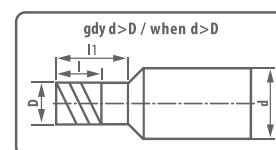
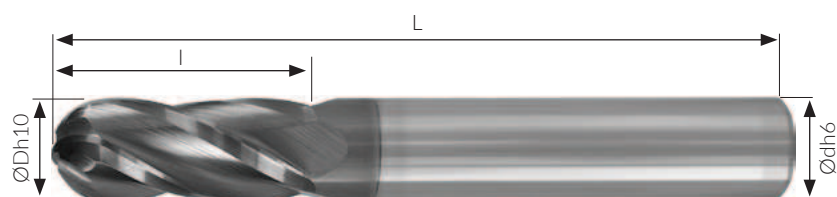


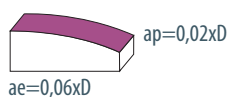
## THM712 - FREZY PROMIENIOWE, Z = 4 BALL NOSE END MILLS, Z = 4

FREZY DO 45 HRC  
END MILLS UP TO 45 HRC

Norma TOOLS TOOLS norm	HM Węgliki		$\lambda 30^\circ$	Z=4	AP Alcrona Pro		Mgła olejowa Oil mist	Emulsja Emulsion
Stale / Steels < 1450 N / mm <sup>2</sup>	Żelazo szare Grey cast iron < 180 HB	Stale / Steels 12% Cr		$\chi > 6\%$	Żelazo sferoidalne Spheroidal cast. iron			



### Zalecane parametry skrawania / Cutting data



Obróbka kształtowa  
Contouring

Stale / Steels < 800 N/mm<sup>2</sup>  
(Vc = 340 - 360 m/min)

Stale / Steels < 1000 N/mm<sup>2</sup>  
Żelazo szare  
Grey cast iron < 180 HB  
(Vc = 275 - 295 m/min)

Stale / Steels < 1450 N/mm<sup>2</sup>  
(Vc = 210 - 230 m/min)

Kod	D [mm]	d [mm]	l [mm]	l1 [mm]	L [mm]	fz [mm/z]	fz [mm/z]	fz [mm/z]
THM712-0400-AP	4	4	8	-	50	0,193	0,173	0,153
THM712-0500-AP	5	5	10	-	50	0,217	0,197	0,177
THM712-0600-AP	6	6	13	-	57	0,242	0,222	0,202
THM712-0800-AP	8	8	19	-	63	0,308	0,288	0,268
THM712-1000-AP	10	10	22	-	72	0,352	0,332	0,312
THM712-1100-RS12-AP	11	12	24	30	83	0,374	0,354	0,334
THM712-1200-AP	12	12	26	-	83	0,396	0,376	0,356
THM712-1400-AP	14	14	26	-	83	0,424	0,404	0,384
THM712-1600-AP	16	16	32	-	92	0,451	0,431	0,411
THM712-1800-AP	18	18	32	-	92	0,479	0,459	0,439
THM712-2000-AP	20	20	32	-	104	0,506	0,486	0,466