



### PRODUKTBESCHREIBUNG

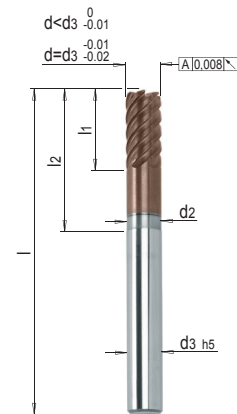
» Hochleistungs-Hartfräser mit Zentrumsschnitt zum Feinschlichten

### MATERIAL

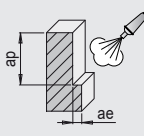
» VHM, TiSiN-beschichtet



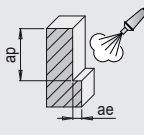
Z	d2	d3	l	l2	l1	d	Nr.	EUR
4	0,9	4	50	6	3	1	WZF 13756/ 1	< >
4	1,9	4	50	10	6	2	WZF 13756/ 2	< >
4	2,9	4	50	15	10	3	WZF 13756/ 3	< >
4	3,9	6	60	17	12	4	WZF 13756/ 4	< >
4	4,9	6	60	22	15	5	WZF 13756/ 5	< >
6	5,9	6	60	25	18	6	WZF 13756/ 6	< >
6	7,9	8	70	30	24	8	WZF 13756/ 8	< >
6	9,9	10	80	38	30	10	WZF 13756/10	< >
6	11,9	12	90	40	36	12	WZF 13756/12	< >
8	15,9	16	100	54	48	16	WZF 13756/16	< >



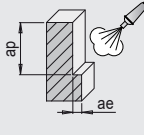
## RICHTWERTE SCHLICHTEN

WZF 13756	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d									
				1	2	3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)									
 <p>ae = 0.04 x d ap = 3 x d</p>	1.2083	52 HRC	80	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.2162	52 HRC	120	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.2343	52 HRC	120	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.2379	60 HRC	75	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.2767	52 HRC	75	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.2842	60 HRC	70	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.2714HH	43 HRC	130	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.3343	64 HRC	55	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	1.3344 PM	64 HRC	55	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
	M V10 PM	62 HRC	60	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032
M W10 PM	65 HRC	55	0.004	0.005	0.007	0.009	0.01	0.012	0.015	0.02	0.025	0.032	

## RICHTWERTE SCHLICHTEN


WZF 13756	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d									
				1	2	3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)									
 <p>ae = 0.04 x d ap = 2 x d</p>	1.2083	52 HRC	80	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.2162	52 HRC	120	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.2343	52 HRC	120	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.2379	60 HRC	75	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.2767	52 HRC	75	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.2842	60 HRC	70	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.2714HH	43 HRC	130	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.3343	64 HRC	55	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	1.3344 PM	64 HRC	55	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
	M V10 PM	62 HRC	60	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035
M W10 PM	65 HRC	55	0.005	0.007	0.009	0.011	0.013	0.015	0.018	0.022	0.028	0.035	

## RICHTWERTE SCHLICHTEN

WZF 13756	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d									
				1	2	3	4	5	6	8	10	12	16
				fz <sup>2</sup> (mm/z)									
 <p>ae = 0.04 x d ap = 1.5 x d</p>	1.2083	52 HRC	80	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.2162	52 HRC	120	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.2343	52 HRC	120	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.2379	60 HRC	75	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.2767	52 HRC	75	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.2842	60 HRC	70	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.2714HH	43 HRC	130	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.3343	64 HRC	55	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	1.3344 PM	64 HRC	55	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
	M V10 PM	62 HRC	60	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038
M W10 PM	65 HRC	55	0.006	0.008	0.01	0.012	0.015	0.017	0.02	0.025	0.03	0.038	

1) Vc: Schnittgeschwindigkeit (m/min.)

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

 Weitere Materialien und Schnittwerte finden Sie im Schnittdaten-Kalkulator