

RRD



**Multifunktionales Werkzeugsystem
zum Schrappen bis hin zum Vorschlichten.**

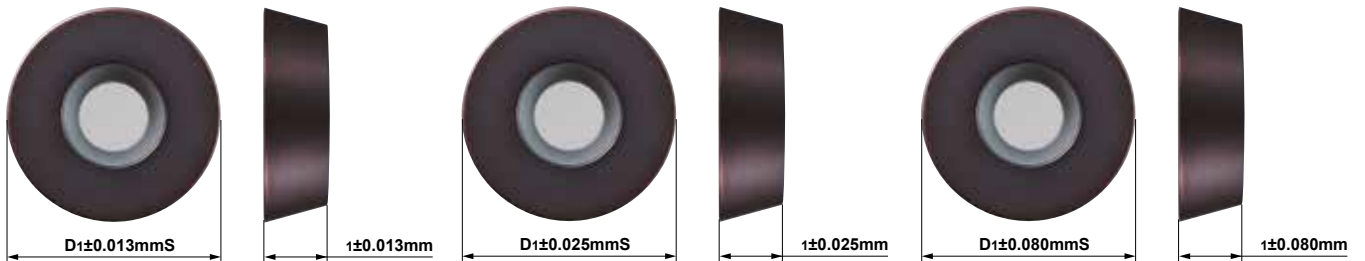


Fräser mit runden WSP

RRD

WSP-Auswahl

Präzisionsgesinterte Wendeschneidplatten in drei unterschiedlichen Toleranzen bieten Ihnen eine gezielte Auswahlmöglichkeit für Ihre Fräsanwendung.



RDHX

RDZX

RDMX

- Präzisionsgesintert (HToleranz)
- Präzisionsgesintert (EToleranz)
- Präzisionsgesintert (MToleranz)
- Für höchste Präzision
- Für hohe Präzisionsanforderungen
- Universell einsetzbar
- Ideal zum Vorschlichten und Schlichten
- Universell einsetzbar
- Ideal zum Schruppen bis hin zum Vorschlichten


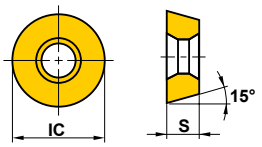

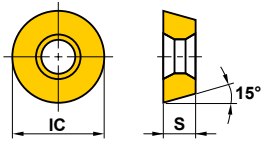

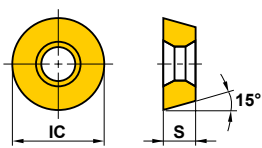
Sorten für das Fräsen mit dem RRD Fräser

ISOB	eschichtetes Hartmetall	Cermet VP beschichtet / Cermet	Hartmetall unbeschichtet	Schneidstoff
P Stahl	P01			↑ Verschleißfestigkeit ↓ Zähigkeit
	P10	VP05HT, VP10H	VP25N	
	P20	VP15TF, VP20M	NX4545	
	P30	VP20M, E7030		
	P40			
M Rostfreier Stahl	M01			
	M10	VP15TF	VP25N	
	M20	VP20M	NX4545	
	M30	VP20M, E7030		
	M40			
K Gussisen	K01			
	K10		VP25N	
	K20	VP15TF		
	K30			
H Gehärteter Stahl	H01	VP05HT, VP10H		
	H10	VP15TF		
	H20			
	H30			

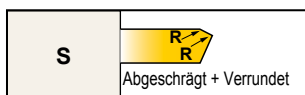
RRD Fräserausführungen



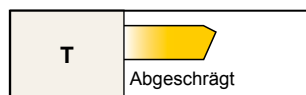
WSP

Werkstoff	P	Stahl	● ● ● ● ●					● ● ● ● ●		Schnittbedingungen (Hinweis): ●: Stabile Bearbeitung ●: Allgemeine Bearbeitung ✖: Instabile Bearbeitung			
	M	Rostfreier Stahl	● ● ● ● ●					● ● ● ● ●					
Form	K	Guss	✖ ✖ ✖ ✖ ✖					✖ ✖ ✖ ✖ ✖		Verfassung: E: Verrundet S: Abgeschrägt + Verrundet T: Abgeschrägt			
	S	Hitzebeständige Legierungen, Titanlegierungen	● ● ● ● ●					● ● ● ● ●					
Form	H	Gehärtete Materialien	● ● ● ● ●					● ● ● ● ●		Abmessungen (mm)			
	Bestellbezeichnung		Klasse	Verfassung	Beschichtet						Hartmetall	IC	S
				F7030	VP15TF	VP20M	VP10H	VP05HT	UTi20T				
	RDHX0501M0E		H	E	●	●	●	●	●		5	1.5	
	RDHX0501M0S		H	S	●	●	●	●	●	●	5	1.5	
	RDHX07T1M0E		H	E	●	●	●	●	●		7	1.98	
	RDHX07T1M0S		H	S	●	●	●	●	●	□	7	1.98	
	RDHX0702M0E		H	E	●	●	●	●	●		7	2.38	
	RDHX0702M0S		H	S	●	●	●	●	●	□	7	2.38	
	RDHX1003M0E		H	E	●	●	●	●	●		10	3.18	
	RDHX1003M0S		H	S	●	●	●	●	●	□	10	3.18	
	RDHX12T3M0E		H	E	●	●	●	●	●		12	3.97	
	RDHX12T3M0S		H	S	●	●	●	●	●	□	12	3.97	
	RDHX1604M0E		H	E	●	●	●	●	●		16	4.76	
	RDHX1604M0S		H	S	●	●	●	●	●	□	16	4.76	
	RDMX07T1M0E		M	E					●		7	1.98	
	RDMX07T1M0T		M	T	●	●	●	●	●	□	7	1.98	
	RDMX0702M0E		M	E					●		7	2.38	
	RDMX0702M0T		M	T	●	●	●	●	●	□	7	2.38	
	RDMX1003M0E		M	E					●		10	3.18	
	RDMX1003M0S		M	S	●	●	●	●	●		10	3.18	
	RDMX1003M0T		M	T	●	●	●	●	●	●	10	3.18	
	RDMX12T3M0E		M	E					●		12	3.97	
	RDMX12T3M0S		M	S	●	●	●	●	●		12	3.97	
	RDMX12T3M0T		M	T	●	●	●	●	●	●	12	3.97	
	RDMX1604M0E		M	E					●		16	4.76	
	RDMX1604M0S		M	S	●	●	●	●	●		16	4.76	
RDMX1604M0T		M	T	●	●	●	●	●	●	16	4.76		
											IC: ±0.013 mm S: ±0.013 mm		
	RDZX0501M0E		Z	E	●						5	1.50	
	RDZX0501M0S		Z	S	●						5	1.50	
	RDZX07T1M0E		Z	E	●						7	1.98	
	RDZX07T1M0S		Z	S	●						7	1.98	
	RDZX0702M0E		Z	E	●						7	2.38	
	RDZX0702M0S		Z	S	●						7	2.38	
	RDZX1003M0E		Z	E	●						10	3.18	
	RDZX1003M0S		Z	S	●	●					10	3.18	
	RDZX12T3M0E		Z	E	●						12	3.97	
	RDZX12T3M0S		Z	S	●	●					12	3.97	
	RDZX1604M0E		Z	E	●						16	4.76	
	RDZX1604M0S		Z	S	●	●					16	4.76	
											IC: ±0.025 mm S: ±0.025 mm		

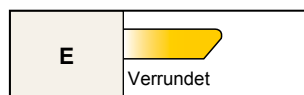
Schneidkantenausführung



Schrappverfassung



Schrapp- Schlichtverfassung



Schlichtverfassung

● : Lagerstandard. □ : Herstellung nur auf Anfrage.

MULTIFUNKTIONALES FRÄSEN

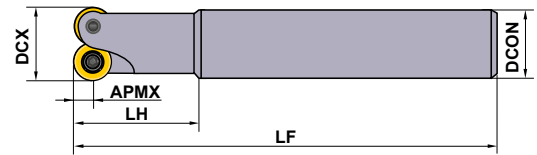
RRD



Schuppen



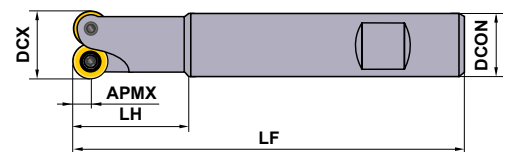
P M K N S H



ZYLINDERSCHAFT

Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager		Abmessungen (mm)					Spanschraube	Schlüssel	WSP
		R	Zähnezahl	DCX	DCON	LF	LH	APMX			
2.5	RRD025R102S10Z-B20	●	2	10	10	75	23	2.5	B-TS20	TKY06F	RDH/Z 0501M0
	RRD025R123S12Z-B20	●	3	12	12	75	23	2.5	B-TS20	TKY06F	
	RRD025R154S16Z-B20	●	4	15	16	80	23	2.5	B-TS20	TKY06F	
3.5	RRD035R122S10Z	●	2	12	10	75	23	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S12Z	●	2	12	12	75	23	3.5	B-TS253	TKY07F	
	RRD035R122S16Z	●	2	12	16	88	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16ZM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16Z	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16ZM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20Z	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20ZM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25Z	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S12Z	●	3	15	12	75	17	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
	RRD035R153S16Z	●	3	15	16	78	30	3.5	TS253	TKY08F	
5	RRD050R202S20Z	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20ZM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25Z	●	2	20	25	136	72	5.0	B-TS35	TKY15F	
	RRD050R202S25ZL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25ZM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	



WELDONSCHAFT

Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager		Abmessungen (mm)					Spanschraube	Schlüssel	WSP
		R	Zähnezahl	DCX	DCON	LF	LH	APMX			
3.5	RRD035R122S16W	●	2	12	16	88	15	3.5	B-TS253	TKY07F	RDH/M/Z 07T1M0
	RRD035R122S16WL	●	2	12	16	128	15	3.5	B-TS253	TKY07F	
	RRD035R122S16WM	●	2	12	16	108	15	3.5	B-TS253	TKY07F	
3.5	RRD035R152S16W	●	2	15	16	88	18	3.5	TS25	TKY08F	RDH/M/Z 0702M0
	RRD035R152S16WM	●	2	15	16	108	18	3.5	TS25	TKY08F	
	RRD035R152S20W	●	2	15	20	130	20	3.5	TS25	TKY08F	
	RRD035R152S20WM	●	2	15	20	150	20	3.5	TS25	TKY08F	
	RRD035R152S25W	●	2	15	25	176	20	3.5	TS25	TKY08F	
3.5	RRD035R153S16W	●	3	15	16	78	30	3.5	TS253	TKY08F	RDH/M/Z 07T1M0
5	RRD050R202S20W	●	2	20	20	90	31	5.0	B-TS35	TKY15F	RDH/M/Z 1003M0
	RRD050R202S20WM	●	2	20	20	110	51	5.0	B-TS35	TKY15F	
	RRD050R202S25W	●	2	20	25	135	72	5.0	B-TS35	TKY15F	
	RRD050R202S25WL	●	2	20	25	176	112	5.0	B-TS35	TKY15F	
	RRD050R202S25WM	●	2	20	25	156	92	5.0	B-TS35	TKY15F	

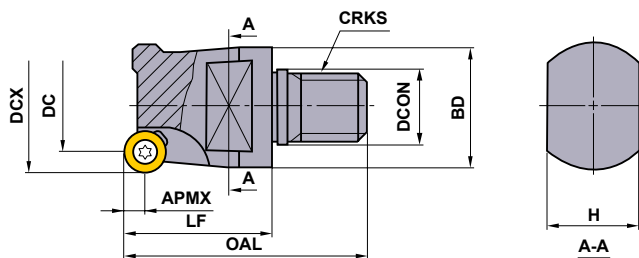
● : Lagerstandard.

MULTIFUNKTIONALES FRÄSEN

RRD



Schruppen



EINSCHRAUBFRÄSER

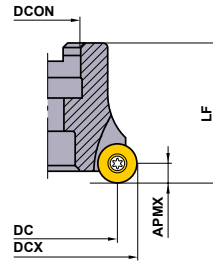
Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager Zähnezahl	Abmessungen (mm)									Spannschraube	Spannschraube	Schlüssel	WSP
			DCX	DC	OAL	LF	DCON	BD	CRKS	APMX	H				
2.5	RRD025R102M5-B20	● 2	10	5	35	20	5.5	9.9	M5	2.5	6	B-TS20	—	TKY06F	RDH/Z 0501M0
	RRD025R123M8-B20	● 3	12	7	38	20	8.5	13.5	M8	2.5	9	B-TS20	—	TKY06F	
	RRD025R154M8-B20	● 4	15	10	38	20	8.5	13.5	M8	2.5	10	B-TS20	—	TKY06F	
	RRD025R205M10-B20	● 5	20	15	44	25	10.5	18	M10	2.5	15	B-TS20	—	TKY06F	
3.5	RRD035R122M8	● 2	12	5	46	28	8.5	13.5	M8	3.5	9	B-TS253	—	TKY07F	RDH/M/Z 07T1M0
	RRD035R153M8	● 3	15	8	46	28	8.5	13.5	M8	3.5	10	TS253	—	TKY08F	
	RRD035R204M10	● 4	20	13	47	28	10.5	18	M10	3.5	15	TS253	—	TKY08F	
	RRD035R255M12	● 5	25	18	50	28	12.5	21	M12	3.5	17	TS253	—	TKY08F	
	RRD035R306M16	● 6	30	23	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
	RRD035R357M16	● 7	35	28	51	28	17	29	M16	3.5	22	TS253	—	TKY08F	
3.5	RRD035R152M8	● 2	15	8	46	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	RDH/M/Z 0702M0
	RRD035R153M8X	● 3	15	8	43	28	8.5	13.5	M8	3.5	10	TS25	—	TKY08F	
5	RRD050R202M10	● 2	20	10	47	28	10.5	18	M10	5.0	15	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	RRD050R252M12	● 2	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R253M12	● 3	25	15	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M12	● 4	30	20	54	32	12.5	21	M12	5.0	17	B-TS35	—	TKY15F	
	RRD050R304M16	● 4	30	20	55	32	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R355M16	● 5	35	25	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
	RRD050R426M16	● 6	42	32	65	42	17	29	M16	5.0	22	B-TS35	—	TKY15F	
6	RRD060R242M12	● 2	24	12	54	32	12.5	21	M12	6.0	17	B-TS35	—	TKY15F	RDH/M/Z 12T3M0
	RRD060R353M16	● 3	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R354M16	● 4	35	23	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
	RRD060R424M16	● 4	42	30	55	32	17	29	M16	6.0	24	B-TS35	TS1001	TKY15F	
	RRD060R425M16	● 5	42	30	65	42	17	29	M16	6.0	22	B-TS35	TS1001	TKY15F	
8	RRD080R322M16	● 2	32	16	65	42	17	29	M16	8.0	22	214	—	TKY20F	RDH/M/Z 1604M0

(Bemerkung) Für Verlängerungen und Aufnahmensiehe Seite K144–K145.

MULTIFUNKTIONALES FRÄSEN

RRD N



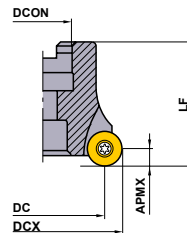
AUFSTECKFRÄSER (Neutral)

Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager R	Zähnezahl	Abmessungen (mm)					* WT (kg)	Zubehör					
				DCX	DC	LF	DCON	APMX		Unterlegplatte	Schr. f. U-platte	Spannschraube	Spannschraube	Schlüssel	WSP
5	RRD050N-042A06R	●	6	42	32	44	16	5	0.26	—	—	B-TS35	—	TKY15F	RDH/M/Z 1003M0
	RRD050N-052A07R	●	7	52	42	50	22	5	0.4	—	—	B-TS35	—	TKY15F	
6	RRD060N-042A05R	●	5	42	30	42	16	6	0.26	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0
	RRD060N-050A05R	●	5	50	38	50	22	6	0.38	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-052A05R	●	5	52	40	50	22	6	0.4	—	—	B-TS35	TS1001	TKY15F	
	RRD060N-063A06R	●	6	63	51	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	
8	RRD080N-050A04R	●	4	50	34	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080N-052A04R	●	4	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-052A05R	●	5	52	36	50	22	8	0.4	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-063A05R	●	5	63	47	50	22	8	0.58	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-066A05R	●	5	66	50	50	27	8	0.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-080A06R	●	6	80	64	52	27	8	1	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080N-125B08R	●	8	125	109	52	40	8	2.5	KS-12	B-TS45	214	—	TKY20F	
RRD080N-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F		

* WT : Werkzeuggewicht

RRD P



AUFSTECKFRÄSER (Positiv)

Nur Rechtsausführung.

R (mm)	Bestellbezeichnung	Lager R	Zähnezahl	Abmessungen (mm)					* WT (kg)	Zubehör					
				DCX	DC	LF	DCON	APMX		Unterlegplatte	Schr. f. U-platte	Spannschraube	Spannschraube	Schlüssel	WSP
6	RRD060P-050A05R	●	5	50	38	50	22	6	0.33	—	—	B-TS35	TS1001	TKY15F	RDH/M/Z 12T3M0E
	RRD060P-052A05R	●	5	52	40	50	22	6	0.35	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-063A06R	●	6	63	51	50	22	6	0.58	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-066A06R	●	6	66	54	52	27	6	0.6	—	—	B-TS35	TS1001	TKY15F	
	RRD060P-080A07R	●	7	80	68	50	27	6	1.0	—	—	B-TS35	TS1001	TKY15F	
8	RRD080P-050A04R	●	4	50	34	50	22	8	0.33	KS-12	B-TS45	214	—	TKY20F	RDH/M/Z 1604M0
	RRD080P-063A05R	●	5	63	47	50	22	8	0.53	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-066A05R	●	5	66	50	50	27	8	0.55	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-080A06R	●	6	80	64	52	27	8	1.0	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-100A07R	●	7	100	84	52	32	8	1.5	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-125B08R	●	8	125	109	52	40	8	2.6	KS-12	B-TS45	214	—	TKY20F	
	RRD080P-160C09R	●	9	160	144	52	40	8	3.5	KS-12	B-TS45	214	—	TKY20F	

* WT : Werkzeuggewicht

● : Lagerstandard.

SCHNITTDATENEMPFEHLUNGEN

SCHNITTDATEN FÜR DAS SCHRUPPEN (ae = 50 % des Ø)

Werkstoff	Härte	Sorte	Schnittgeschw. (m/min)	Ø10–15mm		Ø20mm		Ø24–25mm		Ø30–42mm		Ø50–80mm		Ø100–160mm		
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	
P Allg. Baustahl	≤180HB	NX4545 F7030 VP15TF	(250–320)	–0.2	0.25	–0.5	0.45	–1.0	0.35	–1.0	0.40	–1.0	0.50	–1.5	0.60	
			(240–300)	0.2–0.3	0.20	0.5–1.0	0.25	1.0–2.0	0.30	1.5–2.0	0.32	1.0–1.5	0.40	1.5–2.5	0.45	
			(200–280)	0.3–0.5	0.12	1.0–1.5	0.15	2.0–2.5	0.20	2.0–3.0	0.25	1.5–3.0	0.35	2.5–5.0	0.35	
	C-Stahl Leg. Stahl	180–350HB	NX4545 F7030 VP15TF	(220–300)	–0.2	0.20	–0.5	0.40	–1.0	0.30	–1.0	0.40	–1.0	0.50	–1.5	0.55
				(200–290)	0.2–0.3	0.15	0.5–1.0	0.20	1.0–1.5	0.25	1.5–2.0	0.30	1.0–1.5	0.38	1.5–2.5	0.40
				(160–250)	0.3–0.5	0.10	1.0–1.5	0.10	1.5–2.0	0.22	2.0–3.0	0.22	1.5–3.0	0.30	2.5–4.5	0.32
M Rostfreier Stahl	≤270HB	F7030 VP20M	(180–240)	–0.1	0.15	–0.5	0.20	–1.0	0.20	–1.0	0.25	–1.0	0.25	–1.5	0.30	
			(160–200)	0.1–0.2	0.15	0.5–1.0	0.15	1.0–2.0	0.18	1.5–2.0	0.20	1.0–1.5	0.22	1.5–2.5	0.25	
			(140–180)	0.2–0.25	0.10	1.0–1.5	0.12	2.0–2.5	0.14	2.0–3.0	0.15	1.5–3.0	0.18	2.5–5.0	0.20	
K Guss	Zugfestigkeit ≤450MPa	VP15TF VP20M VP10H	(200–250)	–0.1	0.15	–0.5	0.18	–1.0	0.20	–1.0	0.25	–1.0	0.30	–1.5	0.35	
			(180–230)	0.1–0.2	0.10	0.5–1.0	0.10	1.0–1.5	0.15	1.5–2.0	0.18	1.0–1.5	0.25	1.5–2.5	0.22	
			(160–200)	0.2–0.25	0.10	1.0–1.5	0.10	1.5–2.0	0.12	2.0–3.0	0.15	1.5–3.0	0.18	2.5–4.5	0.20	
H Gehärteter Stahl	–52HRC –58HRC –60HRC	VP15TF VP10H VP05HT	(140–200)	–0.1	0.12	–0.1	0.14	–0.1	0.15	–0.1	0.18	–0.1	0.18	–0.1	0.20	
			(110–180)	0.1–0.15	0.10	0.1–0.20	0.12	0.1–0.30	0.12	0.1–0.30	0.14	0.1–0.30	0.14	0.1–0.30	0.15	
			(100–170)	0.1–0.15	0.10	0.1–0.20	0.10	0.1–0.30	0.10	0.1–0.30	0.12	0.1–0.30	0.12	0.1–0.30	0.12	

(Bemerkung 1) Beim Fräsen mit voller Zustellung reduzieren Sie bitte die Schnittparameter um 20%.

(Bemerkung 2) Beim Fräsen mit langer Auskrugung reduzieren Sie bitte den Vorschub um 20%.

SCHNITTDATEN FÜR DAS SCHLICHTEN (ae = 20 % des Ø)

Werkstoff	Härte	Sorte	Schnittgeschw. (m/min)	Ø10–15mm		Ø20mm		Ø24–25mm		Ø30–42mm		Ø50–80mm		Ø100–160mm		
				ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	ap (mm)	fz (mm)	
P Allg. Baustahl	≤180HB	NX4545 F7030 VP15TF	(260–360)	–0.1	0.15	–0.15	0.20	–0.15	0.25	–0.15	0.30	–0.15	0.32	–0.3	0.35	
			(240–320)	0.1–0.2	0.15	0.1–0.2	0.15	0.1–0.2	0.18	0.1–0.3	0.20	0.1–0.3	0.22	0.2–0.3	0.25	
			(220–280)	0.2–0.24	0.10	0.1–0.30	0.15	0.1–0.30	0.18	0.1–0.30	0.20	0.2–0.30	0.20	0.3–0.40	0.20	
	C-Stahl Leg. Stahl	180–350HB	NX4545 F7030 VP15TF	(250–350)	–0.1	0.12	–0.1	0.15	–0.1	0.18	–0.1	0.25	–0.1	0.28	–0.15	0.30
				(230–310)	0.1–0.15	0.12	0.1–0.30	0.15	0.1–0.30	0.15	0.1–0.30	0.20	0.1–0.3	0.22	0.15–0.3	0.25
				(210–270)	0.15–0.2	0.10	0.15–0.30	0.12	0.15–0.30	0.15	0.15–0.30	0.15	0.2–0.3	0.18	0.2–0.3	0.18
M Rostfreier Stahl	≤270HB	F7030 VP20M	(180–240)	–0.1	0.12	–0.1	0.18	–0.1	0.20	–0.1	0.22	–0.1	0.25	–0.15	0.30	
			(160–200)	0.1–0.2	0.10	0.1–0.30	0.12	0.1–0.3	0.15	0.1–0.3	0.18	0.1–0.3	0.20	0.15–0.3	0.22	
			(140–180)	0.2–0.25	0.10	0.2–0.30	0.10	0.2–0.3	0.12	0.2–0.3	0.12	0.2–0.3	0.15	0.2–0.3	0.18	
K Guss	Zugfestigkeit ≤450MPa	VP15TF VP20M VP10H	(200–300)	–0.1	0.15	–0.1	0.18	–0.1	0.20	–0.1	0.22	–0.1	0.25	–0.15	0.30	
			(200–280)	0.1–0.2	0.10	0.1–0.30	0.10	0.1–0.3	0.15	0.1–0.3	0.15	0.1–0.3	0.20	0.15–0.3	0.22	
			(180–240)	0.2–0.25	0.10	0.2–0.40	0.10	0.2–0.4	0.12	0.2–0.4	0.12	0.2–0.4	0.15	0.2–0.4	0.18	
H Gehärteter Stahl	–52HRC –58HRC –60HRC	VP15TF VP10H VP05HT	(150–200)	–0.1	0.15	–0.1	0.14	–0.1	0.15	–0.1	0.18	–0.1	0.18	–0.1	0.20	
			(120–180)	0.1–0.15	0.10	0.1–0.20	0.12	0.1–0.30	0.12	0.1–0.30	0.14	0.1–0.30	0.14	0.1–0.30	0.15	
			(100–180)	0.1–0.15	0.10	0.1–0.20	0.10	0.1–0.30	0.10	0.1–0.30	0.12	0.1–0.30	0.12	0.1–0.30	0.12	

(Bemerkung 1) Beim Fräsen mit voller Zustellung reduzieren Sie bitte die Schnittparameter um 20%.

(Bemerkung 2) Beim Fräsen mit langer Auskrugung reduzieren Sie bitte den Vorschub um 20%.



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