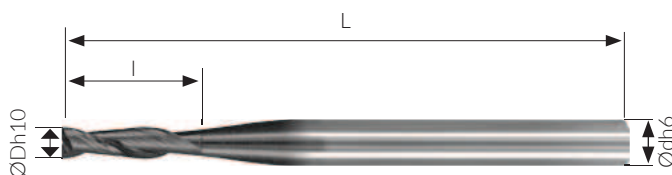
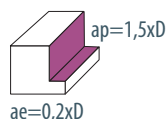


THM917 - FREZY WALCOWO-CZOŁOWE, Z = 2 NA CHWYCIE WZMOCNIONYM d=6 [mm] FACE END MILLS, Z = 2 WITH REINFORCED SHANK d=6 [mm]

UWAGA / REMARK - zmiana kodowania / changes in codification. Stary kod / old code: THM995



Zalecane parametry skrawania / Cutting data



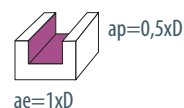
Obróbka boczna
Side milling

Stale / Steels <800 N/mm²
(Vc = 120 - 140 m/min)

Stale / Steels <1000 N/mm²
Żeliwa szare / Grey cast iron
<180 HB
(Vc = 100 - 120 m/min)

Stale / Steels <1450 N/mm²
(Vc = 70 - 90 m/min)

Kod	D [mm]	d [mm]	l [mm]	L [mm]	fz [mm/z]	fz [mm/z]	fz [mm/z]
THM917-0100-RS06-AP	1	6	4	40	0,003	0,003	0,002
THM917-0150-RS06-AP	1.5	6	4	40	0,004	0,004	0,003
THM917-0200-RS06-AP	2	6	6	40	0,006	0,005	0,005
THM917-0250-RS06-AP	2.5	6	6	40	0,007	0,006	0,006
THM917-0300-RS06-AP	3	6	7	40	0,009	0,008	0,007
THM917-0350-RS06-AP	3.5	6	7	40	0,010	0,009	0,008
THM917-0400-RS06-AP	4	6	8	40	0,012	0,010	0,009
THM917-0450-RS06-AP	4.5	6	8	40	0,013	0,011	0,010
THM917-0500-RS06-AP	5	6	10	40	0,014	0,012	0,011
THM917-0550-RS06-AP	5.5	6	10	40	0,016	0,014	0,013



Wykonywanie kanałków
Slotting

Stale / Steels <800 N/mm²
(Vc = 110 - 130 m/min)

Stale / Steels <1000 N/mm²
Żeliwa szare / Grey cast iron
<180 HB
(Vc = 90 - 110 m/min)

Stale / Steels <1450 N/mm²
(Vc = 65 - 85 m/min)

Kod	D [mm]	d [mm]	l [mm]	L [mm]	fz [mm/z]	fz [mm/z]	fz [mm/z]
THM917-0100-RS06-AP	1	6	4	40	0,002	0,001	0,001
THM917-0150-RS06-AP	1.5	6	4	40	0,002	0,001	0,001
THM917-0200-RS06-AP	2	6	6	40	0,003	0,002	0,002
THM917-0250-RS06-AP	2.5	6	6	40	0,004	0,003	0,003
THM917-0300-RS06-AP	3	6	7	40	0,006	0,005	0,004
THM917-0350-RS06-AP	3.5	6	7	40	0,006	0,005	0,004
THM917-0400-RS06-AP	4	6	8	40	0,007	0,005	0,004
THM917-0450-RS06-AP	4.5	6	8	40	0,008	0,006	0,005
THM917-0500-RS06-AP	5	6	10	40	0,009	0,007	0,006
THM917-0550-RS06-AP	5.5	6	10	40	0,010	0,008	0,007