

Dovetail milling cutters

DIN
1833A

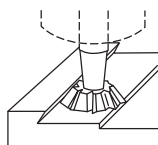
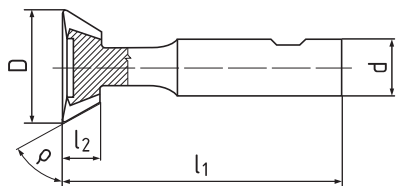
DIN
1833C

$\lambda=0^\circ$
 $\gamma=0^\circ$



HSS
Co5

- CZ** Frézy úhlové čelní
- DE** Winkel-Stirnfräser
- RU** Фрезы угловые торцовые



3302



3302

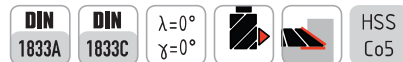


ρ $\pm 30'$	D js 16	d h 6	l1	l2	Z	330205	330215
45	16	12	60	4	10	.045160	.045160
45	20	12	63	5	10	.045200	.045200
45	25	12	67	6,3	10	.045250	.045250
45	32	16	71	8	12	.045320	.045320
45	40	16	80	10	12	.045400	.045400
50	16	12	60	5	10	.050160	.050160
50	20	12	63	6,3	10	.050200	.050200
50	25	12	67	8	10	.050250	.050250
55	16	12	60	5,6	10	.055160	.055160
55	20	12	63	7,1	10	.055200	.055200
55	25	12	67	9	10	.055250	.055250
60	16	12	60	6,3	10	.060160	.060160
60	20	12	63	8	10	.060200	.060200
60	25	12	67	10	10	.060250	.060250
60	32	16	71	12,5	12	.060320	.060320
60	40	16	80	16	12	.060400	.060400

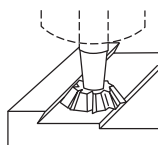
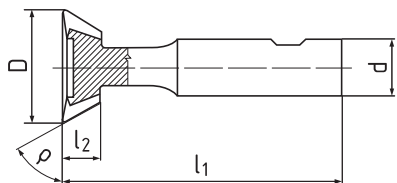
Cutting conditions | Řežné podmínky | Schnittbedingungen | Условия резания

Material	A _p	A _e	V _c	f _z (mm/z) 45°-85°					
				Ø 16	Ø 20	Ø 25	Ø 32	Ø 36	Ø 40
P.1 ≤ 600 N/mm ²	1xI2	t1(DIN 6888)	28	0,011	0,014	0,018	0,022	0,025	0,028
P.2 ≤ 850 N/mm ²	1xI2	t1(DIN 6888)	24	0,01	0,012	0,015	0,019	0,022	0,024
P.3 ≤ 1100 N/mm ²	1xI2	t1(DIN 6888)	18	0,01	0,012	0,015	0,019	0,022	0,024
N.2 ≤ 600 N/mm ²	1xI2	t1(DIN 6888)	41	0,011	0,014	0,018	0,022	0,025	0,028
S.2 ≤ 1250 N/mm ²	1xI2	t1(DIN 6888)	9	0,007	0,008	0,011	0,013	0,015	0,017

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ρ ± 30'	D js 16	d h 6	l1	l2	Z	330205	330215
65*	16	12	60	6,3	10	.065160	.065160
65*	25	12	67	10	12	.065250	.065250
70*	16	12	60	7	10	.070160	.070160
70*	20	12	63	9	10	.070200	.070200
70*	25	16	67	11	10	.070250	.070250
75*	16	12	60	8	10	.075160	.075160
75*	25	12	67	10	12	.075250	.075250
80*	16	12	60	8	10	.080160	.080160
80*	25	12	67	10	12	.080250	.080250
85*	16	12	60	8	10	.085160	.085160
85*	25	12	67	10	12	.085250	.085250

*) ≠ DIN 1833

Cutting conditions | Řezné podmínky | Schnittbedingungen | Условия резания

Material	Ap	Ae	Vc	fz (mm/z) 45°-85°					
				Ø 16	Ø 20	Ø 25	Ø 32	Ø 36	Ø 40
P.1 ≤ 600 N/mm2	1x12	t1(DIN 6888)	28	0,011	0,014	0,018	0,022	0,025	0,028
P.2 ≤ 850 N/mm2	1x12	t1(DIN 6888)	24	0,01	0,012	0,015	0,019	0,022	0,024
P.3 ≤ 1100 N/mm2	1x12	t1(DIN 6888)	18	0,01	0,012	0,015	0,019	0,022	0,024
N.2 ≤ 600 N/mm2	1x12	t1(DIN 6888)	41	0,011	0,014	0,018	0,022	0,025	0,028
S.2 ≤ 1250 N/mm2	1x12	t1(DIN 6888)	9	0,007	0,008	0,011	0,013	0,015	0,017

