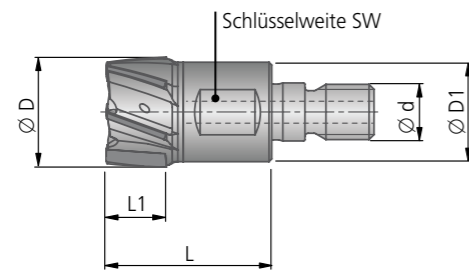
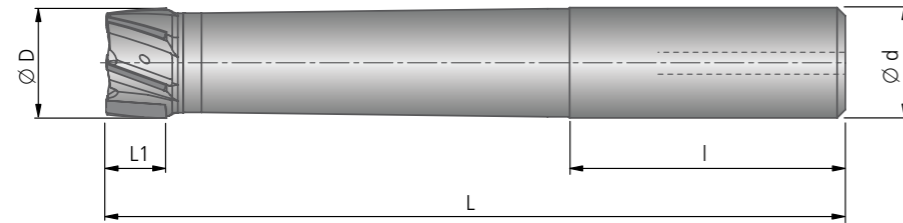
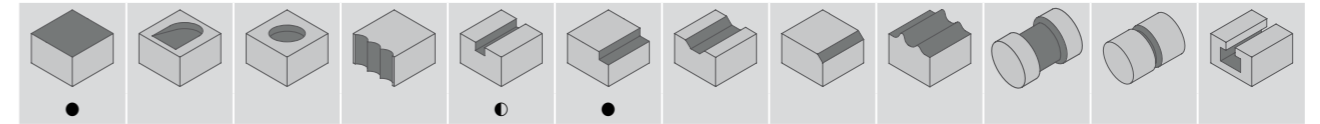


PKD-Planfräser HPC



PKD-Planfräser HPC

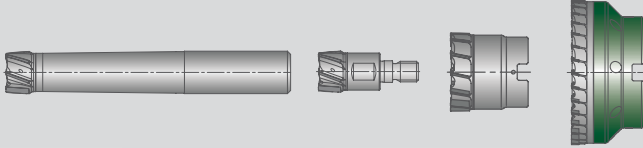


| DIN 6535 HA 2,5xD | | | | | | |
|-------------------|---------------------------|-----|----|----|-------|----------------|
| Ø D | Zylinderschaft Ø d x l | L | L1 | Z | kg | Bestell-Nr. |
| 10 | 10 x 40 | 67 | 5 | 4 | 0,074 | 38320001001000 |
| 12 | 12 x 45 | 78 | 5 | 4 | 0,084 | 38320001001200 |
| 16 | 16 x 48 | 91 | 10 | 5 | 0,132 | 38320001001600 |
| 20 | 20 x 50 | 104 | 10 | 6 | 0,229 | 38320001002000 |
| 25 | 25 x 56 | 124 | 10 | 8 | 0,401 | 38320001002500 |
| 32 | 32 x 60 | 147 | 10 | 10 | 0,871 | 38320001003200 |

| DIN 6535 HA 4xD | | | | | | |
|-----------------|---------------------------|-----|----|----|-------|----------------|
| Ø D | Zylinderschaft Ø d x l | L | L1 | Z | kg | Bestell-Nr. |
| 10 | 10 x 40 | 82 | 5 | 4 | 0,084 | 38321001001000 |
| 12 | 12 x 45 | 96 | 5 | 4 | 0,104 | 38321001001200 |
| 16 | 16 x 48 | 115 | 10 | 5 | 0,192 | 38321001001600 |
| 20 | 20 x 50 | 134 | 10 | 6 | 0,349 | 38321001002000 |
| 25 | 25 x 56 | 161 | 10 | 8 | 0,631 | 38321001002500 |
| 32 | 32 x 60 | 195 | 10 | 10 | 1,391 | 38321001003200 |

| Einschraubfräser | | | | | | | | | |
|------------------|-----|-------------------|-----------------|------|----|----|----|-------|----------------|
| Ø D | Ø d | Schlüsselweite SW | Anzugsmoment Nm | Ø D1 | L | L1 | Z | kg | Bestell-Nr. |
| 10 | M5 | 8 | 7 | 9,6 | 22 | 5 | 4 | 0,012 | 37310001001000 |
| 12 | M5 | 8 | 7 | 9,6 | 28 | 5 | 4 | 0,018 | 37310001001200 |
| 16 | M8 | 13 | 15 | 13,8 | 28 | 10 | 5 | 0,040 | 37310001001600 |
| 20 | M10 | 16 | 30 | 18,0 | 30 | 10 | 6 | 0,070 | 37310001002000 |
| 25 | M12 | 18 | 50 | 21,0 | 35 | 10 | 8 | 0,140 | 37310001002500 |
| 32 | M16 | 27 | 100 | 29,0 | 35 | 10 | 10 | 0,250 | 37310001003200 |

Empfohlene Schnittdaten

| Richtwerte für das Fräsen | | | | PKD-Planfräser ECO PERFORMANCE HPC | | | | | | | | |
|---------------------------|------------------------------------|----------|--|--|---------------------------|-------------------------|---------------------------|-------------------------|---------------------------|-------------------------|---------------------------|-----------|
| Werkstoff-Gruppe | Festigkeit Rm (N/mm ²) | Härte HB | v _c (m/min) = Schnittgeschwindigkeit f _z (mm/Zahn) = Fräsvorschub Werkstoff |  | | | | | | | | |
| | | | | Ø 10 | | Ø 12 | | Ø 16 20 25 32 | | Ø 40 – 100 | | |
| | | | | v _c m/min | f _z mm/Zahn | v _c m/min | f _z mm/Zahn | v _c m/min | f _z mm/Zahn | v _c m/min | f _z mm/Zahn | |
| N | 6.1 | ≤350 | ≤100 | unlegiertes Kupfer | | | | | | | | |
| | 6.2 | ≤700 | ≤200 | kurzspanendes Messing, Bronze, Rotguss | 300-800 | 0,04-0,12 | 300-1000 | 0,04-0,15 | 300-1000 | 0,06-0,20 | 1000-1500 | 0,04-0,15 |
| | 6.3 | ≤700 | ≤200 | langspanendes Messing | | | | | | | | |
| | 6.4 | ≤500 | ≤470 | Cu-Al-Fe-Legierung (Ampco) | | | | | | | | |
| | 7.1 | ≤350 | ≤100 | Al, Mg unlegiert | 400-1000 | 0,04-0,12 | 400-1500 | 0,04-0,15 | 400-1500 | 0,06-0,20 | 1000-3500 | 0,04-0,15 |
| | 7.2 | ≤600 | ≤180 | Al-Knetlegierung, Bruchdehnung (A 5) <14 % | 400-1000 | 0,04-0,12 | 400-1500 | 0,04-0,15 | 400-1500 | 0,06-0,20 | 1000-3500 | 0,04-0,15 |
| | 7.3 | ≤600 | ≤180 | Al-Knetlegierung, Bruchdehnung (A 5) ≥14 % | 400-1000 | 0,04-0,12 | 400-1500 | 0,04-0,15 | 400-1500 | 0,06-0,20 | 1000-3500 | 0,04-0,15 |
| | 7.4 | ≤600 | ≤180 | Al-Gusslegierung, Si <10 % | 400-1000 | 0,04-0,12 | 400-1500 | 0,04-0,15 | 400-1500 | 0,06-0,20 | 1000-1500 | 0,04-0,15 |
| | 7.5 | ≤600 | ≤180 | Al-Gusslegierung, Si ≥10 % | 400-1000 | 0,04-0,12 | 400-1500 | 0,04-0,15 | 400-1500 | 0,06-0,20 | 1000-1500 | 0,04-0,15 |
| | 8.1 | | | Thermoplaste | | | | | | | | |
| 8.2 | | | Duroplaste | | | | | | | | | |
| 8.3 | | | faserverstärkte Kunststoffe | 200-600 | 0,03-0,10 | 200-600 | 0,04-0,12 | 500-1200 | 0,05-0,15 | 500-1200 | 0,05-0,15 | |