

THM543 - FREZY TOROIDALNE, Z = 3 END MILLS WITH CORNER RADIUS, Z = 3

Norma TOOLS
TOOLS norm

HM
Węgiel

Cr

λ 55°

Z=3

Polerowanie
Polishing



Powietrze
Air

Mgła olejowa
Oil mist

Emulsja
Emulsion

ALU
> 6% Si

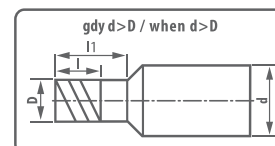
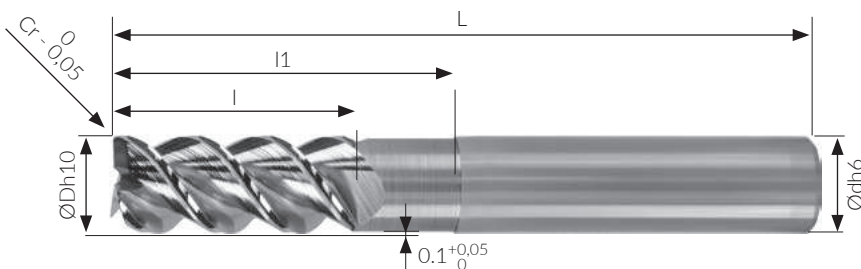
Miedź i stopy miedzi
Copper & copper alloys

ALU
< 6% Si

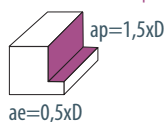
Wzrostki
termoplastyczne
Thermoplastics

UWAGA - aby polepszyć ewakuację wiórów podczas obróbki aluminium zalecane jest stosowanie intensywnego chłodzenia.

REMARK - it is advised to use intensive cooling to improve chips evacuation while machining aluminium.



Zalecane parametry skrawania / Cutting data

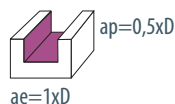


Obróbka boczna
Side milling

Alu i stopy Alu >6% Si
Alu & alloys
(Vc = 260 - 280 m/min)

Miedź i stopy miedzi
Copper & alloys
(Vc = 435 - 455 m/min)

| Kod | D [mm] | d [mm] | l [mm] | l1 [mm] | L [mm] | Cr [mm] | fz [mm/z] | fz [mm/z] |
|----------------------|--------|--------|--------|---------|--------|---------|-----------|-----------|
| THM543-0400CR05 | 4 | 4 | 8 | 16 | 50 | 0.5 | 0,014 | 0,021 |
| THM543-0400CR05-RS06 | 4 | 6 | 8 | 16 | 57 | 0.5 | 0,014 | 0,021 |
| THM543-0500CR05 | 5 | 5 | 10 | 18 | 50 | 0.5 | 0,024 | 0,036 |
| THM543-0500CR05-RS06 | 5 | 6 | 10 | 18 | 57 | 0.5 | 0,024 | 0,036 |
| THM543-0600CR05 | 6 | 6 | 13 | 21 | 57 | 0.5 | 0,034 | 0,050 |
| THM543-0600CR10 | 6 | 6 | 13 | 21 | 57 | 1.0 | 0,034 | 0,050 |
| THM543-0800CR05 | 8 | 8 | 19 | 27 | 63 | 0.5 | 0,046 | 0,073 |
| THM543-0800CR10 | 8 | 8 | 19 | 27 | 63 | 1.0 | 0,046 | 0,073 |
| THM543-1000CR05 | 10 | 10 | 22 | 32 | 72 | 0.5 | 0,058 | 0,091 |
| THM543-1000CR10 | 10 | 10 | 22 | 32 | 72 | 1.0 | 0,058 | 0,091 |
| THM543-1200CR10 | 12 | 12 | 26 | 36 | 83 | 1.0 | 0,070 | 0,105 |
| THM543-1200CR15 | 12 | 12 | 26 | 36 | 83 | 1.5 | 0,070 | 0,105 |



Wykonywanie kanałków
Slotting

Alu i stopy Alu >6% Si
Alu & alloys
(Vc = 190 - 210 m/min)

Miedź i stopy miedzi
Copper & alloys
(Vc = 330 - 350 m/min)

| Kod | D [mm] | d [mm] | l [mm] | l1 [mm] | L [mm] | Cr [mm] | fz [mm/z] | fz [mm/z] |
|----------------------|--------|--------|--------|---------|--------|---------|-----------|-----------|
| THM543-0400CR05 | 4 | 4 | 8 | 16 | 50 | 0.5 | 0,014 | 0,021 |
| THM543-0400CR05-RS06 | 4 | 6 | 8 | 16 | 57 | 0.5 | 0,014 | 0,021 |
| THM543-0500CR05 | 5 | 5 | 10 | 18 | 50 | 0.5 | 0,024 | 0,036 |
| THM543-0500CR05-RS06 | 5 | 6 | 10 | 18 | 57 | 0.5 | 0,024 | 0,036 |
| THM543-0600CR05 | 6 | 6 | 13 | 21 | 57 | 0.5 | 0,034 | 0,050 |
| THM543-0600CR10 | 6 | 6 | 13 | 21 | 57 | 1.0 | 0,034 | 0,050 |
| THM543-0800CR05 | 8 | 8 | 19 | 27 | 63 | 0.5 | 0,046 | 0,073 |
| THM543-0800CR10 | 8 | 8 | 19 | 27 | 63 | 1.0 | 0,046 | 0,073 |
| THM543-1000CR05 | 10 | 10 | 22 | 32 | 72 | 0.5 | 0,058 | 0,091 |
| THM543-1000CR10 | 10 | 10 | 22 | 32 | 72 | 1.0 | 0,058 | 0,091 |
| THM543-1200CR10 | 12 | 12 | 26 | 36 | 83 | 1.0 | 0,070 | 0,105 |
| THM543-1200CR15 | 12 | 12 | 26 | 36 | 83 | 1.5 | 0,070 | 0,105 |