	120 *395*	145 *475*	160 *520*	185 *610*
N1	1725 *5650*	1600 *5250*	1900 *6225*	2100 *6900*	2450 *8050*
N2	690 *2275*	640 *2100*	770 *2525*	850 *2800*	990 *3250*
N3	460 *1500*	430 *1400*	510 *1675*	570 *1875*	660 *2175*
N11	530 *1750*	490 *1600*	590 *1925*	650 *2125*	750 *2450*
S1	55 *180*	47 *155*	55 *180*	60 *195*	80 *260*
S2	44 *145*	38 *125*	44 *145*	50 *165*	65 *215*
S3	38 *125*	33 *110*	38 *125*	43 *140*	55 *180*
S11	75 *245*	70 *230*	80 *260*	85 *280*	110 *360*
S12	55 *180*	47 *155*	55 *180*	60 *195*	75 *245*
S13	30 *100*	27 *90*	30 *100*	35 *115*	45 *150*
H5	46 *150*	42 *140*	50 *165*	55 *180*	70 *230*
H8	49 *160*	44 *145*	50 *165*	55 *180*	70 *230*
H11	60 *195*	55 *180*	65 *215*	70 *230*	85 *280*
H12	85 *280*	80 *260*	90 *295*	100 *330*	125 *410*
H21	49 *160*	44 *145*	50 *165*	55 *180*	70 *230*

MP16 Schaft – Metrisch



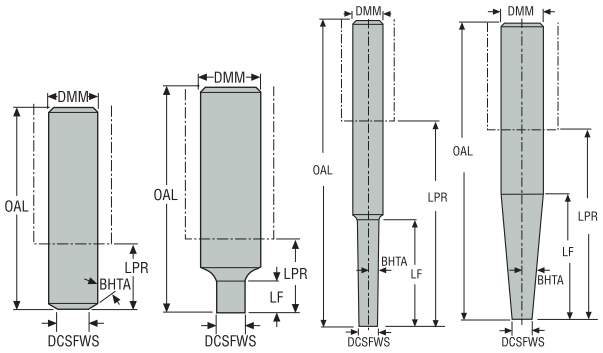
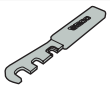
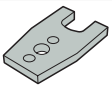


Abb. 1 **Abb. 2** **Abb. 3** **Abb. 4**

- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen.

Bezeichnung	Aufnahme	DCSFWS	DMM	OAL	LPR	LF	RPMX	BHTA°	Abb.		Gewicht
		mm	mm	mm	mm	mm					kg
MP16-16068-016.00	Zylindrisch	15,2	16,0	68,0	20,0	16,0	63600	0,0	2	✓	0,1
MP16-20070-000.60	Zylindrisch	15,2	20,0	70,0	20,0	0,0	63600	60,0	1	✓	0,2
MP16-20090-024.00	Zylindrisch	15,2	20,0	90,0	40,0	24,0	63600	0,0	2	✓	0,2
MP16-20190-056.01	Zylindrisch	15,2	20,0	190,0	140,0	56,0	63600	1,0	3	✓	0,4
MP16-20195-095.01	Zylindrisch	15,2	20,0	195,0	145,0	95,0	63600	1,0	3	✓	0,4
MP16-25136-075.03	Zylindrisch	15,2	25,0	136,0	80,0	75,0	63600	3,0	3	✓	0,4
MP16-25181-125.03	Zylindrisch	15,2	25,0	181,0	125,0	93,5	63600	3,0	4	✓	0,6
MP16-25181-125.05	Zylindrisch	15,2	25,0	181,0	125,0	56,0	63600	5,0	4	✓	0,6
MP16-16126-048.00-E	Zylindrisch	15,2	16,0	126,0	78,0	48,0	63600	0,0	2	✓	0,4
MP16-16140-064.00-E	Zylindrisch	15,2	16,0	140,0	92,0	64,0	63600	0,0	2	✓	0,4
MP16-16180-096.00-E	Zylindrisch	15,2	16,0	180,0	132,0	96,0	63600	0,0	2	✓	0,5
MP16-20135-080.01-E	Zylindrisch	15,2	20,0	135,0	85,0	80,0	63600	1,0	3	✓	0,5
MP16-20180-128.01-E	Zylindrisch	15,2	20,0	180,0	130,0	128,0	63600	1,0	3	✓	0,7
MP16-20200-150.01-E	Zylindrisch	15,2	20,0	200,0	150,0	137,5	63600	1,0	4	✓	0,8
MP16-20180-130.03-E	Zylindrisch	15,2	20,0	180,0	130,0	45,8	63600	3,0	4	✓	0,8
MP16-20210-160.03-E	Zylindrisch	15,2	20,0	210,0	160,0	45,8	63600	3,0	4	✓	0,9

Zubehör

Schlüssel	Ersatzklinge	Drehmoment-schlüssel
		
MP1016	MP00-16M	MP00-16.190

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten.

MP16 Schaft – Zoll

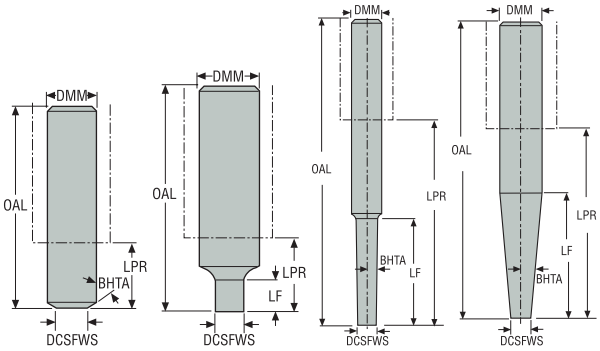


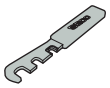
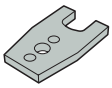
Abb. 1 Abb. 2 Abb. 3 Abb. 4



- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen.

Bezeichnung	Aufnahme	DCSFMS	DMM	OAL	LPR	LF	RPMX	BHTA°	Abb.		Gewicht
		Zoll	Zoll	Zoll	Zoll	Zoll					lbs
MP16-0622.6-0.63.00	Zylindrisch	0.598	0.625	2.662	0.787	0.630	63600	0,0	2	✓	0.220
MP16-0752.7-0.00.60	Zylindrisch	0.598	0.750	2.787	0.787	0	63600	60,0	1	✓	1.540
MP16-0753.5-0.94.00	Zylindrisch	0.598	0.750	3.575	1.575	0.945	63600	0,0	2	✓	0.440
MP16-0757.5-2.20.01	Zylindrisch	0.598	0.750	7.512	5.512	2.205	63600	1,0	3	✓	0.880
MP16-0757.7-3.74.01	Zylindrisch	0.598	0.750	7.709	5.709	3.740	63600	1,0	3	✓	0.880
MP16-1007.1-4.92.05	Zylindrisch	0.598	1.000	7.171	4.921	2.295	63600	5,0	4	✓	0.440
MP16-0627.0-3.77.00-E	Zylindrisch	0.598	0.625	7.072	5.197	3.780	63600	0,0	2	✓	1.100
MP16-0757.9-5.90.01-E	Zylindrisch	0.598	0.750	7.906	5.906	4.342	63600	1,0	4	✓	1.540
MP16-0758.2-6.29.03-E	Zylindrisch	0.598	0.750	8.299	6.299	1.446	63600	3,0	4	✓	1.760

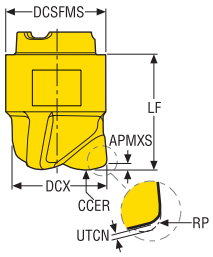
Zubehör

Schlüssel	Ersatzklinge	Drehmoment-schlüssel
		
MP1016	MP00-16M	MP00-16.190

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten.

MP16 Hochvorschubfräser





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 521-522

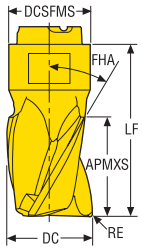
Z3



Bezeichnung	DCX	DC	APMXS	DCSFMS	CCER	RP	LF	UTCN	RMPX°	C min	C max	ZEFP		Sorten	
														Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						MP3000	F40M
MP16-1600.9HFZ3-MD12	16,0 *0.630*	8,0 *0.315*	0,9 *0.035*	15,4 *0.606*	7,8 *0.307*	1,79 *0.070*	18,5 *0.728*	0,46 *0.018*	5,0	17,3	23,8	3	✓	■	
MP16-1580.9HFZ3-MD12	15,875 *0.625*	7,88 *0.310*	0,9 *0.035*	15,4 *0.606*	7,8 *0.307*	1,79 *0.070*	18,5 *0.728*	0,46 *0.018*	5,0	17,2	23,5	3	✓	■	

MP16 Eckfräser

Nut- und Konturfräsen





• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 523-524

Z3

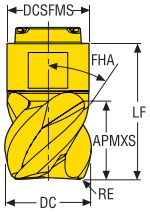


Bezeichnung	DC	APMXS	RE	DCSFMS	FHA	LF	RMPX°	C min	C max	ZEFP		Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						MP3000	F40M
MP16-16010R04Z3-M05	16,0 *0.630*	10,0 *0.394*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	31,0	3	✓	■	
MP16-16010R05Z3-E05	16,0 *0.630*	10,0 *0.394*	0,5 *0.020*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	30,8	3	✓		■
MP16-16010R08Z3-E05	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	30,0	3	✓		■
MP16-16010R08Z3-M05	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	30,0	3	✓	■	
MP16-16010R12Z3-E05	16,0 *0.630*	10,0 *0.394*	1,2 *0.047*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	29,4	3	✓		■
MP16-16010R20Z3-E05	16,0 *0.630*	10,0 *0.394*	2,0 *0.079*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	27,8	3	✓		■
MP16-16010R31Z3-E05	16,0 *0.630*	10,0 *0.394*	3,1 *0.122*	15,4 *0.606*	30 *1.181*	24,6 *0.969*	15,0	19,4	25,6	3	✓		■
MP16-15719KWZ3-E05	15,7 *0.618*	19,0 *0.748*	0,3 *0.012*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,0	29,6	3	✓		■
MP16-16019R04Z3-M05	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	31,0	3	✓	■	
MP16-16019R05Z3-E05	16,0 *0.630*	19,0 *0.748*	0,5 *0.020*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	30,8	3	✓		■
MP16-16019R08Z3-E05	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	30,2	3	✓		■
MP16-16019R08Z3-M05	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	30,2	3	✓	■	
MP16-16019R20Z3-E05	16,0 *0.630*	19,0 *0.748*	2,0 *0.079*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	27,8	3	✓		■
MP16-16019R31Z3-E05	16,0 *0.630*	19,0 *0.748*	3,1 *0.122*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,4	25,6	3	✓		■
MP16-15919R04Z3-E05	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	30,7	3	✓		■
MP16-15919R04Z3-M05	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	30,7	3	✓	■	
MP16-15919R08Z3-E05	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	29,9	3	✓		■
MP16-15919R08Z3-M05	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	29,9	3	✓	■	
MP16-15919R31Z3-E05	15,875 *0.625*	19,0 *0.748*	3,1 *0.122*	15,4 *0.606*	30 *1.181*	32,6 *1.283*	15,0	19,3	25,3	3	✓		■

MP16 Eckfräser

Nut- und Konturfräsen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 523-524

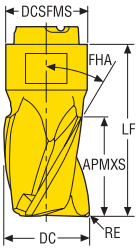
Z4



Bezeichnung	DC	APMXS	RE	DCSFMS	FHA	LF	RMPX°	C min	C max	ZEFP	Sorten Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					MP3000	F40M
MP16-16010R04Z4-M04	16,0 *0.630*	10,0 *0.394*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	31,0	4	■	
MP16-16010R05Z4-E04	16,0 *0.630*	10,0 *0.394*	0,5 *0.020*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	30,8	4		■
MP16-16010R08Z4-E04	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	30,2	4		■
MP16-16010R08Z4-M04	16,0 *0.630*	10,0 *0.394*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	30,2	4	■	
MP16-16010R16Z4-M04	16,0 *0.630*	10,0 *0.394*	1,6 *0.063*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	28,6	4	■	
MP16-16010R31Z4-E04	16,0 *0.630*	10,0 *0.394*	3,1 *0.122*	15,4 *0.606*	50 *1.969*	24,6 *0.969*	15,0	19,4	25,6	4		■
MP16-16019R04Z4-E04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	31,0	4		■
MP16-16019R04Z4-M04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	31,0	4	■	
MP16-16019R05Z4-E04	16,0 *0.630*	19,0 *0.748*	0,5 *0.020*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	30,8	4		■
MP16-16019R08Z4-E04	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	30,2	4		■
MP16-16019R08Z4-M04	16,0 *0.630*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	30,2	4	■	
MP16-16019R16Z4-E04	16,0 *0.630*	19,0 *0.748*	1,6 *0.063*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	28,6	4		■
MP16-16019R20Z4-E04	16,0 *0.630*	19,0 *0.748*	2,0 *0.079*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,4	27,8	4		■
MP16-15919R04Z4-E04	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	30,7	4		■
MP16-15919R04Z4-M04	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	30,7	4	■	
MP16-15919R08Z4-E04	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	29,9	4		■
MP16-15919R08Z4-M04	15,875 *0.625*	19,0 *0.748*	0,8 *0.031*	15,4 *0.606*	50 *1.969*	32,6 *1.283*	15,0	19,3	29,9	4	■	

MP16 Eckfräser

Nur Konturfräsen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 523-524

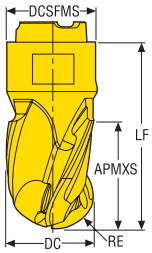
Z6/Z8



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	ZEFP		Sorten	
									Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP16-16019R04Z6-M04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	32,6 *1.283*	40	6	✓	■	
MP16-16019R04Z8-M04	16,0 *0.630*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	32,6 *1.283*	40	8	✓	■	
MP16-15919R04Z6-M04	15,875 *0.625*	19,0 *0.748*	0,4 *0.016*	15,4 *0.606*	32,6 *1.283*	40	6	✓	■	

MP16 Kugelkopffräser





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 525-526

Z3

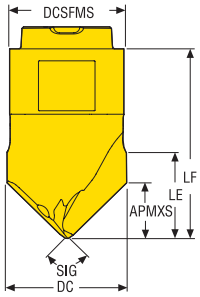


Z4



Bezeichnung	DC	APMXS	RE	DCSFMS	LF	FHA	RMPX°	ZEFP		Sorten	
										Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					MP3000	F40M
MP16-16010B90Z3-E05	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓		■
MP16-16010B90Z3-M05	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓	■	
MP16-16019B90Z3-E05	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓		■
MP16-16019B90Z3-M05	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓	■	
MP16-16010B90Z4-E04	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	20	15,0	4			■
MP16-16010B90Z4-M04	16,0 *0.630*	10,0 *0.394*	8,0 *0.315*	15,4 *0.606*	24,6 *0.969*	20	15,0	4		■	
MP16-15910B90Z3-E05	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓		■
MP16-15910B90Z3-M05	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	30	15,0	3	✓	■	
MP16-15919B90Z3-E05	15,875 *0.625*	19,0 *0.748*	7,9375 *0.313*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓		■
MP16-15919B90Z3-M05	15,875 *0.625*	19,0 *0.748*	7,9375 *0.313*	15,4 *0.606*	32,6 *1.283*	30	15,0	3	✓	■	
MP16-15910B90Z4-E04	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	20	15,0	4			■
MP16-15910B90Z4-M04	15,875 *0.625*	10,0 *0.394*	7,9375 *0.313*	15,4 *0.606*	24,6 *0.969*	20	15,0	4		■	

MP16 Zentrierbohren





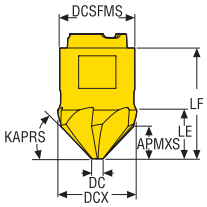
- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 527-528

Z2



Bezeichnung	DC	APMXS	DCSFMS	LE	LF	SIG°	ZEFP		Sorten	
									Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP16-16009C90Z2-M05	16,0 *0.630*	7,4 *0.291*	15,4 *0.606*	12,0 *0.472*	26,4 *1.039*	90,0	2	✓		■

MP16 Anfasen





- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 529-530

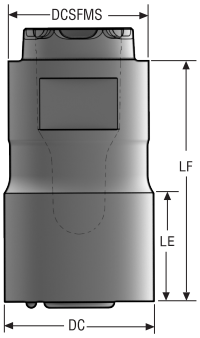
Z6



Bezeichnung	DCX	DC	APMXS	DCSFMS	LE	LF	KAPRS°	ZEFP		Sorten	
										Beschichtet	
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				MP3000	F40M
MP16-16009C90Z6-M05	16,4 *0.646*	3,95 *0.156*	6,0 *0.236*	15,4 *0.606*	10,4 *0.409*	23,5 *0.925*	45,0	6			■

MP16 Zylindrische Rohlinge





- Zylindrische Hartmetall-Rohlinge zur Herstellung eigener Geometrien





Bezeichnung	DC	DCSFMS	LE	LF		Sorten
						Unbeschichtet
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		H25
MP16-16010CYL-SEMI	16,4 *0.646*	15,4 *0.606*	11,4 *0.449*	24,8 *0.976*		■
MP16-16019CYL-SEMI	16,4 *0.646*	15,4 *0.606*	19,5 *0.768*	32,85 *1.293*	✓	■

MP16 Hochvorschubfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
P2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
P3	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
P4	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	0,95 *0.038*
P5	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P6	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P7	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P8	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,80 *0.032*	1,0 *0.040*
P11	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P12	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,44 *0.017*	0,40 *0.016*	0,50 *0.020*	0,60 *0.024*
M1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
M2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
M3	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,55 *0.022*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
M4	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
M5	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
K1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,0 *0.040*
K2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K3	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K4	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K5	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
K6	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K7	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
N1	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
N2	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
N3	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
N11	MP16-1600.9HFZ3-MD12 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*	1,4 *0.055*
S1	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
S2	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
S3	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,44 *0.017*	0,38 *0.015*	0,50 *0.020*	0,60 *0.024*
S11	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,55 *0.022*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
S12	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,55 *0.022*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
S13	MP16-1600.9HFZ3-MD12 MP3000	0,38 *0.015*	0,48 *0.019*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
H5	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,44 *0.017*	0,40 *0.016*	0,50 *0.020*	0,60 *0.024*
H8	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,34 *0.013*	0,30 *0.012*	0,40 *0.016*	0,46 *0.018*
H11	MP16-1600.9HFZ3-MD12 MP3000	0,50 *0.020*	0,44 *0.017*	0,40 *0.016*	0,50 *0.020*	0,60 *0.024*
H12	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,34 *0.013*	0,30 *0.012*	0,40 *0.016*	0,46 *0.018*
H21	MP16-1600.9HFZ3-MD12 MP3000	0,44 *0.017*	0,34 *0.013*	0,30 *0.012*	0,40 *0.016*	0,46 *0.018*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP16 Hochvorschubfräsen – Schnittdaten v_c =(m/min)

SMG	MP3000			
	100%	70%	30%	20%
P1	225 *740*	270 *890*	315 *1025*	335 *1100*
P2	215 *710*	265 *870*	305 *1000*	325 *1075*
P3	190 *620*	230 *750*	265 *870*	280 *920*
P4	165 *540*	205 *670*	235 *770*	250 *820*
P5	160 *520*	195 *640*	230 *750*	240 *790*
P6	180 *590*	220 *720*	255 *840*	265 *870*
P7	170 *560*	205 *670*	240 *790*	250 *820*
P8	160 *520*	195 *640*	225 *740*	235 *770*
P11	165 *540*	200 *660*	235 *770*	245 *800*
P12	105 *345*	130 *425*	150 *490*	160 *520*
M1	160 *520*	195 *640*	230 *750*	245 *800*
M2	130 *425*	165 *540*	190 *620*	200 *660*
M3	105 *345*	135 *445*	155 *510*	160 *520*
M4	85 *280*	105 *345*	115 *375*	125 *410*
M5	70 *230*	85 *280*	100 *330*	105 *345*
K1	170 *560*	210 *690*	240 *790*	255 *840*
K2	150 *490*	185 *610*	215 *710*	225 *740*
K3	125 *410*	155 *510*	185 *610*	190 *620*
K4	120 *395*	150 *490*	175 *570*	180 *590*
K5	75 *245*	95 *310*	105 *345*	110 *360*
K6	105 *345*	130 *425*	155 *510*	160 *520*
K7	95 *310*	120 *395*	135 *445*	145 *475*
N1	1275 *4175*	1550 *5075*	1775 *5825*	1850 *6075*
N2	510 *1675*	630 *2075*	720 *2350*	750 *2450*
N3	340 *1125*	420 *1375*	480 *1575*	500 *1650*
N11	390 *1275*	480 *1575*	550 *1800*	570 *1875*
S1	40 *130*	48 *155*	55 *180*	60 *195*
S2	32 *105*	39 *130*	44 *145*	47 *155*
S3	28 *90*	34 *110*	39 *130*	41 *135*
S11	55 *180*	65 *215*	75 *245*	80 *260*
S12	38 *125*	46 *150*	55 *180*	55 *180*
S13	22 *70*	27 *90*	31 *100*	33 *110*
H5	33 *110*	41 *135*	47 *155*	50 *165*
H8	36 *120*	43 *140*	50 *165*	55 *180*
H11	42 *140*	50 *165*	60 *195*	65 *215*
H12	70 *230*	85 *280*	95 *310*	100 *330*
H21	36 *120*	43 *140*	50 *165*	55 *180*

MP16 Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	30%	10%	5%
P1	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,075 *0.0030*	0,12 *0.0048*	0,16 *0.0065*
P2	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
P3	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*	0,16 *0.0065*
P4	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*	0,16 *0.0065*
P5	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P6	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P7	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P8	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*	0,16 *0.0065*
P11	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
P12	MP16-16010R04Z3-M05 MP3000	4,0 *0.16*	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 *0.0040*
M1	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
M2	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
M3	MP16-16010R05Z3-E05 F40M	4,0 *0.16*	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
M4	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
M5	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
K1	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*
K2	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K3	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K4	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K5	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*	0,14 *0.0055*
K6	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,15 *0.0060*
K7	MP16-16010R04Z3-M05 MP3000	5,0 *0.20*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*	0,14 *0.0055*
N1	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
N2	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
N3	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
N11	MP16-16010R05Z3-E05 F40M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*	0,22 *0.0085*
S1	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
S2	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
S3	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*	0,10 *0.0040*
S11	MP16-16010R05Z3-E05 F40M	3,5 *0.14*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
S12	MP16-16010R05Z3-E05 F40M	3,5 *0.14*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*	0,12 *0.0048*
S13	MP16-16010R05Z3-E05 F40M	3,0 *0.12*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*	0,11 *0.0044*
H5	MP16-16010R04Z3-M05 MP3000	4,0 *0.16*	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 *0.0040*
H8	MP16-16010R04Z3-M05 MP3000	3,5 *0.14*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*
H11	MP16-16010R04Z3-M05 MP3000	4,0 *0.16*	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 *0.0040*
H12	MP16-16010R04Z3-M05 MP3000	3,5 *0.14*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*
H21	MP16-16010R04Z3-M05 MP3000	3,5 *0.14*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*	0,080 *0.0032*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP16 Nutfräsen – Schnittdaten v_c =(m/min)

SMG	MP3000				F40M			
	100%	30%	10%	5%	100%	30%	10%	5%
P1	235 *770*	310 *1025*	360 *1175*	395 *1300*	225 *740*	295 *970*	340 *1125*	375 *1225*
P2	230 *750*	300 *980*	350 *1150*	380 *1250*	215 *710*	280 *920*	335 *1100*	360 *1175*
P3	195 *640*	260 *850*	310 *1025*	330 *1075*	185 *610*	245 *800*	290 *950*	315 *1025*
P4	175 *570*	230 *750*	270 *890*	290 *950*	165 *540*	215 *710*	255 *840*	275 *900*
P5	170 *560*	220 *720*	260 *850*	280 *920*	160 *520*	210 *690*	245 *800*	265 *870*
P6	190 *620*	250 *820*	290 *950*	315 *1025*	180 *590*	235 *770*	275 *900*	300 *980*
P7	180 *590*	235 *770*	275 *900*	300 *980*	170 *560*	225 *740*	260 *850*	285 *940*
P8	165 *540*	220 *720*	260 *850*	280 *920*	155 *510*	205 *670*	245 *800*	265 *870*
P11	175 *570*	230 *750*	265 *870*	290 *950*	165 *540*	215 *710*	255 *840*	275 *900*
P12	110 *360*	145 *475*	170 *560*	185 *610*	105 *345*	140 *460*	160 *520*	175 *570*
M1	170 *560*	225 *740*	265 *870*	285 *940*	175 *570*	225 *740*	270 *890*	290 *950*
M2	140 *460*	185 *610*	215 *710*	235 *770*	145 *475*	190 *620*	220 *720*	240 *790*
M3	115 *375*	150 *490*	175 *570*	190 *620*	115 *375*	150 *490*	175 *570*	190 *620*
M4	85 *280*	115 *375*	135 *445*	145 *475*	90 *295*	115 *375*	135 *445*	145 *475*
M5	75 *245*	95 *310*	110 *360*	120 *395*	75 *245*	95 *310*	115 *375*	120 *395*
K1	180 *590*	235 *770*	280 *920*	300 *980*	170 *560*	225 *740*	265 *870*	285 *940*
K2	160 *520*	210 *690*	245 *800*	270 *890*	150 *490*	200 *660*	235 *770*	255 *840*
K3	135 *445*	180 *590*	210 *690*	225 *740*	130 *425*	170 *560*	195 *640*	215 *710*
K4	130 *425*	170 *560*	200 *660*	215 *710*	120 *395*	160 *520*	190 *620*	205 *670*
K5	80 *260*	105 *345*	120 *395*	130 *425*	75 *245*	95 *310*	115 *375*	125 *410*
K6	115 *375*	150 *490*	175 *570*	190 *620*	110 *360*	140 *460*	165 *540*	180 *590*
K7	100 *330*	130 *425*	155 *510*	165 *540*	95 *310*	125 *410*	145 *475*	160 *520*
N1	1350 *4425*	1775 *5825*	2100 *6900*	2250 *7375*	1275 *4175*	1675 *5500*	1975 *6475*	2125 *6975*
N2	550 *1800*	720 *2350*	850 *2800*	910 *2975*	520 *1700*	680 *2225*	800 *2625*	860 *2825*
N3	365 *1200*	475 *1550*	560 *1825*	600 *1975*	345 *1125*	450 *1475*	530 *1750*	570 *1875*
N11	415 *1350*	540 *1775*	640 *2100*	690 *2275*	395 *1300*	520 *1700*	610 *2000*	650 *2125*
S1	41 *135*	55 *180*	60 *195*	65 *215*	42 *140*	55 *180*	65 *215*	70 *230*
S2	33 *110*	43 *140*	50 *165*	55 *180*	34 *110*	44 *145*	50 *165*	55 *180*
S3	29 *95*	38 *125*	44 *145*	47 *155*	29 *95*	38 *125*	45 *150*	48 *155*
S11	60 *195*	75 *245*	90 *295*	95 *310*	60 *195*	75 *245*	90 *295*	95 *310*
S12	40 *130*	50 *165*	60 *195*	65 *215*	40 *130*	55 *180*	60 *195*	65 *215*
S13	23 *75*	30 *100*	35 *115*	38 *125*	23 *75*	31 *100*	36 *120*	38 *125*
H5	35 *115*	45 *150*	55 *180*	60 *195*	35 *115*	46 *150*	55 *180*	60 *195*
H8	36 *120*	47 *155*	55 *180*	60 *195*	37 *120*	48 *155*	55 *180*	60 *195*
H11	44 *145*	60 *195*	65 *215*	75 *245*	45 *150*	60 *195*	70 *230*	75 *245*
H12	70 *230*	90 *295*	105 *345*	115 *375*	65 *215*	85 *280*	100 *330*	110 *360*
H21	36 *120*	47 *155*	55 *180*	60 *195*	37 *120*	48 *155*	55 *180*	60 *195*

MP16 Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z				
			100%	30%	10%	5%	2%
P1	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
P2	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,28 *0.011*
P3	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
P4	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
P5	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
P6	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,11 *0.0044*	0,16 *0.0065*	0,26 *0.010*
P7	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,11 *0.0044*	0,16 *0.0065*	0,26 *0.010*
P8	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
P11	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,11 *0.0044*	0,16 *0.0065*	0,26 *0.010*
P12	MP16-16010B90Z3-M05 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*	0,17 *0.0065*
M1	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,28 *0.011*
M2	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
M3	MP16-16010B90Z3-E05 F40M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
M4	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
M5	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
K1	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*	0,18 *0.0070*	0,28 *0.011*
K2	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K3	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K4	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K5	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,24 *0.0095*
K6	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
K7	MP16-16010B90Z3-M05 MP3000	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*	0,24 *0.0095*
N1	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
N2	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
N3	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
N11	MP16-16010B90Z3-E05 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,16 *0.0065*	0,22 *0.0085*	0,38 *0.015*
S1	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
S2	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
S3	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
S11	MP16-16010B90Z3-E05 F40M	3,5 *0.14*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
S12	MP16-16010B90Z3-E05 F40M	3,5 *0.14*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
S13	MP16-16010B90Z3-E05 F40M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
H5	MP16-16010B90Z3-M05 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*	0,17 *0.0065*
H8	MP16-16010B90Z3-M05 MP3000	3,5 *0.14*	0,042 *0.0017*	0,042 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H11	MP16-16010B90Z3-M05 MP3000	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*	0,17 *0.0065*
H12	MP16-16010B90Z3-M05 MP3000	3,5 *0.14*	0,042 *0.0017*	0,042 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H21	MP16-16010B90Z3-M05 MP3000	3,5 *0.14*	0,042 *0.0017*	0,042 *0.0017*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP16 Kopierfräsen – Schnittdaten v_c =(m/min)

SMG	MP3000					F40M				
	100%	30%	10%	5%	2%	100%	30%	10%	5%	2%
P1	250 *820*	305 *1000*	330 *1075*	355 *1175*	350 *1150*	235 *770*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P2	240 *790*	295 *970*	320 *1050*	345 *1125*	340 *1125*	225 *740*	275 *900*	300 *980*	325 *1075*	325 *1075*
P3	210 *690*	255 *840*	275 *900*	300 *980*	300 *980*	200 *660*	240 *790*	260 *850*	285 *940*	280 *920*
P4	185 *610*	225 *740*	245 *800*	265 *870*	265 *870*	175 *570*	215 *710*	235 *770*	250 *820*	250 *820*
P5	180 *590*	215 *710*	235 *770*	255 *840*	255 *840*	170 *560*	205 *670*	220 *720*	240 *790*	240 *790*
P6	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	190 *620*	230 *750*	250 *820*	270 *890*	270 *890*
P7	190 *620*	230 *750*	250 *820*	270 *890*	270 *890*	180 *590*	215 *710*	235 *770*	255 *840*	255 *840*
P8	175 *570*	215 *710*	230 *750*	250 *820*	250 *820*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P11	185 *610*	225 *740*	240 *790*	265 *870*	260 *850*	175 *570*	210 *690*	230 *750*	250 *820*	245 *800*
P12	120 *395*	145 *475*	150 *490*	165 *540*	165 *540*	110 *360*	135 *445*	145 *475*	155 *510*	155 *510*
M1	180 *590*	220 *720*	240 *790*	260 *850*	255 *840*	185 *610*	225 *740*	245 *800*	265 *870*	260 *850*
M2	150 *490*	180 *590*	195 *640*	215 *710*	210 *690*	150 *490*	185 *610*	200 *660*	215 *710*	215 *710*
M3	120 *395*	145 *475*	155 *510*	170 *560*	165 *540*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M4	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	95 *310*	120 *395*	120 *395*	130 *425*	130 *425*
M5	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*	80 *260*	100 *330*	100 *330*	110 *360*	110 *360*
K1	190 *620*	230 *750*	255 *840*	275 *900*	270 *890*	180 *590*	220 *720*	240 *790*	260 *850*	255 *840*
K2	170 *560*	205 *670*	225 *740*	245 *800*	240 *790*	160 *520*	195 *640*	210 *690*	230 *750*	225 *740*
K3	145 *475*	175 *570*	190 *620*	205 *670*	205 *670*	135 *445*	165 *540*	180 *590*	195 *640*	190 *620*
K4	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	130 *425*	155 *510*	170 *560*	185 *610*	185 *610*
K5	80 *260*	100 *330*	110 *360*	120 *395*	120 *395*	80 *260*	95 *310*	105 *345*	110 *360*	110 *360*
K6	120 *395*	145 *475*	160 *520*	175 *570*	170 *560*	115 *375*	140 *460*	150 *490*	165 *540*	160 *520*
K7	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*	100 *330*	120 *395*	130 *425*	145 *475*	145 *475*
N1	1425 *4675*	1750 *5750*	1900 *6225*	2050 *6725*	2025 *6650*	1350 *4425*	1650 *5425*	1775 *5825*	1950 *6400*	1925 *6325*
N2	580 *1900*	700 *2300*	760 *2500*	830 *2725*	820 *2700*	550 *1800*	660 *2175*	720 *2350*	780 *2550*	780 *2550*
N3	385 *1275*	470 *1550*	510 *1675*	550 *1800*	550 *1800*	365 *1200*	445 *1450*	480 *1575*	520 *1700*	520 *1700*
N11	440 *1450*	540 *1775*	580 *1900*	630 *2075*	630 *2075*	415 *1350*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	45 *150*	55 *180*	55 *180*	60 *195*	60 *195*
S2	36 *120*	44 *145*	45 *150*	48 *155*	48 *155*	36 *120*	44 *145*	45 *150*	49 *160*	49 *160*
S3	31 *100*	38 *125*	39 *130*	42 *140*	42 *140*	32 *105*	38 *125*	40 *130*	43 *140*	43 *140*
S11	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*	65 *215*	75 *245*	80 *260*	85 *280*	85 *280*
S12	43 *140*	50 *165*	55 *180*	60 *195*	60 *195*	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*
S13	25 *80*	30 *100*	31 *100*	34 *110*	34 *110*	25 *80*	31 *100*	32 *105*	34 *110*	34 *110*
H5	37 *120*	45 *150*	47 *155*	50 *165*	50 *165*	37 *120*	45 *150*	48 *155*	50 *165*	50 *165*
H8	39 *130*	47 *155*	49 *160*	55 *180*	55 *180*	39 *130*	48 *155*	49 *160*	55 *180*	55 *180*
H11	47 *155*	55 *180*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	90 *295*	95 *310*	100 *330*	100 *330*	70 *230*	85 *280*	90 *295*	95 *310*	95 *310*
H21	39 *130*	47 *155*	49 *160*	55 *180*	55 *180*	39 *130*	48 *155*	49 *160*	55 *180*	55 *180*

MP16 Zentrierbohren – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		f_z	a_{so}
			100%
P1	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P2	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P3	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P4	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P5	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P6	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P7	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P8	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
P11	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
P12	MP16-16009C90Z2-M05 F40M	0,044 *0.0017*	3,5 *0.14*
M1	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
M2	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
M3	MP16-16009C90Z2-M05 F40M	0,050 *0.0020*	3,5 *0.14*
M4	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
M5	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
K1	MP16-16009C90Z2-M05 F40M	0,070 *0.0028*	4,5 *0.18*
K2	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K3	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K4	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K5	MP16-16009C90Z2-M05 F40M	0,060 *0.0024*	4,5 *0.18*
K6	MP16-16009C90Z2-M05 F40M	0,065 *0.0026*	4,5 *0.18*
K7	MP16-16009C90Z2-M05 F40M	0,060 *0.0024*	4,5 *0.18*
N1	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
N2	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
N3	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
N11	MP16-16009C90Z2-M05 F40M	0,090 *0.0036*	4,5 *0.18*
S1	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
S2	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
S3	MP16-16009C90Z2-M05 F40M	0,042 *0.0017*	2,5 *0.10*
S11	MP16-16009C90Z2-M05 F40M	0,050 *0.0020*	3,0 *0.12*
S12	MP16-16009C90Z2-M05 F40M	0,050 *0.0020*	3,0 *0.12*
S13	MP16-16009C90Z2-M05 F40M	0,046 *0.0018*	2,5 *0.10*
H5	MP16-16009C90Z2-M05 F40M	0,044 *0.0017*	3,5 *0.14*
H8	MP16-16009C90Z2-M05 F40M	0,034 *0.0013*	3,0 *0.12*
H11	MP16-16009C90Z2-M05 F40M	0,044 *0.0017*	3,5 *0.14*
H12	MP16-16009C90Z2-M05 F40M	0,034 *0.0013*	3,0 *0.12*
H21	MP16-16009C90Z2-M05 F40M	0,034 *0.0013*	3,0 *0.12*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP16 Zentrierbohren – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F40M
	100%
P1	290 *950*
P2	285 *940*
P3	250 *820*
P4	220 *720*
P5	210 *690*
P6	235 *770*
P7	225 *740*
P8	210 *690*
P11	220 *720*
P12	140 *460*
M1	230 *750*
M2	190 *620*
M3	150 *490*
M4	115 *375*
M5	95 *310*
K1	225 *740*
K2	200 *660*
K3	170 *560*
K4	160 *520*
K5	100 *330*
K6	145 *475*
K7	125 *410*
N1	1650 *5425*
N2	670 *2200*
N3	445 *1450*
N11	510 *1675*
S1	55 *180*
S2	43 *140*
S3	37 *120*
S11	75 *245*
S12	50 *165*
S13	30 *100*
H5	46 *150*
H8	48 *155*
H11	60 *195*
H12	85 *280*
H21	48 *155*

MP16 Anfasen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z				
			100%	50%	30%	20%	10%
P1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
P2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
P3	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
P4	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*
P5	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P6	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P7	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P8	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
P11	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
P12	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*
M1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
M2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
M3	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
M4	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
M5	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
K1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
K2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K3	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K4	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K5	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,10 *0.0040*
K6	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K7	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,10 *0.0040*
N1	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N2	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N3	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N11	MP16-16009C90Z2-M05 F40M	3,5 *0.14*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
S1	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
S2	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
S3	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*
S11	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
S12	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*
S13	MP16-16009C90Z2-M05 F40M	2,0 *0.080*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
H5	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*
H8	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*
H11	MP16-16009C90Z2-M05 F40M	3,0 *0.12*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*
H12	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*
H21	MP16-16009C90Z2-M05 F40M	2,5 *0.10*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0024*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MP16 Anfasen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	50%	30%	20%	10%
P1	290 *950*	270 *890*	315 *1025*	350 *1150*	415 *1350*
P2	285 *940*	260 *850*	310 *1025*	345 *1125*	400 *1300*
P3	250 *820*	230 *750*	270 *890*	300 *980*	345 *1125*
P4	220 *720*	200 *660*	235 *770*	265 *870*	310 *1025*
P5	210 *690*	195 *640*	230 *750*	255 *840*	295 *970*
P6	235 *770*	220 *720*	260 *850*	285 *940*	335 *1100*
P7	225 *740*	205 *670*	245 *800*	270 *890*	315 *1025*
P8	210 *690*	190 *620*	225 *740*	250 *820*	290 *950*
P11	220 *720*	200 *660*	235 *770*	260 *850*	305 *1000*
P12	140 *460*	125 *410*	140 *460*	160 *520*	195 *640*
M1	230 *750*	210 *690*	250 *820*	275 *900*	325 *1075*
M2	190 *620*	175 *570*	205 *670*	230 *750*	265 *870*
M3	150 *490*	135 *445*	155 *510*	175 *570*	215 *710*
M4	115 *375*	95 *310*	115 *375*	125 *410*	165 *540*
M5	95 *310*	80 *260*	95 *310*	105 *345*	135 *445*
K1	225 *740*	205 *670*	245 *800*	270 *890*	320 *1050*
K2	200 *660*	185 *610*	220 *720*	240 *790*	280 *920*
K3	170 *560*	155 *510*	185 *610*	205 *670*	240 *790*
K4	160 *520*	150 *490*	175 *570*	195 *640*	230 *750*
K5	100 *330*	90 *295*	105 *345*	120 *395*	140 *460*
K6	145 *475*	130 *425*	155 *510*	170 *560*	200 *660*
K7	125 *410*	115 *375*	135 *445*	150 *490*	175 *570*
N1	1650 *5425*	1500 *4925*	1800 *5900*	2000 *6550*	2325 *7625*
N2	670 *2200*	610 *2000*	720 *2350*	810 *2650*	940 *3075*
N3	445 *1450*	405 *1325*	485 *1600*	540 *1775*	630 *2075*
N11	510 *1675*	465 *1525*	550 *1800*	610 *2000*	720 *2350*
S1	55 *180*	44 *145*	55 *180*	60 *195*	75 *245*
S2	43 *140*	35 *115*	43 *140*	47 *155*	60 *195*
S3	37 *120*	31 *100*	38 *125*	42 *140*	55 *180*
S11	75 *245*	65 *215*	75 *245*	85 *280*	110 *360*
S12	50 *165*	45 *150*	50 *165*	60 *195*	75 *245*
S13	30 *100*	25 *80*	30 *100*	33 *110*	43 *140*
H5	46 *150*	41 *135*	47 *155*	55 *180*	65 *215*
H8	48 *155*	42 *140*	48 *155*	55 *180*	70 *230*
H11	60 *195*	50 *165*	60 *195*	70 *230*	85 *280*
H12	85 *280*	75 *245*	85 *280*	100 *330*	125 *410*
H21	48 *155*	42 *140*	48 *155*	55 *180*	70 *230*



MINIMASTER™

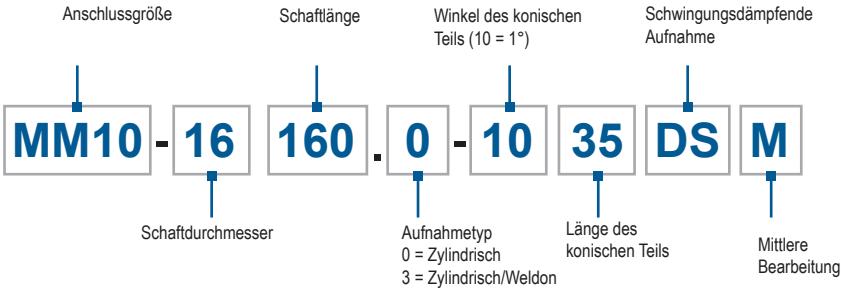
Minimaster ist ein vielseitiges Wechselkopfsystem, das verschiedene Lösungen kombiniert: optimale Zugänglichkeit, maximale Stabilität und Sicherheit.

Die flexible, zweiteilige Kombination aus Schäften und Wechselköpfen spart Zeit und Geld. Ein vielseitiges Werkzeug, das dem Anwender in nahezu jedem Prozess eine Lösung bietet – egal, ob die Auskragung verringert werden soll, maximale Stabilität gefragt ist oder andere Anforderungen erfüllt werden müssen.

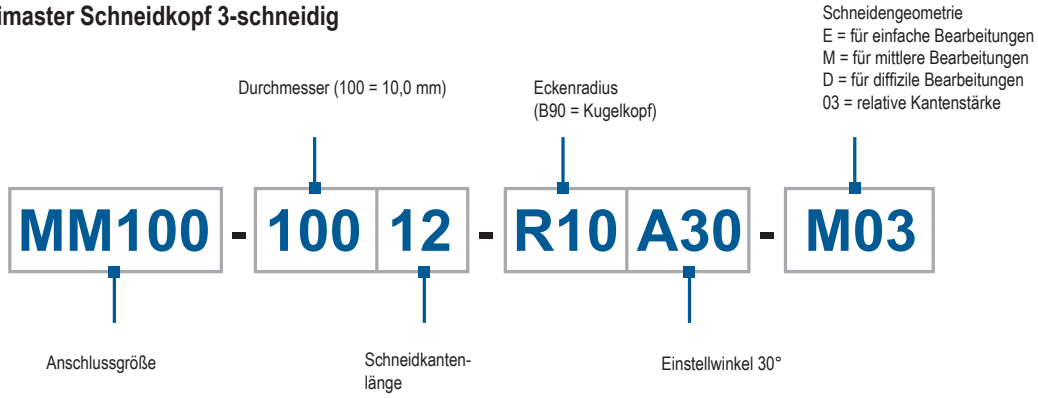
- Schaftfräser: 6 bis 20 mm (.250 - .750”)
- Kugelkopffräser: 6 bis 20 mm (.250 - .750”)
- Zentrier-/Anfasfräser: 6 bis 19,05 mm (.250 - .750”)
- Hochvorschubfräser: 8 bis 12 mm (.375 - .625”)
- Tauchfräser: 6 bis 16 mm (.250 - .625”)
- Konvexradienfräser: 12 mm (.472”)

Code-Schlüssel

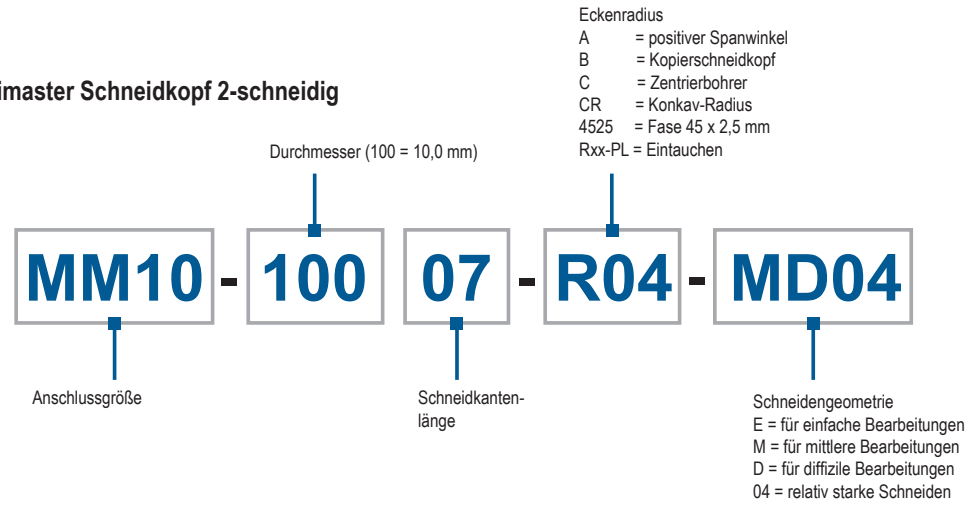
Schäfte



Minimaster Schneidkopf 3-schneidig



Minimaster Schneidkopf 2-schneidig

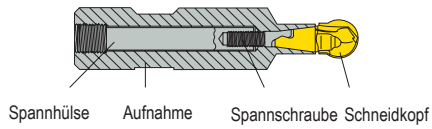
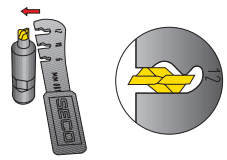
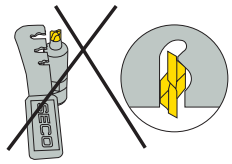
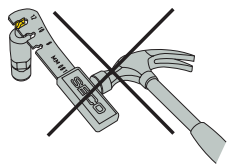
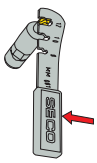


Teile des Codes können bei unterschiedlichen Fräsern variieren.

Mit interner Kühlschmierstoffzufuhr



Montagehinweise - MM-Schlüssel nur für 2-schneidige Schneidköpfe

Drehmomentschlüssel	
	Die Spannhülse muss bei erneuter Montage zuerst befestigt werden. Danach Spannschraube und Schneidkopf montieren. Bei abgebrochenem Schneidkopf die Spannhülse lösen. Den Innensechskant-Schlüssel gegen den Uhrzeigersinn drehen. Danach Spannschraube und Schneidkopf entnehmen. Für Minimaster 3-schneidig ist der Schlüssel (MM0416) erforderlich (Schlüsselansatz an sechseckigem Teil des Schneidkopfs).
	Den korrekten Schlüsselansatz beachten.
	Bei nicht korrektem Ansatz können die Schneidkanten beschädigt werden.
	Den Schneidkopf nicht mit einem Hammer oder ähnlichem Gegenstand festklopfen.
	Den Schneidkopf handfest anziehen.

Auswahl

1. Anschlussgröße wählen
Die Ausführung des Werkstückes und die Bearbeitung entscheiden über die Anschlussgröße. Je größer der Anschlussdurchmesser, desto höher ist die Stabilität.

2. Schneidkopf wählen
a. Werkstoff anhand der Seco Werkstoff-Gruppen ab Seite 626 klassifizieren
b. Die gewählte Anschlussgröße den Katalogseiten entnehmen und den geeigneten Schneidkopf in der Auswahltabelle wählen.

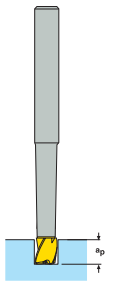
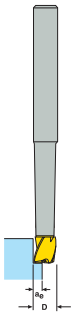
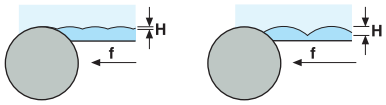
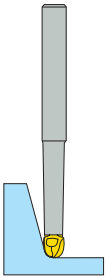
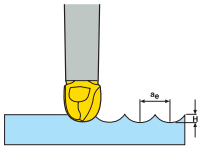
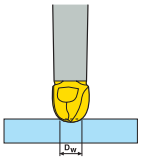
3. Aufnahme wählen
a. Auf den Katalogseiten die geeignete Aufnahme auswählen.
b. Schneidkopf und Aufnahme müssen die gleiche Anschlussgröße haben. Je kürzer die Aufnahme, desto größer ist die Stabilität.

4. Schnittdaten wählen
a. Die maximale axiale Schnitttiefe ist in der Tabelle Abmessungen angegeben. Die Schnittdatenempfehlungen basieren auf stabilen Arbeitsbedingungen und müssen daher je nach Stabilität der Bearbeitung (Werkzeugsystem, Maschine und Aufspannung) angepasst werden. Eine allgemeine Regel für die max. Schnitttiefe beim Nutfräsen ist DC*0.3= Max APMXS. (Siehe Abb. 1).
b. Empfehlungen zu Vorschub und Schnittgeschwindigkeit finden Sie ebenfalls in der Tabelle Abmessungen.
c. Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nie überschritten werden darf, ist auf Seite [XXX] angegeben
d. Wenn die radiale Schnitttiefe (Eingriffsbreite) geringer ist als der volle Schneiddurchmesser, müssen Vorschub/Zahn und Schnittgeschwindigkeit erhöht werden, um die Mittenspandicke und die Arbeitstemperatur konstant zu halten.
e. Den Prozentsatz für das Eingriffsverhältnis ermitteln: radiale Schnitttiefe durch den Durchmesser dividieren (bei Kopierfräsern a_e/DC%), bei Kugelkopffräsern den effektiven Wirkdurchmesser D_w anstatt DC (siehe Abb. 2 & 6) verwenden
f. Die Tabelle Schnittdaten enthält Richtwerte für Vorschub/Zahn sowie den Korrekturfaktor für die Schnittgeschwindigkeit.

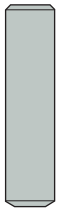
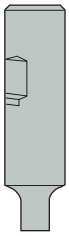
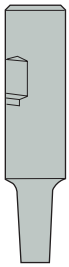
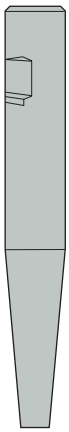
5. Allgemein
- Beim Fräsen an Ecken und Taschenboden vergrößert sich die Eingriffsbreite dramatisch. Der Vorschub muss reduziert werden, weil sonst die Mittenspandicke enorm zunimmt. Daher die Vorschubwerte für die volle Eingriffsbreite einsetzen.
- Beim Bohrfräsen mit einem Kopierwinkel von 40° oder beim Ziehfräsen mit einem Kopierwinkel von 30° in Kombination mit einer geringen Schnitttiefe wird der Wirkdurchmesser Dw immer größer sein als die genannten Werte in der Tabelle. In diesem Falle für die Vorschubberechnung den Fräserdurchmesser DC als Wirkdurchmesser Dw einsetzen.
- Der ZEFP-Faktor ist die effektive Zähnezahl zur Berechnung von Vorschub und Vorschubgeschwindigkeit. Den ZEFP-Faktor finden Schnittdatenberechnung finden in der Tabelle Abmessungen.

Hinweis Beachten, dass bei höheren Vorschubwerten die Qualität der Werkstück-Oberfläche abnimmt. (Abb. 3& 5)

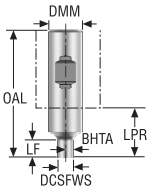
Minimaster

Abb. 1	Abb. 2
	
Abb. 3	**Abb. 4**
	
Abb. 5	**Abb. 6**
	

Version

Version 1, Keilnut-Schaft	Version 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Version 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Version 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Version 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM06 Schaft – Metrisch





Bezeichnung	Produkt-nummer	Aufnahme	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			mm	mm	mm	mm	mm					kg	
MM06-12070.3-0005	75080695	Weldon	5,75	12,0	70,0	5,0	25,0	0,0	2	✓	80000	0,1	1
MM06-16075.3-3009	75080696	Weldon	5,75	16,0	75,0	9,0	27,0	3,0	3	✓	80000	0,1	1
MM06-16110.3-5058	75080697	Weldon	5,75	16,0	110,0	58,6	62,0	5,0	4	✓	80000	0,2	4
MM06-10040.0-0007	00094747	Zylindrisch	5,75	10,0	40,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM06-12065.0-0000	75080694	Zylindrisch	5,7	12,0	65,0	0,0	15,0	60,0	1	✓	80000	0,1	1
MM06-16140.0-1020M	00027102	Zylindrisch	5,75	16,0	140,0	20,0	92,0	1,0	3	✓	80000	0,2	5
MM06-16140.0-1035M	00027103	Zylindrisch	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,2	6
MM06-16140.0-1050M	00094748	Zylindrisch	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,2	6
MM06-10050.0-0007DS	02580666	Zylindrisch	5,75	10,0	50,0	7,0	7,0	0,0	2	✓	80000	0,1	3
MM06-10075.0-3041DS	02580701	Zylindrisch	5,75	10,0	75,0	40,5	35,0	3,0	4	✓	80000	0,1	3
MM06-10100.0-1035DS	02580713	Zylindrisch	5,75	10,0	100,0	35,0	60,0	1,0	3	✓	80000	0,1	3
MM06-12120.0-1050DS	02580714	Zylindrisch	5,75	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM06-16090.0-0012DS	02580670	Zylindrisch	5,75	16,0	90,0	12,0	42,0	0,0	2	✓	80000	0,3	3
MM06-16095.0-0024DS	02580673	Zylindrisch	5,75	16,0	95,0	24,0	47,0	0,0	2	✓	80000	0,3	3
MM06-16140.0-1050DS	02580717	Zylindrisch	5,75	16,0	140,0	50,0	92,0	1,0	3	✓	80000	0,3	3
MM06-16140.0-1035DS	02580716	Zylindrisch	5,75	16,0	140,0	35,0	92,0	1,0	3	✓	80000	0,4	3
MM06-20250.0-1035DS	02580718	Zylindrisch	5,75	20,0	250,0	35,0	190,0	1,0	5	✓	80000	1,0	3

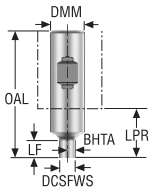
Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-035046	MM06-03518	H05-4
4	MM-035091	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4
3	–	MM06-03518	–

MM06 Schaft – Zoll





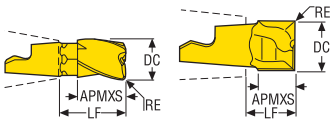
Bezeichnung	Produkt-nummer	Aufnahme	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			Zoll	Zoll	Zoll	Zoll	Zoll					lbs	
MM06-0.50-2.8-3-0002	00096108	Weldon	0.224	0.500	2.756	0.197	0.984	0,0	2	✓	80000	0.220	1
MM06-0.62-3.0-3-3003	00096116	Weldon	0.224	0.625	2.953	0.354	1.063	3,0	1	✓	80000	0.220	1
MM06-0.62-4.3-3-5022	00096117	Weldon	0.224	0.625	4.331	2.291	2.441	5,0	2	✓	80000	0.440	4
MM06-0.38-1.6-0-0002	00096107	Zylindrisch	0.224	0.375	1.575	0.276	0.276	0,0	2	✓	80000	0.220	2
MM06-0.50-2.6-0-0000	00096106	Zylindrisch	0.224	0.500	2.559	0	0.787	60,0	1	✓	80000	0.220	1
MM06-0.62-5.5-0-1007	00096111	Zylindrisch	0.224	0.625	5.512	0.787	3.622	1,0	3	✓	80000	0.440	5
MM06-0.62-5.5-0-1013	00096112	Zylindrisch	0.224	0.625	5.512	1.378	3.622	1,0	3	✓	80000	0.440	6
MM06-0.62-5.5-0-1019	00096114	Zylindrisch	0.224	0.625	5.512	1.969	3.622	1,0	3	✓	80000	0.440	6
MM06-0.62-3.5-0-0004DS	02593394	Zylindrisch	0.224	0.625	3.543	0.472	1.654	0,0	2	✓	80000	0.660	3
MM06-0.62-3.7-0-0009DS	02593395	Zylindrisch	0.224	0.625	3.740	0.945	1.850	0,0	2	✓	80000	0.660	3
MM06-0.62-5.5-0-1013DS	02593396	Zylindrisch	0.224	0.625	5.512	1.378	3.622	1,0	3	✓	80000	0.880	3
MM06-0.62-5.5-0-1019DS	02593397	Zylindrisch	0.224	0.625	5.512	1.969	3.622	1,0	3	✓	80000	0.660	3
MM06-0.75-10.0-0-1013DS	02593399	Zylindrisch	0.224	0.750	9.843	1.378	7.874	1,0	5	✓	80000	1.980	3

Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-035046	MM06-03518	H05-4
4	MM-035091	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4
3	–	MM06-03518	–

Nutfräsen/Eckfräsen



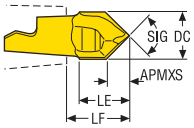


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel		Sorten			
												Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM06-06007-A30-E02	6,0 *0.236*	7,5 *0.295*	0,0 *0.0*	9,9 *0.390*	15,0	7,4	11,8	30	3	MM0416	✓			■	
MM06-06007-R05A30-M02	6,0 *0.236*	7,5 *0.295*	0,5 *0.020*	9,9 *0.390*	15,0	7,4	10,8	30	3	MM0416	✓				■
MM06-06007-R10A30-E02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-M02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓				■
MM06-06007-R10A30-D02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R20A30-M02	6,0 *0.236*	7,5 *0.295*	2,0 *0.079*	9,9 *0.390*	15,0	7,4	7,8	30	3	MM0416	✓				■
MM06-06407-A30-E02	6,35 *0.250*	7,5 *0.295*	0,0 *0.0*	9,9 *0.390*	15,0	7,8	12,5	30	3	MM0416	✓			■	
MM06-06407-R04A30-M02	6,35 *0.250*	7,5 *0.295*	0,4 *0.016*	9,9 *0.390*	15,0	7,8	11,7	30	3	MM0416	✓				■
MM06-06407-R08A30-M02	6,35 *0.250*	7,5 *0.295*	0,8 *0.031*	9,9 *0.390*	15,0	7,8	10,9	30	3	MM0416	✓				■
MM06-06004-M02	6,0 *0.236*	4,1 *0.161*	0,0 *0.0*	5,1 *0.201*	15,0	7,4	11,8	0	2	MM0612		■			
MM06-06004-R04-MD02	6,0 *0.236*	4,1 *0.161*	0,4 *0.016*	5,1 *0.201*	15,0	7,4	11,0	0	2	MM0612		■		■	
MM06-06004-R10-MD02	6,0 *0.236*	4,1 *0.161*	1,0 *0.039*	5,1 *0.201*	15,0	7,4	9,8	0	2	MM0612				■	
MM06-05807-R02A30-M02	5,8 *0.228*	7,5 *0.295*	0,2 *0.008*	9,9 *0.390*	15,0	7,2	11,0	30	3	MM0612	✓				■
MM06-05804T-R02-D02	5,8 *0.228*	4,1 *0.161*	0,2 *0.008*	5,1 *0.201*	15,0	7,2	11,0	0	2	MM0612		■			

Zentrierbohren

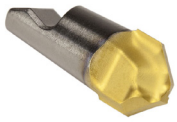


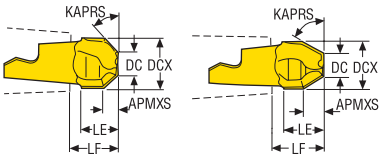


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	LE	LF	SIG°	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM06-06003-C90-M02	6,0 *0.236*	2,86 *0.113*	6,0 *0.236*	7,12 *0.280*	90,0	2	MM0612	■			
MM06-06003-C120-M02	6,0 *0.236*	1,6 *0.063*	6,27 *0.247*	7,19 *0.283*	120,0	2	MM0612	■			

Anfasen

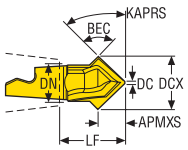


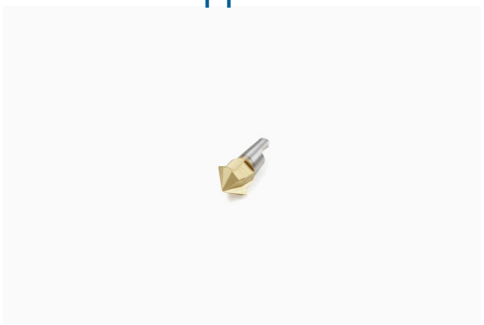


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM06-06004-4515-E02	6,0 *0.236*	1,8 *0.071*	2,1 *0.083*	4,0 *0.157*	5,1 *0.201*	45,0	2	MM0612	■			
MM06-06004-6015-E02	6,0 *0.236*	3,14 *0.124*	2,4 *0.094*	4,6 *0.181*	5,75 *0.226*	60,0	2	MM0612	■			

Doppeltes Anfasen

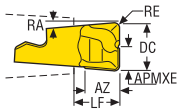




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	LF	DN	BEC°	KAPRS°	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								
MM06-08008-D4510P-M02	8,0 *0.315*	0,6 *0.024*	3,7 *0.146*	8,5 *0.335*	6,0 *0.236*	90,0	45,0	2	MM0612		■		

Tauchfräser



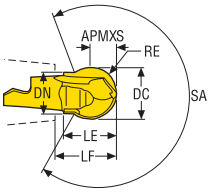


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXE	RE	AZ	LF	RA	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM06-06004-R10-PL-MD02	6,0 *0.236*	3,0 *0.118*	1,0 *0.039*	4,3 *0.169*	5,08 *0.200*	5,0	2	MM0612			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen

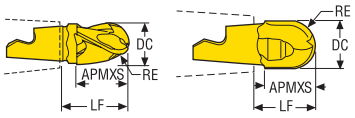




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Schlüssel	Sorten			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM06-08008-B120PF-M01	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	8,73 *0.344*	6,0 *0.236*	263,0	2	MM0612		■		
MM06-08008-B120P-M03	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	8,73 *0.344*	6,0 *0.236*	263,0	2	MM0612			■	

Kopierfräser





• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Sorten			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM06-06007-B90A30-E02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓			■	
MM06-06007-B90A30-M02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓				■
MM06-06006-B90-MD02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612		■		■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*	0,0	2	MM0612				■	
MM06-06406-B90S-E02	6,35 *0.250*	6,3 *0.248*	3,175 *0.125*	7,24 *0.285*	0,0	2	MM0612				■	
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612				■	
MM06-06406-B90P-M02	6,35 *0.250*	5,4 *0.213*	3,175 *0.125*	7,22 *0.284*	0,0	2	MM0612				■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*	0,0	2	MM0612			■		

MM06 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P6	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P7	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P8	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P12	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,030 *0.0012*
M1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
M3	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
M4	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
M5	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
K1	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,038 *0.0015*	0,050 *0.0020*
K2	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N2	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N3	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
N11	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,048 *0.0019*	0,065 *0.0026*
S1	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 *0.0011*	0,026 *0.0010*	0,025 *0.0010*	0,032 *0.0013*
S2	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 *0.0011*	0,026 *0.0010*	0,025 *0.0010*	0,032 *0.0013*
S3	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,026 *0.0010*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0012*
S11	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
S12	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,036 *0.0014*
S13	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 *0.00085*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H5	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 *0.0010*	0,024 *0.00095*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*
H11	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 *0.0010*	0,024 *0.00095*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*
H21	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 *0.00080*	0,019 *0.00075*	0,018 *0.00070*	0,024 *0.00095*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM06 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	280 *920*	350 *1150*	395 *1300*	435 *1425*	270 *890*	335 *1100*	375 *1225*	415 *1350*	220 *720*	270 *890*	300 *980*	330 *1075*
P2	275 *900*	340 *1125*	380 *1250*	420 *1375*	260 *850*	325 *1075*	365 *1200*	400 *1300*	210 *690*	260 *850*	295 *970*	320 *1050*
P3	240 *790*	295 *970*	330 *1075*	365 *1200*	225 *740*	285 *940*	315 *1025*	350 *1150*	185 *610*	230 *750*	255 *840*	280 *920*
P4	210 *690*	260 *850*	295 *970*	320 *1050*	200 *660*	250 *820*	280 *920*	305 *1000*	160 *520*	200 *660*	225 *740*	245 *800*
P5	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	295 *970*	155 *510*	190 *620*	215 *710*	235 *770*
P6	225 *740*	285 *940*	315 *1025*	345 *1125*	215 *710*	270 *890*	300 *980*	330 *1075*	175 *570*	215 *710*	240 *790*	265 *870*
P7	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	285 *940*	310 *1025*	165 *540*	205 *670*	230 *750*	250 *820*
P8	200 *660*	250 *820*	280 *920*	305 *1000*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P11	210 *690*	260 *850*	290 *950*	320 *1050*	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	200 *660*	220 *720*	245 *800*
P12	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	100 *330*	125 *410*	135 *445*	150 *490*
M1	— —	— —	— —	— —	210 *690*	265 *870*	295 *970*	320 *1050*	170 *560*	210 *690*	235 *770*	260 *850*
M2	— —	— —	— —	— —	175 *570*	215 *710*	240 *790*	265 *870*	140 *460*	170 *560*	195 *640*	210 *690*
M3	— —	— —	— —	— —	135 *445*	165 *540*	190 *620*	205 *670*	110 *360*	135 *445*	150 *490*	165 *540*
M4	— —	— —	— —	— —	105 *345*	130 *425*	145 *475*	155 *510*	85 *280*	105 *345*	115 *375*	125 *410*
M5	— —	— —	— —	— —	85 *280*	105 *345*	120 *395*	130 *425*	70 *230*	85 *280*	95 *310*	105 *345*
K1	215 *710*	270 *890*	305 *1000*	335 *1100*	205 *670*	260 *850*	290 *950*	315 *1025*	165 *540*	210 *690*	230 *750*	255 *840*
K2	190 *620*	235 *770*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	150 *490*	180 *590*	205 *670*	225 *740*
K3	160 *520*	200 *660*	225 *740*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	125 *410*	155 *510*	175 *570*	190 *620*
K4	155 *510*	190 *620*	215 *710*	235 *770*	145 *475*	180 *590*	205 *670*	225 *740*	120 *395*	145 *475*	165 *540*	180 *590*
K5	95 *310*	115 *375*	130 *425*	145 *475*	90 *295*	110 *360*	125 *410*	135 *445*	70 *230*	90 *295*	100 *330*	110 *360*
K6	135 *445*	170 *560*	190 *620*	210 *690*	130 *425*	160 *520*	180 *590*	200 *660*	105 *345*	130 *425*	145 *475*	160 *520*
K7	120 *395*	150 *490*	165 *540*	180 *590*	115 *375*	140 *460*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
N1	1650 *5425*	2050 *6725*	2325 *7625*	2525 *8275*	1575 *5175*	1975 *6475*	2200 *7225*	2400 *7875*	1275 *4175*	1575 *5175*	1775 *5825*	1950 *6400*
N2	670 *2200*	830 *2725*	930 *3050*	1025 *3375*	640 *2100*	790 *2600*	890 *2925*	970 *3175*	510 *1675*	640 *2100*	710 *2325*	790 *2600*
N3	445 *1450*	560 *1825*	620 *2025*	680 *2225*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	340 *1125*	425 *1400*	475 *1550*	530 *1750*
N11	510 *1675*	630 *2075*	710 *2325*	780 *2550*	485 *1600*	600 *1975*	680 *2225*	740 *2425*	390 *1275*	485 *1600*	540 *1775*	600 *1975*
S1	50 *165*	65 *215*	70 *230*	75 *245*	49 *160*	60 *195*	65 *215*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
S2	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	32 *105*	39 *130*	44 *145*	48 *155*
S3	36 *120*	44 *145*	49 *160*	55 *180*	34 *110*	42 *140*	47 *155*	50 *165*	27 *90*	34 *110*	38 *125*	41 *135*
S11	— —	— —	— —	— —	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	70 *230*	75 *245*	85 *280*
S12	— —	— —	— —	— —	48 *155*	60 *195*	65 *215*	70 *245*	38 *125*	48 *155*	55 *180*	60 *195*
S13	— —	— —	— —	— —	27 *90*	34 *110*	38 *125*	41 *135*	22 *70*	27 *90*	30 *100*	33 *110*
H5	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	33 *110*	41 *135*	45 *150*	50 *165*
H8	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*
H11	55 *180*	65 *215*	75 *245*	85 *280*	50 *165*	65 *215*	70 *230*	80 *260*	42 *140*	50 *165*	60 *195*	65 *215*
H12	80 *260*	95 *310*	110 *360*	120 *395*	75 *245*	90 *295*	105 *345*	115 *375*	60 *195*	75 *245*	85 *280*	90 *295*
H21	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*

MM06 Z3-Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P8	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
P12	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
M1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
M3	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,028 *0.0011*	0,026 *0.0010*	0,028 *0.0011*	0,036 *0.0014*
M4	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
M5	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 *0.0012*	0,028 *0.0011*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
S1	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
S2	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
S3	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,024 *0.00095*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0012*
S11	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,036 *0.0014*
S12	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 *0.0011*	0,028 *0.0011*	0,028 *0.0011*	0,036 *0.0014*
S13	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 *0.0010*	0,025 *0.0010*	0,025 *0.0010*	0,030 *0.0013*
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 *0.00095*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 *0.00070*	0,018 *0.00070*	0,018 *0.00070*	0,022 *0.00095*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM06 Z3-Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P8	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P12	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
M2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M3	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
M4	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
M5	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,090 *0.0036*
K6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,090 *0.0036*
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S2	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S3	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
S12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,080 *0.0032*
S13	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 *0.0010*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM06 Z3-Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	295 *970*	350 *1150*	370 *1225*	405 *1325*	400 *1300*	280 *920*	330 *1075*	355 *1175*	385 *1275*	380 *1250*
P2	285 *940*	340 *1125*	360 *1175*	395 *1300*	390 *1275*	275 *900*	325 *1075*	345 *1125*	375 *1225*	370 *1225*
P3	250 *820*	295 *970*	315 *1025*	340 *1125*	340 *1125*	235 *770*	280 *920*	300 *980*	320 *1050*	325 *1075*
P4	220 *720*	260 *850*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*
P5	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*
P6	235 *770*	275 *900*	295 *970*	320 *1050*	320 *1050*	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*
P7	225 *740*	260 *850*	280 *920*	305 *1000*	300 *980*	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*
P8	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P11	215 *710*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*
P12	135 *445*	160 *520*	165 *560*	180 *590*	180 *590*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M1	230 *750*	275 *900*	290 *950*	315 *1025*	315 *1025*	220 *720*	260 *850*	280 *920*	300 *980*	300 *980*
M2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*
M3	150 *490*	180 *590*	185 *610*	200 *660*	200 *660*	140 *460*	170 *560*	175 *590*	190 *620*	190 *620*
M4	105 *345*	145 *475*	140 *490*	150 *490*	150 *490*	100 *330*	135 *445*	135 *460*	145 *475*	145 *475*
M5	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*	85 *280*	115 *375*	110 *395*	120 *395*	120 *395*
K1	230 *750*	270 *890*	285 *940*	310 *1025*	310 *1025*	215 *710*	255 *840*	275 *900*	295 *970*	295 *970*
K2	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
K3	170 *560*	200 *660*	210 *690*	230 *750*	230 *750*	160 *520*	190 *620*	200 *660*	220 *720*	220 *720*
K4	160 *520*	190 *620*	205 *670*	220 *720*	220 *720*	155 *510*	180 *590*	195 *640*	210 *690*	210 *690*
K5	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
K6	140 *460*	165 *540*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K7	125 *410*	145 *475*	155 *510*	170 *560*	170 *560*	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*
N1	1750 *5750*	2075 *6800*	2200 *7225*	2375 *7800*	2375 *7800*	1675 *5500*	1975 *6475*	2100 *6900*	2275 *7475*	2250 *7375*
N2	710 *2325*	830 *2725*	890 *2925*	960 *3150*	950 *3125*	670 *2200*	790 *2600*	850 *2800*	920 *3025*	910 *2975*
N3	470 *1550*	560 *1825*	590 *1925*	640 *2100*	640 *2100*	450 *1475*	530 *1750*	570 *1875*	610 *2000*	610 *2000*
N11	540 *1775*	630 *2075*	680 *2225*	730 *2400*	730 *2400*	510 *1675*	600 *1975*	650 *2125*	700 *2300*	690 *2275*
S1	49 *160*	65 *215*	65 *230*	70 *230*	70 *230*	46 *150*	65 *215*	65 *215*	70 *230*	65 *215*
S2	39 *130*	55 *180*	55 *180*	55 *180*	55 *180*	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*
S3	34 *110*	47 *155*	46 *155*	50 *165*	49 *160*	32 *105*	44 *145*	44 *150*	47 *155*	47 *155*
S11	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*
S12	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*
S13	27 *90*	38 *125*	37 *130*	40 *130*	40 *130*	26 *85*	36 *120*	35 *120*	38 *125*	38 *125*
H5	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	42 *140*	50 *165*	55 *180*	55 *180*	55 *180*
H8	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H11	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	55 *180*	65 *215*	65 *230*	70 *230*	75 *245*
H12	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
H21	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*

MM06 Z2-Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 *0.0012*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
P3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
P4	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
P5	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
P6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P8	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
P11	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,044 *0.0017*
P12	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
M1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
M2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M3	MM06-06006-B90S-E02 F30M	2,0 *0.080*	0,024 *0.00095*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
M4	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
M5	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
K1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,048 *0.0019*
K2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K4	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K5	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,040 *0.0016*
K6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
K7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,040 *0.0016*
N1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N11	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
S1	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
S2	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
S3	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0012*
S11	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
S12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 *0.0010*	0,024 *0.00095*	0,028 *0.0011*	0,036 *0.0014*
S13	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 *0.00085*	0,022 *0.00085*	0,024 *0.00095*	0,030 *0.0013*
H5	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H8	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*
H11	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 *0.00080*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*
H12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*
H21	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 *0.00065*	0,016 *0.00065*	0,018 *0.00070*	0,022 *0.00095*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM06 Z2-Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ *Zoll*

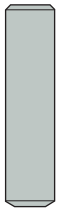
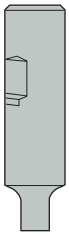
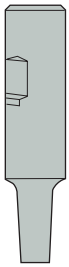
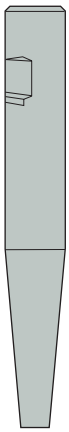
SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P8	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P12	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
M1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
M2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
M3	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
M4	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
M5	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
K1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
K2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
K6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
N1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
N11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 *0.0010*	0,032 *0.0013*	0,044 *0.0017*	0,070 *0.0028*
S1	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S2	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S3	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,013 *0.00050*	0,014 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
S11	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
S12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 *0.00060*	0,018 *0.00070*	0,025 *0.0010*	0,038 *0.0015*
S13	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
H5	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H8	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H11	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H21	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 *0.00040*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

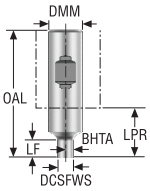
MM06 Z2-Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	325 *1075*	415 *1350*	430 *1400*	470 *1550*	465 *1525*	275 *900*	345 *1125*	375 *1225*	405 *1325*	405 *1325*	225 *740*	280 *920*	305 *1000*	330 *1075*	325 *1075*
P2	320 *1050*	400 *1300*	420 *1375*	455 *1500*	455 *1500*	265 *870*	335 *1100*	365 *1200*	395 *1300*	395 *1300*	215 *710*	270 *890*	295 *970*	320 *1050*	320 *1050*
P3	275 *900*	345 *1125*	360 *1175*	395 *1300*	395 *1300*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*
P4	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	205 *670*	255 *840*	280 *920*	305 *1000*	300 *980*	165 *540*	205 *670*	225 *740*	245 *800*	245 *800*
P5	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	290 *950*	290 *950*	160 *520*	200 *660*	215 *710*	235 *770*	235 *770*
P6	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	220 *720*	275 *900*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P7	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	210 *690*	260 *850*	285 *940*	305 *1000*	305 *1000*	170 *560*	210 *690*	230 *750*	250 *820*	245 *800*
P8	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	285 *940*	290 *950*	160 *520*	200 *660*	215 *710*	230 *750*	235 *770*
P11	240 *790*	300 *980*	315 *1025*	340 *1125*	340 *1125*	200 *660*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
P12	145 *475*	185 *610*	190 *620*	205 *670*	205 *670*	130 *425*	160 *520*	170 *560*	180 *590*	180 *590*	105 *345*	130 *425*	135 *445*	145 *475*	145 *475*
M1	255 *840*	325 *1075*	340 *1125*	365 *1200*	365 *1200*	215 *710*	270 *890*	295 *970*	320 *1050*	315 *1025*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*
M2	210 *690*	265 *870*	275 *900*	300 *980*	300 *980*	175 *570*	220 *720*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
M3	165 *540*	210 *690*	210 *710*	230 *750*	230 *750*	140 *460*	180 *590*	185 *620*	205 *670*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	165 *540*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	140 *490*	155 *510*	155 *510*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*
M5	105 *345*	135 *445*	130 *475*	145 *475*	145 *475*	95 *310*	120 *395*	120 *410*	130 *425*	130 *425*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
K1	250 *820*	320 *1050*	335 *1100*	360 *1175*	360 *1175*	210 *690*	265 *870*	290 *950*	315 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*
K2	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	185 *610*	230 *750*	255 *840*	275 *900*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
K3	185 *610*	235 *770*	245 *800*	265 *870*	265 *870*	160 *520*	195 *640*	215 *710*	230 *750*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*
K4	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	150 *490*	185 *610*	205 *670*	220 *720*	220 *720*	120 *395*	150 *490*	165 *540*	180 *590*	180 *590*
K5	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*	90 *295*	115 *375*	125 *410*	135 *445*	135 *445*	75 *245*	90 *295*	100 *330*	110 *360*	105 *345*
K6	155 *510*	195 *640*	205 *670*	225 *740*	225 *740*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	105 *345*	135 *445*	145 *475*	160 *520*	155 *510*
K7	135 *445*	170 *560*	180 *590*	195 *640*	195 *640*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	140 *460*
N1	1975 *6475*	2475 *8125*	2600 *8525*	2800 *9175*	2800 *9175*	1625 *5325*	2050 *6725*	2225 *7300*	2400 *7875*	2375 *7800*	1325 *4350*	1650 *5425*	1800 *5900*	1950 *6400*	1925 *6325*
N2	790 *2600*	1000 *3275*	1050 *3450*	1125 *3700*	1125 *3700*	660 *2175*	820 *2700*	900 *2950*	970 *3175*	960 *3150*	530 *1750*	670 *2200*	730 *2400*	790 *2600*	780 *2550*
N3	530 *1750*	670 *2200*	700 *2300*	760 *2500*	750 *2450*	440 *1450*	550 *1800*	600 *1975*	650 *2125*	640 *2100*	355 *1175*	445 *1450*	485 *1600*	520 *1700*	520 *1700*
N11	600 *1975*	760 *2500*	800 *2625*	860 *2825*	860 *2825*	500 *1650*	630 *2075*	680 *2225*	740 *2425*	730 *2400*	405 *1325*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	43 *150*	47 *155*	47 *155*
S3	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*	36 *120*	46 *150*	46 *160*	50 *165*	50 *165*	29 *95*	37 *120*	38 *130*	40 *130*	40 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	75 *245*	95 *310*	95 *310*	105 *345*	100 *330*	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*
S12	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	41 *135*	55 *180*	55 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	29 *95*	37 *120*	37 *130*	40 *130*	40 *130*	24 *80*	30 *100*	30 *105*	33 *110*	33 *110*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	45 *150*	49 *160*	49 *160*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*

Version

Version 1, Keilnut-Schaft	Version 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Version 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Design 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Version 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM08 Schaft





Bezeichnung	Produkt-nummer	Aufnahme	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			mm	mm	mm	mm	mm					kg	
MM08-16070.3-0007	75034241	Weldon	7,6	16,0	70,0	7,6	22,0	0,0	2	✓	80000	0,1	1
MM08-16075.3-3012	75034242	Weldon	7,6	16,0	75,0	12,0	27,0	3,0	3	✓	80000	0,1	1
MM08-16120.3-5048M	00042863	Weldon	7,6	16,0	120,0	48,0	72,0	5,0	4	✓	80000	0,2	5
MM08-10040.0-0007	00083980	Zylindrisch	7,6	10,0	40,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM08-12065.0-0000	75034240	Zylindrisch	7,6	12,0	65,0	0,0	20,0	60,0	1	✓	80000	0,1	1
MM08-16150.0-1030M	00094751	Zylindrisch	7,6	16,0	150,0	30,0	102,0	1,0	3	✓	80000	0,2	5
MM08-16150.0-1050M	00094752	Zylindrisch	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,2	4
MM08-16150.0-1070M	00094754	Zylindrisch	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,2	4
MM08-10050.0-0007DS	02580665	Zylindrisch	7,6	10,0	50,0	7,0	10,0	0,0	2	✓	80000	0,1	3
MM08-10080.0-3023DS	02580702	Zylindrisch	7,6	10,0	80,0	22,9	40,0	3,0	4	✓	80000	0,1	3
MM08-12100.0-1035DS	02580719	Zylindrisch	7,6	12,0	100,0	35,0	55,0	1,0	3	✓	80000	0,2	3
MM08-12120.0-1050DS	02580720	Zylindrisch	7,6	12,0	120,0	50,0	75,0	1,0	3	✓	80000	0,2	3
MM08-16085.0-0016DS	02580675	Zylindrisch	7,6	16,0	85,0	16,0	37,0	0,0	2	✓	80000	0,3	3
MM08-16100.0-0032DS	02580687	Zylindrisch	7,6	16,0	100,0	32,0	52,0	0,0	2	✓	80000	0,3	3
MM08-16150.0-1050DS	02580722	Zylindrisch	7,6	16,0	150,0	50,0	102,0	1,0	3	✓	80000	0,4	3
MM08-16150.0-1070DS	02580727	Zylindrisch	7,6	16,0	150,0	70,0	102,0	1,0	3	✓	80000	0,3	3

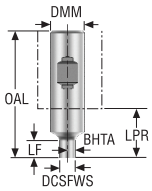
Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-05044	MM08-0524	H05-4
5	MM-05044	MM08-0543	H05-4
2	MM-05019	MM08-0524	H05-4
4	MM-05044	MM08-0582	H05-4
3	–	MM08-0524	–

MM08 Schaft – Zoll





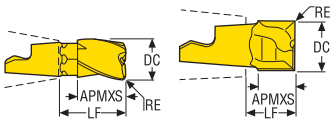
Bezeichnung	Produkt-nummer	Aufnahme	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			Zoll	Zoll	Zoll	Zoll	Zoll					lbs	
MM08-0.62-2.8-3-0003	75054600	Weldon	0.299	0.625	2.756	0.299	0.866	0,0	2	✓	80000	0.220	1
MM08-0.62-3.0-3-3004	75054601	Weldon	0.299	0.625	2.953	0.472	1.063	3,0	3	✓	80000	0.220	1
MM08-0.62-4.7-3-5018	75054602	Weldon	0.299	0.625	4.724	1.850	2.835	5,0	4	✓	80000	0.440	2
MM08-0.38-1.6-0-0002	00096119	Zylindrisch	0.299	0.375	1.575	0.276	0.276	0,0	2	✓	80000	0.220	3
MM08-0.50-2.6-0-0000	75054599	Zylindrisch	0.299	0.500	2.559	0	0.787	60,0	1	✓	80000	0.220	1
MM08-0.62-5.9-0-1011	75054604	Zylindrisch	0.299	0.625	5.906	1.181	4.016	1,0	3	✓	80000	0.440	2
MM08-0.62-3.3-0-0006DS	02593402	Zylindrisch	0.299	0.625	3.346	0.630	1.457	0,0	2	✓	80000	0.660	4
MM08-0.62-4.0-0-0012DS	02593403	Zylindrisch	0.299	0.625	3.937	1.260	2.047	0,0	2	✓	80000	0.660	4
MM08-0.62-5.9-0-1019DS	02593407	Zylindrisch	0.299	0.625	5.906	1.969	4.016	1,0	3	✓	80000	0.880	4
MM08-0.62-5.9-0-1027DS	02593410	Zylindrisch	0.299	0.625	5.906	2.756	4.016	1,0	3	✓	80000	0.660	4
MM08-0.75-10.0-0-1019DS	02593413	Zylindrisch	0.299	0.750	9.843	1.969	7.874	1,0	5	✓	80000	1.980	4

Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-05044	MM08-0524	H05-4
2	MM-05044	MM08-0543	H05-4
3	MM-05019	MM08-0524	H05-4
4	–	MM08-0524	–

Nutfräsen/Eckfräsen



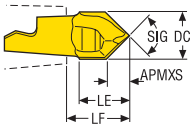


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel		Sorten			
												Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM08-08009-A30-E03	8,0 *0.315*	10,0 *0.394*	0,0 *0.0*	13,0 *0.512*	15,0	9,8	15,0	30	3	MM0416	✓			■	
MM08-08009-R05A30-M03	8,0 *0.315*	10,0 *0.394*	0,5 *0.020*	13,0 *0.512*	15,0	9,8	14,8	30	3	MM0416	✓				■
MM08-08009-R10A30-D03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-E03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-M03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓				■
MM08-08009-R20A30-M03	8,0 *0.315*	10,0 *0.394*	2,0 *0.079*	13,0 *0.512*	15,0	9,8	11,8	30	3	MM0416	✓				■
MM08-08009-R30A30-M03	8,0 *0.315*	10,0 *0.394*	3,0 *0.118*	13,0 *0.512*	15,0	9,8	9,8	30	3	MM0416	✓				■
MM08-08005-M03	8,0 *0.315*	5,5 *0.217*	0,0 *0.0*	6,8 *0.268*	15,0	9,8	15,8	0	2	MM0612		■			
MM08-08005-R04-MD03	8,0 *0.315*	5,5 *0.217*	0,4 *0.016*	6,8 *0.268*	15,0	9,8	15,0	0	2	MM0612		■		■	
MM08-08005-R04P-M02	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	0	2	MM0612				■	
MM08-08005-R10-MD03	8,0 *0.315*	5,4 *0.213*	1,0 *0.039*	6,8 *0.268*	15,0	9,8	13,8	0	2	MM0612				■	
MM08-08005-R04A8-E03	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	8	2	MM0612		■		■	
MM08-07809-R02A30-M03	7,8 *0.307*	10,0 *0.394*	0,2 *0.008*	13,0 *0.512*	15,0	9,6	15,0	30	3	MM0416	✓				■
MM08-07805T-R02-D03	7,8 *0.307*	5,4 *0.213*	0,2 *0.008*	6,8 *0.268*	15,0	9,6	15,0	0	2	MM0612		■			

Zentrierbohren



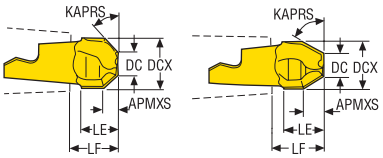


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	LE	LF	SIG°	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-08004-C90-M03	8,0 *0.315*	3,79 *0.149*	8,0 *0.315*	9,5 *0.374*	90,0	2	MM0612	■			
MM08-08006-C120-M03	8,0 *0.315*	2,15 *0.085*	8,32 *0.328*	9,46 *0.372*	120,0	2	MM0612	■			

Anfasen

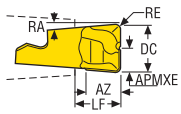




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-08005-4520-E03	8,0 *0.315*	3,87 *0.152*	2,1 *0.083*	5,5 *0.217*	6,7 *0.264*	45,0	2	MM0612	■			
MM08-08006-6030-E03	8,0 *0.315*	4,19 *0.165*	3,3 *0.130*	6,45 *0.254*	7,66 *0.302*	60,0	2	MM0612	■			

Tauchfräser

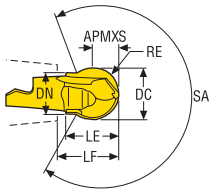




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXE	RE	AZ	LF	RA	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM08-08005-R10-PL-MD03	8,0 *0.315*	4,0 *0.157*	1,0 *0.039*	5,7 *0.224*	6,78 *0.267*	5,0	2	MM0612			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



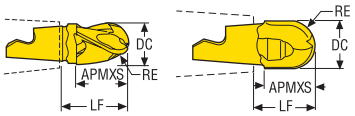


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM08-10010-B120PF-M02	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	10,97 *0.432*	8,0 *0.315*	254,0	2	MM0612		■		
MM08-10010-B120P-M04	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	10,97 *0.432*	8,0 *0.315*	254,0	2	MM0612			■	

Kopierfräser



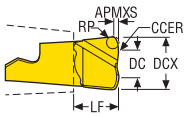


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-08009-B90A30-E03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416 ✓			■	
MM08-08009-B90A30-M03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416 ✓				■
MM08-08008-B90-MD03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	0,0	2	MM0612	■		■	
MM08-08008-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*	0,0	2	MM0612			■	
MM08-08008-B90P-M03	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612			■	
MM08-08008-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*	0,0	2	MM0612		■		

Hochvorschubfräser





• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						T60M	F15M	F30M	F40M
MM08-08.40-HF-MD06	8,0 *0.315*	4,0 *0.157*	0,37 *0.015*	0,88 *0.035*	4,0 *0.157*	6,84 *0.269*	5,0	9,8	14,6	2	MM0612			■	

MM08 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
P3	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P5	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P7	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P8	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P12	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
M2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 *0.0016*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
M5	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
K1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
S12	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
S13	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
H5	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H8	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H12	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 *0.0010*	0,025 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM08 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	370 *1225*	410 *1350*	255 *840*	315 *1025*	350 *1150*	385 *1275*	205 *670*	250 *820*	280 *920*	310 *1025*
P2	255 *840*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	195 *640*	245 *800*	275 *900*	300 *980*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	170 *560*	210 *690*	240 *790*	260 *850*
P4	195 *640*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	290 *950*	150 *490*	185 *610*	210 *690*	230 *750*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	145 *475*	180 *590*	200 *660*	220 *720*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	280 *920*	310 *1025*	160 *520*	200 *660*	225 *740*	250 *820*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	145 *475*	180 *590*	200 *660*	220 *720*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	150 *490*	185 *610*	210 *690*	230 *750*
P12	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	95 *310*	115 *375*	130 *425*	145 *475*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	195 *640*	220 *720*	240 *790*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	130 *425*	160 *520*	180 *590*	200 *660*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	105 *345*	130 *425*	145 *475*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	80 *260*	100 *330*	110 *360*	120 *395*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	85 *280*	90 *295*	100 *330*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	155 *510*	195 *640*	215 *710*	235 *770*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	135 *445*	170 *560*	190 *620*	210 *690*
K3	155 *510*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	115 *375*	145 *475*	160 *520*	180 *590*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	110 *360*	140 *460*	155 *510*	170 *560*
K5	90 *295*	110 *360*	120 *395*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	85 *280*	95 *310*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	150 *490*
K7	115 *375*	140 *460*	155 *510*	170 *560*	110 *360*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1550 *5075*	1950 *6400*	2150 *7050*	2350 *7700*	1475 *4850*	1850 *6075*	2025 *6650*	2250 *7375*	1175 *3850*	1475 *4850*	1625 *5325*	1800 *5900*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	750 *2450*	820 *2700*	910 *2975*	475 *1550*	590 *1925*	660 *2175*	720 *2350*
N3	420 *1375*	520 *1700*	580 *1900*	630 *2075*	400 *1300*	495 *1625*	550 *1800*	610 *2000*	315 *1025*	395 *1300*	440 *1450*	485 *1600*
N11	480 *1575*	600 *1975*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	630 *2075*	690 *2275*	360 *1175*	455 *1500*	500 *1650*	550 *1800*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
S2	39 *130*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	30 *100*	37 *120*	41 *135*	45 *150*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	26 *85*	32 *105*	36 *120*	39 *130*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	75 *245*	80 *260*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	21 *70*	26 *85*	29 *95*	31 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	31 *100*	39 *130*	43 *140*	47 *155*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	60 *195*	70 *230*	80 *260*	90 *295*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*

MM08 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P3	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P8	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P12	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
M1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
M2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,040 *0.0016*	0,040 *0.0016*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
M5	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
S1	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
S12	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
S13	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0017*
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM08 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
P3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
P4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,15 *0.0060*
P5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P8	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
P11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P12	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
M2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,17 *0.0065*
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
K6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*	0,22 *0.0085*
S1	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,038 *0.0015*	0,042 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM08 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	265 *870*	315 *1025*	335 *1100*	360 *1175*	360 *1175*
P2	270 *890*	325 *1075*	345 *1125*	370 *1225*	365 *1200*	260 *850*	310 *1025*	325 *1075*	350 *1150*	350 *1150*
P3	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*	225 *740*	270 *890*	280 *920*	305 *1000*	300 *980*
P4	210 *690*	250 *820*	265 *870*	280 *920*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P6	225 *740*	265 *870*	280 *920*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P7	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*	200 *660*	240 *790*	255 *840*	275 *900*	270 *890*
P8	200 *660*	235 *770*	250 *820*	270 *890*	265 *870*	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*
P11	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	260 *850*	275 *900*	300 *980*	295 *970*	210 *690*	250 *820*	265 *870*	285 *940*	280 *920*
M2	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*	170 *560*	205 *670*	215 *710*	235 *770*	230 *750*
M3	145 *475*	170 *560*	175 *570*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	180 *590*	180 *590*
M4	100 *330*	135 *445*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	80 *260*	110 *360*	105 *375*	115 *375*	115 *375*
K1	215 *710*	255 *840*	270 *890*	295 *970*	290 *950*	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*
K2	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*
K4	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	185 *610*	200 *660*	195 *640*
K5	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	180 *590*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	110 *360*	135 *445*	140 *460*	155 *510*	155 *510*
N1	1625 *5325*	1950 *6400*	2075 *6800*	2225 *7300*	2200 *7225*	1550 *5075*	1850 *6075*	1975 *6475*	2125 *6975*	2100 *6900*
N2	660 *2175*	790 *2600*	830 *2725*	900 *2950*	890 *2925*	630 *2075*	750 *2450*	790 *2600*	850 *2800*	840 *2750*
N3	440 *1450*	520 *1700*	560 *1825*	600 *1975*	590 *1925*	420 *1375*	500 *1650*	530 *1750*	570 *1875*	560 *1825*
N11	500 *1650*	600 *1975*	640 *2100*	680 *2225*	670 *2200*	480 *1575*	570 *1875*	610 *2000*	650 *2125*	640 *2100*
S1	46 *150*	65 *215*	65 *215*	70 *230*	70 *230*	44 *145*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	31 *100*	43 *140*	42 *150*	45 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	35 *125*	38 *125*	38 *125*	25 *80*	34 *110*	34 *120*	36 *120*	37 *120*
H5	43 *140*	50 *165*	55 *180*	60 *195*	55 *180*	41 *135*	49 *160*	50 *165*	55 *180*	55 *180*
H8	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	75 *245*	95 *310*	100 *330*	105 *345*	105 *345*	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*
H21	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*

MM08 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*
P2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
P3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,046 *0.0018*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P8	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,046 *0.0018*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
M1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
M2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M3	MM08-08008-B90S-E03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*	0,055 *0.0022*
M4	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
M5	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
K1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 *0.0016*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
K6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 *0.0016*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
N1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
S2	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
S3	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,032 *0.0013*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*
S11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*
S12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 *0.0014*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*
S13	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0019*
H5	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
H8	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0018*
H12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H21	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 *0.00095*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM08 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
P2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
P3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P8	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,032 *0.0013*	0,050 *0.0020*
P11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
P12	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
M1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
M2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
M3	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
M4	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
M5	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
K1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,034 *0.0013*	0,055 *0.0022*
K2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
K6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 *0.00075*	0,022 *0.00085*	0,030 *0.0012*	0,048 *0.0019*
K7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 *0.00065*	0,020 *0.00080*	0,028 *0.0011*	0,044 *0.0017*
N1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
N11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,070 *0.0028*
S1	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S2	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
S3	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,013 *0.00050*	0,014 *0.00060*	0,020 *0.00080*	0,030 *0.0012*
S11	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
S12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 *0.00060*	0,018 *0.00070*	0,024 *0.00095*	0,038 *0.0015*
S13	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 *0.00055*	0,015 *0.00065*	0,022 *0.00085*	0,034 *0.0013*
H5	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H8	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H11	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 *0.00050*	0,015 *0.00060*	0,020 *0.00080*	0,032 *0.0013*
H12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*
H21	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 *0.00040*	0,011 *0.00048*	0,016 *0.00065*	0,025 *0.0010*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM08 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	320 *1050*	405 *1325*	430 *1400*	465 *1525*	465 *1525*	265 *870*	330 *1075*	360 *1175*	385 *1275*	385 *1275*	215 *710*	265 *870*	290 *950*	315 *1025*	310 *1025*
P2	315 *1025*	395 *1300*	420 *1375*	450 *1475*	450 *1475*	260 *850*	320 *1050*	345 *1125*	375 *1225*	370 *1225*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*
P3	270 *890*	340 *1125*	360 *1175*	390 *1275*	390 *1275*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P4	240 *790*	300 *980*	320 *1050*	345 *1125*	345 *1125*	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
P5	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*
P6	255 *840*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	305 *1000*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*
P7	240 *790*	300 *980*	320 *1050*	350 *1150*	350 *1150*	200 *660*	250 *820*	270 *890*	295 *970*	290 *950*	160 *520*	200 *660*	220 *720*	235 *770*	235 *770*
P8	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	250 *820*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P11	235 *770*	295 *970*	315 *1025*	340 *1125*	340 *1125*	195 *640*	240 *790*	260 *850*	285 *940*	280 *920*	160 *520*	195 *640*	210 *690*	230 *750*	230 *750*
P12	145 *475*	185 *610*	185 *620*	200 *660*	200 *660*	125 *410*	155 *510*	165 *540*	175 *570*	175 *570*	100 *330*	125 *410*	130 *445*	145 *475*	140 *460*
M1	250 *820*	315 *1025*	335 *1100*	365 *1200*	365 *1200*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*	170 *560*	210 *690*	225 *740*	245 *800*	240 *790*
M2	205 *670*	255 *840*	275 *900*	295 *970*	295 *970*	170 *560*	210 *690*	230 *750*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	200 *660*
M3	165 *540*	205 *670*	210 *710*	225 *740*	225 *740*	135 *445*	175 *570*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	135 *475*	150 *490*	150 *490*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*
M5	105 *345*	135 *445*	130 *460*	140 *460*	140 *460*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*	75 *245*	95 *310*	90 *330*	100 *330*	100 *330*
K1	250 *820*	310 *1025*	330 *1075*	360 *1175*	355 *1175*	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
K2	215 *710*	270 *890*	290 *950*	310 *1025*	310 *1025*	180 *590*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
K3	180 *590*	230 *750*	245 *800*	265 *870*	265 *870*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*	125 *410*	155 *510*	165 *540*	180 *590*	180 *590*
K4	175 *570*	220 *720*	235 *770*	250 *820*	250 *820*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	145 *475*	160 *520*	170 *560*	170 *560*
K5	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*	90 *295*	110 *360*	120 *395*	125 *410*	125 *410*	70 *230*	90 *295*	95 *310*	105 *345*	105 *345*
K6	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*	130 *425*	160 *520*	170 *560*	185 *610*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K7	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*	90 *295*	110 *360*	120 *395*	130 *425*	130 *425*
N1	1925 *6325*	2425 *7950*	2575 *8450*	2800 *9175*	2775 *9100*	1550 *5075*	1925 *6325*	2075 *6800*	2250 *7375*	2225 *7300*	1250 *4100*	1550 *5075*	1675 *5500*	1825 *6000*	1800 *5900*
N2	780 *2550*	980 *3225*	1050 *3450*	1125 *3700*	1125 *3700*	630 *2075*	780 *2550*	840 *2750*	910 *2975*	900 *2950*	510 *1675*	630 *2075*	680 *2225*	740 *2425*	730 *2400*
N3	520 *1700*	650 *2125*	700 *2300*	750 *2450*	750 *2450*	420 *1375*	520 *1700*	560 *1825*	610 *2000*	600 *1975*	340 *1125*	420 *1375*	455 *1500*	490 *1600*	485 *1600*
N11	590 *1925*	740 *2425*	800 *2625*	860 *2825*	860 *2825*	480 *1575*	590 *1925*	640 *2100*	700 *2300*	690 *2275*	390 *1275*	480 *1575*	520 *1700*	560 *1825*	560 *1825*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *145*	45 *150*	45 *150*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	45 *150*	45 *155*	48 *155*	48 *155*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*
S12	60 *195*	75 *245*	75 *245*	80 *260*	80 *260*	48 *155*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*	23 *75*	29 *95*	29 *100*	31 *100*	32 *105*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	60 *195*	33 *110*	42 *140*	44 *145*	47 *155*	47 *155*
H8	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *280*	85 *280*	85 *280*
H21	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*

MM08 Hohe Vorschübe – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

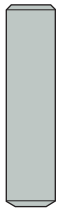
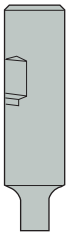
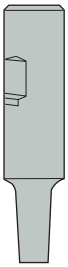
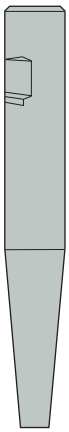
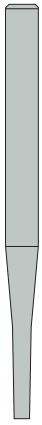
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
P4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,48 *0.019*
P5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
P6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P8	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
P11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,28 *0.011*	0,38 *0.015*	0,46 *0.018*
P12	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
M1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
M2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
M3	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
M4	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
M5	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
K1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*	0,50 *0.020*
K2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,34 *0.013*	0,42 *0.017*
K6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
K7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,34 *0.013*	0,42 *0.017*
N1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
N11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,70 *0.028*
S1	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
S2	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
S3	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*	0,30 *0.012*
S11	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
S12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
S13	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*	0,32 *0.013*
H5	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
H8	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*
H11	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*	0,30 *0.012*
H12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*
H21	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 *0.0065*	0,15 *0.0060*	0,19 *0.0075*	0,24 *0.0095*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM08 Hohe Vorschübe Schnittdaten v_c = (m/min)/*(sf/min)*

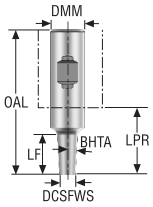
SMG	F30M			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	350 *1150*	375 *1225*
P2	245 *800*	300 *980*	345 *1125*	365 *1200*
P3	215 *710*	260 *850*	300 *980*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	250 *820*	285 *940*	300 *980*
P7	190 *620*	235 *770*	270 *890*	285 *940*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	230 *750*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	195 *640*	240 *790*	275 *900*	295 *970*
M2	165 *540*	195 *640*	230 *750*	240 *790*
M3	130 *425*	155 *510*	180 *590*	190 *620*
M4	100 *330*	120 *395*	140 *460*	145 *475*
M5	85 *280*	100 *330*	115 *375*	120 *395*
K1	195 *640*	235 *770*	270 *890*	290 *950*
K2	170 *560*	210 *690*	240 *790*	255 *840*
K3	145 *475*	175 *570*	205 *670*	215 *710*
K4	140 *460*	170 *560*	195 *640*	205 *670*
K5	85 *280*	105 *345*	120 *395*	125 *410*
K6	125 *410*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1475 *4850*	1800 *5900*	2050 *6725*	2125 *6975*
N2	590 *1925*	720 *2350*	820 *2700*	860 *2825*
N3	395 *1300*	480 *1575*	550 *1800*	570 *1875*
N11	450 *1475*	550 *1800*	630 *2075*	650 *2125*
S1	48 *155*	55 *180*	65 *215*	70 *230*
S2	39 *130*	46 *150*	50 *165*	55 *180*
S3	33 *110*	40 *130*	46 *150*	48 *155*
S11	65 *215*	80 *260*	90 *295*	95 *310*
S12	46 *150*	55 *180*	65 *215*	65 *215*
S13	27 *90*	32 *105*	36 *120*	38 *125*
H5	40 *130*	47 *155*	55 *180*	60 *195*
H8	41 *135*	50 *165*	55 *180*	60 *195*
H11	50 *165*	60 *195*	70 *230*	75 *245*
H12	75 *245*	90 *295*	100 *330*	105 *345*
H21	41 *135*	50 *165*	55 *180*	60 *195*

Version

Version 1, Keilnut-Schaft	Version 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Version 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Version 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Version 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM10 Schaft





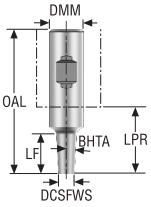
Bezeichnung	Produkt-nummer	Aufnahme	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			mm	mm	mm	mm	mm					kg	
MM10-20075.3-0010	75012787	Weldon	9,5	20,0	75,0	10,0	25,0	0,0	2	✓	80000	0,2	4
MM10-20085.3-3023	75012788	Weldon	9,5	20,0	85,0	23,0	35,0	3,0	3	✓	80000	0,2	4
MM10-20140.3-5060	75012789	Weldon	9,5	20,0	140,0	60,0	90,0	5,0	4	✓	80000	0,3	5
MM10-10045.0-0007	00083979	Zylindrisch	9,6	10,0	45,0	7,0	7,0	0,0	2	✓	80000	0,1	2
MM10-16065.0-0000	75004925	Zylindrisch	9,5	16,0	65,0	0,0	17,0	60,0	1	✓	80000	0,1	1
MM10-16160.0-1035M	00094757	Zylindrisch	9,5	16,0	160,0	35,0	112,0	1,0	3	✓	80000	0,2	6
MM10-16160.0-1055M	00094758	Zylindrisch	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	80000	0,2	7
MM10-16160.0-1075M	00094760	Zylindrisch	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	80000	0,2	7
MM10-32250.0-10063	75069366	Zylindrisch	9,5	32,0	250,0	63,8	190,0	10,0	4	✓	80000	1,3	5
MM10-12060.0-0007DS	02580667	Zylindrisch	9,6	12,0	60,0	7,0	15,0	0,0	2	✓	76300	0,1	3
MM10-12085.0-3024DS	02580704	Zylindrisch	9,5	12,0	85,0	23,8	40,0	3,0	4	✓	76300	0,2	3
MM10-12100.0-1035DS	02580733	Zylindrisch	9,5	12,0	100,0	35,0	55,0	1,0	3	✓	76300	0,2	3
MM10-14120.0-1050DS	02580736	Zylindrisch	9,5	14,0	120,0	50,0	75,0	1,0	3	✓	76300	0,3	3
MM10-16085.0-0020DS	02580688	Zylindrisch	9,5	16,0	85,0	20,0	37,0	0,0	2	✓	76300	0,3	3
MM10-16105.0-0040DS	02580689	Zylindrisch	9,5	16,0	105,0	40,0	57,0	0,0	2	✓	76300	0,3	3
MM10-16160.0-1055DS	02580748	Zylindrisch	9,5	16,0	160,0	55,0	112,0	1,0	3	✓	76300	0,4	3
MM10-16160.0-1075DS	02580749	Zylindrisch	9,5	16,0	160,0	75,0	112,0	1,0	3	✓	76300	0,4	3
MM10-20250.0-1055DS	02580750	Zylindrisch	9,5	20,0	250,0	55,0	200,0	1,0	5	✓	76300	1,0	3

Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
4	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	H06-4
6	MM-06048	MM10-0651	H06-4
7	MM-06032	MM10-0688	H06-4
3	–	MM10-061027	–

MM10 Schaft – Zoll





Bezeichnung	Produkt-nummer	Aufnahme	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			Zoll	Zoll	Zoll	Zoll	Zoll					lbs	
MM10-0.75-3.0-3-0004	75015052	Weldon	0.360	0.750	2.953	0.394	0.984	0,0	2	✓	80000	0.440	3
MM10-0.75-3.3-3-3009	75015053	Weldon	0.374	0.750	3.346	0.906	1.378	3,0	3	✓	80000	0.440	3
MM10-0.75-5.5-3-5021	75015054	Weldon	0.374	0.750	5.512	2.150	3.543	5,0	4	✓	80000	0.660	5
MM10-0.38-1.8-0-0002	00096126	Zylindrisch	0.360	0.375	1.772	0.276	0.276	0,0	2	✓	80000	0.220	2
MM10-0.62-2.6-0-0000	75005069	Zylindrisch	0.374	0.625	2.559	0	0.669	60,0	1	✓	80000	0.220	1
MM10-0.62-6.3-0-1021	75054608	Zylindrisch	0.360	0.625	6.299	2.165	4.409	1,0	3	✓	80000	0.440	7
MM10-1.25-10.0-0-10024	00096132	Zylindrisch	0.374	1.250	9.843	2.484	7.480	10,0	4	✓	80000	2.870	5
MM10-0.75-10.0-0-1021DS	02593420	Zylindrisch	0.360	0.750	9.843	2.165	7.874	1,0	5	✓	76300	1.980	4
MM10-0.75-4.1-0-0015DS	02593422	Zylindrisch	0.360	0.750	4.134	1.575	2.165	0,0	2	✓	76300	0.880	4

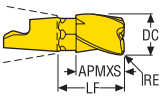
Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
3	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
1	MM-06032	MM10-0627	H06-4
7	MM-06032	MM10-0688	H06-4
4	–	MM10-061027	–

Nutfräsen/Eckfräsen

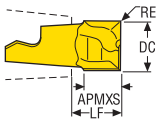




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel		Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*											
MM10-10012-A30-E03	10,0 *0.394*	11,8 *0.465*	0,0 *0.0*	15,72 *0.619*	15,0	12,2	19,8	30	3	MM0416	✓			■	
MM10-10012-R05A30-M03	10,0 *0.394*	11,8 *0.465*	0,5 *0.020*	15,72 *0.619*	15,0	12,2	18,8	30	3	MM0416	✓				■
MM10-10012-R10A30-D03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-E03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-M03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓				■
MM10-10012-R20A30-M03	10,0 *0.394*	11,8 *0.465*	2,0 *0.079*	15,72 *0.619*	15,0	12,2	15,8	30	3	MM0416	✓				■
MM10-10012-R30A30-M03	10,0 *0.394*	11,8 *0.465*	3,0 *0.118*	15,72 *0.619*	15,0	12,2	13,8	30	3	MM0416	✓				■
MM10-09512-R03A30-M03	9,525 *0.375*	11,8 *0.465*	0,3 *0.012*	15,72 *0.619*	15,0	11,6	18,2	30	3	MM0416	✓				■
MM10-09512-A30-E03	9,525 *0.375*	11,8 *0.465*	0,0 *0.0*	15,72 *0.619*	15,0	11,6	18,8	30	3	MM0416	✓			■	
MM10-09512-R04A30-M03	9,525 *0.375*	11,8 *0.465*	0,4 *0.016*	15,72 *0.619*	15,0	11,6	18,0	30	3	MM0416	✓				■
MM10-09512-R08A30-M03	9,525 *0.375*	11,8 *0.465*	0,8 *0.031*	15,72 *0.619*	15,0	11,6	17,2	30	3	MM0416	✓				■
MM10-09512-R16A30-M03	9,525 *0.375*	11,8 *0.465*	1,6 *0.063*	15,72 *0.619*	15,0	11,6	15,6	30	3	MM0416	✓				■

Nutfräsen/Eckfräsen



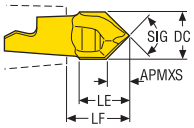


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*										
MM10-10007-M03	10,0 *0.394*	6,9 *0.272*	0,0 *NaN*	8,5 *0.335*	15,0	12,2	19,8	0	2	MM0612	■			
MM10-10007-R04-MD04	10,0 *0.394*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	12,2	19,0	0	2	MM0612	■		■	
MM10-10007-R04P-M03	10,0 *0.394*	6,7 *0.264*	0,4 *0.016*	8,38 *0.330*	15,0	12,2	19,0	0	2	MM0612			■	
MM10-10007-R10-MD04	10,0 *0.394*	6,8 *0.268*	1,0 *0.039*	8,48 *0.334*	15,0	12,2	17,8	0	2	MM0612	■		■	
MM10-10007-R20-MD04	10,0 *0.394*	6,8 *0.268*	2,0 *0.079*	8,46 *0.333*	15,0	12,2	15,8	0	2	MM0612			■	
MM10-10007-R30-MD04	10,0 *0.394*	6,8 *0.268*	3,0 *0.118*	8,44 *0.332*	15,0	12,2	13,8	0	2	MM0612			■	
MM10-09510-M03	9,525 *0.375*	6,8 *0.268*	0,0 *NaN*	8,5 *0.335*	15,0	11,6	18,8	0	2	MM0612	■			
MM10-09510-R04-MD04	9,525 *0.375*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	11,6	18,0	0	2	MM0612	■			
MM10-10007-R04A8-E03	10,0 *0.394*	6,6 *0.260*	0,4 *0.016*	8,44 *0.332*	15,0	12,2	19,0	8	2	MM0612	■		■	
MM10-09510-R08A8-E03	9,525 *0.375*	6,6 *0.260*	0,8 *0.031*	8,37 *0.330*	15,0	11,6	17,2	8	2	MM0612			■	
MM10-09807T-R03-D04	9,8 *0.386*	6,8 *0.268*	0,3 *0.012*	8,49 *0.334*	15,0	11,9	18,8	0	2	MM0612	■			

Zentrierbohren



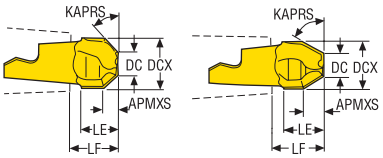


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	LE	LF	SIG°	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM10-10005-C90-M03	10,0 *0.394*	4,69 *0.185*	10,0 *0.394*	11,8 *0.465*	90,0	2	MM0612	■			
MM10-10007-C120-M03	10,0 *0.394*	2,7 *0.106*	10,4 *0.409*	11,8 *0.465*	120,0	2	MM0612	■			

Anfasen

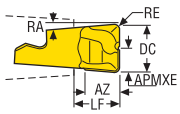




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM10-10007-4525-E03	10,0 *0.394*	4,82 *0.190*	2,6 *0.102*	6,94 *0.273*	8,48 *0.334*	45,0	2	MM0612	■			
MM10-10008-6040-E03	10,0 *0.394*	5,24 *0.206*	4,0 *0.157*	8,05 *0.317*	9,6 *0.378*	60,0	2	MM0612	■			

Tauchfräser

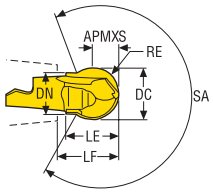




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXE	RE	AZ	LF	RA	ZEFP	Schlüssel	Sorten – Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM10-10007-R10-PL-MD04	10,0 *0.394*	5,0 *0.197*	1,0 *0.039*	7,1 *0.280*	8,48 *0.334*	5,0	2	MM0612			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



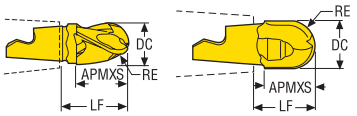


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Schlüssel	Sorten – Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM10-12712-B120PF-M03	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	13,56 *0.534*	10,0 *0.394*	256,0	2	MM1420		■		
MM10-12012-B120P-M05	12,0 *0.472*	6,0 *0.236*	6,0 *0.236*	12,0 *0.472*	13,2 *0.520*	10,0 *0.394*	247,0	2	MM0612			■	
MM10-12712-B120P-M05	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	13,56 *0.534*	10,0 *0.394*	256,0	2	MM1420			■	

Kopierfräser

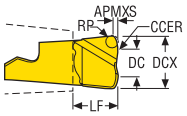




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Sorten			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM10-10012-B90A30-E03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-M03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓				■
MM10-10012-B90A30-D03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10010-B90-MD04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*	0,0	2	MM0612		■		■	
MM10-10010-B90S-E04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*	0,0	2	MM0612				■	
MM10-10010-B90P-M04	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*	0,0	2	MM0612				■	
MM10-10010-B90PF-M02	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*	0,0	2	MM0612			■		
MM10-09510-B90P-M04	9,525 *0.375*	8,7 *0.343*	4,763 *0.188*	11,74 *0.462*	0,0	2	MM0612		■		■	

Hochvorschubfräser





• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Schlüssel	Sorten			
												Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						T60M	F15M	F30M	F40M
MM10-10.50-HF-MD08	10,0 *0.394*	5,0 *0.197*	0,44 *0.017*	1,13 *0.044*	5,0 *0.197*	8,5 *0.335*	5,0	12,2	18,2	2	MM0612		■	■	

MM10 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
P3	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P4	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
P5	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*
P6	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P7	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P8	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
P11	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
P12	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,028 *0.0011*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*
M1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
M2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 *0.0016*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*
M3	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,032 *0.0013*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
M4	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
M5	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
K1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
K2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K4	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K5	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 *0.0016*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*
K6	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K7	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 *0.0016*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*
N1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
S2	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
S3	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
S12	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 *0.0013*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*
S13	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,046 *0.0018*
H5	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
H8	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H11	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 *0.0012*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*
H12	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*
H21	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 *0.0010*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM10 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 870	330 1075	365 1200	405 1325	250 820	315 1025	345 1125	385 1275	190 620	240 790	270 890	295 970
P2	260 850	320 1050	360 1175	390 1275	245 800	305 1000	340 1125	375 1225	185 610	235 770	260 850	290 950
P3	225 740	280 920	315 1025	340 1125	215 710	265 870	295 970	325 1075	165 540	205 670	230 750	250 820
P4	200 660	245 800	275 900	305 1000	190 620	235 770	260 850	290 950	145 475	180 590	200 660	225 740
P5	190 620	235 770	265 870	290 950	180 590	225 740	250 820	275 900	140 460	175 570	195 640	215 710
P6	215 710	265 870	295 970	325 1075	205 670	250 820	280 920	310 1025	155 510	195 640	220 720	240 790
P7	200 660	250 820	280 920	310 1025	190 620	240 790	265 870	290 950	145 475	185 610	205 670	225 740
P8	190 620	235 770	265 870	285 940	180 590	225 740	250 820	270 890	140 460	175 570	190 620	210 690
P11	195 640	245 800	270 890	300 980	185 610	230 750	260 850	285 940	140 460	180 590	200 660	220 720
P12	125 410	150 490	170 560	185 610	115 375	145 475	160 520	175 570	90 295	115 375	125 410	140 460
M1	— —	— —	— —	— —	200 660	245 800	275 900	305 1000	150 490	190 620	210 690	235 770
M2	— —	— —	— —	— —	165 540	200 660	225 740	250 820	125 410	155 510	175 570	190 620
M3	— —	— —	— —	— —	130 425	160 520	175 570	195 640	100 330	125 410	140 460	155 510
M4	— —	— —	— —	— —	100 330	120 395	135 445	150 490	75 245	95 310	105 345	115 375
M5	— —	— —	— —	— —	80 260	100 330	115 375	125 410	65 215	80 260	90 295	95 310
K1	205 670	255 840	285 940	310 1025	195 640	240 790	270 890	300 980	150 490	185 610	205 670	230 750
K2	180 590	225 740	250 820	275 900	170 560	215 710	235 770	260 850	130 425	165 540	185 610	200 660
K3	150 490	190 620	210 690	235 770	145 475	180 590	200 660	220 720	110 360	140 460	155 510	170 560
K4	145 475	180 590	200 660	225 740	140 460	170 560	190 620	210 690	105 345	130 425	150 490	165 540
K5	90 295	110 360	125 410	135 445	85 280	105 345	115 375	125 410	65 215	80 260	90 295	100 330
K6	130 425	160 520	180 590	195 640	120 395	150 490	170 560	185 610	95 310	115 375	130 425	145 475
K7	110 360	140 460	155 510	170 560	105 345	135 445	150 490	165 540	85 280	105 345	115 375	125 410
N1	1550 5075	1925 6325	2150 7050	2350 7700	1475 4850	1825 6000	2025 6650	2250 7375	1125 3700	1400 4600	1550 5075	1725 5650
N2	630 2075	780 2550	870 2850	950 3125	600 1975	740 2425	820 2700	910 2975	450 1475	570 1875	630 2075	690 2275
N3	415 1350	520 1700	580 1900	630 2075	395 1300	495 1625	550 1800	610 2000	300 980	380 1250	420 1375	460 1500
N11	475 1550	590 1925	660 2175	720 2350	455 1500	570 1875	620 2025	690 2275	345 1125	430 1400	480 1575	530 1750
S1	48 155	60 195	65 215	75 245	46 150	55 180	65 215	70 230	36 120	45 150	50 165	55 180
S2	38 125	48 155	55 180	60 195	37 120	46 150	50 165	55 180	29 95	36 120	40 130	44 145
S3	34 110	42 140	47 155	50 165	32 105	40 130	45 150	49 160	25 80	32 105	35 115	38 125
S11	— —	— —	— —	— —	65 215	80 260	90 295	100 330	50 165	65 215	70 230	75 245
S12	— —	— —	— —	— —	45 150	55 180	60 195	70 230	35 115	43 140	49 160	55 180
S13	— —	— —	— —	— —	26 85	32 105	36 120	39 130	20 65	25 80	28 90	30 100
H5	41 135	50 165	55 180	60 195	39 130	48 155	55 180	60 195	30 100	38 125	42 140	46 150
H8	42 140	50 165	60 195	65 215	40 130	50 165	55 180	60 195	31 100	39 130	44 145	48 155
H11	50 165	65 215	70 230	80 260	49 160	60 195	70 230	75 245	38 125	48 155	55 180	60 195
H12	75 245	95 310	105 345	115 375	70 230	90 295	100 330	110 360	55 180	70 230	80 260	85 280
H21	42 140	50 165	60 195	65 215	40 130	50 165	55 180	60 195	31 100	39 130	44 145	48 155

MM10 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
P2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
P3	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P4	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P5	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P6	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P7	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P8	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
P11	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
P12	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
M1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
M2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
M3	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,042 *0.0017*	0,040 *0.0016*	0,042 *0.0017*	0,055 *0.0022*
M4	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
M5	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K5	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
K6	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,050 *0.0020*	0,048 *0.0019*	0,050 *0.0020*	0,065 *0.0026*
K7	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
S1	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S2	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
S3	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,036 *0.0014*	0,034 *0.0013*	0,034 *0.0013*	0,042 *0.0017*
S11	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 *0.0017*	0,042 *0.0017*	0,042 *0.0017*	0,055 *0.0022*
S12	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 *0.0017*	0,042 *0.0017*	0,042 *0.0017*	0,055 *0.0022*
S13	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 *0.0015*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0019*
H5	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H8	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H11	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 *0.0013*	0,034 *0.0013*	0,034 *0.0013*	0,044 *0.0018*
H12	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*
H21	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 *0.0011*	0,026 *0.0010*	0,026 *0.0010*	0,034 *0.0013*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM10 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
P3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*	0,15 *0.0060*
P5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P8	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P12	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
M1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
K6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
S1	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,038 *0.0015*	0,042 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H8	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H11	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 *0.0015*	0,044 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*
H21	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*	0,075 *0.0030*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM10 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	270 *890*	310 *1025*	335 *1100*	365 *1200*	360 *1175*
P2	275 *900*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	260 *850*	305 *1000*	325 *1075*	355 *1175*	355 *1175*
P3	240 *790*	280 *920*	295 *970*	320 *1050*	320 *1050*	230 *750*	265 *870*	280 *920*	305 *1000*	305 *1000*
P4	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	260 *850*
P6	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	250 *820*	270 *890*	290 *950*	290 *950*
P7	215 *710*	250 *820*	265 *870*	290 *950*	285 *940*	205 *670*	235 *770*	255 *840*	275 *900*	275 *900*
P8	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	260 *850*
P11	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	160 *520*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	255 *840*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	260 *850*	285 *940*	285 *940*
M2	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*	175 *570*	200 *660*	215 *710*	235 *770*	230 *750*
M3	145 *475*	175 *570*	175 *590*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	185 *610*	180 *590*
M4	95 *310*	140 *460*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	75 *245*	110 *360*	105 *375*	115 *375*	115 *375*
K1	220 *720*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	255 *840*	280 *920*	280 *920*
K2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	230 *750*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*
K4	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*	145 *475*	170 *560*	185 *610*	200 *660*	195 *640*
K5	95 *310*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	115 *375*	130 *425*	140 *460*	155 *510*	155 *510*
N1	1650 *5425*	1925 *6325*	2050 *6725*	2225 *7300*	2200 *7225*	1575 *5175*	1825 *6000*	1950 *6400*	2125 *6975*	2100 *6900*
N2	670 *2200*	780 *2550*	830 *2725*	900 *2950*	890 *2925*	640 *2100*	740 *2425*	790 *2600*	860 *2825*	850 *2800*
N3	445 *1450*	520 *1700*	550 *1800*	600 *1975*	590 *1925*	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*
N11	510 *1675*	590 *1925*	630 *2075*	690 *2275*	680 *2225*	485 *1600*	560 *1825*	600 *1975*	650 *2125*	650 *2125*
S1	45 *150*	65 *215*	65 *215*	70 *230*	70 *230*	43 *140*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	30 *100*	43 *140*	42 *150*	46 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	45 *150*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	36 *125*	38 *125*	38 *125*	24 *80*	34 *110*	34 *120*	37 *120*	37 *120*
H5	43 *140*	55 *180*	55 *180*	60 *195*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H8	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
H12	75 *245*	100 *330*	100 *330*	105 *345*	105 *345*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*
H21	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*

MM10 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
P3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P4	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P8	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
P11	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P12	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
M1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
M2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M3	MM10-10010-B90S-E04 F30M	3,5 *0.14*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
M4	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
M5	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
K1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
K2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
K6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 *0.0024*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
N1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
N11	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
S1	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
S2	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
S3	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*	0,055 *0.0024*
S11	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
S12	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*
S13	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*	0,060 *0.0026*
H5	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H8	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H11	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H12	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H21	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,046 *0.0018*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM10 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
P3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
P6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P8	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P12	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
M2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
M3	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
M4	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
M5	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
K1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
K2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
K6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,10 *0.0040*
K7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
N1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S2	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
S3	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
S12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
S13	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 *0.0011*	0,030 *0.0013*	0,042 *0.0017*	0,070 *0.0028*
H5	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 *0.00080*	0,022 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM10 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	305 *1000*	390 *1275*	405 *1325*	440 *1450*	440 *1450*	250 *820*	320 *1050*	340 *1125*	370 *1225*	365 *1200*	205 *670*	260 *850*	275 *900*	300 *980*	295 *970*
P2	295 *970*	380 *1250*	395 *1300*	425 *1400*	425 *1400*	240 *790*	305 *1000*	330 *1075*	355 *1175*	355 *1175*	195 *640*	250 *820*	270 *890*	285 *940*	285 *940*
P3	260 *850*	330 *1075*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*
P4	225 *740*	290 *950*	300 *980*	325 *1075*	325 *1075*	185 *610*	235 *770*	255 *840*	270 *890*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P5	215 *710*	275 *900*	290 *950*	315 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	265 *870*	260 *850*	145 *475*	185 *610*	195 *640*	215 *710*	210 *690*
P6	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P7	230 *750*	295 *970*	305 *1000*	330 *1075*	330 *1075*	190 *620*	240 *790*	260 *850*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P11	225 *740*	285 *940*	295 *970*	325 *1075*	320 *1050*	185 *610*	235 *770*	250 *820*	270 *890*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	215 *710*
P12	140 *460*	175 *570*	180 *610*	195 *640*	195 *640*	120 *395*	150 *490*	155 *510*	170 *560*	170 *560*	95 *310*	120 *395*	125 *410*	135 *445*	135 *445*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	195 *640*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
M2	195 *640*	250 *820*	260 *850*	280 *920*	280 *920*	160 *520*	205 *670*	215 *710*	235 *770*	235 *770*	130 *425*	165 *540*	175 *570*	190 *620*	190 *620*
M3	155 *510*	200 *660*	200 *670*	220 *720*	220 *720*	130 *425*	165 *540*	175 *570*	185 *610*	185 *610*	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*
M4	120 *395*	155 *510*	155 *560*	165 *540*	165 *540*	105 *345*	135 *445*	130 *460*	145 *475*	140 *460*	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	335 *1100*	335 *1100*	190 *620*	245 *800*	260 *850*	280 *920*	280 *920*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
K2	205 *670*	265 *870*	275 *900*	295 *970*	295 *970*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*
K3	175 *570*	225 *740*	230 *750*	250 *820*	250 *820*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	150 *490*	155 *510*	170 *560*	170 *560*
K4	165 *540*	215 *710*	220 *720*	240 *790*	240 *790*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	160 *520*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*	70 *230*	85 *280*	90 *295*	100 *330*	100 *330*
K6	145 *475*	185 *610*	195 *640*	210 *690*	210 *690*	120 *395*	155 *510*	165 *540*	180 *590*	175 *570*	95 *310*	125 *410*	130 *425*	145 *475*	145 *475*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	105 *345*	135 *445*	145 *475*	155 *510*	155 *510*	85 *280*	110 *360*	115 *375*	125 *410*	125 *410*
N1	1800 *5900*	2300 *7550*	2425 *7950*	2600 *8525*	2600 *8525*	1450 *4750*	1825 *6000*	1975 *6475*	2150 *7050*	2100 *6900*	1175 *3850*	1475 *4850*	1600 *5250*	1725 *5650*	1700 *5575*
N2	730 *2400*	930 *3050*	970 *3175*	1050 *3450*	1050 *3450*	590 *1925*	740 *2425*	800 *2625*	870 *2850*	850 *2800*	475 *1550*	600 *1975*	650 *2125*	700 *2300*	680 *2225*
N3	485 *1600*	620 *2025*	650 *2125*	700 *2300*	700 *2300*	390 *1275*	495 *1625*	530 *1750*	580 *1900*	560 *1825*	315 *1025*	400 *1300*	435 *1425*	465 *1525*	455 *1500*
N11	550 *1800*	710 *2325*	740 *2425*	800 *2625*	800 *2625*	450 *1475*	570 *1875*	610 *2000*	660 *2175*	640 *2100*	360 *1175*	460 *1500*	495 *1625*	530 *1750*	520 *1700*
S1	55 *180*	70 *230*	70 *260*	80 *260*	75 *245*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S2	46 *150*	60 *195*	60 *215*	65 *215*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	32 *105*	40 *130*	40 *140*	43 *140*	43 *140*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	34 *110*	43 *140*	43 *150*	47 *155*	46 *150*	27 *90*	35 *115*	35 *120*	38 *125*	38 *125*
S11	80 *260*	100 *330*	100 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *295*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	49 *165*	55 *180*	55 *180*
S13	32 *105*	41 *135*	40 *145*	44 *145*	43 *140*	27 *90*	35 *115*	35 *120*	37 *120*	37 *120*	22 *70*	28 *90*	28 *100*	30 *100*	30 *100*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	32 *105*	41 *135*	42 *140*	45 *150*	45 *150*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	40 *130*	50 *165*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*

MM10 Hohe Vorschübe - Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

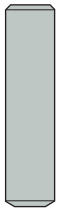
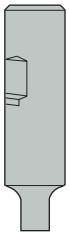
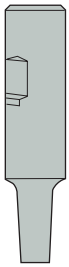
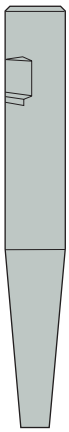
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 *0.019*	0,48 *0.019*	0,65 *0.026*	0,80 *0.032*
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P8	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 *0.018*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
P11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,44 *0.017*	0,60 *0.024*	0,75 *0.030*
P12	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
M1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
M2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
M3	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M4	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
M5	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
K1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*	0,80 *0.032*
K2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
K6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 *0.017*	0,46 *0.018*	0,60 *0.024*	0,75 *0.030*
K7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 *0.016*	0,40 *0.016*	0,55 *0.022*	0,65 *0.026*
N1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
N11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*	1,1 *0.044*
S1	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
S2	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
S3	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*	0,46 *0.018*
S11	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S12	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
S13	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*	0,50 *0.020*
H5	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
H8	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
H11	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 *0.012*	0,30 *0.012*	0,40 *0.016*	0,48 *0.019*
H12	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*
H21	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*	0,36 *0.014*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

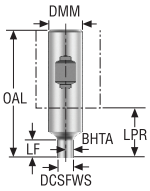
MM10 Hohe Vorschübe Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	230	280	325	340
	—	—	—	—	*750*	*920*	*1075*	*1125*
P2	—	—	—	—	225	270	315	330
	—	—	—	—	*740*	*890*	*1025*	*1075*
P3	—	—	—	—	195	240	275	290
	—	—	—	—	*640*	*790*	*900*	*950*
P4	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P5	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P6	—	—	—	—	185	225	260	270
	—	—	—	—	*610*	*740*	*850*	*890*
P7	—	—	—	—	175	215	245	255
	—	—	—	—	*570*	*710*	*800*	*840*
P8	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P11	—	—	—	—	170	210	240	250
	—	—	—	—	*560*	*690*	*790*	*820*
P12	—	—	—	—	110	135	150	160
	—	—	—	—	*360*	*445*	*490*	*520*
M1	—	—	—	—	180	220	255	265
	—	—	—	—	*590*	*720*	*840*	*870*
M2	—	—	—	—	150	180	210	220
	—	—	—	—	*490*	*590*	*690*	*720*
M3	—	—	—	—	120	145	165	175
	—	—	—	—	*395*	*475*	*540*	*570*
M4	—	—	—	—	95	110	130	135
	—	—	—	—	*310*	*360*	*425*	*445*
M5	—	—	—	—	80	95	110	115
	—	—	—	—	*260*	*310*	*360*	*375*
K1	190	230	270	280	175	215	250	260
	620	*750*	*890*	*920*	*570*	*710*	*820*	*850*
K2	170	205	235	245	160	190	220	230
	560	*670*	*770*	*800*	*520*	*620*	*720*	*750*
K3	145	175	200	210	135	160	185	195
	475	*570*	*660*	*690*	*445*	*520*	*610*	*640*
K4	135	165	190	200	125	155	175	185
	445	*540*	*620*	*660*	*410*	*510*	*570*	*610*
K5	85	100	115	125	75	95	105	115
	280	*330*	*375*	*410*	*245*	*310*	*345*	*375*
K6	120	145	170	175	110	135	155	165
	395	*475*	*560*	*570*	*360*	*445*	*510*	*540*
K7	105	130	150	155	100	120	140	145
	345	*425*	*490*	*510*	*330*	*395*	*460*	*475*
N1	—	—	—	—	1325	1600	1850	1925
	—	—	—	—	*4350*	*5250*	*6075*	*6325*
N2	—	—	—	—	530	650	750	780
	—	—	—	—	*1750*	*2125*	*2450*	*2550*
N3	—	—	—	—	355	430	500	520
	—	—	—	—	*1175*	*1400*	*1650*	*1700*
N11	—	—	—	—	405	495	570	590
	—	—	—	—	*1325*	*1625*	*1875*	*1925*
S1	—	—	—	—	45	50	60	65
	—	—	—	—	*150*	*165*	*195*	*215*
S2	—	—	—	—	36	42	49	50
	—	—	—	—	*120*	*140*	*160*	*165*
S3	—	—	—	—	31	37	42	45
	—	—	—	—	*100*	*120*	*140*	*150*
S11	—	—	—	—	60	75	85	90
	—	—	—	—	*195*	*245*	*280*	*295*
S12	—	—	—	—	43	50	60	60
	—	—	—	—	*140*	*165*	*195*	*195*
S13	—	—	—	—	25	29	34	36
	—	—	—	—	*80*	*95*	*110*	*120*
H5	40	48	55	60	37	44	50	55
	130	*155*	*180*	*195*	*120*	*145*	*165*	*180*
H8	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*
H11	50	60	70	75	47	55	65	70
	165	*195*	*230*	*245*	*155*	*180*	*215*	*230*
H12	75	90	105	110	70	85	95	100
	245	*295*	*345*	*360*	*230*	*280*	*310*	*330*
H21	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*

Version

Version 1, Keilnut-Schaft	Version 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Version 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Version 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Version 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM12 Schaft





Bezeichnung	Produkt-nummer	Aufnahme	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			mm	mm	mm	mm	mm					kg	
MM12-20080.3-0012	75012864	Weldon	11,4	20,0	80,0	12,0	30,0	0,0	2	✓	80000	0,2	4
MM12-20095.3-3027	75012865	Weldon	11,4	20,0	95,0	27,0	45,0	3,0	3	✓	80000	0,2	4
MM12-20150.3-5049	75012866	Weldon	11,4	20,0	150,0	49,1	100,0	5,0	4	✓	80000	0,3	5
MM12-12055.0-0008	00083978	Zylindrisch	11,5	12,0	55,0	8,5	10,0	0,0	2	✓	80000	0,1	2
MM12-16065.0-0000	75004926	Zylindrisch	11,4	16,0	65,0	0,0	17,0	60,0	1	✓	80000	0,1	1
MM12-16170.0-1040	75034505	Zylindrisch	11,4	16,0	170,0	40,0	122,0	1,0	3	✓	80000	0,2	5
MM12-16170.0-1060	75034506	Zylindrisch	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	80000	0,2	5
MM12-16170.0-1080	75034507	Zylindrisch	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	80000	0,2	5
MM12-12070.0-0008DS	02580668	Zylindrisch	11,5	12,0	70,0	8,5	25,0	0,0	2	✓	63600	0,1	3
MM12-16095.0-0024DS	02580690	Zylindrisch	11,4	16,0	95,0	24,0	47,0	0,0	2	✓	63600	0,3	3
MM12-16090.0-3044DS	02580705	Zylindrisch	11,4	16,0	90,0	43,9	42,0	3,0	4	✓	63600	0,3	3
MM12-16120.0-1045DS	02580752	Zylindrisch	11,4	16,0	120,0	45,0	72,0	1,0	3	✓	63600	0,3	3
MM12-16115.0-0048DS	02580691	Zylindrisch	11,4	16,0	115,0	48,0	67,0	0,0	2	✓	63600	0,3	3
MM12-16170.0-1060DS	02580753	Zylindrisch	11,4	16,0	170,0	60,0	122,0	1,0	3	✓	63600	0,5	3
MM12-16170.0-1080DS	02580755	Zylindrisch	11,4	16,0	170,0	80,0	122,0	1,0	3	✓	63600	0,5	3
MM12-20250.0-1060DS	02580756	Zylindrisch	11,4	20,0	250,0	60,0	200,0	1,0	5	✓	63600	1,0	3

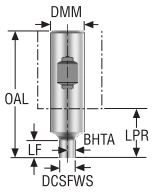
Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
4	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	H06-4
3	–	MM12-061037	–

MM12 Schaft – Zoll





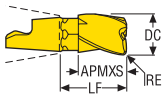
Bezeichnung	Produkt-nummer	Aufnahme	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			Zoll	Zoll	Zoll	Zoll	Zoll					lbs	
MM12-0.75-3.1-3-0004	75015055	Weldon	0.449	0.750	3.150	0.472	1.181	0,0	2	✓	80000	0.440	3
MM12-0.75-3.7-3-3010	75015056	Weldon	0.449	0.750	3.740	1.063	1.772	3,0	3	✓	80000	0.440	3
MM12-0.75-5.9-3-5017	75015057	Weldon	0.449	0.750	5.906	1.720	3.937	5,0	4	✓	80000	0.660	5
MM12-0.50-2.2-0-0003	00096133	Zylindrisch	0.453	0.500	2.165	0.335	0.394	0,0	2	✓	80000	0.220	2
MM12-0.62-2.6-0-0000	75005070	Zylindrisch	0.449	0.625	2.559	0	0.669	60,0	1	✓	80000	0.220	1
MM12-0.62-6.7-0-1015	75054728	Zylindrisch	0.449	0.625	6.693	1.575	4.803	1,0	3	✓	80000	0.660	5
MM12-0.62-6.7-0-1023	75054729	Zylindrisch	0.449	0.625	6.693	2.362	4.803	1,0	3	✓	80000	0.440	5
MM12-0.62-6.7-0-1023DS	02593423	Zylindrisch	0.449	0.625	6.693	2.362	4.803	1,0	3	✓	63600	1.100	4
MM12-0.62-6.7-0-1031DS	02593426	Zylindrisch	0.449	0.625	6.693	3.150	4.803	1,0	3	✓	63600	1.100	4
MM12-0.75-10.0-0-1023DS	02593427	Zylindrisch	0.449	0.750	9.843	2.362	7.874	1,0	5	✓	63600	2.200	4
MM12-0.75-3.8-0-0009DS	02593428	Zylindrisch	0.449	0.750	3.740	0.945	1.772	0,0	2	✓	63600	0.880	4
MM12-0.75-4.5-0-0018DS	02593430	Zylindrisch	0.449	0.750	4.528	1.890	2.559	0,0	2	✓	63600	0.880	4

Ersatzteile

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
3	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
1	MM-06032	MM12-0637	H06-4
4	–	MM12-061037	–

Nutfräsen/Eckfräsen



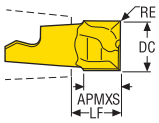


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel		Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*											
MM12-12015-A30-E04	12,0 *0.472*	15,35 *0.604*	0,0 *0.0*	19,9 *0.783*	15,0	14,6	23,8	30	3	MM0416	✓			■	
MM12-12015-R05A30-M04	12,0 *0.472*	15,35 *0.604*	0,5 *0.020*	19,9 *0.783*	15,0	14,6	22,8	30	3	MM0416	✓				■
MM12-12015-R10A30-E04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓			■	
MM12-12015-R10A30-M04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓				■
MM12-12015-R15A30-D04	12,0 *0.472*	15,35 *0.604*	1,5 *0.059*	19,9 *0.783*	15,0	14,6	20,8	30	3	MM0416	✓			■	
MM12-12015-R20A30-M04	12,0 *0.472*	15,35 *0.604*	2,0 *0.079*	19,9 *0.783*	15,0	14,6	19,8	30	3	MM0416	✓				■
MM12-12015-R30A30-E04	12,0 *0.472*	15,3 *0.602*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓			■	
MM12-12015-R30A30-M04	12,0 *0.472*	15,35 *0.604*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓				■
MM12-12015-R40A30-M04	12,0 *0.472*	15,35 *0.604*	4,0 *0.157*	19,9 *0.783*	15,0	14,6	15,8	30	3	MM0416	✓				■
MM12-11715-R03A30-M04	11,7 *0.461*	15,35 *0.604*	0,3 *0.012*	19,9 *0.783*	15,0	14,2	22,6	30	3	MM0416	✓				■
MM12-12715-A30-E04	12,7 *0.500*	15,35 *0.604*	0,0 *0.0*	19,9 *0.783*	15,0	15,4	25,2	30	3	MM0416	✓			■	
MM12-12715-R08A30-M04	12,7 *0.500*	15,35 *0.604*	0,8 *0.031*	19,9 *0.783*	15,0	15,4	23,6	30	3	MM0416	✓				■
MM12-12715-R16A30-M04	12,7 *0.500*	15,35 *0.604*	1,6 *0.063*	19,9 *0.783*	15,0	15,4	22,0	30	3	MM0416	✓				■

Nutfräsen/Eckfräsen

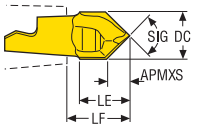




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel	Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*										
MM12-12008-M04	12,0 *0.472*	8,2 *0.323*	0,0 *NaN*	10,2 *0.402*	15,0	14,6	23,8	0	2	MM0612	■			
MM12-12008-R08-MD05	12,0 *0.472*	8,2 *0.323*	0,8 *0.031*	10,18 *0.401*	15,0	14,6	22,2	0	2	MM0612	■		■	
MM12-12008-R08A8-E04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,15 *0.400*	15,0	14,6	22,2	8	2	MM0612	■			
MM12-12008-R08P-M04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,05 *0.396*	15,0	14,6	22,2	0	2	MM0612			■	
MM12-12008-R20-MD05	12,0 *0.472*	8,2 *0.323*	2,0 *0.079*	10,16 *0.400*	15,0	14,6	19,8	0	2	MM0612			■	
MM12-12008-R30-MD05	12,0 *0.472*	8,2 *0.323*	3,0 *0.118*	10,14 *0.399*	15,0	14,6	17,8	0	2	MM0612			■	
MM12-14009-M04	14,0 *0.551*	9,3 *0.366*	0,0 *NaN*	11,26 *0.443*	15,0	17,0	27,8	0	2	MM1420	■			
MM12-14009-R08-MD05	14,0 *0.551*	9,3 *0.366*	0,8 *0.031*	11,26 *0.443*	15,0	17,0	26,2	0	2	MM1420	■		■	
MM12-14009-R08A8-E04	14,0 *0.551*	9,2 *0.362*	0,8 *0.031*	11,06 *0.435*	15,0	17,0	26,2	8	2	MM1420	■		■	
MM12-12708-M04	12,7 *0.500*	9,3 *0.366*	0,0 *NaN*	11,25 *0.443*	15,0	15,4	25,2	0	2	MM1420	■			
MM12-12708-R08-MD05	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420	■			
MM12-12708-R08P-M04	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420			■	
MM12-12708-R32-MD05	12,7 *0.500*	9,3 *0.366*	3,175 *0.125*	11,18 *0.440*	15,0	15,4	18,8	0	2	MM1420			■	
MM12-11708T-R03-D05	11,7 *0.461*	8,2 *0.323*	0,3 *0.012*	10,18 *0.401*	15,0	14,2	22,6	0	2	MM0612	■			
MM12-13709T-R03-D05	13,7 *0.539*	9,3 *0.366*	0,3 *0.012*	11,25 *0.443*	15,0	16,6	26,6	0	2	MM1420	■			

Zentrierbohren

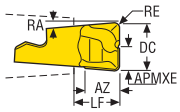




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	LE	LF	SIG°	ZEFP	Schlüssel	Sorten – Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM12-12006-C90-M04	12,0 *0.472*	5,65 *0.222*	12,65 *0.498*	14,64 *0.576*	90,0	2	MM0612	■			

Tauchfräser



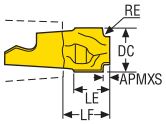


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXE	RE	AZ	LF	RA	ZEFP	Schlüssel	Sorten – Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM12-12008-R10-PL-MD05	12,0 *0.472*	6,0 *0.236*	1,0 *0.039*	8,5 *0.335*	10,2 *0.402*	5,0	2	MM0612			■	

Konvexradienfräsen



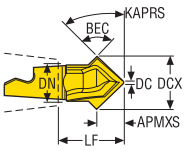


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			T60M	F15M	F30M	F40M
MM12-12010-CR10-MD05	12,0 *0.472*	2,2 *0.087*	1,0 *0.039*	12,14 *0.478*	2	MM0612	■			
MM12-12010-CR20-MD05	12,0 *0.472*	2,4 *0.094*	2,0 *0.079*	12,25 *0.482*	2	MM0612	■			
MM12-12010-CR30-MD05	12,0 *0.472*	3,3 *0.130*	3,0 *0.118*	12,2 *0.480*	2	MM0612	■			

Anfasen

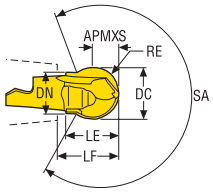




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	LF	DN	BEC°	KAPRS°	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM12-16016-D3020P-M02	16,0 *0.630*	1,0 *0.039*	4,3 *0.169*	15,2 *0.598*	11,5 *0.453*	60,0	30,0	2	MM1420		■		
MM12-16016-D4520P-M02	16,0 *0.630*	1,0 *0.039*	7,5 *0.295*	17,2 *0.677*	11,5 *0.453*	90,0	45,0	2	MM1420		■		

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



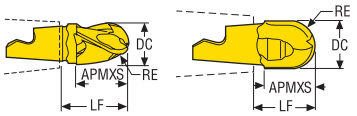


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Schlüssel	Sorten			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM12-14014-B120P-M05	14,0 *0.551*	7,0 *0.276*	7,0 *0.276*	14,0 *0.551*	15,45 *0.608*	12,0 *0.472*	242,0	2	MM1420			■	
MM12-16016-B120P-M07	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	17,46 *0.687*	12,0 *0.472*	263,0	2	MM1420			■	
MM12-16016-B120PF-M03	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	17,46 *0.687*	12,0 *0.472*	263,0	2	MM1420		■		

Kopierfräser

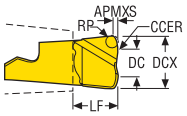




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Sorten			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM12-12015-B90A30-E04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓			■	
MM12-12015-B90A30-M04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓				■
MM12-12715-B90A30-M04	12,7 *0.500*	15,3 *0.602*	6,35 *0.250*	19,75 *0.778*	30,0	3	MM0416	✓				■
MM12-12012-B90-MD05	12,0 *0.472*	12,2 *0.480*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612		■		■	
MM12-12012-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*	0,0	2	MM0612				■	
MM12-14014-B90S-E05	14,0 *0.551*	14,1 *0.555*	7,0 *0.276*	15,92 *0.627*	0,0	2	MM1420				■	
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612				■	
MM12-12713-B90P-M05	12,7 *0.500*	12,2 *0.480*	6,35 *0.250*	15,92 *0.627*	0,0	2	MM1420		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*	0,0	2	MM0612			■		

Hochvorschubfräser





• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Schlüssel	Sorten			
													Beschichtet		
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						T60M	F15M	F30M	F40M
MM12-12.60-HF-MD10	12,0 *0.472*	6,0 *0.236*	0,51 *0.020*	1,21 *0.048*	6,5 *0.256*	10,25 *0.404*	5,0	14,6	22,2	2	MM0612		■	■	

MM12 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P3	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
P4	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P5	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P6	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P7	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P8	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
P11	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
P12	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,036 *0.0014*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*
M1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
M2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
M3	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,042 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
M4	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
M5	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
K1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
K2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K6	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,090 *0.0036*
K7	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
N1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
N11	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S1	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S2	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S3	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,046 *0.0018*	0,044 *0.0017*	0,044 *0.0017*	0,055 *0.0024*
S11	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S12	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S13	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 *0.0015*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*
H5	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H8	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H11	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H12	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*
H21	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*	0,046 *0.0018*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM12 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	250 *820*	315 *1025*	350 *1150*	385 *1275*	240 *790*	300 *980*	335 *1100*	365 *1200*	185 *610*	225 *740*	255 *840*	280 *920*
P2	245 *800*	305 *1000*	340 *1125*	375 *1225*	235 *770*	290 *950*	325 *1075*	355 *1175*	175 *570*	220 *720*	250 *820*	275 *900*
P3	210 *690*	265 *870*	295 *970*	325 *1075*	200 *660*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	215 *710*	235 *770*
P4	190 *620*	235 *770*	260 *850*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P5	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	240 *790*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P6	205 *670*	250 *820*	280 *920*	310 *1025*	195 *640*	240 *790*	270 *890*	295 *970*	150 *490*	185 *610*	205 *670*	225 *740*
P7	190 *620*	240 *790*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	215 *710*
P8	175 *570*	220 *720*	245 *800*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P11	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	220 *720*	245 *800*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P12	115 *375*	145 *475*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	170 *560*	85 *280*	110 *360*	120 *395*	130 *425*
M1	200 *660*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
M2	160 *520*	200 *660*	225 *740*	245 *800*	155 *510*	195 *640*	215 *710*	235 *770*	120 *395*	145 *475*	165 *540*	180 *590*
M3	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	145 *475*
M4	100 *330*	125 *410*	140 *460*	150 *490*	95 *310*	115 *375*	130 *425*	145 *475*	75 *245*	90 *295*	100 *330*	110 *360*
M5	80 *260*	100 *330*	115 *375*	125 *410*	80 *260*	95 *310*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K1	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	230 *750*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	220 *720*
K2	170 *560*	215 *710*	240 *790*	260 *850*	165 *540*	205 *670*	225 *740*	245 *800*	125 *410*	155 *510*	175 *570*	190 *620*
K3	145 *475*	180 *590*	200 *660*	220 *720*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	145 *475*	160 *520*
K4	140 *460*	170 *560*	190 *620*	210 *690*	130 *425*	165 *540*	185 *610*	200 *660*	100 *330*	125 *410*	140 *460*	155 *510*
K5	85 *280*	105 *345*	115 *375*	125 *410*	80 *260*	100 *330*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K6	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	110 *360*	125 *410*	135 *445*
K7	105 *345*	135 *445*	150 *490*	165 *540*	100 *330*	125 *410*	140 *460*	155 *510*	80 *260*	100 *330*	110 *360*	120 *395*
N1	1450 *4750*	1800 *5900*	2025 *6650*	2225 *7300*	1375 *4500*	1725 *5650*	1925 *6325*	2125 *6975*	1050 *3450*	1300 *4275*	1450 *4750*	1600 *5250*
N2	580 *1900*	730 *2400*	820 *2700*	900 *2950*	560 *1825*	690 *2275*	780 *2550*	860 *2825*	420 *1375*	530 *1750*	590 *1925*	650 *2125*
N3	390 *1275*	485 *1600*	550 *1800*	600 *1975*	370 *1225*	460 *1500*	520 *1700*	570 *1875*	280 *920*	350 *1150*	395 *1300*	435 *1425*
N11	445 *1450*	550 *1800*	620 *2025*	690 *2275*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	320 *1050*	405 *1325*	450 *1475*	495 *1625*
S1	46 *150*	55 *180*	65 *215*	70 *230*	44 *145*	55 *180*	60 *195*	65 *215*	34 *110*	43 *140*	47 *155*	50 *165*
S2	37 *120*	46 *150*	50 *165*	55 *180*	35 *115*	44 *145*	49 *160*	55 *180*	28 *90*	34 *110*	38 *125*	42 *140*
S3	32 *105*	40 *130*	45 *150*	50 *165*	31 *100*	38 *125*	43 *140*	47 *155*	24 *80*	30 *100*	33 *110*	37 *120*
S11	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	95 *310*	48 *155*	60 *195*	65 *215*	75 *245*
S12	45 *150*	55 *180*	60 *195*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	33 *110*	41 *135*	47 *155*	50 *165*
S13	26 *85*	32 *105*	36 *120*	40 *130*	25 *80*	31 *100*	34 *110*	38 *125*	19 *60*	24 *80*	27 *90*	29 *95*
H5	39 *130*	49 *160*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
H8	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*
H11	49 *160*	60 *195*	70 *230*	75 *245*	47 *155*	60 *195*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
H12	75 *245*	90 *295*	100 *330*	110 *360*	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	65 *215*	75 *245*	85 *280*
H21	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*

MM12 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,095 *0.0038*
P2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
P3	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P4	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
P6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P8	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,065 *0.0026*	0,070 *0.0028*	0,090 *0.0036*
P11	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
P12	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
M1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
M2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
M3	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
M4	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
M5	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
K7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 *0.0024*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
S1	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S2	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
S3	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,046 *0.0018*	0,046 *0.0018*	0,046 *0.0018*	0,055 *0.0024*
S11	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
S12	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
S13	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 *0.0020*	0,048 *0.0019*	0,048 *0.0019*	0,060 *0.0026*
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 *0.0018*	0,044 *0.0017*	0,046 *0.0018*	0,060 *0.0024*
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 *0.0014*	0,036 *0.0014*	0,036 *0.0014*	0,046 *0.0018*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM12 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
P3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
P5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
P6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P8	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*	0,20 *0.0080*
P11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*	0,19 *0.0075*
P12	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
M1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
M2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
M3	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
M4	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
M5	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,22 *0.0085*
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
K6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
K7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*	0,18 *0.0070*
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,28 *0.011*
S1	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
S2	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
S3	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,050 *0.0020*	0,055 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
S11	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
S12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,16 *0.0065*
S13	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 *0.0022*	0,060 *0.0026*	0,085 *0.0034*	0,14 *0.0055*
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,13 *0.0050*
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM12 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	270 *890*	315 *1025*	335 *1100*	365 *1200*	360 *1175*	255 *840*	300 *980*	320 *1050*	345 *1125*	340 *1125*
P2	265 *870*	305 *1000*	325 *1075*	355 *1175*	350 *1150*	250 *820*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P3	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P4	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*
P5	195 *640*	225 *740*	240 *790*	260 *850*	255 *840*	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*
P6	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*
P7	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*	195 *640*	230 *750*	240 *790*	260 *850*	260 *850*
P8	190 *620*	225 *740*	240 *790*	255 *840*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
P11	200 *660*	235 *770*	245 *800*	265 *870*	265 *870*	190 *620*	220 *720*	235 *770*	255 *840*	255 *840*
P12	125 *410*	150 *490*	155 *510*	170 *560*	165 *540*	120 *395*	140 *460*	145 *490*	160 *520*	160 *520*
M1	210 *690*	245 *800*	265 *870*	285 *940*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
M2	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*	165 *540*	195 *640*	205 *670*	220 *720*	220 *720*
M3	140 *460*	165 *540*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	160 *540*	175 *570*	175 *570*
M4	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M5	80 *260*	110 *360*	110 *375*	115 *375*	115 *375*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
K1	210 *690*	240 *790*	260 *850*	280 *920*	275 *900*	200 *660*	230 *750*	245 *800*	265 *870*	265 *870*
K2	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*
K3	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	180 *590*	200 *660*	195 *640*
K4	150 *490*	175 *570*	180 *590*	200 *660*	195 *640*	140 *460*	165 *540*	175 *570*	190 *620*	185 *610*
K5	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*
K6	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	145 *475*	155 *510*	165 *540*	165 *540*
K7	115 *375*	135 *445*	140 *460*	155 *510*	155 *510*	110 *360*	125 *410*	135 *445*	145 *475*	145 *475*
N1	1575 *5175*	1825 *6000*	1950 *6400*	2100 *6900*	2100 *6900*	1500 *4925*	1750 *5750*	1850 *6075*	2000 *6550*	2000 *6550*
N2	640 *2100*	740 *2425*	790 *2600*	850 *2800*	840 *2750*	610 *2000*	700 *2300*	750 *2450*	810 *2650*	800 *2625*
N3	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*	405 *1325*	470 *1550*	500 *1650*	540 *1775*	540 *1775*
N11	485 *1600*	560 *1825*	600 *1975*	650 *2125*	640 *2100*	460 *1500*	540 *1775*	570 *1875*	620 *2025*	610 *2000*
S1	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	60 *195*	60 *195*	65 *215*	60 *195*
S2	37 *120*	50 *165*	49 *165*	55 *180*	55 *180*	35 *115*	47 *155*	47 *165*	50 *165*	50 *165*
S3	32 *105*	43 *140*	43 *150*	46 *150*	46 *150*	31 *100*	41 *135*	41 *140*	44 *145*	44 *145*
S11	70 *230*	85 *280*	85 *295*	95 *310*	90 *295*	65 *215*	80 *260*	80 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*	46 *150*	55 *180*	55 *195*	60 *195*	60 *195*
S13	26 *85*	35 *115*	34 *120*	37 *120*	37 *120*	25 *80*	33 *110*	33 *115*	35 *115*	35 *115*
H5	42 *140*	50 *165*	50 *165*	55 *180*	55 *180*	40 *130*	47 *155*	49 *160*	55 *180*	55 *180*
H8	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H11	55 *180*	65 *215*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	75 *245*	90 *295*	90 *310*	100 *330*	100 *330*
H21	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*

MM12 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 *0.0030*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P4	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
P6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P8	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
P11	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P12	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
M1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
M2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
M3	MM12-12012-B90S-E05 F30M	4,0 *0.16*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
M4	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
M5	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
K1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 *0.0032*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
K2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K4	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
K6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
K7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 *0.0026*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
N1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
N11	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
S1	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
S2	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
S3	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,050 *0.0020*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0030*
S11	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
S12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
S13	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,075 *0.0032*
H5	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
H8	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*
H11	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*
H12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*
H21	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,055 *0.0024*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM12 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,11 *0.0044*
P2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
P3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P8	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*	0,10 *0.0040*
P11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
P12	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
M1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
M2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
M3	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
M4	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
M5	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
K1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 *0.0017*	0,048 *0.0019*	0,070 *0.0028*	0,11 *0.0044*
K2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
K6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
K7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*	0,085 *0.0034*
N1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
N11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*	0,14 *0.0055*
S1	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
S2	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
S3	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,025 *0.0010*	0,028 *0.0012*	0,040 *0.0016*	0,065 *0.0026*
S11	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
S12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 *0.0012*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*
S13	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*
H5	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H8	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H11	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*	0,065 *0.0026*
H12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*
H21	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,050 *0.0020*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM12 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	310 *1025*	390 *1275*	410 *1350*	445 *1450*	440 *1450*	240 *790*	300 *980*	325 *1075*	350 *1150*	345 *1125*	195 *640*	240 *790*	265 *870*	285 *940*	280 *920*
P2	300 *980*	380 *1250*	400 *1300*	430 *1400*	430 *1400*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	275 *900*
P3	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	205 *670*	225 *740*	240 *790*	240 *790*
P4	230 *750*	290 *950*	305 *1000*	325 *1075*	330 *1075*	175 *570*	225 *740*	245 *800*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P5	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*	140 *460*	170 *560*	190 *620*	205 *670*	200 *660*
P6	245 *800*	310 *1025*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	260 *850*	285 *940*	280 *920*	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*
P7	230 *750*	295 *970*	310 *1025*	335 *1100*	335 *1100*	180 *590*	230 *750*	245 *800*	270 *890*	265 *870*	145 *475*	185 *610*	200 *660*	215 *710*	215 *710*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*	135 *445*	170 *560*	190 *620*	200 *660*	200 *660*
P11	225 *740*	285 *940*	300 *980*	325 *1075*	325 *1075*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*
P12	140 *460*	180 *590*	180 *610*	195 *640*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	160 *520*	95 *310*	120 *395*	120 *410*	135 *445*	130 *425*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	225 *740*	220 *720*
M2	195 *640*	250 *820*	260 *850*	285 *940*	285 *940*	155 *510*	190 *620*	210 *690*	225 *740*	225 *740*	125 *410*	155 *510*	170 *560*	185 *610*	180 *590*
M3	155 *510*	200 *660*	205 *670*	220 *720*	220 *720*	125 *410*	160 *520*	165 *560*	180 *590*	180 *590*	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*
M4	120 *395*	155 *510*	155 *540*	165 *540*	165 *540*	100 *330*	130 *425*	130 *445*	135 *445*	140 *460*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	105 *375*	115 *375*	115 *375*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	340 *1125*	340 *1125*	180 *590*	230 *750*	250 *820*	270 *890*	270 *890*	145 *475*	185 *610*	205 *670*	220 *720*	215 *710*
K2	205 *670*	265 *870*	275 *900*	300 *980*	300 *980*	160 *520*	200 *660*	220 *720*	240 *790*	235 *770*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*
K3	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	135 *445*	170 *560*	185 *610*	205 *670*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*
K4	165 *540*	215 *710*	225 *740*	240 *790*	240 *790*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*	105 *345*	130 *425*	145 *475*	155 *510*	155 *510*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	80 *260*	100 *330*	110 *360*	115 *375*	115 *375*	65 *215*	80 *260*	85 *280*	95 *310*	95 *310*
K6	145 *475*	185 *610*	195 *640*	215 *710*	215 *710*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	135 *445*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	100 *330*	125 *410*	140 *460*	150 *490*	150 *490*	80 *260*	105 *345*	110 *360*	120 *395*	120 *395*
N1	1825 *6000*	2300 *7550*	2425 *7950*	2625 *8600*	2600 *8525*	1375 *4500*	1725 *5650*	1900 *6225*	2025 *6650*	2000 *6550*	1100 *3600*	1400 *4600*	1525 *5000*	1650 *5425*	1625 *5325*
N2	730 *2400*	930 *3050*	980 *3225*	1050 *3450*	1050 *3450*	550 *1800*	690 *2275*	760 *2500*	820 *2700*	810 *2650*	450 *1475*	560 *1825*	620 *2025*	660 *2175*	660 *2175*
N3	490 *1600*	620 *2025*	650 *2125*	710 *2325*	700 *2300*	370 *1225*	465 *1525*	510 *1675*	550 *1800*	540 *1775*	300 *980*	375 *1225*	410 *1350*	440 *1450*	440 *1450*
N11	560 *1825*	710 *2325*	750 *2450*	810 *2650*	800 *2625*	425 *1400*	530 *1750*	580 *1900*	620 *2025*	620 *2025*	340 *1125*	430 *1400*	470 *1550*	500 *1650*	500 *1650*
S1	55 *180*	70 *230*	70 *260*	80 *260*	80 *260*	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
S2	45 *150*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	39 *130*	39 *135*	42 *140*	42 *140*
S3	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	43 *140*	42 *145*	45 *150*	45 *150*	27 *90*	34 *110*	34 *120*	37 *120*	36 *120*
S11	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	45 *150*	60 *195*	60 *195*	65 *215*	60 *195*	37 *120*	47 *155*	47 *160*	50 *165*	50 *165*
S13	32 *105*	41 *135*	40 *145*	44 *145*	44 *145*	26 *85*	34 *110*	34 *120*	36 *120*	36 *120*	21 *70*	28 *90*	27 *95*	29 *95*	29 *95*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	50 *165*	55 *180*	55 *180*	31 *100*	39 *130*	41 *135*	44 *145*	44 *145*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	49 *160*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*

MM12 Hohe Vorschübe – Auswahl der Wendeschneidplatten – Schlichten

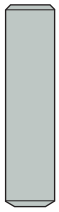
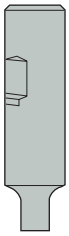
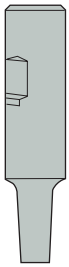
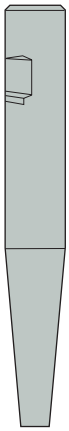
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,75 *0.030*	0,95 *0.038*
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
P6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P8	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*	0,90 *0.036*
P11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,50 *0.020*	0,70 *0.028*	0,85 *0.034*
P12	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
M1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
M2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
M3	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
M4	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
M5	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
K1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 *0.022*	0,60 *0.024*	0,75 *0.030*	0,95 *0.038*
K2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
K6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*	0,85 *0.034*
K7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*	0,75 *0.030*
N1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
N11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*	1,3 *0.050*
S1	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
S2	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
S3	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,34 *0.013*	0,34 *0.013*	0,44 *0.017*	0,55 *0.022*
S11	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S12	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 *0.017*	0,42 *0.017*	0,55 *0.022*	0,65 *0.026*
S13	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*	0,60 *0.024*
H5	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H8	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*
H11	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*	0,55 *0.022*
H12	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*
H21	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*	0,42 *0.017*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

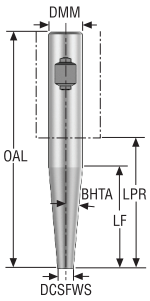
MM12 Hohe Vorschübe Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	— —	— —	— —	— —	225 *740*	275 *900*	315 *1025*	330 *1075*
P2	— —	— —	— —	— —	220 *720*	265 *870*	310 *1025*	320 *1050*
P3	— —	— —	— —	— —	190 *620*	230 *750*	270 *890*	280 *920*
P4	— —	— —	— —	— —	165 *540*	205 *670*	235 *770*	245 *800*
P5	— —	— —	— —	— —	165 *540*	195 *640*	225 *740*	240 *790*
P6	— —	— —	— —	— —	185 *610*	225 *740*	255 *840*	270 *890*
P7	— —	— —	— —	— —	170 *560*	210 *690*	240 *790*	255 *840*
P8	— —	— —	— —	— —	160 *520*	195 *640*	225 *740*	235 *770*
P11	— —	— —	— —	— —	165 *540*	205 *670*	235 *770*	245 *800*
P12	— —	— —	— —	— —	110 *360*	130 *425*	150 *490*	160 *520*
M1	— —	— —	— —	— —	175 *570*	215 *710*	250 *820*	260 *850*
M2	— —	— —	— —	— —	145 *475*	175 *570*	205 *670*	215 *710*
M3	— —	— —	— —	— —	120 *395*	140 *460*	165 *540*	175 *570*
M4	— —	— —	— —	— —	95 *310*	110 *360*	125 *410*	130 *425*
M5	— —	— —	— —	— —	80 *260*	90 *295*	105 *345*	110 *360*
K1	185 *610*	225 *740*	260 *850*	275 *900*	175 *570*	210 *690*	245 *800*	255 *840*
K2	165 *540*	200 *660*	230 *750*	245 *800*	155 *510*	185 *610*	215 *710*	225 *740*
K3	140 *460*	170 *560*	195 *640*	205 *670*	130 *425*	155 *510*	180 *590*	190 *620*
K4	135 *445*	160 *520*	185 *610*	195 *640*	125 *410*	150 *490*	175 *570*	185 *610*
K5	80 *260*	100 *330*	115 *375*	120 *395*	75 *245*	90 *295*	105 *345*	110 *360*
K6	120 *395*	140 *460*	165 *540*	175 *570*	110 *360*	130 *425*	155 *510*	160 *520*
K7	105 *345*	125 *410*	145 *475*	155 *510*	95 *310*	115 *375*	135 *445*	145 *475*
N1	— —	— —	— —	— —	1275 *4175*	1575 *5175*	1800 *5900*	1875 *6150*
N2	— —	— —	— —	— —	520 *1700*	630 *2075*	730 *2400*	750 *2450*
N3	— —	— —	— —	— —	345 *1125*	420 *1375*	485 *1600*	500 *1650*
N11	— —	— —	— —	— —	395 *1300*	480 *1575*	550 *1800*	570 *1875*
S1	— —	— —	— —	— —	44 *145*	50 *165*	60 *195*	60 *195*
S2	— —	— —	— —	— —	35 *115*	41 *135*	47 *155*	50 *165*
S3	— —	— —	— —	— —	31 *100*	36 *120*	42 *140*	44 *145*
S11	— —	— —	— —	— —	60 *195*	70 *230*	85 *280*	90 *295*
S12	— —	— —	— —	— —	42 *140*	50 *165*	55 *180*	60 *195*
S13	— —	— —	— —	— —	25 *80*	29 *95*	33 *110*	35 *115*
H5	39 *130*	46 *150*	55 *180*	55 *180*	36 *120*	43 *140*	50 *165*	55 *180*
H8	41 *135*	49 *160*	55 *180*	60 *195*	38 *125*	45 *150*	50 *165*	55 *180*
H11	49 *160*	60 *195*	70 *230*	70 *230*	46 *150*	55 *180*	65 *215*	65 *215*
H12	75 *245*	90 *295*	100 *330*	105 *345*	70 *230*	80 *260*	95 *310*	100 *330*
H21	41 *135*	49 *160*	55 *180*	60 *195*	38 *125*	45 *150*	50 *165*	55 *180*

Version

Version 1, Keilnut-Schaft	Version 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Version 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Version 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Version 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM16 Schaft





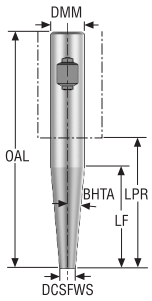
Bezeichnung	Produkt-nummer	Aufnahme	DCSFWS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			mm	mm	mm	mm	mm					kg	
MM16-20115.3-3045	75014109	Weldon	15,2	20,0	115,0	45,8	65,0	3,0	4	✓	63600	0,2	3
MM16-25100.3-0019	75012790	Weldon	15,2	25,0	100,0	19,0	40,0	0,0	2	✓	63600	0,3	3
MM16-25115.3-3035	75012791	Weldon	15,2	25,0	115,0	35,0	59,0	3,0	3	✓	63600	0,3	3
MM16-25170.3-5056	75012792	Weldon	15,2	25,0	170,0	56,0	114,0	5,0	4	✓	63600	0,6	4
MM16-16070.0-0011M	00023547	Zylindrisch	15,2	16,0	70,0	11,3	22,0	0,0	2	✓	63600	0,1	1
MM16-20070.0-0000	00023548	Zylindrisch	15,2	20,0	70,0	0,0	20,0	60,0	1	✓	63600	0,2	1
MM16-20190.0-1055M	00094766	Zylindrisch	15,2	20,0	190,0	55,0	140,0	1,0	3	✓	63600	0,4	5
MM16-20190.0-1075M	00094768	Zylindrisch	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	63600	0,4	5
MM16-20190.0-1095M	00094770	Zylindrisch	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	63600	0,4	6
MM16-25170.0-1060	00094767	Zylindrisch	19,0	25,0	170,0	60,0	114,0	1,0	3	✓	63600	0,5	5
MM16-32250.0-10047	75069368	Zylindrisch	15,2	32,0	250,0	47,6	190,0	10,0	4	✓	63600	1,3	4
MM16-16150.0-0080DS	02580692	Zylindrisch	15,2	16,0	150,0	80,0	102,0	0,0	2	✓	47600	0,4	2
MM16-20080.0-0011DS	02580669	Zylindrisch	15,2	20,0	80,0	11,3	30,0	0,0	2	✓	47600	0,4	2
MM16-20150.0-0038DS	02580695	Zylindrisch	15,2	20,0	150,0	38,0	100,0	0,0	2	✓	47600	0,6	2
MM16-20160.0-0076DS	02580699	Zylindrisch	15,2	20,0	160,0	76,0	110,0	0,0	2	✓	47600	0,6	2
MM16-20130.0-1045DS	02580757	Zylindrisch	15,2	20,0	130,0	45,0	80,0	1,0	3	✓	47600	0,5	2
MM16-20190.0-1075DS	02580758	Zylindrisch	15,2	20,0	190,0	75,0	140,0	1,0	3	✓	47600	0,8	2
MM16-20190.0-1095DS	02580760	Zylindrisch	15,2	20,0	190,0	95,0	140,0	1,0	3	✓	47600	0,8	2
MM16-25250.0-1075DS	02580761	Zylindrisch	15,2	25,0	250,0	75,0	194,0	1,0	5	✓	47600	1,6	2

Ersatzteile

Für Fräser	Hülse	Spannschraube
		
3	MM-10062	MM16-1045
4	MM-10132	MM16-1045
1	MM-10030	MM16-1045
5	MM-10062	MM16-1093
6	MM-10062	MM16-10113
2	–	MM16-1045

MM16 Schaft – Zoll



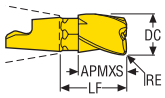


Bezeichnung	Produkt-nummer	Aufnahme	DCSFMS	DMM	OAL	LF	LPR	BHTA°	Abb.		RPMX	Gewicht	Ersatzteil Bezeichnung
			Zoll	Zoll	Zoll	Zoll	Zoll					lbs	
MM16-0.75-4.5-3-3018	75054603	Weldon	0.598	0.750	4.528	1.445	2.559	3,0	3	✓	63600	0.440	4
MM16-1.00-3.9-3-0007	75015058	Weldon	0.598	1.000	3.937	0.748	1.732	0,0	2	✓	63600	0.880	4
MM16-1.00-4.5-3-3013	75015059	Weldon	0.598	1.000	4.528	1.378	2.323	3,0	3	✓	63600	0.880	4
MM16-1.00-6.7-3-5022	75015060	Weldon	0.598	1.000	6.693	2.295	4.488	5,0	4	✓	63600	1.320	5
MM16-0.62-2.8-0M-0004	00037209	Zylindrisch	0.598	0.625	2.756	0.445	0.866	0,0	2	✓	63600	0.220	1
MM16-0.75-2.8-0-0000	00037175	Zylindrisch	0.598	0.750	2.756	0	0.787	60,0	1	✓	63600	0.440	1
MM16-0.75-7.5-0-1021	75054731	Zylindrisch	0.598	0.750	7.480	2.165	5.512	1,0	3	✓	63600	0.880	6
MM16-0.75-7.5-0-1037	75054733	Zylindrisch	0.598	0.750	7.480	3.740	5.512	1,0	3	✓	63600	0.880	7
MM16-0.75-7.5-0-1029DS	02567719	Zylindrisch	0.598	0.750	7.480	2.953	5.512	1,0	3	✓	47600	1.760	3
MM16-0.75-7.5-0-1037DS	02593431	Zylindrisch	0.598	0.750	7.480	3.740	5.512	1,0	3	✓	47600	1.540	3
MM16-1.00-5.9-0-0015DS	02593433	Zylindrisch	0.598	1.000	5.906	1.496	3.701	0,0	2	✓	47600	2.200	3
MM16-1.00-6.3-0-0030DS	02593434	Zylindrisch	0.598	1.000	6.299	2.992	4.094	0,0	2	✓	47600	1.980	3

Ersatzteile

Für Fräser	Hülse	Spannschraube
		
4	MM-10062	MM16-1045
5	MM-10132	MM16-1045
1	MM-10030	MM16-1045
6	MM-10062	MM16-1093
7	MM-10062	MM16-10113
3	–	MM16-1045

Nutfräsen/Eckfräsen



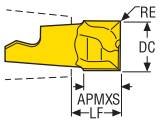


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel		Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*											
MM16-15719-R03A30-M06	15,7 *0.618*	19,05 *0.750*	0,3 *0.012*	24,5 *0.965*	15,0	19,0	30,6	30	3	MM0416	✓				■
MM16-16019-A30-E06	16,0 *0.630*	19,05 *0.750*	0,0 *0.0*	24,5 *0.965*	15,0	19,4	31,8	30	3	MM0416	✓			■	
MM16-16019-R05A30-M06	16,0 *0.630*	19,05 *0.750*	0,5 *0.020*	24,5 *0.965*	15,0	19,4	30,8	30	3	MM0416	✓				■
MM16-16019-R10A30-E06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓			■	
MM16-16019-R10A30-M06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓				■
MM16-16019-R20A30-M06	16,0 *0.630*	19,05 *0.750*	2,0 *0.079*	24,5 *0.965*	15,0	19,4	27,8	30	3	MM0416	✓				■
MM16-16019-R30A30-E06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓			■	
MM16-16019-R30A30-M06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓				■
MM16-16019-R40A30-M06	16,0 *0.630*	19,05 *0.750*	4,0 *0.157*	24,5 *0.965*	15,0	19,4	23,8	30	3	MM0416	✓				■
MM16-16019-R50A30-M06	16,0 *0.630*	19,05 *0.750*	5,0 *0.197*	24,5 *0.965*	15,0	19,4	21,8	30	3	MM0416	✓				■
MM16-16019-R60A30-M06	16,0 *0.630*	19,05 *0.750*	6,0 *0.236*	24,5 *0.965*	15,0	19,4	19,8	30	3	MM0416	✓				■
MM16-20015-A30-E06	20,0 *0.787*	15,0 *0.591*	0,0 *0.0*	20,15 *0.793*	15,0	24,2	39,8	30	3	MM0416	✓			■	
MM16-20015-R05A30-M06	20,0 *0.787*	15,0 *0.591*	0,5 *0.020*	20,15 *0.793*	15,0	24,2	38,8	30	3	MM0416	✓				■
MM16-20015-R10A30-M06	20,0 *0.787*	15,0 *0.591*	1,0 *0.039*	20,15 *0.793*	15,0	24,2	37,8	30	3	MM0416	✓				■
MM16-20015-R20A30-D06	20,0 *0.787*	15,0 *0.591*	2,0 *0.079*	20,15 *0.793*	15,0	24,2	35,8	30	3	MM0416	✓			■	
MM16-20015-R30A30-M06	20,0 *0.787*	15,0 *0.591*	3,0 *0.118*	20,15 *0.793*	15,0	24,2	33,8	30	3	MM0416	✓				■
MM16-20015-R50A30-M06	20,0 *0.787*	15,0 *0.591*	5,0 *0.197*	20,15 *0.793*	15,0	24,2	29,8	30	3	MM0416	✓				■
MM16-15919-R08A30-M06	15,875 *0.625*	19,05 *0.750*	0,8 *0.031*	24,5 *0.965*	15,0	19,2	29,9	30	3	MM0416	✓				■

Nutfräsen/Eckfräsen

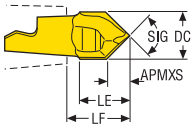




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel	Sorten			
											Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							T60M	F15M	F30M	F40M
MM16-15711T-R03-D07	15,7 *0.618*	11,0 *0.433*	0,3 *0.012*	13,6 *0.535*	15,0	19,0	30,6	0	2	MM1420	■			
MM16-16011-M06	16,0 *0.630*	11,0 *0.433*	0,0 *NaN*	13,6 *0.535*	15,0	19,4	31,8	0	2	MM1420	■			
MM16-16011-R08A8-E06	16,0 *0.630*	10,5 *0.413*	0,8 *0.031*	13,62 *0.536*	15,0	19,4	30,2	8	2	MM1420	■		■	
MM16-16011-R08-MD07	16,0 *0.630*	11,0 *0.433*	0,8 *0.031*	13,58 *0.535*	15,0	19,4	30,2	0	2	MM1420	■		■	
MM16-16011-R08P-M05	16,0 *0.630*	10,8 *0.425*	0,8 *0.031*	13,41 *0.528*	15,0	19,4	30,2	0	2	MM1420			■	
MM16-16011-R20-MD07	16,0 *0.630*	10,9 *0.429*	2,0 *0.079*	13,55 *0.533*	15,0	19,4	27,8	0	2	MM1420			■	
MM16-16011-R30-MD07	16,0 *0.630*	10,9 *0.429*	3,0 *0.118*	13,54 *0.533*	15,0	19,4	25,8	0	2	MM1420			■	
MM16-16011-R40-MD07	16,0 *0.630*	10,9 *0.429*	4,0 *0.157*	13,52 *0.532*	15,0	19,4	23,8	0	2	MM1420	■			
MM16-16011-R50-MD07	16,0 *0.630*	10,9 *0.429*	5,0 *0.197*	13,5 *0.531*	15,0	19,4	21,8	0	2	MM1420	■			
MM16-20013-R08A8-E06	20,0 *0.787*	12,7 *0.500*	0,8 *0.031*	15,42 *0.607*	15,0	24,2	38,2	8	2	MM1420	■		■	
MM16-19013-R08A8-E06	19,05 *0.750*	12,7 *0.500*	0,8 *0.031*	15,39 *0.606*	15,0	23,1	36,3	8	2	MM1420			■	

Zentrierbohren

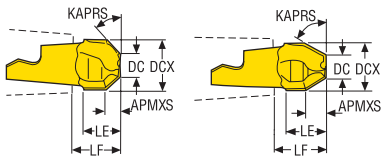




• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	LE	LF	SIG°	ZEFP	Schlüssel	Sorten – Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM16-16008-C90-M06	16,0 *0.630*	7,53 *0.296*	16,7 *0.657*	19,2 *0.756*	90,0	2	MM1420	■			
MM16-16011-C120-M06	16,0 *0.630*	4,3 *0.169*	16,64 *0.655*	18,9 *0.744*	120,0	2	MM1420	■			
MM16-19019-C90	19,05 *0.750*	9,6 *0.378*	20,3 *0.799*	22,15 *0.872*	90,0	2	MM1420	■			

Anfasen



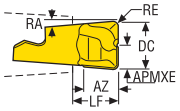


• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DCX	DC	APMXS	LE	LF	KAPRS°	ZEFP	Schlüssel	Sorten – Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM16-16011-4540-E06	16,0 *0.630*	7,69 *0.303*	3,9 *0.154*	10,9 *0.429*	13,25 *0.522*	45,0	2	MM1420	■			
MM16-16012-6060-E06	16,0 *0.630*	8,38 *0.330*	6,7 *0.264*	12,9 *0.508*	15,3 *0.602*	60,0	2	MM1420	■			

Tauchfräser



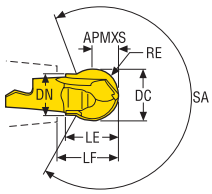


- Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXE	RE	AZ	LF	RA	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM16-16011-R10-PL-MD07	16,0 *0.630*	8,0 *0.315*	1,0 *0.039*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	
MM16-16011-R20-PL-MD07	16,0 *0.630*	8,0 *0.315*	2,0 *0.079*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen

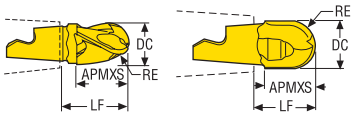




- Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LE	LF	DN	SA	ZEFP	Schlüssel	Sorten Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM16-20020-B120PF-M04	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	21,94 *0.864*	15,9 *0.626*	254,0	2	MM1420		■		
MM16-20020-B120P-M07	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	21,94 *0.864*	15,9 *0.626*	254,0	2	MM1420			■	

Kopierfräser





• Drehmomentschlüssel und Drehmomente, siehe Seite 624

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Sorten Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								
MM16-16019-B90A30-E06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓			■	
MM16-20015-B90A30-E06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓			■	
MM16-16019-B90A30-M06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓				■
MM16-20015-B90A30-M06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓				■
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420		■		■	
MM16-20020-B90-MD07	20,0 *0.787*	20,3 *0.799*	10,0 *0.394*	22,15 *0.872*	0,0	2	MM1420		■		■	
MM16-16016-B90P-M07	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*	0,0	2	MM1420				■	
MM16-15916-B90P-M07	15,875 *0.625*	13,8 *0.543*	7,938 *0.313*	18,4 *0.724*	0,0	2	MM1420				■	
MM16-19020-B90P-M07	19,05 *0.750*	7,4 *0.291*	9,525 *0.375*	22,12 *0.871*	0,0	2	MM1420		■			
MM16-16016-B90PF-M03	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*	0,0	2	MM1420			■		

MM16 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
P2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
P3	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
P4	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P5	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P6	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P7	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P8	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
P11	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
P12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
M2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
M3	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
M4	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
M5	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
K1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K4	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K5	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K6	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K7	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
N1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N11	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
S1	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S2	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S3	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
S11	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
S12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*
S13	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
H5	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H8	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
H11	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H12	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
H21	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 *0.0017*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM16 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	230 *750*	285 *940*	315 *1025*	350 *1150*	215 *710*	270 *890*	300 *980*	335 *1100*	200 *660*	250 *820*	275 *900*	310 *1025*
P2	220 *720*	275 *900*	310 *1025*	345 *1125*	210 *690*	260 *850*	290 *950*	325 *1075*	195 *640*	240 *790*	270 *890*	295 *970*
P3	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	225 *740*	255 *840*	280 *920*	170 *560*	210 *690*	235 *770*	260 *850*
P4	170 *560*	215 *710*	240 *790*	265 *870*	160 *520*	205 *670*	225 *740*	250 *820*	150 *490*	185 *610*	205 *670*	225 *740*
P5	165 *540*	205 *670*	230 *750*	250 *820*	155 *510*	195 *640*	215 *710*	240 *790*	140 *460*	175 *570*	200 *660*	220 *720*
P6	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	215 *710*	245 *800*	270 *890*	160 *520*	200 *660*	220 *720*	245 *800*
P7	175 *570*	220 *720*	245 *800*	265 *870*	165 *540*	205 *670*	230 *750*	255 *840*	150 *490*	190 *620*	210 *690*	235 *770*
P8	160 *520*	205 *670*	230 *750*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	140 *460*	175 *570*	200 *660*	215 *710*
P11	170 *560*	210 *690*	235 *770*	260 *850*	160 *520*	200 *660*	225 *740*	245 *800*	145 *475*	185 *610*	205 *670*	225 *740*
P12	110 *360*	135 *445*	150 *490*	165 *540*	105 *345*	130 *425*	145 *475*	155 *510*	95 *310*	120 *395*	130 *425*	145 *475*
M1	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	155 *510*	190 *620*	215 *710*	240 *790*
M2	150 *490*	185 *610*	205 *670*	225 *740*	140 *460*	175 *570*	195 *640*	215 *710*	125 *410*	160 *520*	180 *590*	200 *660*
M3	120 *395*	150 *490*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	175 *570*	105 *345*	130 *425*	145 *475*	155 *510*
M4	90 *295*	115 *375*	130 *425*	140 *460*	85 *280*	110 *360*	120 *395*	135 *445*	80 *260*	100 *330*	110 *360*	120 *395*
M5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	85 *280*	95 *310*	100 *330*
K1	175 *570*	220 *720*	245 *800*	270 *890*	165 *540*	205 *670*	230 *750*	260 *850*	150 *490*	190 *620*	210 *690*	235 *770*
K2	155 *510*	195 *640*	215 *710*	240 *790*	145 *475*	185 *610*	205 *670*	225 *740*	135 *445*	170 *560*	190 *620*	210 *690*
K3	130 *425*	165 *540*	185 *610*	205 *670*	125 *410*	155 *510*	175 *570*	190 *620*	115 *375*	145 *475*	160 *520*	175 *570*
K4	125 *410*	160 *520*	175 *570*	195 *640*	120 *395*	150 *490*	165 *540*	185 *610*	110 *360*	135 *445*	150 *490*	170 *560*
K5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	80 *260*	95 *310*	100 *330*
K6	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	130 *425*	145 *475*	160 *520*	95 *310*	120 *395*	135 *445*	150 *490*
K7	100 *330*	120 *395*	135 *445*	150 *490*	95 *310*	115 *375*	130 *425*	140 *460*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1325 *4350*	1650 *5425*	1825 *6000*	2025 *6650*	1225 *4025*	1550 *5075*	1725 *5650*	1925 *6325*	1125 *3700*	1425 *4675*	1575 *5175*	1750 *5750*
N2	530 *1750*	670 *2200*	730 *2400*	820 *2700*	500 *1650*	630 *2075*	690 *2275*	770 *2525*	455 *1500*	570 *1875*	640 *2100*	700 *2300*
N3	355 *1175*	445 *1450*	490 *1600*	540 *1775*	335 *1100*	420 *1375*	465 *1525*	520 *1700*	305 *1000*	385 *1275*	425 *1400*	470 *1550*
N11	405 *1325*	510 *1675*	560 *1825*	620 *2025*	380 *1250*	475 *1550*	530 *1750*	590 *1925*	345 *1125*	435 *1425*	485 *1600*	540 *1775*
S1	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	38 *125*	46 *150*	50 *165*	55 *180*
S2	35 *115*	43 *140*	48 *155*	55 *180*	33 *110*	41 *135*	45 *150*	50 *165*	30 *100*	37 *120*	42 *140*	46 *150*
S3	30 *100*	38 *125*	42 *140*	46 *150*	29 *95*	35 *115*	40 *130*	44 *145*	27 *90*	33 *110*	37 *120*	40 *130*
S11	60 *195*	75 *245*	85 *280*	90 *295*	55 *180*	70 *230*	80 *260*	90 *295*	50 *165*	65 *215*	75 *245*	80 *260*
S12	42 *140*	50 *165*	60 *195*	65 *215*	39 *130*	49 *160*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*
S13	24 *80*	30 *100*	34 *110*	37 *120*	23 *75*	29 *95*	32 *105*	35 *115*	21 *70*	26 *85*	29 *95*	32 *105*
H5	36 *120*	45 *150*	50 *165*	55 *180*	34 *110*	43 *140*	48 *155*	50 *165*	31 *100*	39 *130*	44 *145*	48 *155*
H8	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*
H11	46 *150*	60 *195*	65 *215*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*
H12	70 *230*	85 *280*	95 *310*	105 *345*	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	90 *295*
H21	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*

MM16 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*
P2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
P3	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
P4	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P5	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P6	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P7	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P8	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
P11	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
P12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
M1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
M2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
M3	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,080 *0.0032*	0,11 *0.0044*
M4	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
M5	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,095 *0.0038*	0,10 *0.0040*	0,13 *0.0050*
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 *0.0036*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 *0.0055*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
S1	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
S2	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
S3	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,085 *0.0036*
S11	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 *0.0034*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S13	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*	0,090 *0.0038*
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 *0.0022*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM16 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*	0,32 *0.013*
P2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
P3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,32 *0.013*
P4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,19 *0.0075*	0,30 *0.012*
P5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P8	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,32 *0.013*
P11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
P12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
M1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
M2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
M3	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
M4	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
M5	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*	0,34 *0.013*
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*	0,30 *0.012*
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*	0,44 *0.017*
S1	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S2	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S3	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,075 *0.0030*	0,085 *0.0036*	0,12 *0.0048*	0,19 *0.0075*
S11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
S12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*	0,24 *0.0095*
S13	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 *0.0032*	0,090 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM16 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/*(sf/min)*

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	245 *800*	295 *970*	310 *1025*	335 *1100*	335 *1100*	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*
P2	240 *790*	285 *940*	300 *980*	325 *1075*	320 *1050*	230 *750*	270 *890*	285 *940*	310 *1025*	305 *1000*
P3	210 *690*	250 *820*	260 *850*	285 *940*	280 *920*	200 *660*	240 *790*	250 *820*	270 *890*	265 *870*
P4	185 *610*	220 *720*	235 *770*	250 *820*	250 *820*	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*
P5	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*	170 *560*	200 *660*	215 *710*	230 *750*	230 *750*
P6	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P7	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	240 *790*
P8	175 *570*	210 *690*	220 *720*	240 *790*	235 *770*	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*
P11	185 *610*	215 *710*	230 *750*	250 *820*	245 *800*	175 *570*	205 *670*	220 *720*	235 *770*	235 *770*
P12	115 *375*	145 *475*	145 *475*	160 *520*	155 *510*	110 *360*	140 *460*	140 *460*	150 *490*	150 *490*
M1	195 *640*	230 *750*	240 *790*	265 *870*	260 *850*	185 *610*	220 *720*	230 *750*	250 *820*	245 *800*
M2	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	150 *490*	180 *590*	190 *620*	205 *670*	205 *670*
M3	130 *425*	160 *520*	160 *520*	170 *560*	170 *560*	120 *395*	150 *490*	150 *490*	165 *540*	165 *540*
M4	90 *295*	125 *410*	125 *425*	130 *425*	135 *445*	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*
M5	75 *245*	105 *345*	100 *360*	110 *360*	110 *360*	70 *230*	100 *330*	100 *345*	105 *345*	105 *345*
K1	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K2	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*
K3	140 *460*	170 *560*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K4	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	165 *540*	175 *570*	175 *570*
K5	85 *280*	100 *330*	105 *345*	110 *360*	110 *360*	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*
K6	120 *395*	140 *460*	150 *490*	165 *540*	160 *520*	115 *375*	135 *445*	145 *475*	155 *510*	155 *510*
K7	105 *345*	125 *410*	130 *425*	145 *475*	145 *475*	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*
N1	1425 *4675*	1700 *5575*	1775 *5825*	1925 *6325*	1900 *6225*	1350 *4425*	1625 *5325*	1700 *5575*	1850 *6075*	1800 *5900*
N2	580 *1900*	690 *2275*	720 *2350*	780 *2550*	770 *2525*	550 *1800*	650 *2125*	680 *2225*	740 *2425*	730 *2400*
N3	385 *1275*	455 *1500*	480 *1575*	520 *1700*	510 *1675*	365 *1200*	435 *1425*	455 *1500*	495 *1625*	485 *1600*
N11	440 *1450*	520 *1700*	550 *1800*	600 *1975*	580 *1900*	420 *1375*	495 *1625*	520 *1700*	570 *1875*	560 *1825*
S1	42 *140*	60 *195*	55 *195*	60 *195*	60 *195*	40 *130*	55 *180*	55 *195*	60 *195*	60 *195*
S2	34 *110*	48 *155*	46 *160*	50 *165*	50 *165*	33 *110*	45 *150*	44 *155*	47 *155*	48 *155*
S3	30 *100*	41 *135*	40 *140*	43 *140*	43 *140*	28 *90*	39 *130*	38 *135*	41 *135*	41 *135*
S11	65 *215*	80 *260*	80 *280*	85 *280*	85 *280*	60 *195*	80 *260*	75 *260*	85 *280*	80 *260*
S12	45 *150*	55 *180*	55 *195*	60 *195*	60 *195*	43 *140*	55 *180*	55 *180*	55 *180*	55 *180*
S13	24 *80*	33 *110*	32 *110*	35 *115*	35 *115*	23 *75*	32 *105*	31 *110*	33 *110*	33 *110*
H5	39 *130*	48 *155*	48 *160*	55 *180*	50 *165*	37 *120*	46 *150*	46 *150*	50 *165*	50 *165*
H8	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
H11	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
H21	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*

MM16 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ *Zoll*

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P8	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P11	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
P12	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
M1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
M3	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,085 *0.0034*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0050*
M4	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
M5	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
K1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*
K7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S1	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S2	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
S3	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*
S11	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0050*
S12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0050*
S13	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*
H5	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
H8	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H11	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0044*
H12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H21	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM16 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*	0,16 *0.0065*
P2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
P3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
P6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P8	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,15 *0.0060*
P11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,14 *0.0055*
P12	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
M1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
M2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
M3	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
M4	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
M5	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
K1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*	0,16 *0.0065*
K2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,13 *0.0050*
K6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,15 *0.0060*
K7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,13 *0.0050*
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,20 *0.0080*
S1	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S2	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
S3	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,038 *0.0015*	0,044 *0.0017*	0,060 *0.0024*	0,095 *0.0038*
S11	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*	0,12 *0.0048*
S13	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 *0.0016*	0,046 *0.0019*	0,065 *0.0026*	0,10 *0.0040*
H5	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H8	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
H11	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 *0.0015*	0,046 *0.0018*	0,060 *0.0024*	0,10 *0.0040*
H12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*
H21	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 *0.0012*	0,034 *0.0014*	0,048 *0.0019*	0,075 *0.0030*

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte.

MM16 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	285 *940*	360 *1175*	390 *1275*	420 *1375*	415 *1350*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	185 *610*	225 *740*	245 *800*	265 *870*	265 *870*
P2	275 *900*	350 *1150*	375 *1225*	405 *1325*	405 *1325*	220 *720*	270 *890*	295 *970*	315 *1025*	315 *1025*	180 *590*	220 *720*	240 *790*	255 *840*	255 *840*
P3	240 *790*	305 *1000*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	255 *840*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P4	215 *710*	270 *890*	285 *940*	310 *1025*	310 *1025*	170 *560*	210 *690*	225 *740*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	195 *640*
P5	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	200 *660*	220 *720*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P6	230 *750*	290 *950*	310 *1025*	335 *1100*	335 *1100*	180 *590*	225 *740*	245 *800*	265 *870*	265 *870*	150 *490*	180 *590*	200 *660*	215 *710*	215 *710*
P7	215 *710*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	210 *690*	230 *750*	250 *820*	250 *820*	140 *460*	170 *560*	190 *620*	200 *660*	200 *660*
P8	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	200 *660*	215 *710*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P11	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	165 *540*	205 *670*	225 *740*	240 *790*	240 *790*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*
P12	135 *445*	175 *570*	175 *590*	190 *620*	190 *620*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
M1	225 *740*	285 *940*	300 *980*	330 *1075*	325 *1075*	175 *570*	220 *720*	235 *770*	255 *840*	250 *820*	145 *475*	180 *590*	190 *620*	205 *670*	205 *670*
M2	185 *610*	230 *750*	250 *820*	270 *890*	265 *870*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	120 *395*	145 *475*	160 *520*	170 *560*	170 *560*
M3	150 *490*	190 *620*	195 *660*	210 *690*	210 *690*	120 *395*	150 *490*	155 *520*	170 *560*	170 *560*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M4	115 *375*	150 *490*	150 *520*	160 *520*	160 *520*	95 *310*	125 *410*	120 *425*	130 *425*	130 *425*	75 *245*	100 *330*	95 *345*	105 *345*	105 *345*
M5	95 *310*	125 *410*	125 *445*	135 *445*	135 *445*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	85 *280*	80 *280*	90 *295*	85 *280*
K1	220 *720*	280 *920*	295 *970*	320 *1050*	320 *1050*	175 *570*	215 *710*	235 *770*	250 *820*	250 *820*	140 *460*	175 *570*	190 *620*	205 *670*	200 *660*
K2	195 *640*	245 *800*	260 *850*	285 *940*	280 *920*	155 *510*	190 *620*	210 *690*	220 *720*	220 *720*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*
K3	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K4	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*	100 *330*	125 *410*	135 *445*	145 *475*	145 *475*
K5	95 *310*	120 *395*	125 *410*	135 *445*	140 *460*	75 *245*	95 *310*	100 *330*	110 *360*	110 *360*	60 *195*	75 *245*	80 *260*	90 *295*	90 *295*
K6	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	135 *445*	150 *490*	160 *520*	155 *510*	90 *295*	110 *360*	120 *395*	130 *425*	125 *410*
K7	120 *395*	150 *490*	165 *540*	175 *570*	175 *570*	95 *310*	120 *395*	130 *425*	140 *460*	140 *460*	80 *260*	95 *310*	105 *345*	115 *375*	115 *375*
N1	1675 *5500*	2125 *6975*	2250 *7375*	2450 *8050*	2450 *8050*	1300 *4275*	1625 *5325*	1725 *5650*	1875 *6150*	1850 *6075*	1050 *3450*	1325 *4350*	1400 *4600*	1525 *5000*	1500 *4925*
N2	680 *2225*	860 *2825*	910 *2975*	990 *3250*	990 *3250*	530 *1750*	660 *2175*	700 *2300*	760 *2500*	750 *2450*	425 *1400*	530 *1750*	570 *1875*	620 *2025*	610 *2000*
N3	450 *1475*	570 *1875*	610 *2000*	660 *2175*	660 *2175*	350 *1150*	435 *1425*	465 *1525*	510 *1675*	500 *1650*	285 *940*	355 *1175*	380 *1250*	410 *1350*	405 *1325*
N11	520 *1700*	650 *2125*	690 *2275*	750 *2450*	760 *2500*	400 *1300*	500 *1650*	530 *1750*	580 *1900*	570 *1875*	325 *1075*	405 *1325*	430 *1400*	470 *1550*	465 *1525*
S1	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	45 *160*	49 *160*	49 *160*
S2	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	35 *115*	46 *150*	45 *155*	49 *160*	49 *160*	29 *95*	37 *120*	36 *130*	40 *130*	39 *130*
S3	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	40 *130*	39 *140*	43 *140*	43 *140*	25 *80*	32 *105*	32 *110*	35 *115*	35 *115*
S11	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
S12	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	35 *115*	44 *145*	44 *150*	48 *155*	48 *155*
S13	31 *100*	39 *130*	39 *140*	42 *140*	42 *140*	25 *80*	32 *105*	31 *110*	34 *110*	34 *110*	20 *65*	26 *85*	25 *90*	28 *90*	28 *90*
H5	45 *150*	55 *180*	60 *195*	65 *215*	65 *215*	36 *120*	46 *150*	48 *155*	50 *165*	50 *165*	30 *100*	37 *120*	39 *130*	41 *135*	41 *135*
H8	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*
H11	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	47 *155*	49 *165*	55 *180*	50 *165*
H12	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	80 *260*	80 *260*
H21	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*

Drehmomentschlüssel und maximale Drehzahl

Drehmomentschlüssel

Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nicht überschritten werden darf, ist auf jeder Produktseite angegeben. Normalerweise ist es nicht notwendig, Werkzeuge bis 10.000 U/min auszuwuchten.
Trotzdem kann eine Auswuchtung in einigen Fällen erforderlich sein, z. B. wenn schwere Werkzeuge und Aufnahmen auf kleinen Maschinen eingesetzt werden.



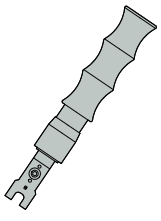
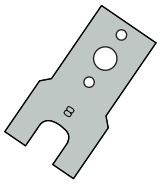
Drehmomentschlüssel für feste Drehmomente generieren automatisch die richtige Klemmkraft beim Einsatz des Minimaster-Schneidkopfes in die Aufnahme.
Drehmomentschlüssel sind gemäß ISO 6789 voreingestellt.
Code-Schlüssel: MM02-4006
MM02 = 2-schneidig
(MM03 = 3-schneidig)
40 = Drehmoment 4,0 Nm
06 = Schneidkopf-Größe

Über 10.000 U/min:
Wir empfehlen, Werkzeug und Aufnahme separat auszuwuchten.
Über 20.000 U/min:
Werkzeug und Aufnahme müssen als Einheit ausgewuchtet werden.
Über 30.000 U/min:
Werkzeug und Aufnahme müssen als Einheit ausgewuchtet werden.
Die maximale Drehzahl laut Tabelle muss eingehalten werden.

Schneidkopf 2-schneidig

WSP-Größe	Drehmomentschlüssel (einschließlich Schlüsselkopf)	Austausch-barer Schlüsselkopf	Drehmoment
			
MM06	MM02-4006	MM02-06	4 Nm
MM08	MM02-8008	MM02-08	8 Nm
MM10	MM02-1201012	MM02-1012	12 Nm
MM12	MM02-1201012	MM02-1012	12 Nm
MM12 DC = Ø 14,0	MM02-16014	MM02-14	16 Nm
MM12 DCX = Ø 16,0	MM02-1601620	MM02-1620	16 Nm
MM16	MM02-1601620	MM02-1620	16 Nm

Schneidkopf 3-schneidig

WSP-Größe	Drehmomentschlüssel (einschließlich Schlüsselkopf)	Austausch-barer Schlüsselkopf	Drehmoment
			
MM06	MM03-4006	MM03-06	4 Nm
MM08	MM03-8008	MM03-08	8 Nm
MM10	MM03-1201012	MM03-1012	12 Nm
MM12	MM03-1201012	MM03-1012	12 Nm
MM16	MM03-16016	MM03-16	16 Nm

SMG – Einführung

Die Basis für SMG ist eine Klassifizierung der Werkstoffe auf der Grundlage ihres Typs und nicht ihrer relativen Zerspanbarkeit; sie enthält folglich Werkstoffe wie beispielsweise Verbundwerkstoffe. Sie ist umfangreich und dabei gleichzeitig übersichtlich, so dass es einfach ist, zu ermitteln, zu welcher Seco Werkstoff-Gruppe ein Werkstoff gehört.
Jede Werkstoffgruppe verfügt über einen spezifischen Werkstoffstandard in einer speziellen Ausführung als Referenz. So sind die Schnittdaten für jeden vorhandenen Werkstoff im Vergleich zu jedem Seco Referenz-Werkstoff leicht anzupassen, siehe Seite 626 - 629.
Als Beispiel werden die Referenzwerkstoffe EN C45E für SMG P4 und EN 42 CrMo 4 für die beiden Materialgruppen SMG P5 und SMG H5 in der nachstehenden Tabelle dargestellt. Die entsprechenden Materialeigenschaften sind mit aufgeführt.

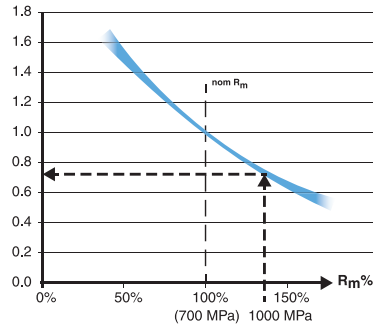
SMG	Beschreibung	Bezeichnung	Referenz
P4	Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungs- stähle	520 < R_m < 1200	C 45E R_m = 660 N/mm²
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²

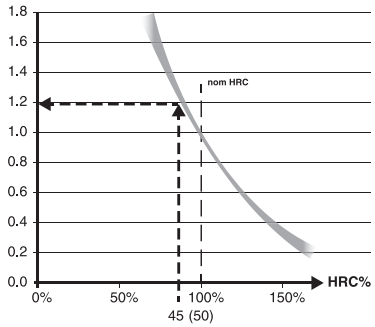
SMG	Beschreibung	Bezeichnung	Referenz
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 50 HRC

Bei dem Werkstoff EN 42 CrMo 4 in lösungsgeglühtem Zustand liegt die Bruchfestigkeit Rm typischerweise zwischen R_m = 630 N/mm² und R_m = 780 N/mm² und bietet damit einen Referenzbereich für SMG P5. Im geglühten Zustand liegt die Bruchfestigkeit R_m typischerweise zwischen R_m = 900 N/mm² und R_m = 1100 N/mm² . Damit wird dieser Werkstoff immer noch der Materialgruppe SMG P5 zugeordnet.

SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI / ASTM	GOST	Zustand	R_{m_nom}	HRC_{nom}
P5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Geglüht	700	
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Angelassen & vergütet	1000	
H5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Angelassen & vergütet		45
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Angelassen & vergütet		50

Ab einer Zugfestigkeit von R_m = 1200 N/mm² gehört EN 42 CrMo 4 zur Materialgruppe SMG H5. Am Beispiel des Werkstoffes vergüteter Stahl EN 42CrMo4 wird die Abhängigkeit der Bearbeitbarkeit der Werkstoffe von den Werkstoffeigenschaften erläutert und die Ermittlung des Schnittdatenfaktors dargestellt.
Die nachstehenden Graphiken zeigen, wie die Schnittdatenempfehlung für nominelle Werkstoffausführungen an entsprechende R_m (linkes Diagramm für ISO-P) und an entsprechende HRC (für ISO-H) angepasst werden kann.





Ermittlung der Schnittdaten für EN 42 CrMo4 BIS Rm = 1200 N/mm²: Um darzustellen, wie in der SMG die nominelle Schnittgeschwindigkeit der SMG P5 genauer berechnet werden kann, benötigen wir die Zugfestigkeit Rm. In diesem Falle verwenden wir EN 42 CrMo 4 vergütet auf Rm = 1000 N/mm² gemäß der obigen Tabelle.
Bei der SMG P5 beträgt die nominelle Schnittgeschwindigkeit für ein Produkt z.B. v_c = 280 m/min. Bei einer Zugfestigkeit R_m = 1000 N/mm² ergibt sich ein Schnittdatenfaktor von 0,75 (siehe Abbildung links). Daraus errechnet sich die empfohlene Schnittgeschwindigkeit v_c = 280 m/min x 0,75 = 210 m/min.
Ermittlung der Schnittdaten für EN 42 CrMo4 AB R_m = 1200 N/mm² (entsprechen 38 HRC). Die Anpassung der nominellen Schnittgeschwindigkeit des gehärteten Werkstoffes EN 42 CrMo 4 mit einer Härte von HRC 45 erfolgt auf die gleiche Weise (siehe dazu Darstellung mit grauer Kurve rechts). Wir gehen davon aus, dass die nominelle Schnittgeschwindigkeit für SMG H5 v_c = 50 m/min für ein bestimmtes Produkt und eine bestimmte Bearbeitung beträgt. Daraus errechnet sich der Schnittdatenfaktor 1,2. Die tatsächliche Schnittgeschwindigkeit beträgt dann v_c = 50 m/min x 1,2 = 60 m/min.
Weitere Werkstoffdetails finden Sie auf Seite(n) 266-273, weitere Schnittdatenempfehlungen auf den entsprechenden Katalogseiten.

Auf www.secotools.com können Sie die Schnittdaten für Ihre individuelle Anwendung ganz einfach berechnen.

Stahl, ferritische und martensitisch rostfreie Stähle

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
P1	Automatenstähle mit niedrigem Kohlenstoffgehalt	360 < R_m < 880	11 SMn30 R_m = 385 N/mm^2	1500	0,14
P2	Niedrig legierte ferritische Stähle mit C < 0,25%wt Niedrig legierte normale Baustähle	320 < R_m < 600	S235JRG2 R_m = 420 N/mm^2	1600	0,23
P3	Ferritische und ferritisch/perlitische Stähle mit C < 0,25%wt schweißbare Baustähle Einsatzstähle	430 < R_m < 610	16 MnCr 5 R_m = 550 N/mm^2	1800	0,14
P4	Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungsstähle	520 < R_m < 1200	C 45E R_m = 660 N/mm^2	2000	0,15
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm^2	2020	0,18
P6	Niedrig legierte härtbare Stähle mit C > 0,67%wt Niedrig legierte Feder- und Lagerstähle	520 < R_m < 1200	C 100S R_m = 600 N/mm^2	2100	0,17
P7	Härtbare Stähle mit C > 0,67%wt Feder- und Lagerstähle	600 < R_m < 1200	100 Cr 6 R_m = 650 N/mm^2	2160	0,17
P8	Werkzeugstähle Schnellarbeitsstähle (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm^2	2400	0,20
P11	Ferritische und martensitische Stähle	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm^2	2000	0,15
P12	Martensitaushärtbares und lösungsbehandeltes Rostfrei	500 < R_m < 1200	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm^2	2100	0,17

Austenitisch rostfreie Stähle

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
M1	Leicht schneidendes Rostfrei		X 10 CrNiS 18 9	1700	0,14
M2	Niedrig legierte austenitische rostfreie Stähle		X 5 CrNi 18 10	1920	0,18
M3	Legierte austenitische rostfreie Stähle		X 2 CrNiMo 18 14 3	2070	0,17
M4	Hoch legierte rostfreie Stähle (Austenit und Duplex)		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Austenit und Duplex, sehr schwierig zerspanbar		X 2 CrNiMoN 25 7 4	2510	0,13

Guss

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
K1	Grauguss (GCI)		EN-GJL-250	930	0,32
K2	Vermikularguss (CGI)		EN-GJV-400	1000	0,35
K3	Temperguss (MCI)		EN-GJMB-550-4	1050	0,37
K4	Sphäroguss, Kugelgrafitguss (SGI)		EN-GJS-500-7	1160	0,37
K5	Wärmebehandelter Kugelgrafitguss (ADI)		EN-GJS-1000-5		
K6	Austenitischer Guss mit Lamellengrafit		EN-GJLA-XNiCuCr15-6-2		
K7	Austenitischer Sphäroguss		EN-GJSA-XNiMn23-4		

Nicht-Eisen-Metalle

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
N1	Aluminiumlegierungen, Si < 9%		AW-7075		
N2	Aluminiumlegierungen, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Aluminiumlegierungen, Si >16%		AlSi17Cu5		
N11	Kupferlegierungen		CW614N	740	0,26

Superlegierungen und Titan

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
S1	Superlegierungen auf Fe-Basis		Discalloy		
S2	Superlegierungen auf Co-Basis		Stellite 21		
S3	Superlegierungen auf Ni-Basis		Inconel 718	2530	0,21
S11	Titan, niedrig legiert, (α)		Ti		
S12	Titan, mittlere Legierung, (α+β)		TiAl6V4	1500	0,24
S13	Titan, hoch legiert, (nahe β und β)		Ti10V2Fe3Al		

Harte Werkstoffe

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
H3	Einsatzstahl gehärtet	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Vergütungsstähle Lagerstähle	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Werkzeugstähle Schnellarbeitsstähle (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Martensitische, rostfreie Stähle	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Martensitausgehärtetes und lösungsbehandeltes Rostfrei	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Manganstahl	23 < HRC < 64	X 120 Mn 12 50 HRC		
H31	Weißhartguss	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

Andere Werkstoffe

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
PM1	Niedrig legierte Pulvermetall-Werkstoffe		F-0008 Fe-0.7C		
PM2	PM-Werkstofflegierungen im mittleren Bereich		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	Hoch legierte PM-Werkstoffe Werkstoffe für Abgasventilsitze, etc.				
HF1	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Legierungen auf Eisen-Basis				
HF2	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Kobalt- und Nickel-basis-Legierungen				
CC1	Gesintertes Wolfram-Hartmetall		G50		

Kunststoffe und Composite

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
TS1	Duroplaste		Urea Formaldehyde (UF)		
TS2	Duroplastische Kohlenstoff-faser-Verbundwerkstoffe		T300 T700 T800 HTA-S IMA - Epoxy (M21)...		
TS3	Duroplastische Glasfaser-Verbundwerkstoffe		Epoxy - HX..(42..)/E-Glas (7781...)...		
TS4	Duroplastische Aramidfaser-Verbundwerkstoffe		Kevlar 49		
TP1	Thermoplastische Polymere		Polycarbonat (PC)		
TP2	Thermoplastische Kohlenstofffaser-Verbundwerkstoffe		PPS/PEEK - T300..		
TP3	Thermoplastische Glasfaser-Verbundwerkstoffe		PPS/PEEK - E-Glas oder A-Glas...		
TP4	Thermoplastische Aramidfaser-Verbundwerkstoffe				

Grafit

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
GR1	Grafit		R 8500		

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	AF 34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	AF 37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3,5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4,5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCr 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCr 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

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U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
	1213				geglüht	
	12 L 13				geglüht	
	1108				geglüht	
	11 L 08				geglüht	
					geglüht	
	1140	40			geglüht	
	1146				geglüht	
	1215				geglüht	
	12 L 14				geglüht	
		16D			geglüht	
	ASTM Grade 58	18kp	11 378		geglüht	
	ASTM Grade 70	St14kP	11 448		geglüht	
	1010	10			geglüht	
F.1110	1015	15			geglüht	
	1020, 1023	20	12 024		geglüht	
		17G1S	11 523		geglüht	
F.1511	1015	15			geglüht	
F.1120	1025	25			geglüht	
					geglüht	
	A204 Grade A		15 020		geglüht	
	4520				geglüht	
	3310, 9314	20X2H4A	16 420		geglüht	
	4320		16 220		geglüht	
					geglüht	
F.1516	5115	12KHN2	14 220		geglüht	
		18HG			geglüht	
	5120	20KH	14 221		geglüht	
	5120 H	20KH			geglüht	
	A182-F11, A182-F12	12KHM	15 121		geglüht	
	A387 Grade 12 Cl. 2				geglüht	
F.155	A182-F22	12KH8	15 313		geglüht	
F.1130	1035	35	12 040		geglüht	
F.5110	1045	45	12 050		geglüht	
	1040	40	12 041		geglüht	
F.1150	1055	55			geglüht	
	1060	60	12 061		geglüht	
	1039	40G			geglüht	
	1330	30G2			geglüht	
F.1135	1035	35			geglüht	
F.1140	1045	45	12 050		geglüht	
F.1150	1064	60			geglüht	
	1060	60			geglüht	
F.144	9255	55S2			geglüht	
F.1250	4135	35KHM			geglüht	
F.5241	S1	5KHV2S			geglüht	
	L6	5KHNV			geglüht	
	5045				geglüht	
	3135				vergütet	
	3435				geglüht	
	9840				vergütet	
F.1280	4340	38H2N2MA	16 343		geglüht	
	5132	35KH			vergütet	
	5140	40H	14 140		vergütet	
F.1251	4130	20KHM	15 130		vergütet	
F.1252	4142, 4140	38HM	15 142		geglüht	
F.1252	4142, 4140	38HM	15 142		vergütet	
					vergütet	
F.143	6150	50KHFA	15 260		vergütet	
F.1740	A355 Cl. A				geglüht	
F.5103	1070	70			geglüht	
F.5117	1095				geglüht	
F.5118	W1	U10A			geglüht	
		U10			geglüht	
	W1	U13			geglüht	

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SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 CrNiMoAl 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

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U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
F.520L	L2	11KHF			geglüht	
F.5220	O1	9KHVG			geglüht	
	O2	9G2F			geglüht	
F.5230	52100	SHKH15	14 109		geglüht	
F.5212	D3	KH12			geglüht	
	H11	4KH5MFS			geglüht	
F.5318	H13	4KH5MF1S			geglüht	
F.5227	A2	9KH5VF			geglüht	
	H10	3KH3M3F			geglüht	
F.5213		KH12			geglüht	
		KH12MF			geglüht	
F.520.S	L6	5KHNM			geglüht	
F.5613	M35	R6M5K5			geglüht	
	M42	R2AM9K5			geglüht	
	T4	R18K5F2			geglüht	
F.5603	M2	R6M5			geglüht	
	M7				geglüht	
	T1	R18			geglüht	
	403	08KH13			geglüht	ferritisch
F.3401	410, -15	12KH13, 08KH13			geglüht	martensitisch
F.3113	430	12KH17			geglüht	ferritisch
F.5261	420	20KH13	17 022		geglüht	martensitisch
F.3404	420	40KH13			geglüht	martensitisch
	440 A				geglüht	martensitisch
	440 B	95KH18			geglüht	martensitisch
	440 C	95KH18			geglüht	martensitisch
	A182 F6NM			F6NM	geglüht	martensitisch
	446	15KH28			geglüht	ferritisch
	XM-13			PH 13-8 Mo	lösungsgeglüht	austenitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H1150	martensitisch
	XM-12			15-5-PH	lösungsgeglüht	martensitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H1025	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H1150	martensitisch
	630			17-4-PH	lösungsgeglüht	martensitisch
	631	09KH17N7YU1		17-7-PH	lösungsgeglüht	austenitisch/ferritisch
	AMS 6515			Marage 350	lösungsgeglüht	martensitisch
	AMS 6521			Marage 300	lösungsgeglüht	martensitisch
	AMS 6514			Marage 300, Vascomax C300	lösungsgeglüht	martensitisch
	AMS 6512			Marage 250	lösungsgeglüht	martensitisch
	AMS 6512			Marage 250, Vascomax C250	lösungsgeglüht	martensitisch
F.3508	303	12KH19N9			geglüht	austenitisch
F.3504	304 L	03KH18N11			geglüht	austenitisch
F.3504	304	08KH18N10	17 240		geglüht	austenitisch
F.3534	316	08KH17H13M2T	17 346		geglüht	austenitisch
F.3524	347	08KH18N12B			geglüht	austenitisch
F.3517	301	07KH16N6			geglüht	austenitisch
	302	12KH18N9			geglüht	austenitisch
F.3533	316 L	03KH17N14M3	17 349		geglüht	austenitisch
	316 LN	03KH16N15M3			geglüht	austenitisch
F.3541	304 LN	03KH18N11			geglüht	austenitisch
	317	08KH17H15M3T			geglüht	austenitisch
				253 MA	geglüht	austenitisch
	310 S	12KH25N20			geglüht	austenitisch
	329 LN			SAF 2205	geglüht	Duplex
				3RE60	geglüht	Duplex
	904L				geglüht	Super Austenit
	329				geglüht	Duplex
	660			A286	lösungsgeglüht	austenitisch
				254 SMO	geglüht	Super Austenit
				654 SMO	geglüht	Super Austenit
				Alloy 800	geglüht	austenitisch
	F 53			SAF 2507	geglüht	Super Duplex

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SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
K1	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
K2	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
	EN-GJS-350-22	0.7033	0.7033	DMM=-35,3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
K4	EN-GJS-400-18	0.7043	0.7043	DMM=-40,3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
K5	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
K6	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
K7	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
	AW-1050A	Al99.5	3.0255	Al99.5	-51050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
N1	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
N2	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
N11			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

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U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
	A48 25 B	Sc 15	422 415			Grauguss (GCI)
	A48 30 B	Sc 20	422 420			Grauguss (GCI)
	A48 35 B	Sc 25	422 425			Grauguss (GCI)
	A48 50 B	Sc 35				Grauguss (GCI)
	G 3500					Grauguss (GCI)
	Grade 350					Vermikularguss (CGI)
	Grade 400					Vermikularguss (CGI)
	Grade 400-15					Vermikularguss (CGI)
	Grade 450					Vermikularguss (CGI)
	Grade 500					Vermikularguss (CGI)
	A220 60004				geglüht	Temperguss (MCI)
						Sphäroguss (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Sphäroguss (SGI)
	60-40-18	Vc 42-12				Sphäroguss (SGI)
FGE 50-7	A536 80-55-06	Vc 50-2	422 305			Sphäroguss (SGI)
FGE 60-2	A476 80-60-03	Vc 60-2	422 306			Sphäroguss (SGI)
FGE 70-2	A536 100-70-03	Vc 70-2				Sphäroguss (SGI)
	1600/1300					wärmebehandelter Kugelgrafitguss (ADI)
	1050/700/7					wärmebehandelter Kugelgrafitguss (ADI)
	1200/850/4					wärmebehandelter Kugelgrafitguss (ADI)
	1400/1100/1					wärmebehandelter Kugelgrafitguss (ADI)
	850/550/10					wärmebehandelter Kugelgrafitguss (ADI)
	A436 Type 2			Ni-Resist 2		austenitischer Guss mit Lamellengrafit
	A436 Type 3			Ni-Resist 3		austenitischer Guss mit Lamellengrafit
	A436 Type 1			Ni-Resist 1		austenitischer Guss mit Lamellengrafit
				Nodumag		austenitischer Sphäroguss
	A436 Type D-2			Ni-Resist D-2		austenitischer Sphäroguss
	A439 Type D-2M			Ni-Resist D-2M		austenitischer Sphäroguss
	A436 Type D-3			Ni-Resist D-3		austenitischer Sphäroguss
	A439 Type D-5			Ni-Resist D-5		austenitischer Sphäroguss
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

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U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
				Discalloy	ausscheidungsgehärtet	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel -750	lösungsgeglüht	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	technisch rein	Ti (α)
	AMS 4919			Ti 6-2-4-2	geglüht	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	geglüht	Ti (α+β)
	AMS 4920, Grd 5	VT6		Ti 6Al-4V	geglüht	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	geglüht	Ti (β)
F.1516	5115	12KHN2	14 220		einsatzgehärtet	
F.5103	1070	70			vergütet	
F.5107	1078, 1080	75			vergütet	
F.5117	1095				vergütet	
F.5118	W1	U10A			vergütet	
	S1	5KHV2SF			vergütet	
	5155				vergütet	
F.1252	4142, 4140	38HM	15 142		vergütet	
F.520L	L2	11KHF			vergütet	
F.5220	O1	9KHVG			vergütet	
	O2	9G2F			vergütet	
F.5230	52100	SHKH15	14 109		vergütet	
F.5318	H13	4KH5MF1S			vergütet	
F.5227	A2	9KH5VF			vergütet	
F.5211	D2	KH12MF			vergütet	
F.5213		KH12			vergütet	
		KH12MF			vergütet	
F.520.S	L6	5KHNM			vergütet	
F.5613	M35	R6M5K5			vergütet	
	M42	R2AM9K5			vergütet	
	T1	R18			vergütet	
F.5261	420	20KH13	17 022		vergütet	martensitisch
	440 A				vergütet	martensitisch
	440 B	95KH18			vergütet	martensitisch
	440 C	95KH18			vergütet	martensitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H900	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H1025	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H900	martensitisch
	AMS 5528	09KH17N7YU1		17-7-PH	ausscheidungsgehärtet TH1050	martensitisch
	632			PH 15-7 Mo	ausscheidungsgehärtet TH1050	martensitisch
	660			A286	ausscheidungsgehärtet	austenitisch
	AMS 6512			Marage 250	ausscheidungsgehärtet	martensitisch
	AMS 6521			Marage 300	ausscheidungsgehärtet	martensitisch
	AMS 6521			Marage 300	ausscheidungsgehärtet	martensitisch
	AMS 6515			Marage 350	ausscheidungsgehärtet	martensitisch
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		Weißhartguss
	A532 IA (NiCr-HC)			Ni-Hard 1		Weißhartguss
	A532 ID (Ni-HiCr)			Ni-Hard 4		Weißhartguss

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