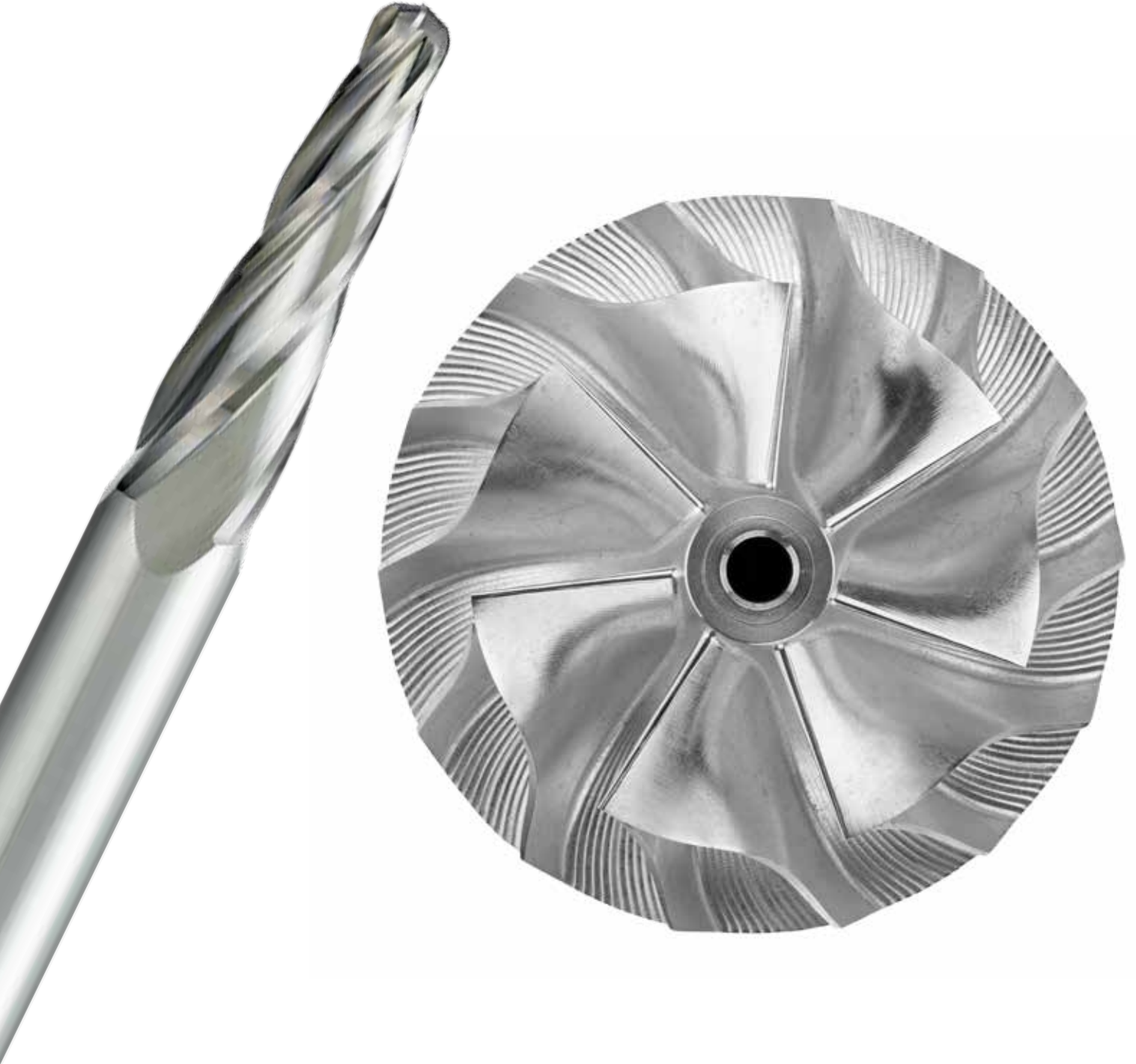


# C4LATB

KONİK KÜRE UÇLU YEKPARE KARBÜR FREZE  
ALÜMİNYUM ALAŞIMLARININ İŞLENMESİNDE  
YÜKSEK VERİMLİLİK

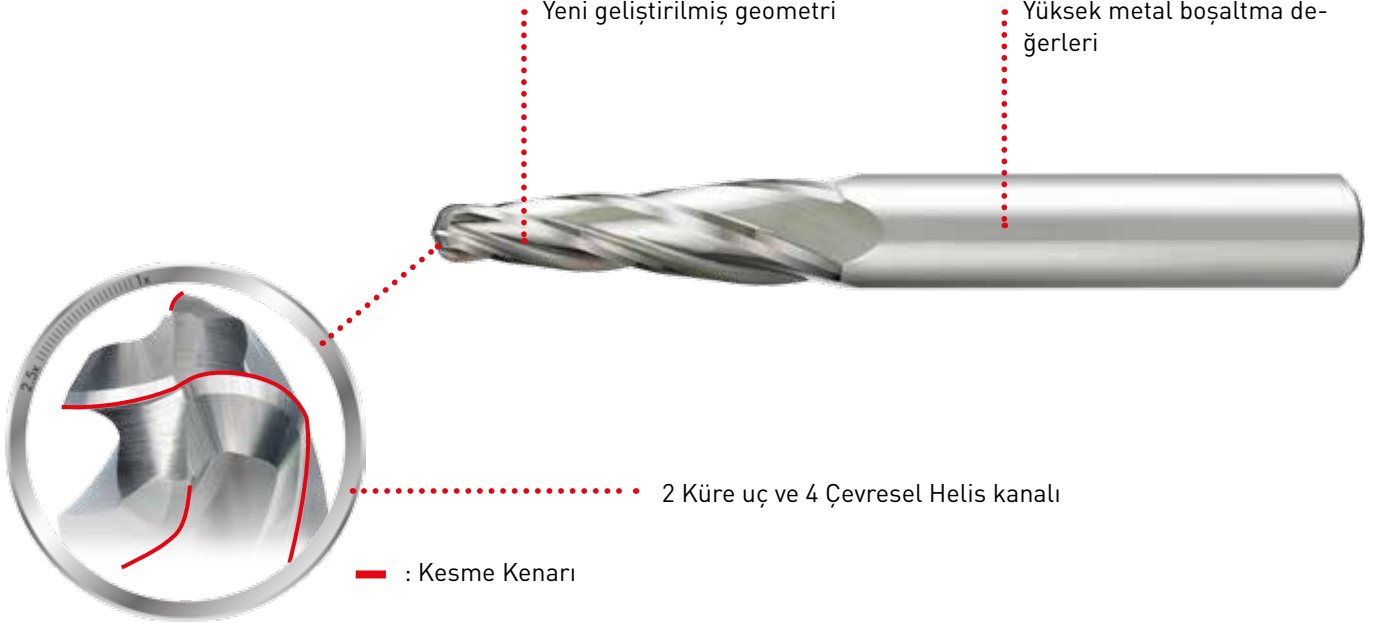


**DIAEDGE**

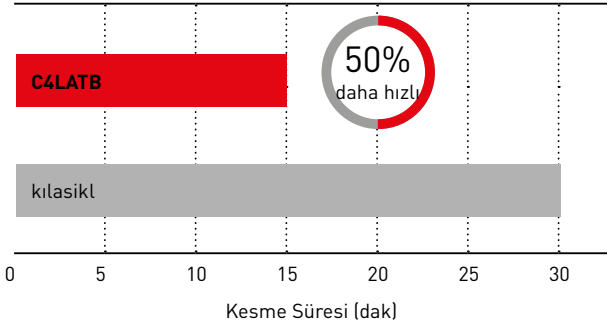
 **MITSUBISHI MATERIALS**

# C4LATB

## ALÜMİNYUM ALAŞIMLARININ İŞLENMESİNDE YÜKSEK VERİMLİLİK



## UYGULAMA ÖRNEĞİ / KESME PERFORMANSI

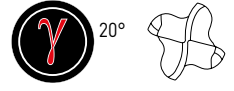


Malzeme	Alüminyum Alaşımları
Takım	C4LATBR200T040AP30
Devir n (dak <sup>-1</sup> )	25.000
İlerleme Hızı Vf (mm/min)	5.600
Diş başına ilerleme fz (mm/t)	0.056 Maks.
Kesme Derinliği ap (mm)	8 (Kanal açma) 22 (Kenar frezeleme Finiş işleme)
Soğutma Sıvısı	Emülsiyon, Dışarıdan Soğutma

Ø 91 x Ø 66 x 36 (h)



# C4LATB



N



RE<2

± 0.010

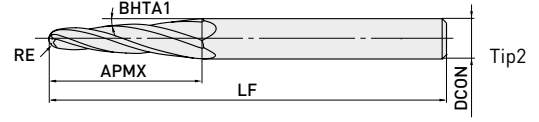
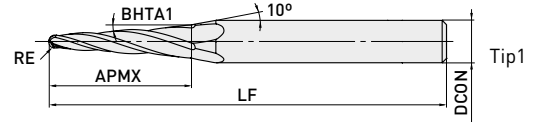


±5'



DCON = 6 DCON = 8

h6 0 - 0.008 0 - 0.009




Sipariş Numarası	RE	BHTA1	APMX	LF	DCON	ZEFP	Stok	Tip
<b>NEW</b> C4LATBR050T040AP20	0.5	4°	20	70	6	4	●	1
<b>NEW</b> C4LATBR100T040AP20	1	4°	20	70	6	4	●	1
<b>NEW</b> C4LATBR150T040AP20	1.5	4°	20	75	8	4	●	1
<b>NEW</b> C4LATBR200T040AP30	2	4°	30	75	8	4	●	2

Modifiye edilmiş ve özel tasarım konik küre uçlu frezeler temin edilir. Lütfen ayrıntılar için Mitsubishi tedarikciniz ile irtibat kurunuz.

# ÖNERİLEN KESME ŞARTLARI

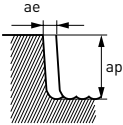
## KANAL AÇMA

		N		
Malzeme	Alimiyum Alaşımları			
RE	n (min <sup>-1</sup> )	Vf (mm/min)	ap (mm)	
R 0.5	20.000	600	10	
R 1	20.000	2.800	10	
R 1.5	20.000	4.000	10	
R 2	20.000	4.000	15	



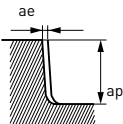
## KENAR FREZELEME

		N			
Malzeme	Alimiyum Alaşımları				
RE	n (min <sup>-1</sup> )	Vf (mm/min)	ap (mm)	ae (mm)	
R 0.5	20.000	2.000	15	0.75	
R 1	20.000	4.000	15	1.5	
R 1.5	20.000	5.200	15	2.25	
R 2	20.000	5.200	23	3	



## KENAR FREZELEME (FİNİŞ İŞLEME)

		N			
Malzeme	Alimiyum Alaşımları				
RE	n (min <sup>-1</sup> )	Vf (mm/min)	ap (mm)	ae (mm)	
R 0.5	20.000	800	18	0.1	
R 1	20.000	2.000	18	0.2	
R 1.5	20.000	2.400	18	0.3	
R 2	20.000	2.400	27	0.3	



1. Suda çözünebilir kesme sıvısı önerilir.  
Kenar frezeleme için aşağıdan kesme önerilir.



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# NOTLAR

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# NOTLAR

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# NOTLAR

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