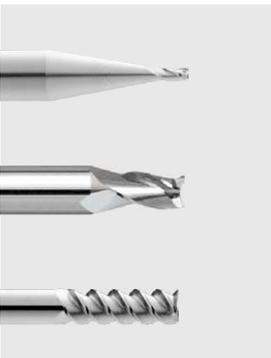


MICRO-Line

Fraises en bout de finition

Schlicht Schafffräser

Finishing end mills

		Shank	Z	Spiral	Type	page	
	Sharp Corner	∅ 6 mm	Z = 3	30°	3336-HA	41	
				30°	3337-HA	41	
				30°	3330-S	42	
		D1 = D2	D1 = D2	Z = 3	30°	3330	42
					Z = 3	30°	3231
				30°		3331	43
				45°		3341	44
				Z = 4	60°	3361	44
					30°	3431	45
				45°	3441	45	
	U	D1 = D2	Z = 2	30°	3238	46	
			Z = 3	30°	3338	46	
		∅ 6 mm	Z = 3	30°	3383	47	
			∅ 10 mm	Z = 10	30°	3830	47
		∅ 3 mm	Z = 3	0°	3911	48	
		D1 = D2	Z = 4	0°	1901/3901	49	

Paramètres de coupe indicatifs

Empfohlene Schnittwerte

Standard machining data

Matière Werkstoff Material	VC (m/min)	fz [mm/z]	
		∅ 2 - 4	∅ 4 - 6
Acier Stahl Steel < 700 N/mm ²	60 - 100	0.010 - 0.030	0.015 - 0.040
Acier Stahl Steel > 700 N/mm ²	40 - 70	0.008 - 0.020	0.010 - 0.030
Acier inoxydable Rostfreistahl Stainless steel	40 - 80	0.010 - 0.030	0.015 - 0.040
Titane Titan Titanium	25 - 50	0.010 - 0.030	0.015 - 0.040
Aluminium	100 - 250	0.015 - 0.050	0.020 - 0.060
Cuivre Kupfer Copper	80 - 160	0.010 - 0.040	0.020 - 0.060
Laiton Messing Brass	100 - 200	0.015 - 0.040	0.030 - 0.070