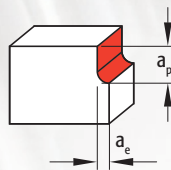


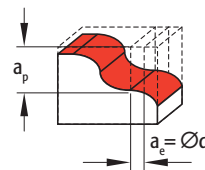
Material group	TSR (N/mm ²)	Hardness	Cutting speed Vc m/min	Coolant
H2.2		50-55 HRc	110 - 170	min.lub.
H2.3		55-70 HRc	80 - 140	min.lub.

For an extra charge we offer an inspection report of the tool geometry.

Auf Wunsch erhalten Sie zu jedem Werkzeug ein separates Prüfprotokoll (aufpreispflichtig).



Hardened material
Gehärtete Werkstoffe
a_p up to 2,00 x d
a_e up to 0,02 x d



Hardened material
Gehärtete Werkstoffe
a_p up to 2,00 x d
a_e up to 0,02 x d

Shoulder milling / Eckfräsen

Ød (mm)	a _p max. (mm)	a _e max. (mm)	f _z (mm/tooth)
3,0	< 3,0	< 0,03	0,020 - 0,035
4,0	< 6,0	< 0,05	0,030 - 0,045
5,0	< 7,5	< 0,07	0,035 - 0,055
6,0	< 12,0	< 0,10	0,045 - 0,065
8,0	< 16,0	< 0,13	0,060 - 0,080
10,0	< 20,0	< 0,17	0,070 - 0,095
12,0	< 24,0	< 0,21	0,085 - 0,110
16,0	< 32,0	< 0,28	0,095 - 0,125
20,0	< 40,0	< 0,35	0,105 - 0,140