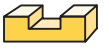
# Nutenfräsen

| | | | |
|---|---|---|---|
| **Schneidstoff** | **K10-20** | **VHM-UF** | **K10-20** |
| **Norm** | 6527 | 6527 | 6527 |
| **Typ** | N | N | N |
| **Oberfläche** | **TiAlN** | | **TiAlN** |
| **Bestell-Nr.** | **15 352 010–043 (HB)** | **15 352 100–142 (HA)** | **15 354 013–052 (HB)** |
| **Schneidenzahl** | 3-schneidig | 3-schneidig | 3-schneidig |
| | **Seite 2/58** | **Seite 2/59** | **Seite 2/59** |
| | | | |
| Zustellung/ Anwendung | $a_p = 0,5 \times D$ |  $a_p = 1 \times D$ | $a_p = 0,5 \times D$ |

| $v_c$ m/min | VR-Code | $v_c$ m/min | VR-Code | $v_c$ m/min | VR-Code |
|---|---|---|---|---|---|
| 98–120 | **43** | 51–63 | **42** | 85–105 | **42** |
| 93–115 | **42** | 48–60 | **40** | 81– 99 | **41** |
| 98–120 | **42** | 51–63 | **40** | 85–105 | **41** |
| 72– 90 | **43** | 37–47 | **41** | 63– 77 | **42** |
| 98–120 | **42** | 51–63 | **40** | 85–105 | **41** |
| 88–108 | **42** | 45–57 | **40** | 76– 94 | **41** |
| 72– 90 | **43** | 37–47 | **41** | 63– 77 | **42** |
| 88–108 | **43** | 45–57 | **41** | 76– 94 | **42** |
| 72– 90 | **43** | 37–47 | **41** | 63– 77 | **42** |
| 103–127 | **42** | 54–66 | **40** | 90–110 | **41** |
| 88–108 | **42** | 45–57 | **40** | 76– 94 | **41** |
| 62– 76 | **43** | 32–40 | **41** | 54– 66 | **42** |
| 98–120 | **42** | 51–63 | **40** | 85–105 | **41** |
| 88–108 | **41** | 45–57 | **39** | 76– 94 | **40** |
| 88–108 | **42** | 45–57 | **40** | 76– 94 | **41** |
| 72– 90 | **41** | 37–47 | **39** | 63– 77 | **40** |
| 52– 64 | **43** | 27–33 | **41** | 45– 55 | **42** |
| 52– 64 | **41** | 27–33 | **39** | 45– 55 | **40** |
| 52– 64 | **43** | 27–33 | **41** | 45– 55 | **42** |
| 46– 58 | **41** | 24–30 | **39** | 40– 50 | **40** |
| 41– 51 | **42** | 21–27 | **40** | 36– 44 | **41** |
| 52– 64 | **41** | 27–33 | **39** | 45– 55 | **40** |
| 31– 39 | **41** | 16–20 | **39** | 27– 33 | **40** |
| 124–152 | **42** | 64–80 | **40** | 108–132 | **41** |
| 114–140 | **41** | 59–73 | **39** | 99–121 | **40** |
| 103–127 | **42** | 54–66 | **40** | 90–110 | **41** |
| 93–115 | **41** | 48–60 | **39** | 81– 99 | **40** |
| 62– 76 | **41** | 32–40 | **39** | 54– 66 | **40** |
| 52– 64 | **41** | 27–33 | **39** | 45– 55 | **40** |
| 41– 51 | **41** | 21–27 | **39** | 36– 44 | **40** |
| 1,5 x D = 75 % | | 1,5 x D = 75 %<br>2 x D = 50 % | | 1,5 x D = 75 %<br>2 x D = 50 % | |