

Table with 2 columns: Härte (Rm < 450, Rm 450-700, Rm 700-900, Rm 900-1200) and Gruppe (1a, 1b, 1c, 1d).

1 Bearbeitungs-Typ

2 Werkstoffe Gruppe p. III-IV

3 Empfohlene Werkzeuge

4 Anwendungsparameter

Schruppfräsen / Umfangfräsen

Table with 2 columns: Gruppe Index p. III-IV (1a, 1b, 1c, 1d) and Empfohlene Referenz (115-1, 1510-1540/102/..., 115-1, 1510-1540/102/..., 115-1, 1510-1540/102/..., 115-1, 1510-1540/102/...).

Table with 2 columns: Empfohlene Beschichtungen (Trio) and Empfohlene Beschichtungen (Trio).

Table with 15 columns: Vc unbeschichtet [m/min], Vc beschichtet [m/min], Fz Ø 0.25 [mm], Fz Ø 0.5 [mm], Fz Ø 1 [mm], Fz Ø 2 [mm], Fz Ø 4 [mm], Fz Ø 6 [mm], Fz Ø 8 [mm], Fz Ø 10 [mm], Fz Ø 12 [mm], Fz Ø 16 [mm], Fz Ø 20 [mm].

Schlichtfräsen / Umfangfräsen

Table with 2 columns: Gruppe Index p. III-IV (1a, 1b, 1c, 1d) and Empfohlene Referenz (1620, 1510-1540/102/..., 1620, 1510-1540/102/..., 1620, 1510-1540/102/..., 1620).

Table with 2 columns: Empfohlene Beschichtungen (Trio) and Empfohlene Beschichtungen (Trio).

Table with 15 columns: Vc unbeschichtet [m/min], Vc beschichtet [m/min], Fz Ø 0.25 [mm], Fz Ø 0.5 [mm], Fz Ø 1 [mm], Fz Ø 2 [mm], Fz Ø 4 [mm], Fz Ø 6 [mm], Fz Ø 8 [mm], Fz Ø 10 [mm], Fz Ø 12 [mm], Fz Ø 16 [mm], Fz Ø 20 [mm].

Zentrieren

Table with 2 columns: Gruppe Index p. III-IV (1a, 1b, 1c, 1d) and Empfohlene Referenz (337, 337, 337, 337).

Table with 2 columns: Empfohlene Beschichtungen (Trio) and Empfohlene Beschichtungen (Trio).

Table with 4 columns: Vc unbeschichtet [m/min], Vc beschichtet [m/min], F [mm], Entspannvorgang.

Bohren

Table with 2 columns: Gruppe Index p. III-IV (1a, 1b, 1c, 1d) and Empfohlene Referenz (339/340/343-6-343-12/352, 340/343-6-343-12/352, 340/340-1/343-6-343-12/352, 3340/343-6-343-12/348/352).

Table with 2 columns: Empfohlene Beschichtungen (Nemo) and Empfohlene Beschichtungen (Nemo).

Table with 4 columns: Vc unbeschichtet [m/min], Vc beschichtet [m/min], F [mm], Entspannvorgang.

Sägen/Trennen

Table with 2 columns: Gruppe Index p. III-IV (1a, 1b, 1c, 1d) and Empfohlene Referenz (223-223-2/226/227, 223-223-2/226/227, 223-223-2/226/227, 223-223-2/226/227).

Table with 2 columns: Empfohlene Beschichtungen (Trio) and Empfohlene Beschichtungen (Trio).

Table with 3 columns: Vc unbeschichtet [m/min], Vc beschichtet [m/min], Fz [mm].

Gravieren

Table with 2 columns: Gruppe Index p. III-IV (1a, 1b, 1c, 1d) and Empfohlene Referenz (119/119-3/119-4, 119/119-3/119-4, 119/119-3/119-4, 119/119-3/119-4).

Table with 2 columns: Empfohlene Beschichtungen (Hot) and Empfohlene Beschichtungen (Hot).

Table with 3 columns: n [rpm], Fz [mm], Fz-> [mm].

Formeln: F = Fz * Z, Vc = pi * d1 * n / 1000, Vf = Fz * Z * n, n = Vc * 1000 / (pi * d1), fz = Vf / (Z * n). Zeichenerklärung: F [mm]: Vorschub pro Umdrehung, Fz [mm]: Vorschub pro Zahn, Z: Anzahl Zähne, n: Drehzahl, Vc [mm/min]: Vorschubgeschwindigkeit.

Table with 4 columns: N° Wsn, DIN, AFNOR, Gr. (1.0033, 1.0037, 1.0038, 1.0044, 1.0050, 1.0060, 1.0070, 1.0114, 1.0116, 1.0143, 1.0301, 1.0401, 1.0402, 1.0406, 1.0501, 1.0503, 1.0511, 1.0553, 1.0570, 1.0601, 1.0715, 1.0718, 1.0721, 1.0722, 1.0726, 1.0727, 1.0728, 1.0736, 1.0737, 1.0904, 1.0961, 1a121, 1a133, 1a141, 1a141, 1a151, 1a157, 1a158, 1a16, 1a165, 1a167, 1a17, 1a178, 1a179, 1a181, 1a186, 1a189, 1a191, 1a193, 1a206, 1a221, 1a231, 1a248, 1a274, 1a525, 1a545, 1a625, 1a645, 1a663).

Table with 4 columns: N° Wsn, DIN, AFNOR, Gr. (1a673, 1a73, 1a74, 1a83, 1b067, 1b08, 1b162, 1b21, 1b33, 1b332, 1b343, 1b344, 1b363, 1b365, 1b379, 1b419, 1b51, 1b516, 1b55, 1b567, 1b581, 1b706, 1b711, 1b713, 1b735, 1b767, 1b833, 1b842, 1c207, 1c243, 1c246, 1c247, 1c255, 1c342, 1c343, 1c344, 1c346, 1c348, 1c355, 1d027, 1d742, 1d762, 1d943, 1.5026, 1.5415, 1.5680, 1.5710, 1.5732, 1.5736, 1.5736, 1.5752, 1.5755, 1.5919, 1.5920, 1.6511, 1.6523, 1.6526, 1.6545).

Table with 4 columns: N° Wsn, DIN, AFNOR, Gr. (1.6546, 1.6580, 1.6582, 1.6587, 1.6746, 1.7003, 1.7006, 1.7033, 1.7034, 1.7035, 1.7039, 1.7045, 1.7131, 1.7139, 1.7139 Pb, 1.7147, 1.7176, 1.7213, 1.7218, 1.7220, 1.7223, 1.7225, 1.7226, 1.7227, 1.7262, 1.7264, 1.7335, 1.7337, 1.7361, 1.7380, 1.7709, 1.7711, 1.7735, 1.8159, 1.8507, 1.8509, 1.8515, 1.8523).

Table with 4 columns: N° Wsn, DIN, AFNOR, Gr. (Böhler M200, Böhler M238, Böhler Resist440, Böhler S600, Böhler V155, Böhler V320, Böhler V930, Böhler V945, Böhler W300, Böhler W302, Böhler W720, Haba EC80, Matthey H1 dur).

Stähle nach Hersteller

Table with 4 columns: N° Wsn, DIN, AFNOR, Gr. (Böhler E110, Böhler E200, Böhler E410, Böhler F550, Böhler K100, Böhler K105, Böhler K107, Böhler K110, Böhler K110, Böhler K190, Böhler K245, Böhler K305, Böhler K455, Böhler K460, Böhler K510, Böhler K600, Böhler K720, Böhler M100, Böhler M130).