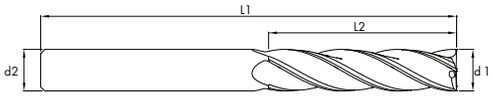
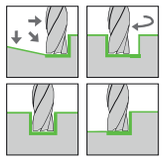
# SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER LANG

KARBÜR FREZE UZUN





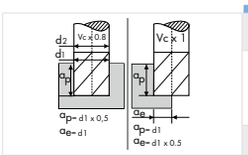



## BLITZ LONG

<52 HRC


| $d_1$(e8) | $L_2$ | $L_1$ | $d_2$(h6) | Z | Uncoated Code | Coated Code |
|---|---|---|---|---|---|---|
| 3 | 16 | 65 | 3 | 4 | 4003720 | 4003730 |
| 4 | 18 | 65 | 4 | 4 | 4003740 | 4003750 |
| 5 | 20 | 65 | 5 | 4 | 4003760 | 4003770 |
| 6 | 24 | 68 | 6 | 4 | 4003780 | 4003790 |
| 8 | 38 | 88 | 8 | 4 | 4003800 | 4003810 |
| | | | | | | |
| 3 | 20 | 100 | 3 | 4 | 4003820 | 4003830 |
| 4 | 26 | 100 | 4 | 4 | 4003840 | 4003850 |
| 5 | 26 | 100 | 5 | 4 | 4003860 | 4003870 |
| 6 | 40 | 100 | 6 | 4 | 4003880 | 4003890 |
| 8 | 45 | 100 | 8 | 4 | 4003900 | 4003910 |
| 10 | 45 | 100 | 10 | 4 | 4003920 | 4003930 |
| 12 | 45 | 100 | 12 | 4 | 4003940 | 4003950 |
| 14 | 45 | 100 | 14 | 4 | 4003960 | 4003970 |
| 16 | 45 | 100 | 16 | 4 | 4003980 | 4003990 |
| 18 | 45 | 100 | 18 | 4 | 4004000 | 4004010 |
| 20 | 45 | 104 | 20 | 4 | 4004020 | 4004030 |

| $d_1$(e8) | $L_2$ | $L_1$ | $d_2$(h6) | Z | Uncoated Code | Coated Code |
|---|---|---|---|---|---|---|
| | | | | | | |
| 8 | 40 | 130 | 8 | 4 | 4004040 | 4004050 |
| 10 | 50 | 130 | 10 | 4 | 4004060 | 4004070 |
| 12 | 50 | 130 | 12 | 4 | 4004080 | 4004090 |
| 14 | 50 | 130 | 14 | 4 | 4004100 | 4004110 |
| 16 | 60 | 130 | 16 | 4 | 4004120 | 4004130 |
| 18 | 60 | 130 | 18 | 4 | 4004140 | 4004150 |
| 20 | 60 | 130 | 20 | 4 | 4004160 | 4004170 |
| | | | | | | |
| 10 | 65 | 165 | 10 | 4 | 4004180 | 4004190 |
| 12 | 65 | 165 | 12 | 4 | 4004200 | 4004210 |
| 14 | 65 | 165 | 14 | 4 | 4004220 | 4004230 |
| 16 | 75 | 165 | 16 | 4 | 4004240 | 4004250 |
| 18 | 75 | 165 | 18 | 4 | 4004260 | 4004270 |
| 20 | 75 | 165 | 20 | 4 | 4004280 | 4004290 |
| 25 | 75 | 165 | 25 | 4 | 4004300 | 4004310 |




| | P (20-30 Hrc) | | | P (30-40 Hrc) | | | M | | | GG | | | AL | | | CU | | | Titan | | | < 52 HRC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 1.0050-2<br>1.0060-2<br>1.0070-2 | | | 1.5864<br>1.6580<br>1.7225 | | | 1.4405<br>1.4460<br>1.4505 | | | 0.6035<br>0.7080<br>0.8055 | | | 3.2151<br>3.2373<br>3.2382 | | | 2.1247<br>2.0580<br>2.0598 | | | 3.7035<br>3.7055<br>3.7065 | | | 1.3255<br>1.3265<br>1.3333 | | |
| | Vc=100 m/dk. | | | Vc = 80 m/dk. | | | Vc = 55 m/dk. | | | Vc= 120 m/dk. | | | Vc = 300 m/dk. | | | Vc = 190 m/dk. | | | Vc = 45 m/dk. | | | Vc = 45 m/dk. | | |
| d1 | ap | ae | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf |
| 3 | 1.5 | 1.5 | 0.015 | 10616 | 160XZ | 0.015 | 8492 | 130XZ | 0.020 | 5838 | 115XZ | 0.043 | 12738 | 550XZ | 0.036 | 31846 | 1150XZ | 0.037 | 20170 | 755XZ | 0.012 | 4777 | 55XZ | 0.011 | 4777 | 50XZ |
| 4 | 2.0 | 2.0 | 0.020 | 7962 | 160xZ | 0.020 | 6370 | 130xZ | 0.026 | 4379 | 115xZ | 0.058 | 9554 | 550xZ | 0.048 | 23885 | 1150xZ | 0.050 | 15127 | 755 xZ | 0.015 | 3582 | 55 xZ | 0.014 | 3582 | 50 xZ |
| 5 | 2.5 | 2.5 | 0.025 | 6370 | 160xZ | 0.025 | 5100 | 130xZ | 0.033 | 3503 | 115xZ | 0.072 | 7643 | 550xZ | 0.060 | 19108 | 1150xZ | 0.062 | 12102 | 755 xZ | 0.019 | 2866 | 55 xZ | 0.017 | 2866 | 50 xZ |
| 6 | 3.0 | 3.0 | 0.030 | 5308 | 160xZ | 0.030 | 4250 | 130xZ | 0.039 | 2919 | 115xZ | 0.086 | 6369 | 550xZ | 0.072 | 15923 | 1150xZ | 0.075 | 10085 | 755 xZ | 0.023 | 2388 | 55 xZ | 0.021 | 2388 | 50 xZ |
| 8 | 4.0 | 4.0 | 0.040 | 3981 | 160xZ | 0.040 | 3185 | 130xZ | 0.053 | 2189 | 115xZ | 0.115 | 4777 | 550xZ | 0.092 | 11942 | 1150xZ | 0.100 | 7564 | 755 xZ | 0.031 | 1791 | 55 xZ | 0.028 | 1791 | 50 xZ |
| 10 | 5.0 | 5.0 | 0.050 | 3185 | 160xZ | 0.050 | 2550 | 130xZ | 0.066 | 1751 | 115xZ | 0.144 | 3821 | 550xZ | 0.120 | 9554 | 1150xZ | 0.125 | 6051 | 755 xZ | 0.038 | 1433 | 55 xZ | 0.035 | 1433 | 50 xZ |
| 12 | 6.0 | 6.0 | 0.060 | 2654 | 160xZ | 0.060 | 2123 | 130xZ | 0.079 | 1460 | 115xZ | 0.173 | 3185 | 550xZ | 0.144 | 7962 | 1150xZ | 0.150 | 5042 | 755 xZ | 0.046 | 1194 | 55 xZ | 0.042 | 1194 | 50 xZ |
| 14 | 7.0 | 7.0 | 0.070 | 2275 | 160xZ | 0.070 | 1820 | 130xZ | 0.092 | 1251 | 115xZ | 0.202 | 2730 | 550xZ | 0.168 | 6824 | 1150xZ | 0.175 | 4322 | 755 xZ | 0.054 | 1024 | 55 xZ | 0.049 | 1024 | 50 xZ |
| 16 | 8.0 | 8.0 | 0.080 | 1990 | 160xZ | 0.080 | 1592 | 130xZ | 0.105 | 1095 | 115xZ | 0.230 | 2388 | 550xZ | 0.193 | 5971 | 1150xZ | 0.200 | 3782 | 755 xZ | 0.062 | 896 | 55 xZ | 0.056 | 896 | 50 xZ |
| 18 | 9.0 | 9.0 | 0.090 | 1760 | 160xZ | 0.090 | 1415 | 130xZ | 0.118 | 973 | 115xZ | 0.259 | 2123 | 550xZ | 0.217 | 5308 | 1150xZ | 0.225 | 3362 | 755 xZ | 0.070 | 796 | 55 xZ | 0.063 | 796 | 50 xZ |
| 20 | 10.0 | 10.0 | 0.100 | 1592 | 160xZ | 0.100 | 1275 | 130xZ | 0.131 | 875 | 115xZ | 0.288 | 1910 | 550xZ | 0.241 | 4777 | 1150xZ | 0.250 | 3025 | 755 xZ | 0.078 | 716 | 55 xZ | 0.070 | 716 | 50 xZ |
| 25 | 12.5 | 12.5 | 0.130 | 1274 | 160xZ | 0.130 | 1020 | 130xZ | 0.164 | 700 | 115xZ | 0.360 | 1528 | 550xZ | 0.300 | 3822 | 1150xZ | 0.312 | 2420 | 755 xZ | 0.086 | 573 | 55 xZ | 0.087 | 573 | 50 xZ |