

# CoroMill® Plura

Optimiert

## Schnittgeschwindigkeitsempfehlungen

Schaffräser für die Heavy Duty Fräsbearbeitung																		
				1730		1740		1730		1740		1730		1740				
MC-Nr.	CMC-Nr.	Werkstoff	HB	f <sub>z</sub>	vc m/min	vc Fuß/min	vc m/min	vc Fuß/min	f <sub>z</sub>	vc m/min	vc Fuß/min	vc m/min	vc Fuß/min	f <sub>z</sub>	vc m/min	vc Fuß/min	vc m/min	vc Fuß/min
P1.1.Z.AN	01.1	Unlegierter Stahl	125	A	180	590	144	472	B	216	708	173	566	C	302	992	242	793
P1.2.Z.AN	01.2	Unlegierter Stahl	150	A	150	492	120	394	B	180	590	144	472	C	252	826	202	661
P1.3.Z.AN	01.3	Unlegierter Stahl	170	A	135	442	108	354	B	162	531	130	425	C	227	744	181	595
P2.2.Z.AN	02.2	Niedriglegierter Stahl	300	D	120	393	96	314	B	144	472	115	378	C	202	661	161	529
P3.0.Z.HT	03.22	Hoch legierter Stahl	380	D	80	262	64	210	B	96	314	77	251	C	134	440	108	352
P5.0.Z.AN	05.11	Ferritisch/martensitischer rostfreier Stahl	200	D	130	426	104	341	B	156	511	125	409	C	218	716	175	573
M1.0.Z.AQ	05.21	Austenischer rostfreier Stahl	200	D	68	210	80	262	E	85	278	100	328	F	119	390	140	459
M2.0.Z.AQ	05.23	Super austenitischer rostfreier Stahl	200	D	64	210	80	262	E	77	251	96	314	F	108	352	134	440
M3.2.Z.AQ	05.52	Rostfreie (austenitische/ferritische) Duplex-Stähle	260	G	64	210	80	262	H	77	251	96	314	I	108	352	134	440
K1.1.C.NS	07.2	Temperguss	220	A	150	492	113	369	B	180	590	135	442	C	252	826	189	620
K2.1.C.UT	08.2	Grauguss	215	A	150	492	113	369	B	180	590	135	442	C	252	826	189	620
K3.2.C.UT	09.2	Kugelgraphitguss	200	A	160	524	120	393	B	192	629	144	472	C	269	881	202	661
S1.0.U.AG	20.12	Eisen basierte Superlegierungen	280	D	60	197	80	262	E	72	236	96	314	F	101	330	134	440
S2.0.Z.AG	20.22	Nickel basierte Superlegierungen	350	G	45	147	60	196	H	54	177	72	236	I	76	248	101	330
S4.3.Z.AN	23.22	Titan basierte Legierungen	350	G	45	147	60	196	H	54	177	72	236	I	76	248	101	330

Für optimierte Schnittdaten, siehe CoroGuide 2.0.

## Vorschubempfehlungen

DC	mm	2.000	3.000	3.175	4.000	4.765	6.000	6.350	7.938	8.000	9.525	10.000	11.113	12.000	12.700	14.000	15.875	16.000	18.000	19.050	20.000	25.000	
	Zoll	.079	.118	.125	.157	.188	.236	.250	.313	.315	.375	.394	.438	.472	.500	.551	.625	.630	.709	.750	.787	.984	
f <sub>z</sub> Code																							
A	mm	-	0.020	0.024	0.024	0.028	0.030	0.035	0.036	0.042	0.043	0.048	0.050	0.054	0.057	0.059	0.063	0.070	0.070	0.077	0.080	0.083	0.100
	Zoll	-	.0008	.0009	.0010	.0011	.0012	.0014	.0014	.0017	.0017	.0019	.0020	.0021	.0022	.0023	.0025	.0027	.0028	.0030	.0032	.0033	.0039
B	mm	-	0.024	0.030	0.031	0.036	0.040	0.047	0.049	0.058	0.059	0.067	0.070	0.076	0.080	0.084	0.090	0.099	0.100	0.110	0.115	0.120	0.145
	Zoll	-	.0009	.0012	.0012	.0014	.0016	.0019	.0019	.0023	.0023	.0026	.0028	.0030	.0031	.0033	.0035	.0039	.0039	.0043	.0045	.0047	.0057
C	mm	-	0.028	0.035	0.036	0.041	0.046	0.054	0.056	0.067	0.067	0.077	0.080	0.087	0.093	0.098	0.107	0.119	0.120	0.133	0.140	0.147	0.180
	Zoll	-	.0011	.0014	.0014	.0016	.0018	.0021	.0022	.0026	.0026	.0030	.0031	.0034	.0037	.0039	.0042	.0047	.0047	.0052	.0055	.0058	.0071
D	mm	-	0.020	0.023	0.023	0.025	0.027	0.030	0.031	0.035	0.035	0.039	0.040	0.044	0.047	0.049	0.053	0.060	0.060	0.067	0.070	0.073	0.090
	Zoll	-	.0008	.0009	.0009	.0010	.0011	.0012	.0012	.0014	.0014	.0015	.0016	.0017	.0018	.0019	.0021	.0023	.0024	.0026	.0028	.0029	.0035
E	mm	-	0.020	0.023	0.023	0.025	0.028	0.037	0.040	0.051	0.052	0.063	0.067	0.072	0.076	0.079	0.084	0.093	0.0933	0.102	0.107	0.111	0.133
	Zoll	-	.0008	.0009	.0009	.0010	.0011	.0015	.0016	.0020	.0020	.0025	.0026	.0028	.0030	.0031	.0033	.0037	.0037	.0040	.0042	.0044	.0052
F	mm	-	0.020	0.023	0.023	0.026	0.033	0.040	0.047	0.061	0.062	0.076	0.080	0.086	0.090	0.094	0.100	0.109	0.110	0.120	0.125	0.130	0.200
	Zoll	-	.0008	.0009	.0009	.0010	.0013	.0017	.0019	.0024	.0024	.0030	.0031	.0034	.0035	.0037	.0039	.0043	.0043	.0047	.0049	.0051	.0079
G	mm	-	0.020	0.020	0.020	0.020	0.020	0.020	0.021	0.027	0.028	0.033	0.035	0.037	0.038	0.040	0.042	0.045	0.045	0.048	0.050	0.052	0.060
	Zoll	-	.0008	.0008	.0008	.0008	.0008	.0008	.0008	.0011	.0011	.0013	.0014	.0015	.0015	.0016	.0016	.0018	.0018	.0019	.0020	.0020	.0024
H	mm	-	0.024	0.026	0.027	0.029	0.030	0.033	0.034	0.037	0.038	0.041	0.042	0.045	0.048	0.050	0.054	0.060	0.060	0.066	0.069	0.072	0.087
	Zoll	-	.0009	.0010	.0010	.0011	.0012	.0013	.0013	.0015	.0015	.0016	.0017	.0018	.0019	.0020	.0021	.0023	.0024	.0026	.0027	.0028	.0034
I	mm	-	0.030	0.033	0.033	0.035	0.037	0.040	0.041	0.045	0.045	0.049	0.050	0.061	0.070	0.077	0.091	0.110	0.111	0.131	0.142	0.152	0.203
	Zoll	-	.0012	.0013	.0013	.0014	.0015	.0016	.0016	.0018	.0018	.0019	.0020	.0024	.0028	.0030	.0036	.0043	.0044	.0052	.0056	.0060	.0080

## Eintauchwinkel

Werkstoffgruppe	Werkstoff	Eintauchwinkel	
		ZEFP=4	ZEFP=5
P	Stahl	7*	5*
M	Rostfreier Stahl	7	5
K	Grauguss	10	6
S	Hochwarmfeste Legierungen und Titanlegierungen	7	5

\*Bei R<sub>m</sub>> 1100 N/mm<sup>2</sup> Eintauchwinkel um 25% reduzieren