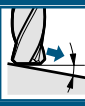
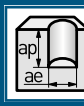
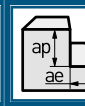
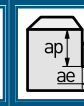


F2004MN – DUO-LOCK® HAIMER MILL FASE/CHAMFER

Schnittdaten/Cutting data

| HAIMER Werkstoff Gruppen HAIMER Material groups | Beispiel Werkstoffe Example material | Werkstoffnr. Material no. | Werkstoff Information Material information | | Schnittbreite/Cutting width     | Rampe Ramping | Schnittgeschwindigkeit Vc (m/min) Cutting speed Vc (m/min) | | |
|---|---|--------------------------------|---|--------------------------------------|--|------------------|---|-----------------------------|----------------------------|
| | | | Zugfestigkeit Tensile strength | Inhalt/Härte Content/ Hardness | | | ae = 100% D1 ap = 1 x D1 | ae = 15% D1 ap = L1 max. | ae = 5% D1 ap = L1 max. |
| P1 Allg. Bau-, Einsatzstähle General construction steels | S235JR (RST37-2), E295 (St 50-2), C45 | 1.0038, 1.0050, 1.0503 | ≤ 800 N/mm² | bis 25 HRC up to 25 HRC | | 45° | 255 – 275 | 320 – 340 | 400 – 420 |
| P2 Werkzeug/ Vergütungsstähle Heat treated steels | X38CrMoV5-3, X153CrMoV12, X100CrMoV5, 42CrMo4 | 1.2367, 1.2379, 1.2363, 1.7225 | > 800 N/mm² | bis 45 HRC up to 45 HRC | | 30° | 190 – 210 | 220 – 240 | 290 – 310 |
| M1 Rostfreie Stähle Stainless steels | X8CrNiS18-9, X5CrNi18-10, X46Cr13 | 1.4305, 1.4301, 1.4034 | ≤ 650 N/mm² | | | 10° | 95 – 110 | 115 – 135 | 150 – 170 |
| M2 Rostfreie Stähle Stainless steels | X6CrNiMoTi17-12-2, X2CrNiMo17-12-2, X4CrNiMo16-5-1 | 1.4571, 1.4404, 1.4418 | > 650 N/mm² | | | 5° | 75 – 90 | 95 – 105 | 110 – 130 |
| K1 Gusseisen Cast iron | EN-GJL200 (GG20), EN-GJLZ (GG40), EN-GJS-400-15 (GGG40) | 0.6020, 0.6040, 0.7040 | ≤ 450 N/mm² | | | 45° | 160 – 180 | 180 – 200 | 210 – 230 |
| K2 Gusseisen Cast iron | EN-GJS-600-3 (GGG60) EN-GJS-700-2 (GGG70) | 0.7060, 0.7070 | > 450 N/mm² | | | 20° | 130 – 150 | 150 – 170 | 180 – 200 |
| S1 Titan & Titanlegierungen Titanium & titanium alloys | TiAl6V4 | 3.7165 | | | | 10° | 50 – 60 | 60 – 80 | 80 – 90 |
| S2 Warmfeste Legierungen High Temp alloys | Inconel; NIMONIC | | 800 – 1700 N/mm² | | | 5° | 30 – 40 | 30 – 40 | 30 – 40 |
| N1 Alu-Knetlegierungen Wrought aluminum alloys | AlMg1 | 3.3315 | | Si < 9% | | 30° | 470 – 490 | 600 – 630 | 780 – 820 |
| N2 Alu-Gusslegierungen Aluminum cast alloys | G-Alsi12 | 3.2581 | | Si > 9% | | 30° | 340 – 360 | 420 – 440 | 540 – 580 |
| H1 Gehärtete Stähle Hardened steels | | | | 45 – 55 HRC | | 10° | 40 – 60 | 60 – 80 | 60 – 80 |

Schnittdaten dienen als Richtwerte und müssen dem Bearbeitungsumfeld angepasst werden.
Beim Bohren wird Entspannen je nach Werkstoff, bei 0,5 – 1 x D empfohlen.
Cutting data are reference values and need to be adjusted according to the application area.
Chip removal recommended for drilling depth 0,5 – 1 x D.

| Vorschubtable f _z (mm/Zahn) abhängig von D1 und Schnittbreite ae / Feed per tooth (mm/tooth) in relation with D1 and cutting width ae | | | | | | |
|--|---------------|---------------|---------------|---------------|---------------|---------------|
| | ø 2 | ø 3 | ø 4 | ø 5 | ø 6 | ø 8 |
| f _z | 0,006 – 0,018 | 0,009 – 0,027 | 0,012 – 0,036 | 0,015 – 0,045 | 0,018 – 0,054 | 0,024 – 0,072 |
| | ø 10 | ø 12 | ø 16 | ø 20 | ø 25 | ø 32 |
| f _z | 0,03 – 0,09 | 0,03 – 0,10 | 0,04 – 0,12 | 0,05 – 0,13 | 0,06 – 0,17 | 0,07 – 0,20 |

Schnittdaten Basis zylindrische Verlängerung kurz, Schnittdaten bei längeren Auskragungen anpassen.
Cutting data is based on cylindrical extensions short, cutting data for long overhang need to be adjusted.