

- EN** Taper shank end mills, NR
- DE** Schafffräser mit MK, NR
- RU** Фрезы концевые с коническим хвостовиком, NR

DIN 228A

DIN 2207
D_z≥32

DIN Ø45B

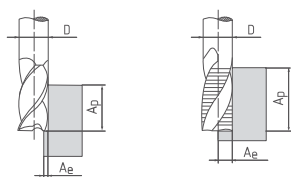
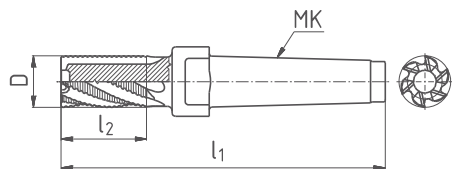
DIN Ø45C

typ NR

λ=30°
γ=12°

HSS
Co8

4242
4252



| D k 12 | MK | l ₁ | | l ₂ | | Z | | |
|-----------|----|----------------|------|----------------|------|---|--------|--------|
| | | 4242 | 4252 | 4242 | 4252 | | 424248 | 425248 |
| 10 | 1 | 92 | | 22 | | 4 | .100 | |
| 12 | 1 | 96 | | 26 | | 4 | .120 | |
| 14 | 2 | 111 | | 26 | | 4 | .140 | |
| 16 | 2 | 117 | 148 | 32 | 63 | 4 | .160 | .160 |
| 18 | 2 | 117 | | 32 | | 4 | .180 | |
| 20 | 2 | 123 | 160 | 38 | 75 | 4 | .200 | .200 |
| 22 | 2 | 123 | 160 | 38 | 75 | 5 | .220 | .220 |
| 24 | 3 | 147 | 192 | 45 | 90 | 5 | .240 | .240 |
| 25 | 3 | 147 | 192 | 45 | 90 | 5 | .250 | .250 |
| 26 | 3 | 147 | 192 | 45 | 90 | 5 | .260 | .260 |
| 28 | 3 | 147 | 192 | 45 | 90 | 5 | .280 | .280 |
| 30 | 3 | 147 | 192 | 45 | 90 | 5 | .300 | .300 |
| 32 | 4 | 201 | 254 | 53 | 106 | 6 | .320 | .320 |
| 35 | 4 | 201 | | 53 | | 6 | .350 | |
| 36 | 4 | 201 | 254 | 53 | 106 | 6 | .360 | .360 |
| 40 | 4 | 211 | 273 | 63 | 125 | 6 | .400 | .400 |
| 41 | 4 | 211 | | 63 | | 6 | .410 | |
| 45 | 4 | 211 | 273 | 63 | 125 | 6 | .450 | .450 |
| 50 | 5 | 261 | 336 | 75 | 150 | 8 | .500 | .500 |
| 63 | 5 | 276 | 366 | 90 | 180 | 8 | .630 | .630 |

Řezné podmínky / Cutting conditions / Schnittbedingungen / Условия резания

| Material | A _p | A _e | V _c | f _z (mm/z) | | | | | |
|------------|-----------------------------|----------------|----------------|-----------------------|-------|------|------|------|------|
| | | | | Ø 10 | Ø 12 | Ø 16 | Ø 18 | Ø 20 | |
| P.1 | ≤ 600 N/mm ² | 1,5xD | 0,5xD | 45 | 0,035 | 0,04 | 0,07 | 0,08 | 0,09 |
| P.2 | ≤ 850 N/mm ² | 1,5xD | 0,5xD | 39 | 0,035 | 0,04 | 0,07 | 0,08 | 0,09 |
| P.4 | ≤ 900 N/mm ² | 1,5xD | 0,5xD | 30 | 0,035 | 0,04 | 0,07 | 0,08 | 0,09 |
| M.2 | 750 - 850 N/mm ² | 1,5xD | 0,5xD | 15 | 0,035 | 0,04 | 0,07 | 0,08 | 0,09 |
| K.1 | < 240 HB | 1,5xD | 0,5xD | 35 | 0,035 | 0,04 | 0,07 | 0,08 | 0,09 |