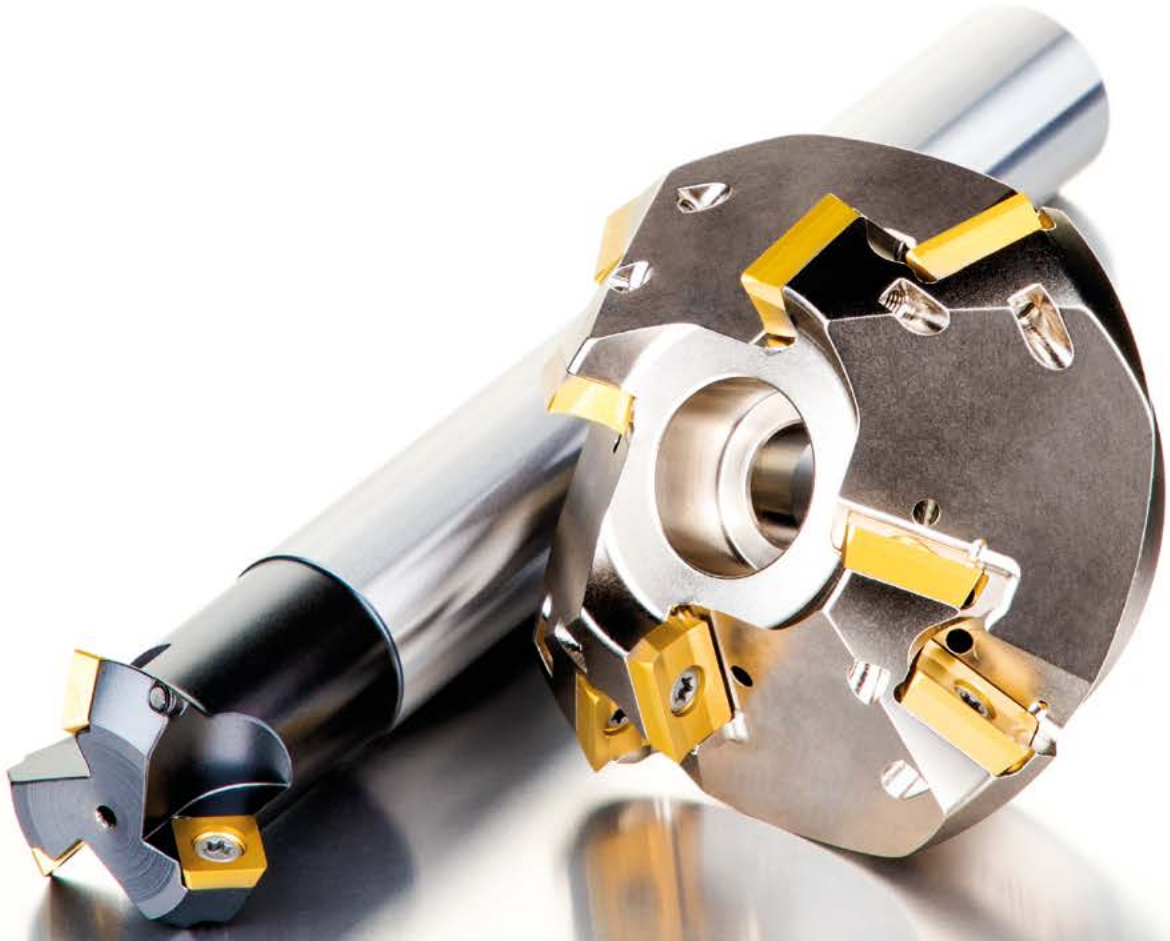


ZRÁŽACIE FRÉZY A FRÉZY NA T-DRÁŽKY

ZRAZENIE, FRÉZOVANIE T-DRÁŽKY

>>>

	SSD09	N-SSO09	2516	2636	J(T)-SXP16
	45°	45°	45°	10°– 80°	15°– 75°
	APMX (mm) 4.5	APMX (mm) 4.5	APMX (mm) 8.5	APMX (mm) 8.5	APMX (mm) 7.0– 28.0
	DC (mm) 10 – 25	DC (mm) 8 – 25	DC (mm) 11 – 19	DC (mm) 5 – 23	DC (mm) 35 – 45
Valcová stopka	DC = 16 – 25 (mm)				
Weldon stopka	DC = 10 – 25 (mm)				
Morse kužeľ	DC = 10 – 25 (mm)				
Nástrčná					
Strana	648	651	654	657	660
ISO	P M K S H	P M K S	P M K S	P M K S	P M K N
Tvar doštičky					
Doštičky	SDE. 0903	SOMT 09T3	TCMT 16T3	TCMT 16T3	XPHT 1604
Počet rezných hrán	4	4	3	3	2
Zrážacie frézovanie	■	■	■	■	■
Zadné čelné frézovanie					
Frézovanie T-drážky					
Plytké frézovanie do rohu					
Frézovanie plytkých drážok					

■ Hlavné použitie ◪ Možné použitie

<<<

ZRAZENIE, FRÉZOVANIE T-DRÁŽKY

	F-SCC											
	90°											
	APMX (mm) 11.0 – 18.0											
	DC (mm) 25 – 40											
	664											
	P M K											
	CCMX											
	2											
	■											
	■											
	◪											
	◪											

■ Hlavné použitie ◪ Možné použitie

SSD09

P M K S H

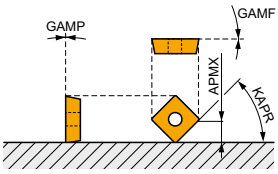
PRAMET

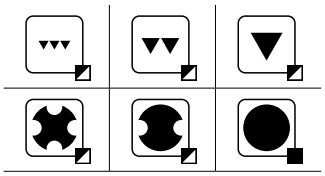
S

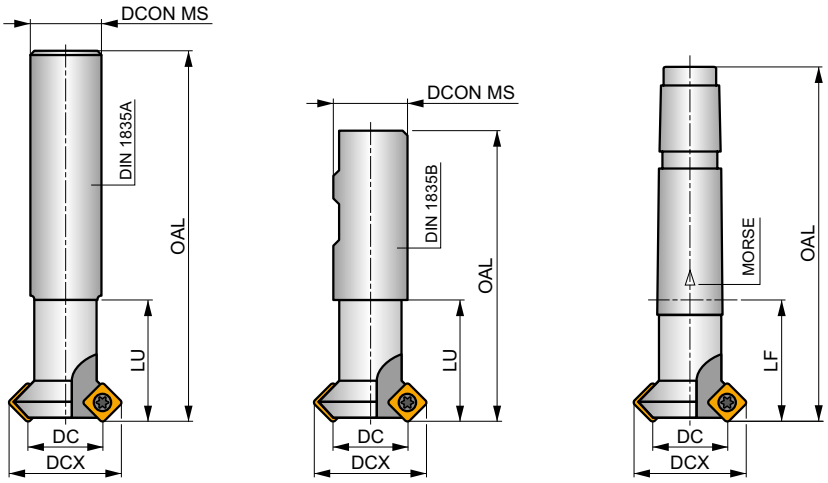
Fréza pre 45° zrazenia na štvorcové doštičky SD.. 09

Fréza pre 45° zrazenia na jednostranné doštičky SD.. 09 s APMX 4.5 mm. Vhodná pre čelné a spätné zrážanaie hrán. Dostupná v prevedení s valcovou, Weldon a Morse stopkou, s maximálnym činným priemerom Ø 22, Ø 28 a Ø 37 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	45°
APMX	4.5 mm







h_m 0.095 – 0.15

	Produkt	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	CZC MS	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	**16N2R027A16-SSD09**	16	28	200	16	27	–	–	0	0	2	–	32200	–	0.37	GI129	C0070
	25N3R042A25-SSD09	25	37	200	25	42	–	–	0	0	3	–	25800	–	0.78	GI129	CH011
DIN 1835B	**10N1R027B16-SSD09-A**	10	22	75	16	27	–	–	0	0	1	–	40700	–	0.14	GI129	C0070
	16N2R027B16-SSD09-A	16	28	75	16	27	–	–	0	0	2	–	32200	–	0.14	GI129	C0070
	25N3R042B25-SSD09-A	25	37	98	25	42	–	–	0	0	3	–	25800	–	0.37	GI129	CH011
DIN 228A	**10N1R030E02-SSD09-A**	10	22	94	–	–	30	2	0	0	1	–	40700	–	0.17	GI129	C0070
	16N2R030E02-SSD09-A	16	28	94	–	–	30	2	0	0	2	–	32200	–	0.25	GI129	C0070
	25N3R043E03-SSD09-A	25	37	124	–	–	43	3	0	0	3	–	25800	–	0.38	GI129	CH011

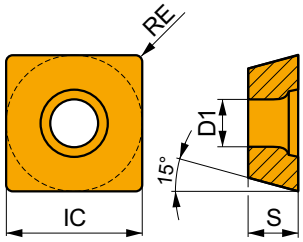
GI129	SDEW 0903..	SDEX 0903..

		Nm			
C0070	US 3507-T15	3.0	M 3.5	7	Flag T15
CH011	US 3509-T15	3.0	M 3.5	9	Flag T15

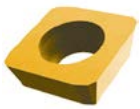
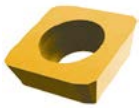
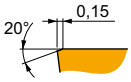
SDEW 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18



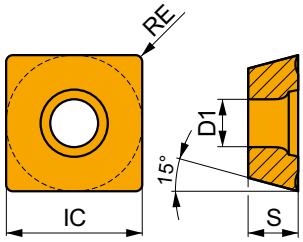
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U E																	
			EN geometria s neutrálnym uhlom čela pre frézovanie 45° zrazení.																	
SDEW 090308EN	**M8330**	0.8	235	0.10	4.5	–	–	–	220	0.10	4.5	–	–	–	–	–	–	45	0.15	1.0
	M8340	0.8	210	0.10	4.5	–	–	–	195	0.10	4.5	–	–	–	–	–	–	–	–	–
			S																	
			SN geometria s neutrálnym uhlom čela pre frézovanie 45° zrazení.																	
SDEW 090308SN	**8215**	0.8	215	0.15	4.5	–	–	–	200	0.15	4.5	–	–	–	–	–	–	40	0.15	1.0
	M8330	0.8	215	0.15	4.5	–	–	–	200	0.15	4.5	–	–	–	–	–	–	40	0.15	1.0
	M8340	0.8	195	0.15	4.5	–	–	–	185	0.15	4.5	–	–	–	–	–	–	–	–	–

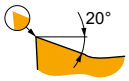
SDEX 09

PRAMET

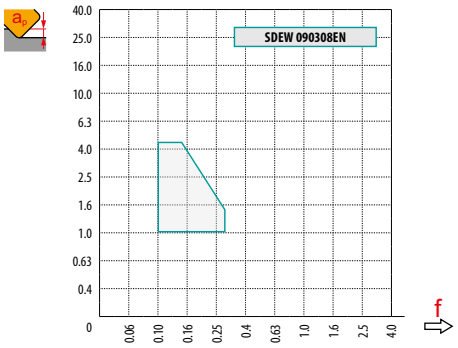
	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18

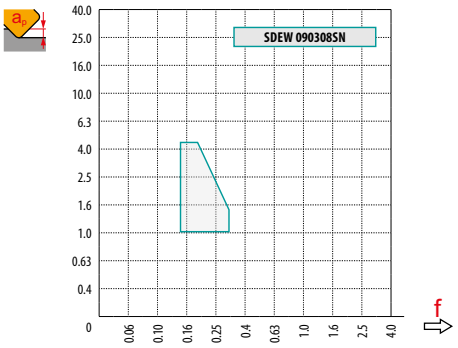


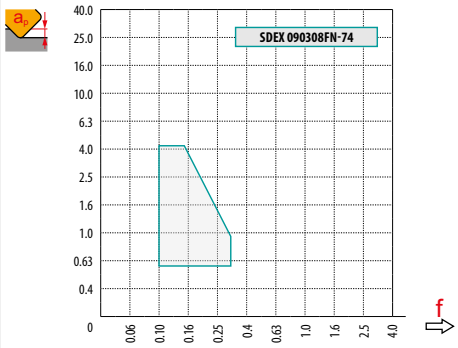
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			F																	
			Geometria 74 s pozitívnym prevedením pre frézovanie 45° zrazení.																	
SDEX 090308FN-74	**M8330**	0.8	305	0.12	4.5	180	0.11	4.5	285	0.12	4.5	–	–	–	75	0.11	3.6	–	–	–

	SDEW 09 EN	SDEW 09 SN	SDEX 09-74
RE	0.8	0.8	0.8
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
10	22	1.09	0.20	0.30
16	28	1.17	0.25	0.34
25	37	1.24	0.32	0.39

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
45°	0.42	0.54	0.67	0.35	0.44	0.55	0.30	0.38	0.47	0.27	0.34	0.42	0.25	0.31	0.39	0.23	0.29	0.36	0.21	0.27	0.34	0.19	0.24	0.30
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

N-SSO09

P M K S

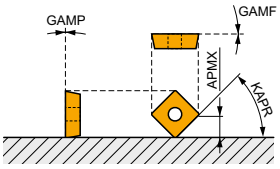
PRAMET

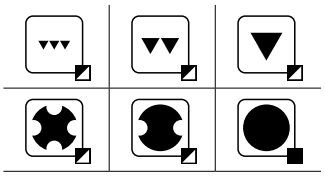
S

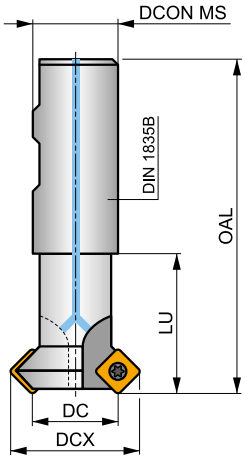
Fréza pre 45° zrazenia na štvorcové doštičky SOMT 09 s vnútorným chladením

Fréza pre 45° zrazenia na jednostranné doštičky SOMT 09 s APMX 4.5 mm a vnútorným chladením. Vhodná pre čelné a spätné zrážanaie hrán. Dostupná iba v prevedení s Weldon stopkou, s maximálnym činným priemerom Ø 20.5, Ø 28.8 a Ø 37.8 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	45°
APMX	4.5 mm







h_m 0.095 – 0.18

	Produkt	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**16N2R027B16-SSO09-C**	16	28.8	110	16	27	0	0	2	–	26600	✓	0.23	GI146	SQ500
	25N3R042B25-SSO09-C	25	37.8	125	25	42	0	0	3	–	21300	✓	0.50	GI146	SQ500
	8N1R027B16-SSO09-C	8	20.5	90	16	27	0	0	1	–	37700	✓	0.12	GI146	SQ500

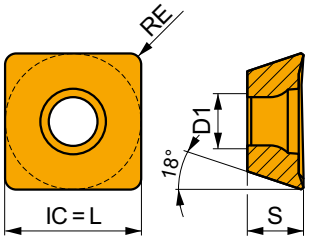
GI146	SOMT 09T3..

		Nm			
SQ500	US 3006-T09P	2.0	M 3	6	Flag T09P

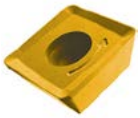
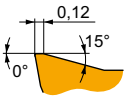
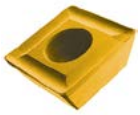
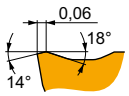
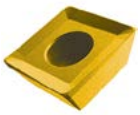
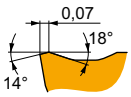
SOMT 09

PRAMET

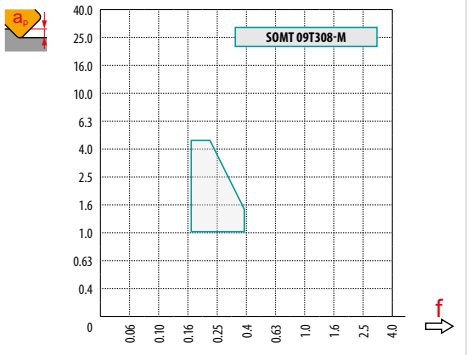
	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.550	3.50	9.55	3.97

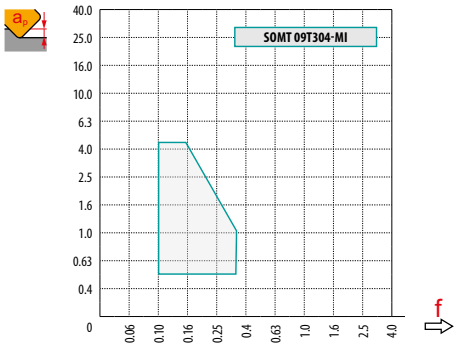


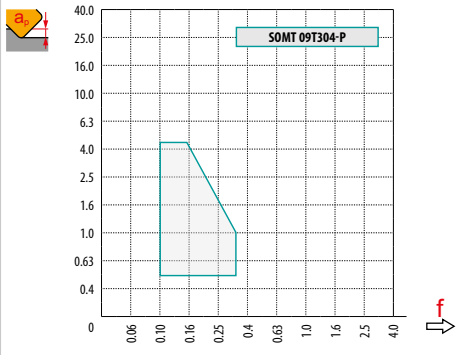
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Podmienky platia pre uhol nastavenia 90°. Ďalšie možnosti výpočtov sú v našej app Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			M geometria s pozitívnym prevedením pre stredné obrábanie.																	
SOMT 09T308-M	**8215**	0.8	275	0.14	2.5	165	0.13	2.5	260	0.14	2.5	–	–	–	65	0.13	2.0	–	–	–
	M5315	0.8	390	0.14	2.5	–	–	–	370	0.14	2.5	–	–	–	–	–	–	–	–	–
	M8330	0.8	270	0.14	2.5	160	0.13	2.5	255	0.14	2.5	–	–	–	65	0.13	2.0	–	–	–
	M8340	0.8	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	–	–	–	60	0.13	2.0	–	–	–
	M9315	0.8	380	0.14	2.5	–	–	–	360	0.14	2.5	–	–	–	–	–	–	–	–	–
			MI geometria so stabilným pozitívnym prevedením pre stredné obrábanie.																	
SOMT 09T304-MI	**8215**	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
	M8310	0.4	255	0.14	2.5	130	0.13	2.5	240	0.14	2.5	–	–	–	–	–	–	–	–	–
	M8330	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
	M8340	0.4	210	0.14	2.5	125	0.13	2.5	195	0.14	2.5	–	–	–	50	0.10	2.0	–	–	–
	M9315	0.4	320	0.14	2.5	–	–	–	300	0.14	2.5	–	–	–	–	–	–	–	–	–
	M9340	0.4	265	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.10	2.0	–	–	–
			P geometria s veľmi pozitívnym prevedením pre stredné obrábanie.																	
SOMT 09T304-P	**M8330**	0.4	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	–	–	–	60	0.10	2.0	–	–	–
	M8340	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
	M9325	0.4	320	0.14	2.5	–	–	–	300	0.14	2.5	–	–	–	–	–	–	–	–	–

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
RE	0.8	0.4	0.4
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
8	20.5	1.06	0.18	0.29
16	28.8	1.17	0.25	0.34
25	37.8	1.24	0.32	0.39

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
45°	0.42	0.63	0.80	0.35	0.51	0.66	0.30	0.44	0.57	0.27	0.40	0.51	0.25	0.36	0.46	0.23	0.33	0.43	0.21	0.31	0.40	0.19	0.28	0.36
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

2516

P M K N

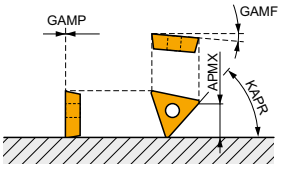
PRAMET

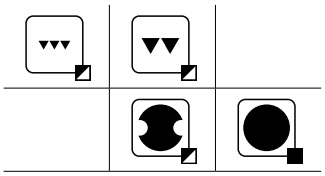
S

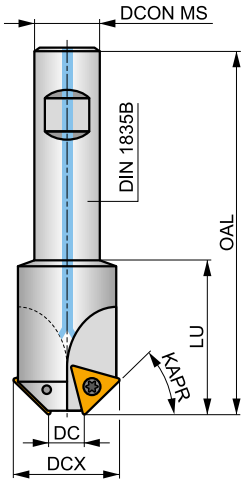
Fréza pre 45° zrazenia na doštičky TCMT 16 s vnútorným chladením

Fréza pre 45° zrazenia na jednostranné doštičky TCMT 16 s APMX 8.5 mm a vnútorným chladením. Vhodná pre čelné a spätné zrážanaie hrán. Dostupná iba v prevedení s Weldon stopkou, s maximálnym činným priemerom Ø 31, a Ø 39 mm. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	45°
APMX	8.5 mm







h_m 0.065 – 0.095

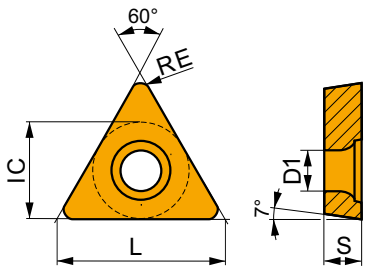
	Produkt	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)			max.		kg		
DIN 1835B	**2516 – 45 – 11**	31	11	100	16	30	2	–	18100	✓	0.24	GI155	SQ220
	2516 – 45 – 19	39	19	100	20	30	2	–	16200	✓	0.35	GI155	SQ220

GI155	TCMT 16T308E-FM:T83..

SQ220	US 4011-T15P	3.5 Nm	M 4	10.6	Flag T15P

TCMT

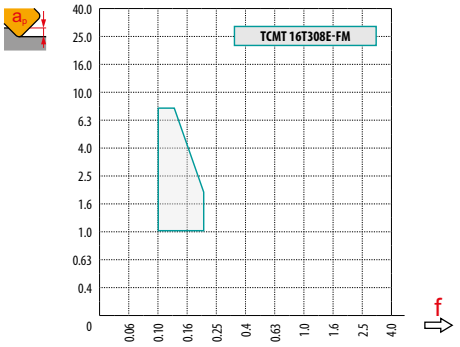
	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.4	16.5	3.97



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			FM geometria pre dokončovacie až polohrubovacie obrábanie a plynulý až mierne prerušovaný rez.																	
TCMT 16T308E-FM	**T8315**	0.80	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
	T8330	0.80	160	0.17	1.7	95	0.15	1.7	150	0.17	1.7	480	0.20	1.7	–	–	–	–	–	–

	TCMT 16-FM
RE	0.8
BS	–



DC	DCX	X.V	f_{min}	f_{max}
11.0	31.0	1.02	0.10	0.18
19.0	39.0	1.10	0.14	0.20

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
45°	0.29	0.34	0.42	0.24	0.27	0.35	0.21	0.24	0.30	0.18	0.21	0.27	0.17	0.19	0.25	0.16	0.18	0.23	0.15	0.17	0.21	0.13	0.15	0.19
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

2636

P M K N

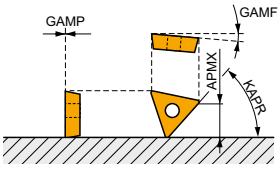
PRAMET

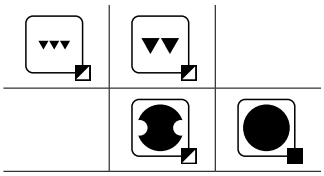
S

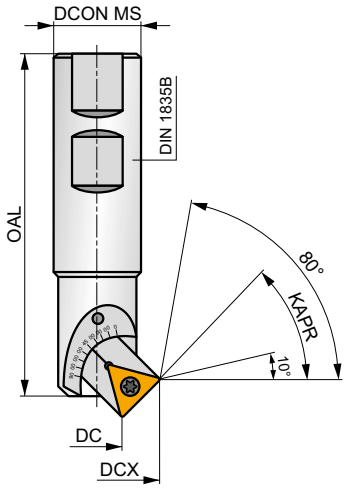
Nastaviteľná stopková fréza na plátky TCMT 16

Nastaviteľná stopková fréza pre zrážanie hrán na doštičky TCMT 16 s APMX 8.5 mm. Možnosť nastavenia uhla v rozsahu od 10° do 80°. Dostupná iba v prevedení s Weldon stopkou. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	10° – 80°
APMX	8.5 mm







h_m 0.03 – 0.08

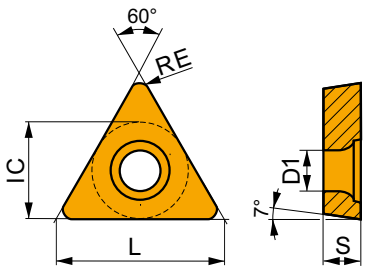
	Produkt	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**2636-05-25**	5.0	31.0	100	25	10	-8	0	1	–	18100	–	0.35	GI294	CH040
		5.5	31.0			15									
		7.0	29.5			30									
		11.0	29.5			45									
		16.0	28.5			60									
		21.0	26.5			75									
		23.0	26.0			80									

GI294	TCMT 16T304E-FM:T83..	TCMT 16T308E-FM:T83..

CH040	USI 0614	CA 2669	US 4011-T15P	3.5	M 4	10.6	Flag T15

TCMT

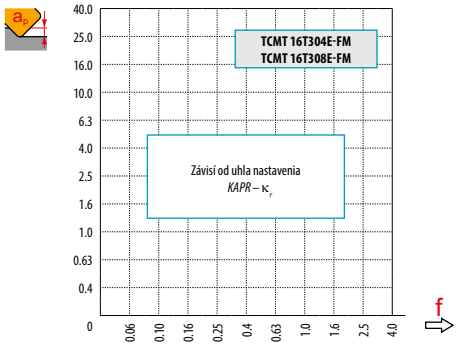
	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.4	16.5	3.97



Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			FM geometria pre dokončovacie až polohrubovacie obrábanie a plynulý až mierne prerušovaný rez.																	
TCMT 16T304E-FM	**T8315**	0.40	◪ 155	0.12	1.7	■ 90	0.11	1.7	◪ 145	0.12	1.7	◪ 465	0.14	1.7	–	–	–	–	–	–
	T8330	0.40	■ 150	0.12	1.7	■ 90	0.11	1.7	◪ 140	0.12	1.7	◪ 450	0.14	1.7	–	–	–	–	–	–
TCMT 16T308E-FM	**T8315**	0.80	◪ 170	0.17	1.7	■ 100	0.15	1.7	◪ 160	0.17	1.7	◪ 510	0.20	1.7	–	–	–	–	–	–
	T8330	0.80	■ 160	0.17	1.7	■ 95	0.15	1.7	◪ 150	0.17	1.7	◪ 480	0.20	1.7	–	–	–	–	–	–

	TCMT 16-FM	
RE	0.8	0.4
BS	–	–



	a_p	DC	DCX	X.V	f_{min}	f_{max}
10°	2.6	5.0	31.0	1.38	0.24	0.59
15°	3.9	5.5	31.0	1.30	0.17	0.40
30°	7.6	7.0	29.5	1.18	0.10	0.20
45°	10.7	11.0	29.5	1.13	0.09	0.14
60°	13.2	16.0	28.5	1.09	0.09	0.11
75°	14.7	21.0	26.5	1.06	0.09	0.10
80°	15.0	23.0	26.0	1.06	0.09	0.10

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
10°	0.55	0.91	1.46	0.45	0.74	1.19	0.39	0.64	1.03	0.35	0.58	0.92	0.32	0.53	0.84	0.29	0.49	0.78	0.27	0.46	0.73	0.24	0.41	0.65
15°	0.37	0.61	0.98	0.30	0.50	0.80	0.26	0.43	0.69	0.23	0.39	0.62	0.21	0.35	0.56	0.20	0.33	0.52	0.18	0.31	0.49	0.16	0.27	0.44
30°	0.19	0.32	0.51	0.15	0.26	0.41	0.13	0.22	0.36	0.12	0.20	0.32	0.11	0.18	0.29	0.10	0.17	0.27	0.09	0.16	0.25	0.08	0.14	0.23
45°	0.13	0.22	0.36	0.11	0.18	0.29	0.09	0.16	0.25	0.08	0.14	0.23	0.08	0.13	0.21	0.07	0.12	0.19	0.07	0.11	0.18	0.06	0.10	0.16
60°	0.11	0.18	0.29	0.09	0.15	0.24	0.08	0.13	0.21	0.07	0.12	0.18	0.06	0.11	0.17	0.06	0.10	0.16	0.05	0.09	0.15	0.05	0.08	0.13
75°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.12	0.19	0.06	0.10	0.17	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.12
80°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.11	0.18	0.06	0.10	0.16	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.11
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

J(T)-SXP16

P M K N

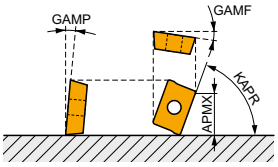
PRAMET

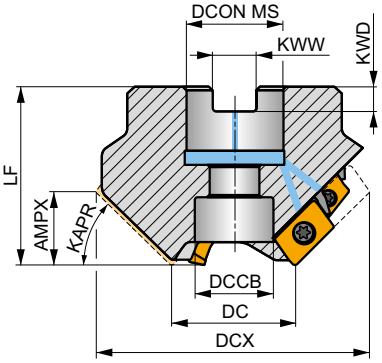
S

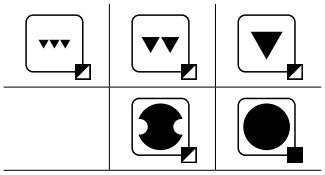
Fréza pre zrážanie hrán s dlhým britom na doštičky XPHT s vnútorným chladením

Fréza pre zrážanie hrán na jednostranné doštičky XPHT 16 s APMX v rozsahu 7 až 28 mm. Telesá fréz podporujú vnútorné chladenie. Vhodná pre frézovanie úkosov a zrazení. Dostupná iba v nástrčnom prevedení. Malý priemer Ø 35 a Ø 45 mm, s uhlami nastavenia hrany 15°, 25°, 30°, 35°, 40°, 45°, 50°, 55°, 60° a 75°. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	15° – 75°
APMX	7.0 – 28.0 mm







h_m 0.05 – 0.11

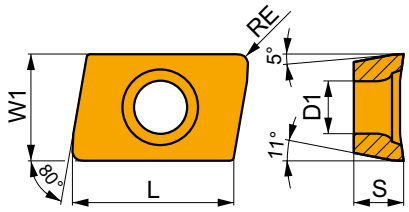
	Produkt	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	KAPR (°)	KWW (mm)	KWD (mm)	APMX (mm)	GAMF (°)	GAMP (°)	NOF			max.		kg		
	35T03R-S15XP1607-C	35	90.6	50	27	22	15	12.4	7	7.00	-6	-1	3	6	–	15200	✓	1.38	GI208	CH050
	35T03R-S25XP1612-C	35	87.3	50	27	22	25	12.4	7	12.00	-6	0	3	6	–	15200	✓	1.24	GI208	CH050
	35T03R-S30XP1614-C	35	85.1	50	27	22	30	12.4	7	14.00	-6	0	3	6	–	15200	✓	1.28	GI208	CH050
	35T03R-S35XP1616-C	35	82.4	50	27	22	35	12.4	7	16.00	-6	0	3	6	–	15200	✓	1.15	GI208	CH050
	35T03R-S40XP1618-C	35	79.4	50	27	22	40	12.4	7	18.00	-6	1	3	6	–	15200	✓	1.07	GI208	CH050
	35T03R-S45XP1620-C	35	76.1	50	27	22	45	12.4	7	20.00	-6	2	3	6	–	15200	✓	0.97	GI208	CH050
	35T03R-S50XP1622-C	35	72.4	50	27	22	50	12.4	7	22.00	-6	2	3	6	–	15200	✓	0.91	GI208	CH050
	35T03R-S55XP1623-C	35	68.4	50	27	22	55	12.4	7	23.00	-6	2	3	6	–	15200	✓	0.83	GI208	CH050
ISO 646Z DIN 8030	35T03R-S60XP1625-C	35	64.2	50	27	22	60	12.4	7	25.00	-5	4	3	6	–	15200	✓	0.67	GI208	CH050
	45T03R-S75XP1628-C	45	60.1	50	27	22	75	12.4	7	28.00	-5	5	3	6	–	13400	✓	0.73	GI208	CH050
	45T04R-S25XP1612-C	45	97.3	50	27	22	25	12.4	7	12.00	-6	0	4	8	✓	13400	✓	1.63	GI208	CH050
	45T04R-S30XP1614-C	45	95.1	50	27	22	30	12.4	7	14.00	-6	0	4	8	✓	13400	✓	1.22	GI208	CH050
	45T04R-S35XP1616-C	45	92.4	50	27	22	35	12.4	7	16.00	-6	2	4	8	✓	13400	✓	1.30	GI208	CH050
	45T04R-S40XP1618-C	45	89.5	50	27	22	40	12.4	7	18.00	-6	2	4	8	✓	13400	✓	1.18	GI208	CH050
	45T04R-S45XP1620-C	45	86.1	50	27	22	45	12.4	7	20.00	-6	2	4	8	✓	13400	✓	1.11	GI208	CH050
	45T04R-S50XP1622-C	45	82.4	50	27	22	50	12.4	7	22.00	-6	2	4	8	✓	13400	✓	1.04	GI208	CH050
	45T04R-S55XP1623-C	45	78.4	50	27	22	55	12.4	7	23.00	-6	2	4	8	✓	13400	✓	0.96	GI208	CH050
	45T04R-S60XP1625-C	45	74.2	50	27	22	60	12.4	7	25.00	-5	4	4	8	✓	13400	✓	0.82	GI208	CH050

GI208	XPHT 1604..

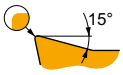
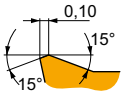
CH050	US 3509-T15	3.0 Nm	M 3.5	9	D-T07/T15	FG-15	HS 1230C

XPHT 16

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	15.88	4.76

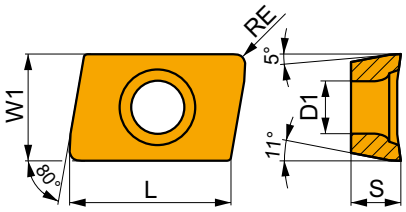


Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

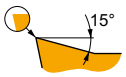
Produkt		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U E																	
			E geometria s veľmi pozitívnym prevedením pre frézovanie zrazení.																	
XPHT 160412E	**8215**	1.2	225	0.10	15.0	135	0.09	15.0	210	0.10	15.0	–	–	–	–	–	–	–	–	–
	M6330	1.2	190	0.10	15.0	135	0.09	15.0	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	1.2	220	0.10	15.0	130	0.09	15.0	205	0.10	15.0	–	–	–	–	–	–	–	–	–
	M8340	1.2	195	0.10	15.0	115	0.09	15.0	185	0.10	15.0	–	–	–	–	–	–	–	–	–
			1 U S																	
			S geometria s veľmi pozitívnym prevedením pre frézovanie zrazení.																	
XPHT 160412S	**8215**	1.2	210	0.12	15.0	125	0.11	15.0	195	0.12	15.0	–	–	–	–	–	–	–	–	–
	M8330	1.2	210	0.12	15.0	125	0.11	15.0	195	0.12	15.0	–	–	–	–	–	–	–	–	–
	M8340	1.2	190	0.12	15.0	110	0.11	15.0	180	0.12	15.0	–	–	–	–	–	–	–	–	–
	M9325	1.2	270	0.12	15.0	–	–	–	255	0.12	15.0	–	–	–	–	–	–	–	–	–
	M9340	1.2	245	0.12	15.0	145	0.11	15.0	–	–	–	–	–	–	–	–	–	–	–	–

XPHT 16-FA

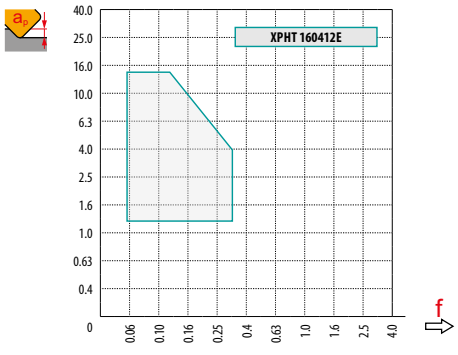
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	15.88	4.76

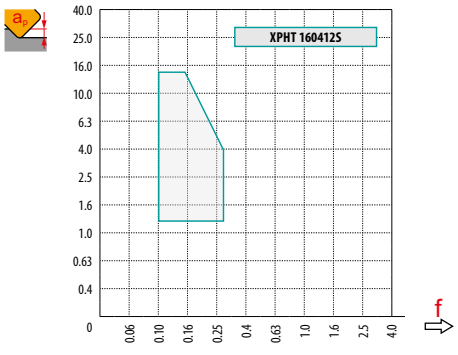


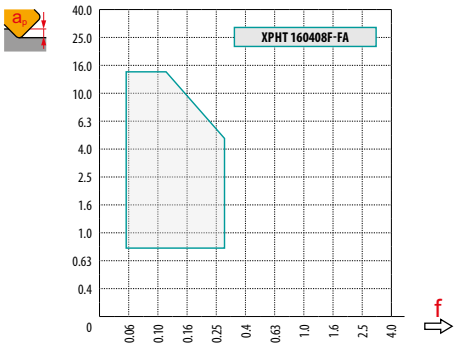
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			F FA geometria s veľmi pozitívnym prevedením pre frézovanie zrazení.																	
XPHT 160408F-FA	**HF7**	0.8	–	–	–	–	–	–	–	–	–	255	0.12	15.0	–	–	–	–	–	–

	XPHT 16 E	XPHT 16 S	XPHT 16-FA
RE	1.2	1.2	0.8
BS	–	–	–







ae / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
15°	0.61	0.98	1.34	0.50	0.80	1.10	0.43	0.69	0.95	0.39	0.62	0.85	0.35	0.56	0.78	0.33	0.52	0.72	0.31	0.49	0.67	0.27	0.44	0.60
25°	0.37	0.60	0.82	0.31	0.49	0.67	0.26	0.42	0.58	0.24	0.38	0.52	0.22	0.35	0.48	0.20	0.32	0.44	0.19	0.30	0.41	0.17	0.27	0.37
30°	0.32	0.51	0.70	0.26	0.41	0.57	0.22	0.36	0.49	0.20	0.32	0.44	0.18	0.29	0.40	0.17	0.27	0.37	0.16	0.25	0.35	0.14	0.23	0.31
35°	0.28	0.44	0.61	0.23	0.36	0.50	0.19	0.31	0.43	0.17	0.28	0.38	0.16	0.25	0.35	0.15	0.24	0.32	0.14	0.22	0.30	0.12	0.20	0.27
40°	0.25	0.39	0.54	0.20	0.32	0.44	0.17	0.28	0.38	0.16	0.25	0.34	0.14	0.23	0.31	0.13	0.21	0.29	0.12	0.20	0.27	0.11	0.18	0.24
45°	0.22	0.36	0.49	0.18	0.29	0.40	0.16	0.25	0.35	0.14	0.23	0.31	0.13	0.21	0.28	0.12	0.19	0.26	0.11	0.18	0.25	0.10	0.16	0.22
50°	0.21	0.33	0.45	0.17	0.27	0.37	0.15	0.23	0.32	0.13	0.21	0.29	0.12	0.19	0.26	0.11	0.18	0.24	0.10	0.17	0.23	0.09	0.15	0.20
55°	0.19	0.31	0.42	0.16	0.25	0.35	0.14	0.22	0.30	0.12	0.20	0.27	0.11	0.18	0.25	0.10	0.17	0.23	0.10	0.15	0.21	0.09	0.14	0.19
60°	0.18	0.29	0.40	0.15	0.24	0.33	0.13	0.21	0.28	0.12	0.18	0.25	0.11	0.17	0.23	0.10	0.16	0.21	0.09	0.15	0.20	0.08	0.13	0.18
75°	0.16	0.26	0.36	0.13	0.21	0.29	0.12	0.19	0.25	0.10	0.17	0.23	0.09	0.15	0.21	0.09	0.14	0.19	0.08	0.13	0.18	0.07	0.12	0.16
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

	ap	DC	DCX	X.V	fmin	fmax
15°	7	35.0	90.6	1.16	0.43	0.70
25°	12	35.0	87.3	1.16	0.20	0.32
30°	14	35.0	85.1	1.17	0.16	0.25
35°	16	35.0	82.4	1.17	0.13	0.20
40°	18	35.0	79.4	1.17	0.11	0.16
45°	20	35.0	76.0	1.18	0.09	0.14
50°	22	35.0	72.4	1.18	0.08	0.12
55°	23	35.0	68.4	1.20	0.08	0.11
60°	25	35.0	64.1	1.20	0.07	0.09
25°	12	45.0	97.3	1.18	0.23	0.34
30°	14	45.0	95.0	1.18	0.18	0.26
35°	16	45.0	92.4	1.19	0.15	0.21
40°	18	45.0	89.5	1.19	0.12	0.17
45°	20	45.0	86.0	1.20	0.11	0.15
50°	22	45.0	82.4	1.21	0.09	0.13

	ap	DC	DCX	X.V	fmin	fmax
55°	23	45.0	78.4	1.22	0.09	0.11
60°	25	45.0	74.1	1.23	0.08	0.10
75°	28	45.0	60.1	1.31	0.07	0.08

Frézy s uhlom nastavenia 15° možno použiť ako HFC. Použite posuvy z fázovacej tabuľky.

F-SCC

P M K

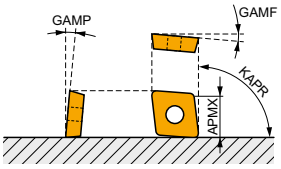
PRAMET

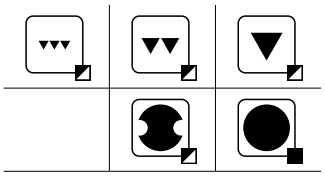
S

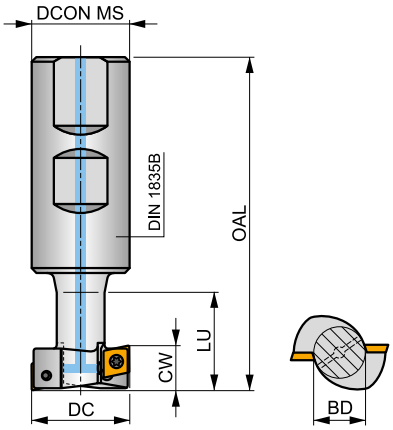
Fréza na T-drážky pre doštičky CCMX s vnútorným chladením

Fréza na frézovanie T-drážok s jednostrannými doštičkami CCMX. Dostupné vnútorné chladenie. Vhodná na operácie frézovania T-drážok, zadného čela, do rohu a plytkých drážok. Dostupná iba so stopkou Weldon a činnými priemermi Ø 25, Ø 32 a Ø 40. Teleso je povrchovo upravené pre predĺženie životnosti nástroja.

KAPR	90°
APMX	11.0 – 18.0 mm







h_m 0.05 – 0.08

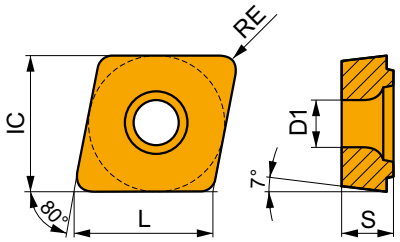
	Produkt	DC (mm)	BD (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	CW (mm)				max.		kg		
DIN 1835B	25F1R030B25-SCC06-C	25	12	86	25	25	11.00	1	2	–	28100	✓	0.26	GI148	SQ213
	32F1R038B32-SCC08-C	32	16	98	32	33	14.00	1	2	–	19100	✓	0.50	GI149	SQ212
	40F2R046B32-SCC09-C	40	20	105	32	41	18.00	2	4	–	14900	✓	0.56	GI150	SQ212

GI148	CCMX 060304
GI149	CCMX 08T308
GI150	CCMX 09T308

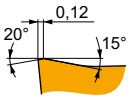
		Nm			
SQ212	US 3007-T09P	2.0	M 3	7.3	Flag T09P
SQ213	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P

CCMX

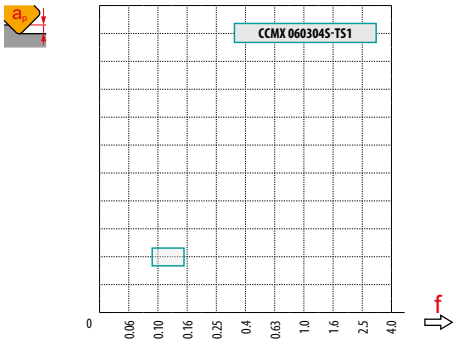
	IC (mm)	D1 (mm)	L (mm)	S (mm)
0603	6.350	2.80	6.40	3.50
08T3	8.030	3.50	8.10	4.40
09T3	9.525	3.50	9.70	3.97

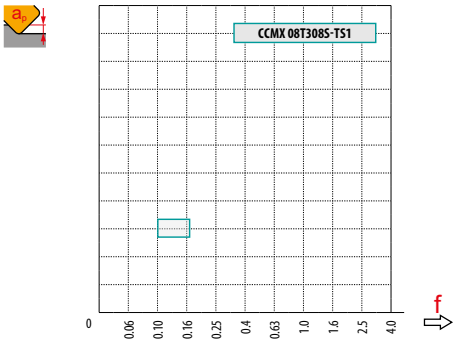


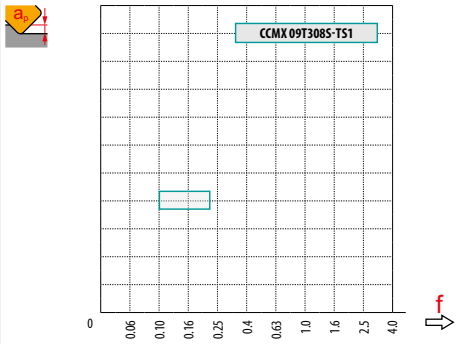
Vhodnosť a štartovacie hodnoty pre reznú rýchlosť (vc), posuv (f) a hĺbku rezu (ap). Ďalšie možnosti výpočtov rezných parametrov nájdete v našej aplikácii Machining Calculator.

Produkt		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U S Špeciálna geometria pre frézovanie T-drážok s ľahkými až strednými podmienkami obrábania.																	
CCMX 060304S-TS1	M8330	0.4	■ 240	0.10	–	◪ 140	0.09	–	■ 225	0.10	–	–	–	–	–	–	–	–	–	–
	M8340	0.4	■ 215	0.10	–	◪ 125	0.09	–	◪ 200	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 08T308S-TS1	M8330	0.8	■ 275	0.10	–	◪ 165	0.10	–	■ 260	0.10	–	–	–	–	–	–	–	–	–	–
	M8340	0.8	■ 245	0.10	–	◪ 145	0.10	–	◪ 230	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 09T308S-TS1	M8330	0.8	■ 270	0.10	–	◪ 160	0.10	–	■ 255	0.10	–	–	–	–	–	–	–	–	–	–
	M8340	0.8	■ 240	0.10	–	◪ 140	0.10	–	◪ 225	0.10	–	–	–	–	–	–	–	–	–	–

	CCMX 06-TS1	CCMX 08-TS1	CCMX 09-TS1
RE	0.4	0.8	0.8
BS	–	–	–







a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

DC	a_e = 1		a_e = 2		a_e = 3		a_e = 4		a_e = 5		a_e = 8		a_e = 10	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.25	0.40	0.18	0.29	0.15	0.24	0.13	0.21	0.12	0.19	0.09	0.15	0.09	0.14
32	0.28	0.45	0.20	0.32	0.17	0.27	0.14	0.23	0.13	0.21	0.10	0.17	0.09	0.15
40	0.32	0.51	0.23	0.36	0.18	0.30	0.16	0.26	0.14	0.23	0.12	0.19	0.10	0.17

DC	a_e = 12		a_e = 16		a_e = 20		a_e = 25		a_e = 32		a_e = 40	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–	–	–
32	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–
40	0.10	0.15	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

Platí pre T drážku

Platí pre osadenie a zadné čelo

Platí iba pre osadenie

DC		APMX	$a_{p\,max}$
25	1	11	6.4
32	1	14	8.0
40	2	18	9.7