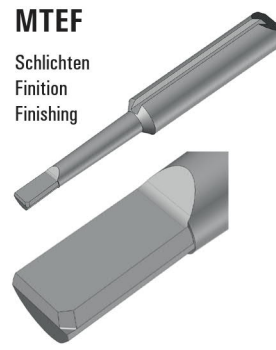
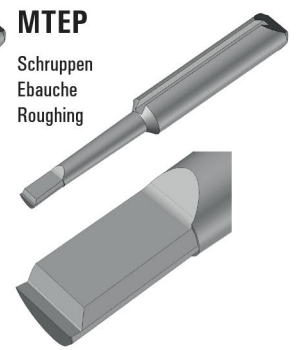
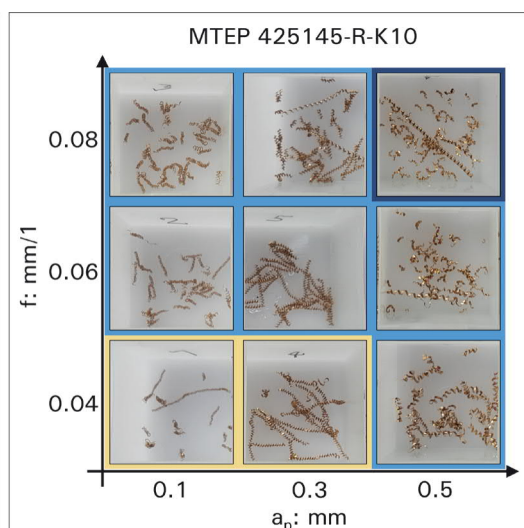
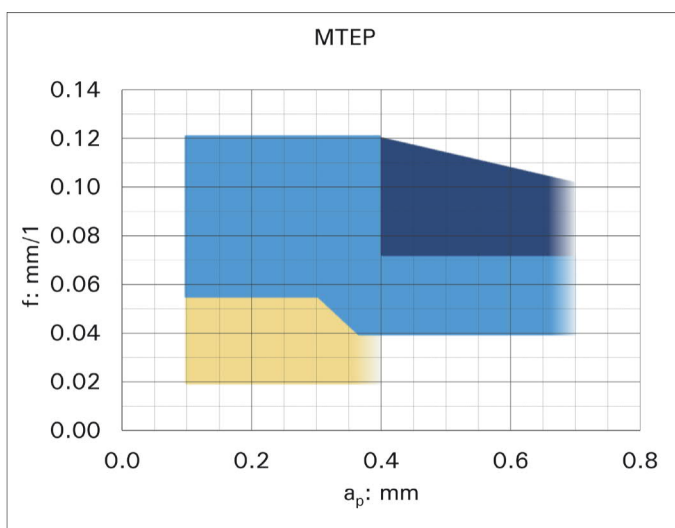
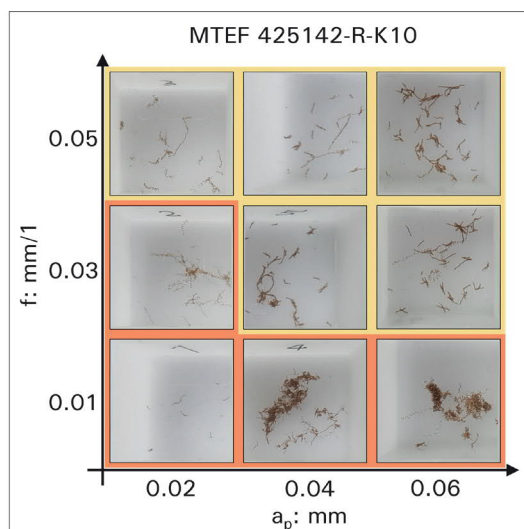
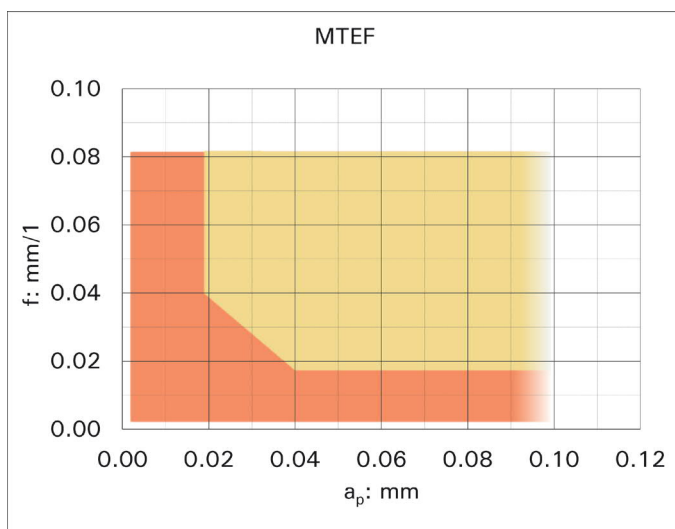
 $\gamma$ : Spanwinkel $\gamma$ : Angle de coupe $\gamma$ : Rake angle**MTEF**Schlichten  
Finition  
Finishing**MTEP**Schruppen  
Ebauche  
Roughing

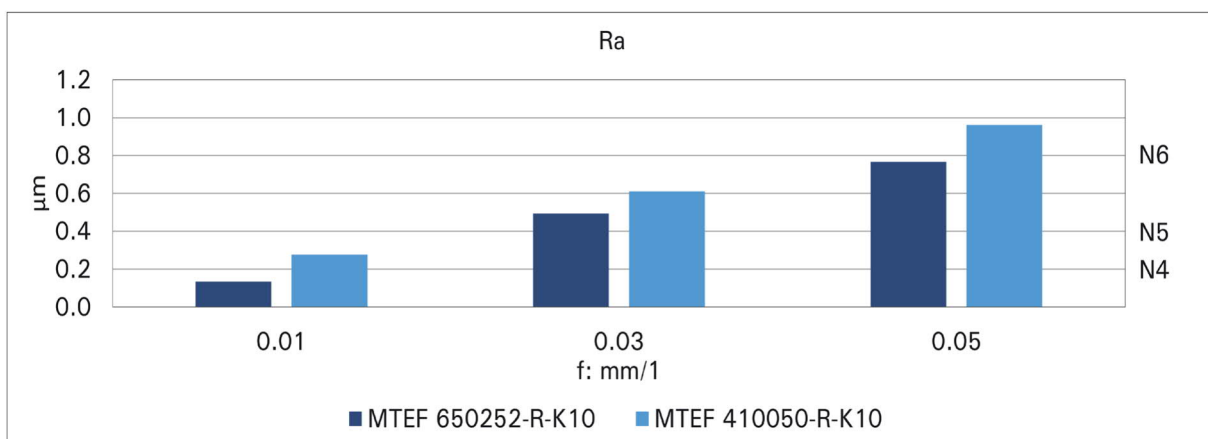
ØS	L	L <sub>1</sub>	L <sub>2</sub>	F	$\gamma$	ØD <sub>min</sub>	R, MTEF	R, MTEP	MTEF	MTEP
4	26	1,2	10	0,50	12°	1,0	0		MTEF 410020-R-K10	
4	26	3	10	0,50	12°	1,0	0		MTEF 410030-R-K10	
4	26	5	10	0,50	12°	1,0	0		MTEF 410050-R-K10	
4	26	2	10	0,60	12°	1,2	0		MTEF 412020-R-K10	
4	31	4	15	0,60	12°	1,2	0		MTEF 412040-R-K10	
4	31	7	15	0,60	12°	1,2	0		MTEF 412070-R-K10	
4	26	3	10	0,75	12°	1,5	0		MTEF 415030-R-K10	
4	31	5	15	0,75	12°	1,5	0		MTEF 415050-R-K10	
4	31	8	15	0,75	12°	1,5	0		MTEF 415080-R-K10	
4	26	4	10	0,90	12°	1,8	0		MTEF 418040-R-K10	
4	31	5	15	0,90	12°	1,8	0		MTEF 418050-R-K10	
4	31	9	15	0,90	12°	1,8	0		MTEF 418090-R-K10	
4	31	6	15	1,10	12°	2,2	0		MTEF 422060-R-K10	
4	31	10	15	1,10	12°	2,2	0		MTEF 422100-R-K10	
4	31	14	15	1,10	12°	2,2	0		MTEF 422140-R-K10	
4	31	6	15	1,25	12°	2,5	0,02x45°	R0,05	MTEF 425062-R-K10	MTEP 425065-R-K10
4	31	10	15	1,25	12°	2,5	0,02x45°	R0,05	MTEF 425102-R-K10	MTEP 425105-R-K10
4	31	14	15	1,25	12°	2,5	0,02x45°	R0,05	MTEF 425142-R-K10	MTEP 425145-R-K10
4	31	8	15	1,60	12°	3,2	0,02x45°	R0,05	MTEF 432082-R-K10	MTEP 432085-R-K10
4	31	12	15	1,60	12°	3,2	0,02x45°	R0,05	MTEF 432122-R-K10	MTEP 432125-R-K10
4	36	17	20	1,60	12°	3,2	0,02x45°	R0,05	MTEF 432172-R-K10	MTEP 432175-R-K10
4	31	10	15	1,95	12°	4,0	0,02x45°	R0,05	MTEF 440102-R-K10	MTEP 440105-R-K10
4	31	14	15	1,95	12°	4,0	0,02x45°	R0,05	MTEF 440142-R-K10	MTEP 440145-R-K10
4	36	19	20	1,95	12°	4,0	0,02x45°	R0,05	MTEF 440192-R-K10	MTEP 440195-R-K10
6	35	12	16	2,50	12°	5,0	0,02x45°	R0,05	MTEF 650122-R-K10	MTEP 650125-R-K10
6	43	17	24	2,50	12°	5,0	0,02x45°	R0,05	MTEF 650172-R-K10	MTEP 650175-R-K10
6	48	25	29	2,50	12°	5,0	0,02x45°	R0,05	MTEF 650252-R-K10	MTEP 650255-R-K10
6	35	12	16	2,95	12°	6,0	0,02x45°	R0,05	MTEF 660122-R-K10	MTEP 660125-R-K10
6	43	20	24	2,95	12°	6,0	0,02x45°	R0,05	MTEF 660202-R-K10	MTEP 660205-R-K10
6	53	30	34	2,95	12°	6,0	0,02x45°	R0,05	MTEF 660302-R-K10	MTEP 660305-R-K10



Oberflächengüte

État de surface

Surface roughness



Hinweise

Innenkühlung unterstützt die Spanabfuhr.  
Hochdruck wird empfohlen.

Remarques

L'arrosage interne favorise l'évacuation des copeaux. La haute pression est recommandée.

Notes

Internal cooling supports chip removal.  
High pressure recommended.