



### PRODUKTBESCHREIBUNG

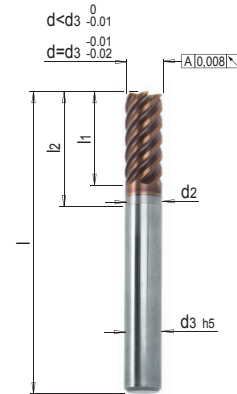
» Hochleistungs-Hartfräser mit Zentrumschnitt zum Feinschlichten

### MATERIAL

» VHM, TiSiN-beschichtet



Z	d2	d3	l	l2	l1	d	Nr.	EUR
4	2,9	4	50	15	9	3	WZF 13746/ 3	< >
4	3,9	6	60	16	11	4	WZF 13746/ 4	< >
4	4,9	6	60	20	13	5	WZF 13746/ 5	< >
6	5,9	6	60	20	13	6	WZF 13746/ 6	< >
6	7,9	8	70	25	19	8	WZF 13746/ 8	< >
6	9,9	10	80	30	22	10	WZF 13746/10	< >
6	11,9	12	80	35	26	12	WZF 13746/12	< >
8	15,9	16	90	40	32	16	WZF 13746/16	< >



### RICHTWERTE SCHLICHTEN

WZF 13746	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d							
				3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)							
<p>ae = 0.03 x d ap = 1.7 x d</p>	1.2083	52 HRC	100	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2162	52 HRC	130	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2343	52 HRC	130	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2379	60 HRC	75	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2767	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2842	60 HRC	75	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2714HH	43 HRC	140	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3343	64 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3344 PM	64 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M V10 PM	62 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M W10 PM	65 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046

### RICHTWERTE SCHLICHTEN

WZF 13746	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d							
				3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)							
<p>ae = 0.06 x d ap = 1.7 x d</p>	1.2083	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2162	52 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2343	52 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2379	60 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2767	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2842	60 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2714HH	43 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3343	64 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3344 PM	64 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M V10 PM	62 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M W10 PM	65 HRC	55	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046

1) Vc: Schnittgeschwindigkeit (m/min.)

2) fz: Vorschub pro Schneide (mm/z)

**i** Weitere Materialien und Schnittwerte finden Sie im Schnittdaten-Kalkulator