

End mills



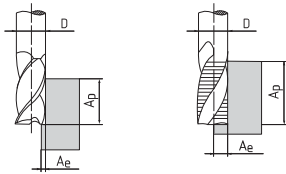
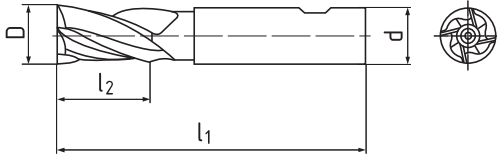
D ≤ 20

D > 20

CZ Frézy válcové čelní

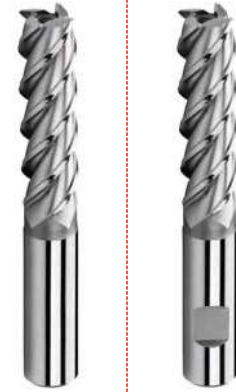
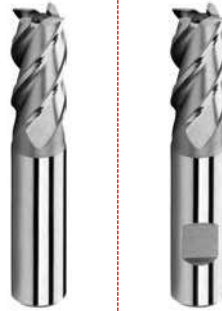
DE Schaftfräser

RU Фрезы концевые с цилиндрическим хвостовиком



1402

1412



D	d	l1	l1	l2	l2	Z	140208	140218	141208	141218
k 10	h 6	1402	1412	1402	1412					
6	6	57	68	13	24	4	.060	.060	.060	.060
7	10	66	80	16	30	4	.070	.070	.070	.070
8	10	69	88	19	38	4	.080	.080	.080	.080
9	10	69	88	19	38	4	.090	.090	.090	.090
10	10	72	95	22	45	4	.100	.100	.100	.100
11	12	79	102	22	45	4	.110	.110	.110	.110
12	12	83	110	26	53	4	.120	.120	.120	.120
13	12	83	110	26	53	4	.130	.130	.130	.130
14	12	83	110	26	53	4	.140	.140	.140	.140
15	12	83	110	26	53	4	.150	.150	.150	.150
16	16	92	123	32	63	4	.160	.160	.160	.160
17	16	92	123	32	63	4	.170	.170	.170	.170
18	16	92	123	32	63	4	.180	.180	.180	.180
19	16	92	123	32	63	4	.190	.190	.190	.190
20	20	104	141	38	75	4	.200	.200	.200	.200
21	20	104	141	38	75	5	.210	.210	.210	.210
22	20	104	141	38	75	5	.220	.220	.220	.220
24	25	121	166	45	90	5	.240	.240	.240	.240
25	25	121	166	45	90	5	.250	.250	.250	.250
28	25	121	166	45	90	5	.280	.280	.280	.280
30	25	121	166	45	90	6	.300	.300	.300	.300
32	32	133	186	53	106	6	.320	.320	.320	.320
36	32	133	186	53	106	6	.360	.360	.360	.360
40*	32	143	205	63	125	6	.40032	.40032	.40032	.40032

*) ≠ DIN 844

Cutting conditions | Řezné podmínky | Schnittbedingungen | Условия резания

Material	Ap	Ae	Vc	fz (mm/z)										
				Ø 6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 18	Ø 20	Ø 25	Ø 32	Ø 40	
P.1 ≤ 600 N/mm ²	1xD	0,1xD	45	0,015	0,021	0,028	0,034	0,044	0,051	0,057	0,071	0,085	0,11	
P.2 ≤ 850 N/mm ²	1xD	0,1xD	39	0,015	0,021	0,028	0,034	0,044	0,051	0,057	0,071	0,085	0,11	
P.3 ≤ 1100 N/mm ²	1xD	0,1xD	24	0,015	0,021	0,028	0,034	0,044	0,051	0,057	0,071	0,085	0,11	
P.4 ≤ 900 N/mm ²	1xD	0,1xD	30	0,015	0,021	0,028	0,034	0,044	0,051	0,057	0,071	0,085	0,11	
P.5 ≤ 1100 N/mm ²	1xD	0,1xD	24	0,015	0,021	0,028	0,034	0,044	0,051	0,057	0,071	0,085	0,11	