



NACHREINER

spanabhebende Werkzeuge



spanabhebende Werkzeuge

GEWINDESCHNEIDEN

Präzision bedeutet,
nichts dem Zufall zu überlassen.

BOHREN



FRÄSEN

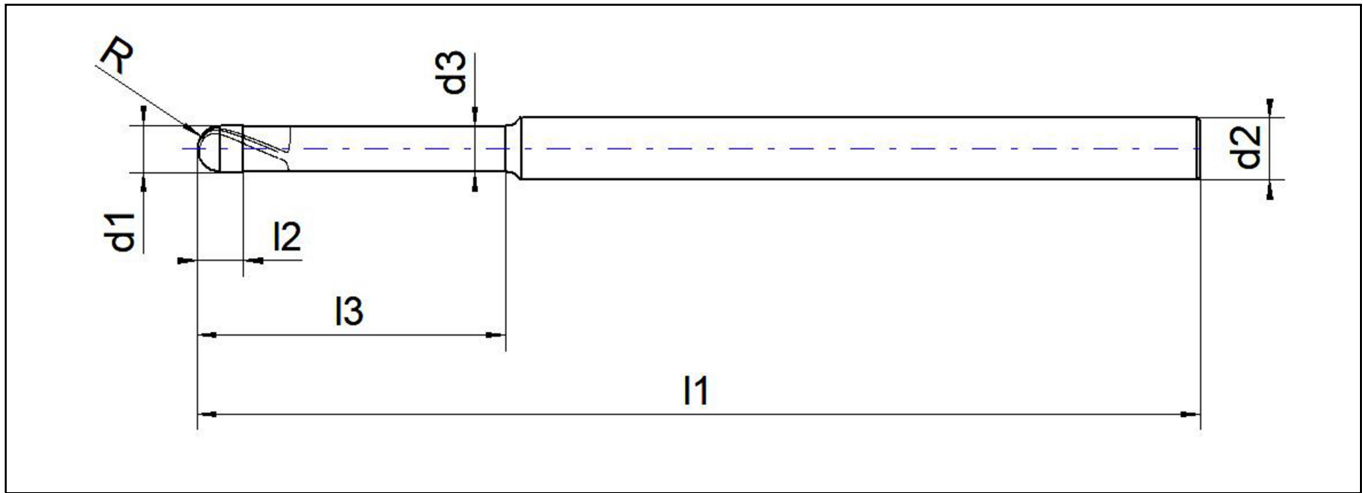
REIBEN

SENKEN



Fräser VHM
End mills solid carbide





VHM-Alu-Mikroradiusfräser 30°

E.7690.0



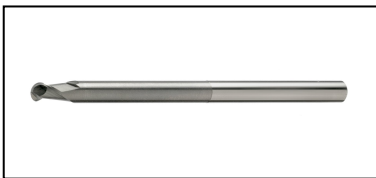
[Schnittdaten >](#)

Einsatzrichtwerte

| Material | Nr. | Vc m/min |
|--|-----|-----------|
| allg. Stähle -500 N/mm ² | 1.1 | 320 - 360 |
| allg. Stähle -700 N/mm ² | 1.2 | 240 - 280 |
| allg. Stähle - 850N/mm ² | 1.3 | 200 - 240 |
| allg. Stähle -1000 N/mm ² | 1.4 | |
| allg. Stähle -1400 N/mm ² | 1.5 | |
| Einsatzstähle < 1000N/mm ² | 1.6 | |
| Nitrierstähle < 1000N/mm ² | 1.7 | |
| Vergütungsstähle < 850N/mm ² | 1.8 | |
| Werkzeugstähle (legiert und unlegiert) | 1.9 | |
| Rost und säurebeständige Stähle bis 700N/mm ² | 2.1 | 110 - 150 |
| Rost und säurebeständige Stähle ab 700N/mm ² | 2.2 | 90 - 120 |
| Gusseisen bis 180 HB | 3.1 | 300 - 350 |
| Temperguss | 3.2 | 280 - 320 |

| Material | Nr. | Vc m/min |
|--------------------------------------|-----|-----------|
| Gusseisen mit Kugelgraphit | 3.3 | 280 - 320 |
| AL-und AL-Legierungen bis 6% Si | 4.1 | 420 - 480 |
| AL-und AL-Legierungen (unter 12% Si) | 4.2 | 330 - 380 |
| AL-Legierung (über 12% Si) | 4.3 | 280 - 330 |
| Messing, Kupfer, Bronze, Rotguss | 4.4 | 400 - 430 |
| Duroplaste und Thermoplast | 4.5 | |
| Grafit, GFK, Kupfer | 4.6 | |
| Titan und Titanlegierung | 5.1 | 70 - 95 |
| Nickel | 5.2 | |
| gehärtete Stähle 45-55 HRC | 6.1 | |
| gehärtete Stähle 55-60 HRC | 6.2 | |
| gehärtete Stähle 60-65 HRC | 6.3 | |

Weitere Ansichten



Verfügbare Varianten

| Artikel-Nr. | l1 | l2 | d1 +0,00/-0,02 h6 | | d3 | l3 | R |
|------------------|----|-----|-------------------|-----|------|----|------|
| E.7690.0.0040.02 | 55 | 0.5 | 0.4 | 3,0 | 0.38 | 2 | 0.2 |
| E.7690.0.0040.04 | 55 | 0.5 | 0.4 | 3,0 | 0.38 | 4 | 0.2 |
| E.7690.0.0050.03 | 55 | 0.6 | 0.5 | 3,0 | 0.48 | 3 | 0.25 |
| E.7690.0.0050.05 | 55 | 0.6 | 0.5 | 3,0 | 0.48 | 5 | 0.25 |
| E.7690.0.0060.02 | 55 | 0.8 | 0.6 | 4,0 | 0.58 | 2 | 0.3 |
| E.7690.0.0060.04 | 55 | 0.8 | 0.6 | 4,0 | 0.58 | 4 | 0.3 |
| E.7690.0.0060.06 | 55 | 0.8 | 0.6 | 4,0 | 0.58 | 6 | 0.3 |
| E.7690.0.0080.04 | 55 | 1 | 0.8 | 4,0 | 0.77 | 4 | 0.4 |
| E.7690.0.0080.06 | 55 | 1 | 0.8 | 4,0 | 0.77 | 6 | 0.4 |
| E.7690.0.0100.05 | 55 | 1.2 | 1 | 4,0 | 0.95 | 5 | 0.5 |

| | | | | | | | |
|------------------|----|-----|-----|-----|------|----|------|
| E.7690.0.0100.10 | 55 | 1.2 | 1 | 4,0 | 0.95 | 10 | 0.5 |
| E.7690.0.0100.15 | 55 | 1.2 | 1 | 4,0 | 0.95 | 15 | 0.5 |
| E.7690.0.0100.20 | 55 | 1.2 | 1 | 4,0 | 0.95 | 20 | 0.5 |
| E.7690.0.0100.25 | 60 | 1.2 | 1 | 4,0 | 0.95 | 25 | 0.5 |
| E.7690.0.0120.06 | 55 | 1.4 | 1.2 | 4,0 | 1.15 | 6 | 0.6 |
| E.7690.0.0120.12 | 55 | 1.4 | 1.2 | 4,0 | 1.15 | 12 | 0.6 |
| E.7690.0.0120.18 | 55 | 1.4 | 1.2 | 4,0 | 1.15 | 18 | 0.6 |
| E.7690.0.0120.25 | 60 | 1.4 | 1.2 | 4,0 | 1.15 | 25 | 0.6 |
| E.7690.0.0150.04 | 55 | 1.8 | 1.5 | 4,0 | 1.44 | 4 | 0.75 |
| E.7690.0.0150.08 | 55 | 1.8 | 1.5 | 4,0 | 1.44 | 8 | 0.75 |
| E.7690.0.0150.12 | 55 | 1.8 | 1.5 | 4,0 | 1.44 | 12 | 0.75 |
| E.7690.0.0150.16 | 55 | 1.8 | 1.5 | 4,0 | 1.44 | 16 | 0.75 |
| E.7690.0.0150.20 | 55 | 1.8 | 1.5 | 4,0 | 1.44 | 20 | 0.75 |
| E.7690.0.0150.25 | 60 | 1.8 | 1.5 | 4,0 | 1.44 | 25 | 0.75 |
| E.7690.0.0200.05 | 65 | 2 | 2 | 4,0 | 1.92 | 5 | 1 |
| E.7690.0.0200.10 | 65 | 2 | 2 | 4,0 | 1.92 | 10 | 1 |
| E.7690.0.0200.15 | 65 | 2 | 2 | 4,0 | 1.92 | 15 | 1 |
| E.7690.0.0200.20 | 65 | 2 | 2 | 4,0 | 1.92 | 20 | 1 |
| E.7690.0.0200.25 | 75 | 2 | 2 | 4,0 | 1.92 | 25 | 1 |
| E.7690.0.0200.30 | 75 | 2 | 2 | 4,0 | 1.92 | 30 | 1 |
| E.7690.0.0300.05 | 65 | 3 | 3 | 4,0 | 2.9 | 5 | 1.5 |
| E.7690.0.0300.10 | 65 | 3 | 3 | 4,0 | 2.9 | 10 | 1.5 |
| E.7690.0.0300.15 | 65 | 3 | 3 | 4,0 | 2.9 | 15 | 1.5 |
| E.7690.0.0300.20 | 65 | 3 | 3 | 4,0 | 2.9 | 20 | 1.5 |
| E.7690.0.0300.25 | 75 | 3 | 3 | 4,0 | 2.9 | 25 | 1.5 |
| E.7690.0.0300.30 | 75 | 3 | 3 | 4,0 | 2.9 | 30 | 1.5 |
| E.7690.0.0400.15 | 65 | 4 | 4 | 6,0 | 3.9 | 15 | 2 |
| E.7690.0.0400.20 | 65 | 4 | 4 | 6,0 | 3.9 | 20 | 2 |

| | | | | | | | |
|------------------|----|---|---|-----|-----|----|-----|
| E.7690.0.0400.25 | 75 | 4 | 4 | 6,0 | 3.9 | 25 | 2 |
| E.7690.0.0400.30 | 75 | 4 | 4 | 6,0 | 3.9 | 30 | 2 |
| E.7690.0.0500.10 | 65 | 5 | 5 | 6,0 | 4.9 | 10 | 2.5 |
| E.7690.0.0500.20 | 65 | 5 | 5 | 6,0 | 4.9 | 20 | 2.5 |
| E.7690.0.0500.30 | 75 | 5 | 5 | 6,0 | 4.9 | 30 | 2.5 |
| E.7690.0.0500.40 | 90 | 5 | 5 | 6,0 | 4.9 | 40 | 2.5 |
| E.7690.0.0600.10 | 65 | 6 | 6 | 6,0 | 5.9 | 10 | 3 |
| E.7690.0.0600.20 | 65 | 6 | 6 | 6,0 | 5.9 | 20 | 3 |
| E.7690.0.0600.30 | 75 | 6 | 6 | 6,0 | 5.9 | 30 | 3 |
| E.7690.0.0600.40 | 90 | 6 | 6 | 6,0 | 5.9 | 40 | 3 |

Verfügbarkeit prüfen unter

<https://www.nachreiner-werkzeuge.de/sortiment/fraeser-vhm/aluminium/1060/vhm-alu-mikroradiusfraeser-300>.





NACHREINER

spanabhebende Werkzeuge

Nachreiner GmbH

Egert 6, Industriegebiet Rote Länder

D-72336 Balingen

Telefon: 07433-90977-0

Telefax: 07433-90977-77

E-Mail: info@nachreiner-werkzeuge.de