

H-4EM / H-6EM / H-8EM

Schnittdatenempfehlungen
Cutting data recommendations



| Umsäumen / side milling | | | | | | | | | | | | | | | | |
|------------------------------|---|------------------|------------------------------|-------------------------------------|-------------------|------------------|------------------------------|-------------------------------------|-------------------|------------------|------------------------------|-------------------------------------|-------------------|------------------|------------------------------|------------|
| Material | legierte Stähle alloy steels | | | gehärtete Stähle hardened steels | | | | gehärtete Stähle hardened steels | | | | gehärtete Stähle hardened steels | | | | |
| Härte hardness | 30 ~ 40HRC | | | 40 ~ 50HRC | | | | 50 ~ 55HRC | | | | 55 ~ 60HRC | | | | |
| Ø | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | | Drehzahl rpm | Vorschub feed | Schnitttiefe depth of cut | |
| | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) | min ⁻¹ | mm / min | Ap (mm) | Ae (mm) |
| 1,00 | 40.000 | 1200 | 1,500 | 0,050 | 45.000 | 1100 | 1,500 | 0,050 | 40.000 | 770 | 0,500 | 0,030 | 38.000 | 308 | 0,500 | 0,060 |
| 1,50 | 40.000 | 1500 | 2,250 | 0,075 | 40.000 | 1250 | 2,250 | 0,075 | 38.500 | 875 | 0,750 | 0,045 | 35.600 | 350 | 0,750 | 0,240 |
| 2,00 | 40.000 | 2000 | 3,000 | 0,100 | 38.000 | 1800 | 3,000 | 0,100 | 36.500 | 1260 | 1,000 | 0,060 | 31.000 | 504 | 1,000 | 0,045 |
| 3,00 | 38.400 | 4560 | 4,500 | 0,150 | 34.560 | 4104 | 4,500 | 0,150 | 27.648 | 2873 | 1,500 | 0,090 | 22.118 | 1149 | 1,500 | 0,300 |
| 4,00 | 28.800 | 5280 | 6,000 | 0,200 | 25.920 | 4752 | 6,000 | 0,200 | 20.736 | 3326 | 2,000 | 0,120 | 16.589 | 1331 | 2,000 | 0,030 |
| 5,00 | 24.000 | 6000 | 7,500 | 0,250 | 21.600 | 5400 | 7,500 | 0,250 | 17.280 | 3780 | 2,500 | 0,150 | 13.824 | 1512 | 2,500 | 0,090 |
| 6,00 | 19.200 | 6960 | 9,000 | 0,300 | 17.280 | 6264 | 9,000 | 0,300 | 13.824 | 4385 | 3,000 | 0,180 | 11.059 | 1754 | 3,000 | 0,120 |
| 8,00 | 14.400 | 6960 | 12,000 | 0,400 | 12.960 | 6264 | 12,000 | 0,400 | 10.368 | 4385 | 4,000 | 0,240 | 8.294 | 1754 | 4,000 | 0,750 |
| 10,00 | 11.520 | 6960 | 15,000 | 0,500 | 10.368 | 6264 | 15,000 | 0,500 | 8.294 | 4385 | 5,000 | 0,300 | 6.636 | 1754 | 5,000 | 0,600 |
| 12,00 | 9.600 | 5760 | 18,000 | 0,600 | 8.640 | 5184 | 18,000 | 0,600 | 6.912 | 3629 | 6,000 | 0,360 | 5.530 | 1452 | 6,000 | 0,480 |
| 16,00 | 7.200 | 4320 | 24,000 | 0,800 | 6.480 | 3888 | 24,000 | 0,800 | 5.184 | 2722 | 8,000 | 0,480 | 4.147 | 1089 | 8,000 | 0,360 |
| 20,00 | 5.760 | 3480 | 30,000 | 1,000 | 5.184 | 3132 | 30,000 | 1,000 | 4.147 | 2192 | 10,000 | 0,600 | 3.318 | 877 | 10,000 | 0,150 |
| 25,00 | 5.150 | 3120 | 37,500 | 1,250 | 4.635 | 2808 | 37,500 | 1,250 | 3.708 | 2246 | 12,500 | 0,750 | 2.966 | 899 | 12,500 | 0,180 |
| Schnitttiefe depth of cut | | | | | | | | | | | | | | | | |
| | <div><div><div>~ 50HRC</div><div><div>0,05D</div><div>1,50D</div></div></div><div><div>50HRC ~</div><div><div>0,03D</div><div>0,50D</div></div></div></div> | | | | | | | | | | | | | | | |

Verwenden Sie beim H-6EM und H-8EM die gleiche Drehzahl und erhöhen den Vorschub pro Zahn um bis zu 50%, um stabil zu fräsen.
For the H-6EM and H-8EM use the same rpm and raise up the feed per tooth up to 50% for stable milling.