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GERMAN TOOLS GROUP

VHM Werkzeuge für Aluminium

Solid Carbide tools for Aluminium

2014

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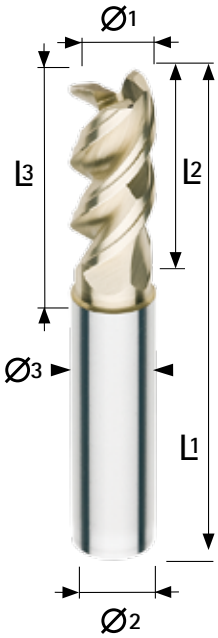
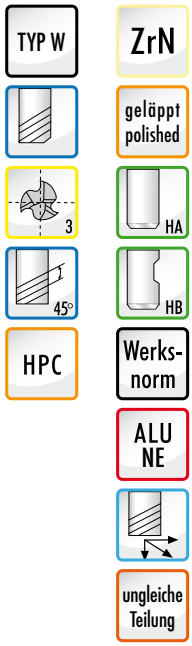
VHM-Schaftfräser / *Solid carbide cutter*

Artikel-Nr. 244 ...



Ø1	Ø2	L2	L1	Ø3	L3	Eckfase *chamfer*	Z	Artikel-Nr. *Article No.*
3,00	6,00	8	57	2,80	12	0,10	3	244.030...
4,00	6,00	11	57	3,80	18	0,10	3	244.040...
5,00	6,00	13	57	4,80	18	0,10	3	244.050...
6,00	6,00	13	57	5,80	18	0,20	3	244.060...
6,00	6,00	13	80	5,80	42	0,20	3	244.061...
8,00	8,00	21	63	7,80	25	0,20	3	244.080...
8,00	8,00	21	100	7,80	62	0,20	3	244.081...
10,00	10,00	22	72	9,70	30	0,20	3	244.100...
10,00	10,00	22	100	9,70	58	0,20	3	244.101...
12,00	12,00	26	83	11,70	36	0,20	3	244.120...
12,00	12,00	26	120	11,70	73	0,20	3	244.121...
16,00	16,00	36	92	15,70	42	0,20	3	244.160...
16,00	16,00	36	150	15,70	100	0,20	3	244.161...
18,00	18,00	36	92	17,60	42	0,20	3	244.180...
18,00	18,00	36	150	17,60	100	0,20	3	244.181...
20,00	20,00	41	104	19,50	52	0,20	3	244.200...
20,00	20,00	41	150	19,50	98	0,20	3	244.201...
25,00	25,00	50	121	24,50	65	0,30	3	244.250...

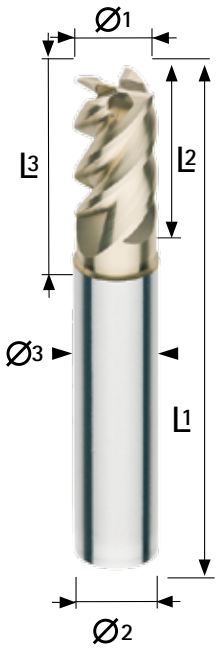


Bitte fügen Sie bei Ihrer Bestellung folgende Codes hinzu: mit Weldon .10 ohne weldon .00

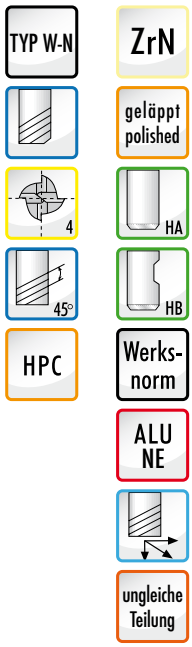
Please add the following code to your order: with weldon .10 without weldon .00

VHM-Schaftfräser / *Solid carbide cutter*

Artikel-Nr. 414 ...



Ø1	Ø2	L2	L1	Ø3	L3	Eckfase *chamfer*	Z	Artikel-Nr. *Article No.*
3,00	6,00	8	57	2,80	12	0,10	4	414.030...
4,00	6,00	11	57	3,80	18	0,10	4	414.040...
5,00	6,00	13	57	4,80	18	0,10	4	414.050...
6,00	6,00	13	57	5,80	18	0,20	4	414.060...
6,00	6,00	13	80	5,80	42	0,20	4	414.061...
8,00	8,00	21	63	7,80	25	0,20	4	414.080...
8,00	8,00	21	100	7,80	62	0,20	4	414.081...
10,00	10,00	22	72	9,70	30	0,20	4	414.100...
10,00	10,00	22	100	9,70	58	0,20	4	414.101...
12,00	12,00	26	83	11,70	36	0,20	4	414.120...
12,00	12,00	26	120	11,70	73	0,20	4	414.121...
16,00	16,00	36	92	15,70	42	0,20	4	414.160...
16,00	16,00	36	150	15,70	100	0,20	4	414.161...
18,00	18,00	36	92	17,60	42	0,20	4	414.180...
18,00	18,00	36	150	17,60	100	0,20	4	414.181...
20,00	20,00	41	104	19,50	52	0,20	4	414.200...
20,00	20,00	41	150	19,50	98	0,20	4	414.201...
25,00	25,00	50	121	24,50	65	0,30	4	414.250...

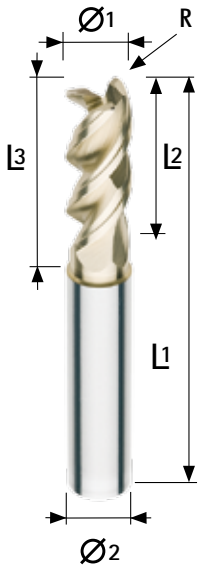


Bitte fügen Sie bei Ihrer Bestellung folgende Codes hinzu: mit Weldon .10 ohne weldon .00

Please add the following code to your order: with weldon .10 without weldon .00

VHM – Schaftfräser^{ER} / *Solid carbide cutter with corner radius*

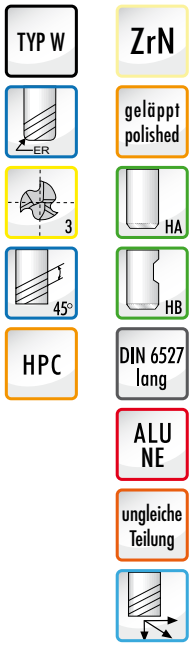
Artikel-Nr. 245 ...



Ø1	Ø2	L2	L1	L3	R	Z	Artikel-Nr. *Article No.*
5,00	6,00	13	57	18	0,50	3	245.050...
5,00	6,00	13	57	18	1,00	3	245.051...
6,00	6,00	13	57	18	0,50	3	245.060...
6,00	6,00	13	57	18	1,00	3	245.061...
8,00	8,00	21	63	25	0,50	3	245.080...
8,00	8,00	21	63	25	1,00	3	245.081...
10,00	10,00	22	72	30	0,50	3	245.100...
10,00	10,00	22	72	30	1,00	3	245.101...
12,00	12,00	26	83	36	0,50	3	245.120...
12,00	12,00	26	83	36	1,00	3	245.121...
16,00	16,00	36	92	42	2,00	3	245.160...
16,00	16,00	36	92	42	4,00	3	245.161...
20,00	20,00	41	104	52	4,00	3	245.200...
25,50	25,00	50	121	65	5,00	3	245.250...

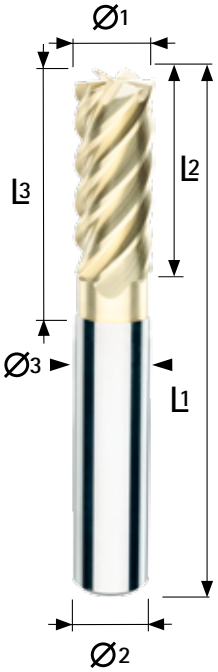
Bitte fügen Sie bei Ihrer Bestellung folgende Codes hinzu: mit Weldon .10 ohne weldon .00

Please add the following code to your order: with weldon .10 without weldon .00



VHM - Schlichtfräser Multicut / *Solid carbide finishing cutter*

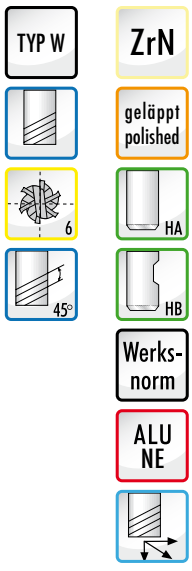
Artikel-Nr. 246 ...



Ø1	Ø2	L2	L1	Ø3	L3	Z	Artikel-Nr. *Article No.*
6,00	6,00	15	57	5,70	20	6	246.060...
6,00	6,00	15	80	5,70	43	6	246.061...
8,00	8,00	20	63	7,40	26	6	246.080...
8,00	8,00	20	100	7,40	62	6	246.081...
10,00	10,00	25	73	9,20	32	6	246.100...
10,00	10,00	25	100	9,20	58	6	246.101...
12,00	12,00	30	83	11,00	37	6	246.120...
12,00	12,00	30	120	11,00	73	6	246.121...
16,00	16,00	40	93	15,00	45	6	246.160...
16,00	16,00	40	150	15,00	100	6	246.161...
20,00	20,00	50	104	19,00	53	6	246.200...
20,00	20,00	50	150	19,00	100	6	246.201...
25,00	25,00	56	150	24,00	92	6	246.250...

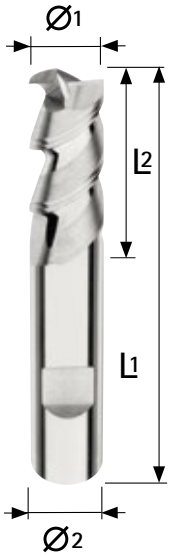
Bitte fügen Sie bei Ihrer Bestellung folgende Codes hinzu: mit Weldon .10 ohne weldon .00

Please add the following code to your order: with weldon .10 without weldon .00

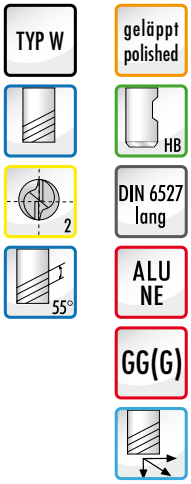


VHM - Schlichtfräser / *Solid carbide finishing cutter*

Artikel-Nr. 402 ...

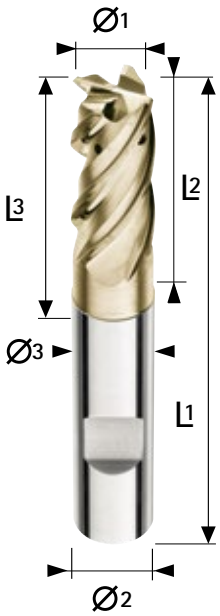


Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
3,00	6,00	8	57	2	402.030.09
4,00	6,00	11	57	2	402.040.09
5,00	6,00	13	57	2	402.050.09
6,00	6,00	13	57	2	402.060.09
8,00	8,00	19	63	2	402.080.09
10,00	10,00	22	72	2	402.100.09
12,00	12,00	26	83	2	402.120.09
14,00	14,00	26	83	2	402.140.09
16,00	16,00	32	92	2	402.160.09
18,00	18,00	32	92	2	402.180.09
20,00	20,00	38	104	2	402.200.09



VHM – Schaftfräser **Starmax NE^{IK}** / *Solid carbide cutter Starmax non-ferrous with internal cooling*

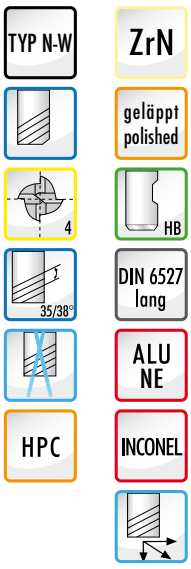
Artikel-Nr. 408 ...



Ø1	Ø2	L2	L1	Ø3	L3	Eckfase *chamfer*	Z	Artikel-Nr. *Article No.*
3,00	6,00	11	57	2,80	18	0,10	4	408.030.00
4,00	6,00	12	57	3,60	21	0,15	4	408.040.00
5,00	6,00	15	57	4,50	21	0,18	4	408.050.00
6,00	6,00	15	57	5,50	21	0,20	4	408.060.00
8,00	8,00	21	63	7,50	28	0,20	4	408.080.00
10,00	10,00	22	72	9,50	32	0,20	4	408.100.00
12,00	12,00	28	83	11,50	38	0,20	4	408.120.00
14,00	14,00	30	83	13,50	42	0,20	4	408.140.00
16,00	16,00	35	92	15,50	45	0,20	4	408.160.00
20,00	20,00	41	104	19,50	55	0,20	4	408.200.00
25,00	25,00	51	110	24,00	65	0,20	4	408.250.00

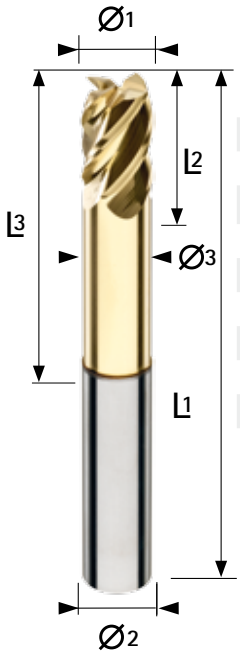
Schaftausführung, Toleranz h5,
Rundlaufgenauigkeit 0,005 mm,
Polierte Ausführung,
erhöhte Radiustoleranz

Shank design, tolerance h5,
rotation accuracy 0,005 mm,
polished design
increased radius tolerance

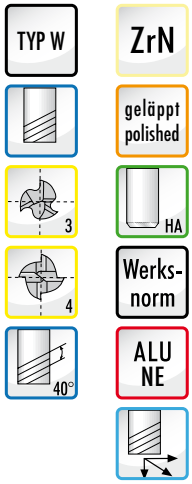


VHM - Schlichfräser / *Solid carbide finishing cutter*

Artikel-Nr. 412 ...

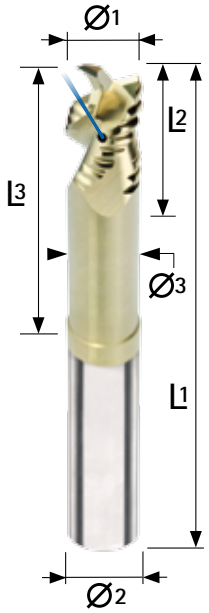


Ø1	Ø2	L2	L1	Ø3	L3	Z	Artikel-Nr. *Article No.*
3,00	6,00	8	70	5,70	20	3	412.030.09
4,00	6,00	11	70	5,70	25	3	412.040.09
5,00	6,00	13	70	5,70	30	3	412.050.09
6,00	6,00	13	70	5,70	30	3	412.060.09
8,00	8,00	20	80	7,40	35	3	412.080.09
10,00	10,00	22	90	9,20	45	3	412.100.09
12,00	12,00	26	100	11,00	55	4	412.120.09
16,00	16,00	36	115	15,00	65	4	412.160.09
20,00	20,00	41	125	19,00	75	4	412.200.09
25,00	25,00	52	150	24,00	95	4	412.250.09

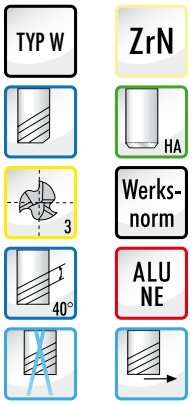


VHM – Schruppfräser NE[IK] Typ WR / *Solid carbide cutter non-ferrous with internal cooling*

Artikel-Nr. 253 ...

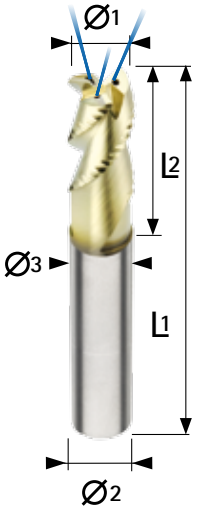


Ø1	Ø2	L2	L1	Ø3	L3	Eckfase *chamfer*	Z	Artikel-Nr. *Article No.*
6,00	6,00	10	63	5,50	24	0,30	3	253.060.00
8,00	8,00	12	72	7,50	29	0,40	3	253.080.00
10,00	10,00	14	83	9,50	35	0,50	3	253.100.00
12,00	12,00	16	100	11,40	50	0,60	3	253.120.00
16,00	16,00	20	115	15,20	63	0,80	3	253.160.00
20,00	20,00	20	125	19,00	70	1,00	3	253.200.00
25,00	25,00	25	135	23,75	75	1,25	3	253.250.00

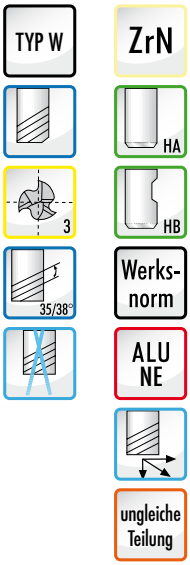


VHM – Schruppfräser NE Typ WF / *Solid carbide cutter non-ferrous*

Artikel-Nr. 252 ...



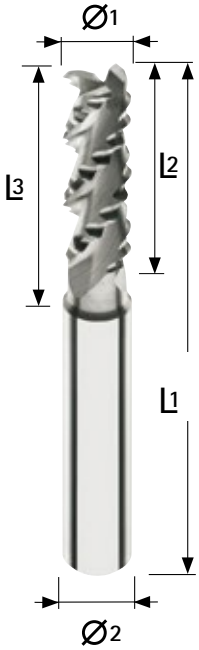
Ø1	Ø2	L2	L1	Ø3	L3	Eckfase *chamfer*	Z	Artikel-Nr. *Article No.*
6,00	6,00	13	70	5,70	18	0,40	3	252.060.00
8,00	8,00	21	80	7,40	25	0,40	3	252.080.00
10,00	10,00	22	80	9,20	30	0,40	3	252.100.00
12,00	12,00	26	90	11,00	36	0,40	3	252.120.00
16,00	16,00	36	100	15,00	42	0,40	3	252.160.10
20,00	20,00	41	120	19,00	52	0,40	3	252.200.10
25,00	25,00	50	150	24,00	75	0,50	3	252.250.10



Ø6,0 – Ø12,0 = HA
Ø16,0 – Ø25,0 = HB

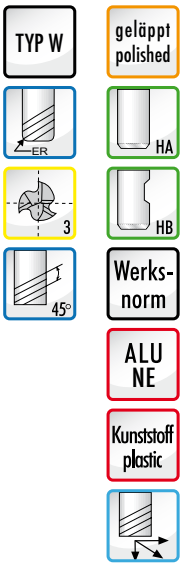
VHM – Schruppfräser **ALU^{3D}** Typ WR / *Solid carbide cutter*

Artikel-Nr. 405 ...



Ø1	Ø2	L2	L1	L3	Ecken-radius *corner radius*	Z	Artikel-Nr. *Article No.*
6,00	6,00	16	60	25	0,40	3	405.060...
8,00	8,00	25	78	33	0,50	3	405.080...
10,00	10,00	28	78	35	0,60	3	405.100...
12,00	12,00	32	89	40	0,80	3	405.120...
14,00	14,00	32	89	40	1,00	3	405.140...
16,00	16,00	36	96	45	1,00	3	405.160...
20,00	20,00	45	111	60	1,20	3	405.200...
25,00	25,00	50	121	65	1,50	3	405.250...

Bitte fügen Sie bei Ihrer Bestellung folgende Codes hinzu: mit Weldon .10 ohne weldon .00
Please add the following code to your order: with weldon .10 without weldon .00

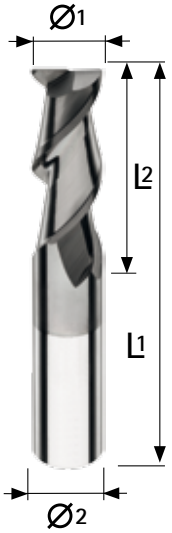


Stirnwinkel x 2 für mehr Spanraum und weniger Schnittdruck.
Two face angles for more chip space and less cutting pressure.

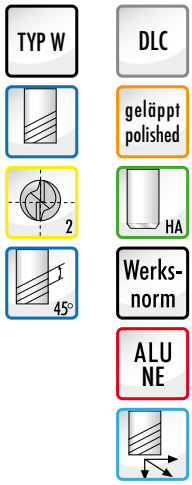
Diese Spezialkordel mit Facetten hat zusätzlich einen axialen Freiwinkel für schräges Eintauchen.
This special rough-profile has an axial clearance angle for angular milling.

VHM – Schlichtfräser **DLC** / *Solid carbide finishing cutter*

Artikel-Nr. 248 ...

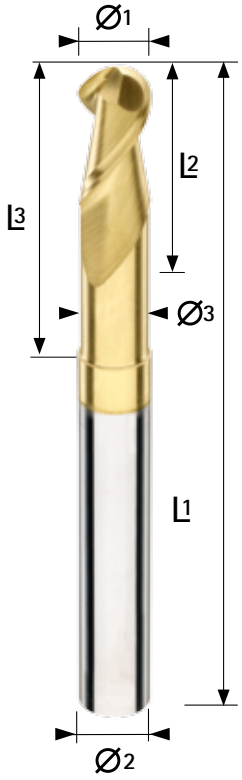


Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
0,50	4,00	1,50	50	2	248.005.00
0,60	4,00	1,50	50	2	248.006.00
0,80	4,00	2,00	50	2	248.008.00
1,00	6,00	3,00	50	2	248.010.00
1,20	6,00	4,00	50	2	248.012.00
1,50	6,00	4,00	50	2	248.015.00
1,80	6,00	5,00	50	2	248.018.00
2,00	6,00	6,00	50	2	248.020.00
3,00	6,00	8,00	50	2	248.030.00
4,00	6,00	10,00	50	2	248.040.00
5,00	6,00	13,00	50	2	248.050.00
6,00	6,00	15,00	50	2	248.060.00
8,00	8,00	20,00	60	2	248.080.00
10,00	10,00	25,00	75	2	248.100.00
12,00	12,00	30,00	75	2	248.120.00
16,00	16,00	42,00	104	2	248.160.00
20,00	20,00	52,00	104	2	248.200.00

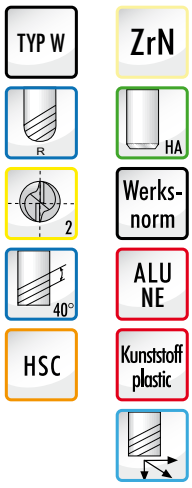


VHM – Vollradiusfräser **ALU** / *Solid carbide ball-nosed cutter*

Artikel-Nr. 533 ...



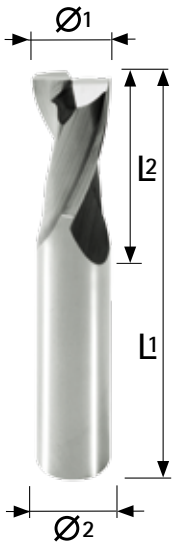
Ø1	Ø2	L2	L1	Ø3	L3	Z	Artikel-Nr. *Article No.*
1,00	6,00	2	60	0,90	15	2	533.010.07
2,00	6,00	4	60	1,80	20	2	533.020.07
3,00	6,00	6	70	2,80	25	2	533.030.07
4,00	6,00	8	70	3,70	25	2	533.040.07
5,00	6,00	10	70	4,60	25	2	533.050.07
6,00	6,00	12	80	5,50	35	2	533.060.07
8,00	8,00	16	80	7,40	35	2	533.080.07
10,00	10,00	20	90	9,20	45	2	533.100.07
12,00	12,00	24	100	11,00	50	2	533.120.07
14,00	14,00	26	100	13,20	60	2	533.140.07
16,00	16,00	30	150	15,00	92	2	533.160.07
20,00	20,00	40	150	19,00	92	2	533.200.07



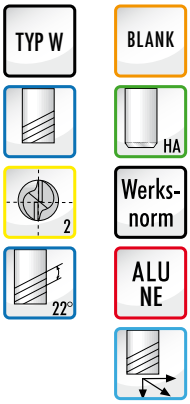
VHM-Schlichtfräser / *Solid carbide finishing cutter*

NEW

Artikel-Nr. 256 ...



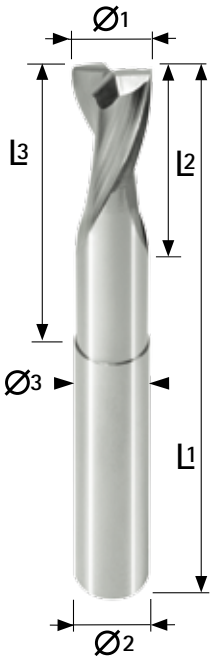
Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
1,50	6,00	3	57	2	256.015.00
2,00	6,00	6	57	2	256.020.00
2,50	6,00	7	57	2	256.025.00
3,00	6,00	7	57	2	256.030.00
4,00	6,00	8	57	2	256.040.00
5,00	6,00	10	57	2	256.050.00
6,00	6,00	10	57	2	256.060.00
8,00	8,00	16	63	2	256.080.00
10.00	10,00	19	72	2	256.100.00
12.00	12,00	22	83	2	256.120.00
16.00	16,00	26	92	2	256.160.00
20.00	20,00	32	104	2	256.200.00



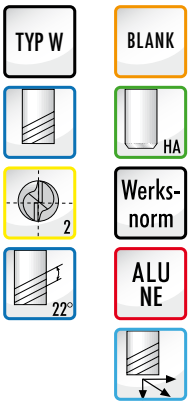
VHM-Schlichtfräser / *Solid carbide finishing cutter*

NEW

Artikel-Nr. 257 ...



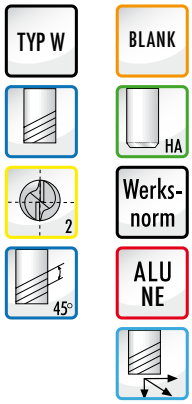
Ø1	Ø2	L2	L1	Ø3	L3	Z	Artikel-Nr. *Article No.*
2,00	3,00	3	38	1,92	9	2	257.020.00
3,00	3,00	4	38	2,90	12	2	257.030.00
4,00	4,00	6	50	3,80	14	2	257.040.00
5,00	6,00	8	57	4,75	16	2	257.050.00
6,00	6,00	10	65	5,70	28	2	257.060.00
8,00	8,00	12	80	7,60	35	2	257.080.00
10,00	10,00	14	90	9,50	45	2	257.100.00
12,00	12,00	16	100	11,40	55	2	257.120.00
16,00	16,00	20	115	15,20	63	2	257.160.00
20,00	20,00	20	125	19,00	70	2	257.200.00



VHM-Schlichtfräser / *Solid carbide finishing cutter*

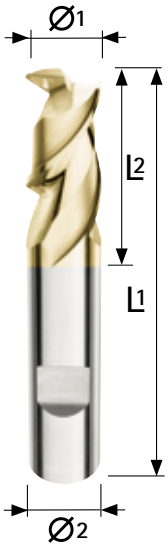
Artikel-Nr. 258 ...

Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
1,50	6,00	3	57	2	258.015.00
2,00	6,00	6	57	2	258.020.00
2,50	6,00	7	57	2	258.025.00
3,00	6,00	7	57	2	258.030.00
4,00	6,00	8	57	2	258.040.00
5,00	6,00	10	57	2	258.050.00
6,00	6,00	10	57	2	258.060.00
8,00	8,00	16	63	2	258.080.00
10,00	10,00	19	72	2	258.100.00
12,00	12,00	22	83	2	258.120.00
16,00	16,00	26	92	2	258.160.00
20,00	20,00	32	104	2	258.200.00

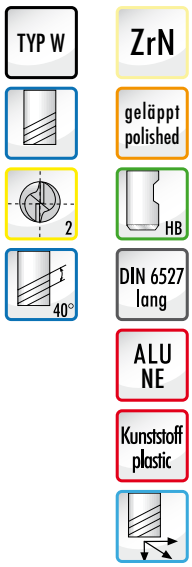


VHM-Schlichtfräser / *Solid carbide finishing cutter*

Artikel-Nr. 407 ...

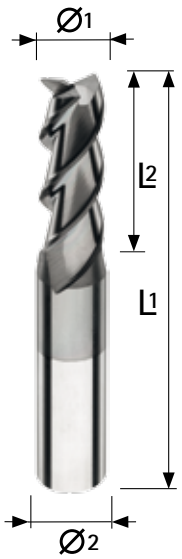


Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
6,00	6,00	13	57	2	407.060.09
8,00	8,00	19	63	2	407.080.09
10,00	10,00	22	72	2	407.100.09
12,00	12,00	26	83	2	407.120.09
16,00	16,00	32	92	2	407.160.09
20,00	20,00	42	104	2	407.200.09
25,00	25,00	42	110	2	407.250.09

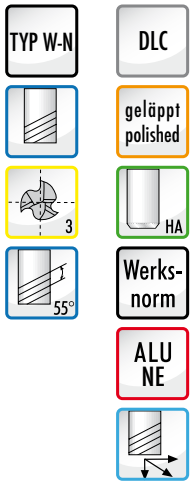


VHM-Schlichtfräser **DLC** / *Solid carbide finishing cutter*

Artikel-Nr. 249 ...

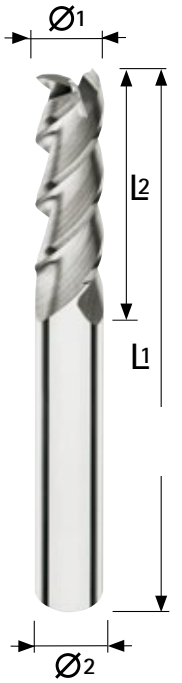


Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
1,00	4,00	3	50	3	249.010.00
1,20	4,00	4	50	3	249.012.00
1,50	4,00	4	50	3	249.015.00
1,80	4,00	5	50	3	249.018.00
2,00	4,00	6	50	3	249.020.00
3,00	6,00	8	50	3	249.030.00
4,00	6,00	10	50	3	249.040.00
5,00	6,00	13	50	3	249.050.00
6,00	6,00	15	50	3	249.060.00
8,00	8,00	20	60	3	249.080.00
10,00	10,00	25	75	3	249.100.00
12,00	12,00	30	75	3	249.120.00
16,00	16,00	42	104	3	249.160.00
20,00	20,00	52	104	3	249.200.00
25,00	25,00	62	125	3	249.250.00



VHM-Schlichtfräser / *Solid carbide finishing cutter*

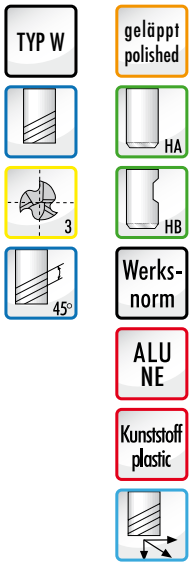
Artikel-Nr. 404 ...



Ø1	Ø2	L2	L1	Z	Artikel-Nr. *Article No.*
6,00	6,00	16	60	3	404.060...
8,00	8,00	25	78	3	404.080...
10,00	10,00	28	78	3	404.100...
12,00	12,00	32	89	3	404.120...
14,00	14,00	32	89	3	404.140...
16,00	16,00	36	96	3	404.160...
20,00	20,00	45	111	3	404.200...
25,00	25,00	50	121	3	404.250...

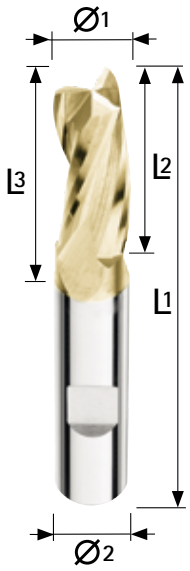
Bitte fügen Sie bei Ihrer Bestellung folgende Codes hinzu: mit Weldon .10 ohne weldon .00
Please add the following code to your order: with weldon .10 without weldon .00

Stirnwinkel x 2 für mehr Spanraum und weniger Schnittdruck.
Two face angles for more chip space and less cutting pressure.

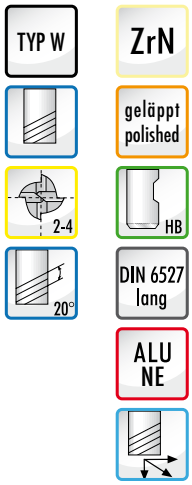


VHM-Schlichtfräser / *Solid carbide finishing cutter*

Artikel-Nr. 406 ...

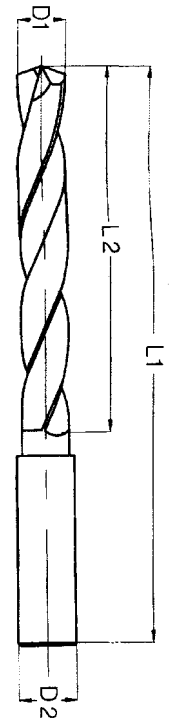


Ø1	Ø2	L2	L1	L3	Z	Artikel-Nr. *Article No.*
4,00	4,00	13	54	16	2	406.040.09
5,00	5,00	15	54	18	2	406.050.09
6,00	6,00	16	64	21	2	406.060.09
8,00	8,00	22	70	27	2	406.080.09
10,00	10,00	25	72	32	2	406.100.09
12,00	12,00	28	83	38	3	406.120.09
14,00	14,00	30	83	42	3	406.140.09
16,00	16,00	36	92	44	3	406.160.09
18,00	18,00	36	92	50	3	406.180.09
20,00	20,00	41	104	54	4	406.200.09
25,00	25,00	43	110	63	4	406.250.09

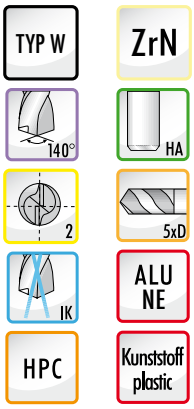


VHM-Spiralbohrer 5xD / *Solid carbide drill 5xD*

Artikel-Nr. 706 ...

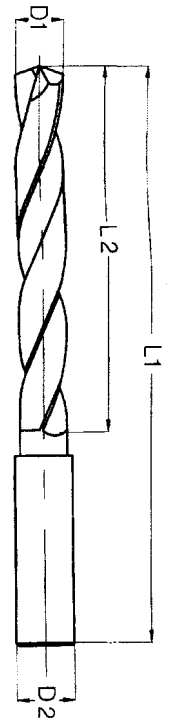


Ø1	Ø2	L2	L1	NL	Artikel-Nr. *Article No.*
3,00	6,00	28	66	23	706.030.00
3,10	6,00	28	66	23	706.031.00
3,20	6,00	28	66	23	706.032.00
3,30	6,00	28	66	23	706.033.00
3,40	6,00	28	66	23	706.034.00
3,50	6,00	28	66	23	706.035.00
3,60	6,00	28	66	23	706.036.00
3,70	6,00	28	66	23	706.037.00
3,80	6,00	36	74	29	706.038.00
3,90	6,00	36	74	29	706.039.00
4,00	6,00	36	74	29	706.040.00
4,10	6,00	36	74	29	706.041.00
4,20	6,00	36	74	29	706.042.00
4,30	6,00	36	74	29	706.043.00
4,40	6,00	36	74	29	706.044.00
4,50	6,00	36	74	29	706.045.00
4,60	6,00	36	74	29	706.046.00
4,70	6,00	36	74	29	706.047.00
4,80	6,00	44	82	35	706.048.00
4,90	6,00	44	82	35	706.049.00
5,00	6,00	44	82	35	706.050.00
5,10	6,00	44	82	35	706.051.00
5,20	6,00	44	82	35	706.052.00
5,30	6,00	44	82	35	706.053.00
5,40	6,00	44	82	35	706.054.00
5,50	6,00	44	82	35	706.055.00
5,60	6,00	44	82	35	706.056.00
5,70	6,00	44	82	35	706.057.00
5,80	6,00	44	82	35	706.058.00
5,90	6,00	44	82	35	706.059.00
6,00	6,00	44	82	35	706.060.00
6,10	8,00	53	91	43	706.061.00
6,20	8,00	53	91	43	706.062.00
6,30	8,00	53	91	43	706.063.00
6,40	8,00	53	91	43	706.064.00
6,50	8,00	53	91	43	706.065.00
6,60	8,00	53	91	43	706.066.00
6,70	8,00	53	91	43	706.067.00
6,80	8,00	53	91	43	706.068.00
6,90	8,00	53	91	43	706.069.00
7,00	8,00	53	91	43	706.070.00
7,10	8,00	53	91	43	706.071.00

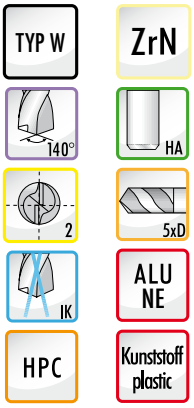


VHM-Spiralbohrer 5xD / *Solid carbide drill 5xD*

Artikel-Nr. 706 ...



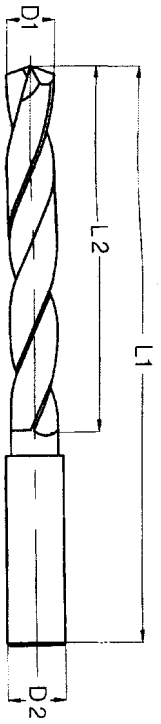
Ø1	Ø2	L2	L1	NL	Artikel-Nr. *Article No.*
7,20	8,00	53	91	43	706.072.00
7,30	8,00	53	91	43	706.073.00
7,40	8,00	53	91	43	706.074.00
7,50	8,00	53	91	43	706.075.00
7,60	8,00	53	91	43	706.076.00
7,70	8,00	53	91	43	706.077.00
7,80	8,00	53	91	43	706.078.00
7,90	8,00	53	91	43	706.079.00
8,00	8,00	53	91	43	706.080.00
8,10	10,00	61	103	49	706.081.00
8,20	10,00	61	103	49	706.082.00
8,30	10,00	61	103	49	706.083.00
8,40	10,00	61	103	49	706.084.00
8,50	10,00	61	103	49	706.085.00
8,60	10,00	61	103	49	706.086.00
8,70	10,00	61	103	49	706.087.00
8,80	10,00	61	103	49	706.088.00
8,90	10,00	61	103	49	706.089.00
9,00	10,00	61	103	49	706.090.00
9,10	10,00	61	103	49	706.091.00
9,20	10,00	61	103	49	706.092.00
9,30	10,00	61	103	49	706.093.00
9,40	10,00	61	103	49	706.094.00
9,50	10,00	61	103	49	706.095.00
9,60	10,00	61	103	49	706.096.00
9,70	10,00	61	103	49	706.097.00
9,80	10,00	61	103	49	706.098.00
9,90	10,00	61	103	49	706.099.00
10,00	10,00	61	103	49	706.100.00
10,10	12,00	71	118	56	706.101.00
10,20	12,00	71	118	56	706.102.00
10,30	12,00	71	118	56	706.103.00
10,40	12,00	71	118	56	706.104.00
10,50	12,00	71	118	56	706.105.00
10,60	12,00	71	118	56	706.106.00
10,70	12,00	71	118	56	706.107.00
10,80	12,00	71	118	56	706.108.00
10,90	12,00	71	118	56	706.109.00
11,00	12,00	71	118	56	706.110.00
11,10	12,00	71	118	56	706.111.00
11,20	12,00	71	118	56	706.112.00
11,30	12,00	71	118	56	706.113.00



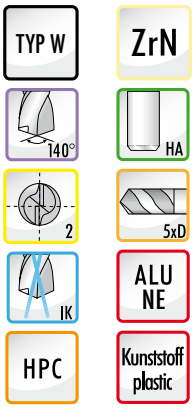
Fortsetzung nächste Seite / to be continued

VHM-Spiralbohrer 5xD / *Solid carbide drill 5xD*

Artikel-Nr. 706 ...



Ø1	Ø2	L2	L1	NL	Artikel-Nr. *Article No.*
11,40	12,00	71	118	56	706.114.00
11,50	12,00	71	118	56	706.115.00
11,60	12,00	71	118	56	706.116.00
11,70	12,00	71	118	56	706.117.00
11,80	12,00	71	118	56	706.118.00
11,90	12,00	71	118	56	706.119.00
12,00	12,00	71	118	56	706.120.00
12,20	14,00	77	124	60	706.122.00
12,30	14,00	77	124	60	706.123.00
12,50	14,00	77	124	60	706.125.00
12,80	14,00	77	124	60	706.128.00
13,00	14,00	77	124	60	706.130.00
13,50	14,00	77	124	60	706.135.00
13,80	14,00	77	124	60	706.138.00
14,00	14,00	77	124	60	706.140.00
14,50	16,00	83	133	63	706.145.00
14,80	16,00	83	133	63	706.148.00
15,00	16,00	83	133	63	706.150.00
15,50	16,00	83	133	63	706.155.00
15,80	16,00	83	133	63	706.158.00
16,00	16,00	83	133	63	706.160.00
16,50	18,00	93	143	71	706.165.00
16,80	18,00	93	143	71	706.168.00
17,00	18,00	93	143	71	706.170.00
17,50	18,00	93	143	71	706.175.00
17,80	18,00	93	143	71	706.178.00
18,00	18,00	93	143	71	706.180.00
18,50	20,00	101	153	77	706.185.00
19,00	20,00	101	153	77	706.190.00
19,50	20,00	101	153	77	706.195.00
20,00	20,00	101	153	77	706.200.00



Schnittwerte für / *Cutting Data for* Art.-Nr. 244/245/248/249/252/253/402/405/408/414/533

Werkstoffbezeichnung *Description of material*	Vc m/min	Ø 3-4	Ø 5-6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 20	Ø 25
Aluminium und AL Leg. bis 6%Si *Aluminium and aluminium alloys up to 6%Si*	500	0,035	0,06	0,06	0,07	0,07	0,09	0,12	0,18
Aluminium und AL Leg. bis 12%Si *Aluminium and aluminium alloys up to 12%Si*	350-450	0,035	0,06	0,06	0,07	0,07	0,09	0,12	0,18
Aluminium und AL Leg. über 12%Si *Aluminium and aluminium alloys over12%Si*	190-290	0,035	0,05	0,05	0,07	0,07	0,09	0,12	0,18
Kupfer / *copper*	135	0,02	0,04	0,04	0,06	0,06	0,08	0,12	0,18
Messing / *brass*	180-240	0,02	0,04	0,04	0,06	0,06	0,08	0,12	0,18
Bronze / *bronze*	150-170	0,02	0,04	0,04	0,06	0,06	0,08	0,12	0,18

a_e 1,0xD
a_p 1,0xD

Korrekturfaktor für überlange Werkzeuge 0,85 auf Vc / *Correction factor for extra long tools 0,85 at Vc*
Korrekturfaktor für unbeschichtete Werkzeuge 0,5 auf Vc / *Correction factor for uncoated tools 0,5 at Vc*

Schnittwerte für / *Cutting Data for* Art.-No. 246

Werkstoffbezeichnung *Description of material*	Vc m/min	Ø 3-4	Ø 5-6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 20	Ø 25
Aluminium und AL Leg. bis 6%Si *Aluminium and aluminium alloys up to 6%Si*	460	0,02	0,035	0,04	0,06	0,06	0,06	0,07	0,07
Aluminium und AL Leg. bis 12%Si *Aluminium and aluminium alloys up to 12%Si*	350-450	0,02	0,035	0,04	0,06	0,06	0,06	0,07	0,07
Aluminium und AL Leg. über 12%Si *Aluminium and aluminium alloys over12%Si*	180-230	0,015	0,035	0,04	0,05	0,05	0,05	0,07	0,07
Kupfer / *copper*	120	0,015	0,02	0,02	0,04	0,04	0,05	0,06	0,06
Messing / *brass*	130-220	0,015	0,02	0,02	0,04	0,04	0,05	0,06	0,06
Bronze / *bronze*	110-160	0,015	0,02	0,02	0,04	0,04	0,05	0,06	0,06

a_e max 0,05xD
a_p max. 2,0xD

Schnittwerte für / *Cutting Data for* Art.-No. 706

Werkstoffbezeichnung *Description of material*	Vc m/min	Ø 4-5	Ø6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 20
Aluminium und AL Leg. bis 6%Si *Aluminium and aluminium alloys up to 6%Si*	260	0,14	0,14	0,2	0,2	0,28	0,35	0,45
Aluminium und AL Leg. bis 12%Si *Aluminium and aluminium alloys up to 12%Si*	240	0,14	0,14	0,2	0,2	0,28	0,35	0,45
Aluminium und AL Leg. über 12%Si *Aluminium and aluminium alloys over12%Si*	160	0,14	0,14	0,2	0,2	0,28	0,35	0,45

Empfohlener Kühldruck sollte 40 bar betragen / *Recommended cooling pressure should be 40 bar*

Alle angegebenen Werte sind Richtwerte abhängig von der Werkstückaufspannung und den Maschinenverhältnissen!
All indicated values are standard values depending on work mounting and machine conditions!

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Main catalogue

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