

CoroMill Plura mit iLock

Vollhartmetall-Schaftfräser

Bietet eine Kombination aus hoher Sicherheit beim Herausziehen und eine optimierte Produktivität

- Hochleistungssorten GC1620, GC1640 bieten exzellente Schneidkantenschärfe bei langen Eingriffszeiten in Titan
- Ergänzende Anwendungsbereiche sind Stähle und Rostfreie Stähle
- Radius bei typischen Bändern in Luftfahrt Rahmenbauteilen
- Taschenfräsen mit hohem axialen Eingriff



Typische Bänder in Luftfahrt-Rahmenbauteilen

Dc, mm	0.5	1.0	1.5	2.0	2.5	3.0	4.0	6.3
12	x	x	x	x	x	x	x	
16	x	x	x	x	x	x	x	x
20		x		x		x	x	x
25						x	x	x



Schrumpffutter:

- Coromant Capto
- HSK A/C
- ISO 7388.1
- MAS-BT 403
- CAT-V



ISO Anwendungsbereiche:

S

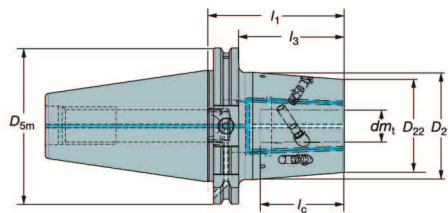
Einteiliges Coromant Schrumpffutter mit iLock

Für Zylinderschäfte

391.45019/391.55019/391.14019



Kurze Ausführung



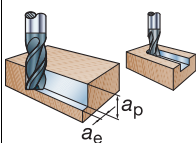
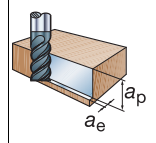
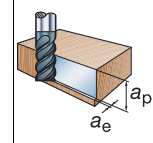
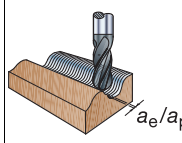
Maschinenseitige Aufnahme	Kegelgröße	Bestellnummer	Kühlschmierstoff ¹⁾	Abmessungen, mm									
				D_{5m}	dm_1	D_{21}	D_{22}	$l_c \text{ min}$	$l_c \text{ max}$	l_1	l_3		
ISO7388.1	40	392.14019Y-4012065	7	44.45	12	34	26.5	37	47	65	45.9	1.2	
		392.14019Y-4016065	7	44.45	16	37	29.5	40	50	65	45.9	1.0	
		392.14019Y-4020065	7	44.45	20	43	35.5	42	52	65	45.9	1.5	
		392.14019Y-4025075	7	44.45	25	50	45.5	48	58	75	55.9	1.7	
	50	392.14019Y-5012080	7	69.85	12	55	27	37	47	80	60.9	3.0	
		392.14019Y-5016080	7	69.85	16	43	33.3	40	50	80	60.9	3.1	
		392.14019Y-5020080	7	69.85	20	54.3	44.7	42	52	80	60.9	3.4	
		392.14019Y-5025100	7	69.85	25	78	44	48	58	100	80.9	3.8	
MAS-BT 403	40	392.5519Y-40 12 070	7	44.45	12	33.3	26.5	37	47	70	43	1.2	
		392.5519Y-40 16 075	7	44.45	16	37	29.5	40	50	75	48	1.4	
		392.5519Y-40 20 075	7	44.45	20	43	35.5	42	52	75	48	1.5	
		392.5519Y-40 25 085	7	44.45	25	54.7	45.5	47	57	85	58	1.7	
	50	392.5519Y-50 12 100	7	69.85	12	55	27	37	47	100	62	1.2	
		392.5519Y-50 16 100	7	69.85	16	43.1	33.3	40	50	100	62	1.2	
		392.5519Y-50 20 100	7	69.85	20	54.5	44.7	42	52	100	62	1.2	
		392.5519Y-50 25 100	7	69.85	25	54.5	44.7	48	58	100	62	1.2	
Maschinenseitige Aufnahme	Kegelgröße	Bestellnummer	Kühlschmierstoff ¹⁾	Abmessungen, Zoll									
				D_{5m}	dm_1	D_{21}	D_{22}	$l_c \text{ min}$	$l_c \text{ max}$	l_1	l_3		
CAT V	40	392.4519Y-40 12 065	7	1.750	.472	1.331	1.043	1.457	1.850	2.559	1.807	2.6	
		392.4519Y-40 16 065	1	1.750	.630	1.449	1.161	1.575	1.968	2.559	1.807	2.6	
		392.4519Y-40 20 065	1	1.750	.787	1.724	1.398	1.575	1.968	2.559	1.795	2.6	
		392.4519Y-40 25 075	1	1.750	.984	1.791	1.713	1.890	2.284	2.953	2.201	2.9	
	50	392.4519Y-50 12 080	1	2.750	.472	2.165	1.063	1.457	1.850	3.150	2.398	6.5	
		392.4519Y-50 16 080	7	2.750	.630	1.697	1.311	1.575	1.968	3.150	2.398	6.7	
		392.4519Y-50 20 080	7	2.750	.787	2.146	1.760	1.654	2.047	3.150	2.398	8.0	
		392.4519Y-50 25 125	7	2.750	.984	2.146	1.760	1.890	2.284	4.921	4.169	8.1	

¹⁾ 1 = Kühlschmierstoff durch Mitte, 7 = Kühlschmierstoff durch Mitte und Flansch

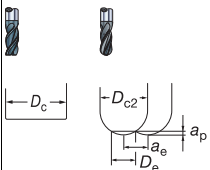
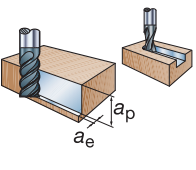
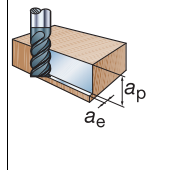
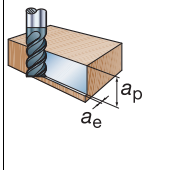
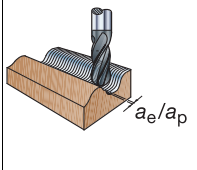


CoroMill® Plura Schnittdaten

Schnittdatenempfehlungen

			GC1620 GC1630 H10F									
					$a_p \times a_e > D_c$		$a_p \times a_e > D_c$		$a_e \leq 0.05 \times D_c$		$a_e \leq 0,05 \times D_c$ oder D_{c2} $a_p \leq 0,05 \times D_c$ oder D_{c2}	
ISO	MC	CMC-Nr.	HB	HRC	v_e m/min	v_e Fuß/min	v_e m/min	v_e Fuß/min	v_e m/min	v_e Fuß/min	v_e m/min	v_e Fuß/min
P	P1.1.Z.AN	01.1	125		155	510	200	660	375	1230	690	2260
	P1.2.Z.AN	01.2	150		135	440	185	610	340	1120	630	2070
	P1.3.Z.AN	01.4	200		120	390	140	460	255	840	470	1540
	P2.5.Z.HT	02.2	250		100	330	130	430	245	800	450	1480
	P2.5.Z.HT	02.2	300		90	300	120	390	220	720	410	1350
	P3.0.Z.HT	03.22	400		75	250	95	310	180	590	335	1100
	P3.0.Z.HT	03.22	450		65	210	85	280	160	520	300	980
M	P5.0.Z.AN	05.11	200		60	200	90	300	165	540	300	980
	M1.0.Z.AQ	05.21	200		60	200	75	250	145	480	270	890
	M3.1.Z.AQ	05.51	230		45	150	55	180	110	360	200	660
K		07.1	150		135	440	180	590	330	1080	610	2000
	K3.3.C.UT	09.2	200		100	330	130	430	240	790	440	1440
	K2.1.C.UT	08.1	180		85	280	110	360	210	690	385	1260
N	N1.3.C.AG	30.22	90		1000	3280	1100	3610	1250	4100	1300	4270
S	S2.0.Z.AG	20.22	350		50	165	60	195	100	330	150	490
	S4.3.Z.AG	23.22	350		70	230	80	260	160	525	300	985
H	H1.3.Z.HA	04.1		50	55	180	80	260	GC1610			
	H1.3.Z.HA	04.1		55	-	-	55	180				
	H1.3.Z.HA	04.1		60	-	-	40	130				

Vorschubempfehlungen

CoroMill®  GC1620 GC1630 H10F										
Metrisch	Dc oder mm	Zoll	f_z mm/Zahn	f_z Zoll/Zahn	f_z mm/Zahn	f_z Zoll/Zahn	f_z mm/Zahn	f_z Zoll/Zahn	f_z mm/Zahn	f_z Zoll/Zahn
$n = \frac{1000 \times v_c}{\pi \times D_c}$ (U/min)	0.5	.020	Plura Guide							
$v_f = n \times f_z \times z_n$ (mm/min)	1	.039	0.002	.0001	0.002	.0001	0.013	.0005	0.023	.0009
$D_e = 2 \times \sqrt{a_p \times (D_{c2} - a_p)}$ (mm)	2	.079	0.004	.0002	0.003	.0001	0.032	.0013	0.056	.0022
	3	.118	0.006	.0002	0.007	.0003	0.039	.0015	0.07	.0028
Zoll	3.175	.125 (1/8")	0.006	.0003	0.008	.0003	0.040	.0016	0.072	.0028
	4	.157	0.008	.0003	0.014	.0006	0.045	.0018	0.08	.0031
$n = \frac{v_c \times 12}{\pi \times D_e}$ (rpm)	4.76	.188 (3/16")	0.010	.0004	0.019	.0008	0.046	.0018	0.078	.0031
	5	.197	0.011	.0004	0.021	.0008	0.046	.0018	0.078	.0031
$v_f = n \times f_z \times z_n$ (inch/min)	6	.236	0.014	.0006	0.03	.0012	0.055	.0022	0.099	.0039
	6.35	.250 (1/4")	0.015	.0006	0.031	.0012	0.056	.0022	0.102	.0040
$D_e = 2 \times \sqrt{a_p \times (D_{c2} - a_p)}$ (inch)	8	.315	0.020	.0008	0.033	.0013	0.063	.0025	0.114	.0045
	9.525	.375 (3/8")	0.025	.0010	0.050	.0020	0.069	.0027	0.124	.0049
Hinweis: In der Formel für n können die Parameter v_c und D_c durch v_e und D_{c2} ersetzt werden.	10	.394	0.027	.0011	0.055	.0022	0.071	.0028	0.127	.0050
	12	.472	0.036	.0014	0.071	.0028	0.077	.0030	0.139	.0055
	12.7	.500 (1/2")	0.039	.0015	0.074	.0029	0.079	.0031	0.143	.0056
	15.875	.625 (5/8")	0.054	.0021	0.089	.0035	0.089	.0035	0.160	.0063
	16	.630	0.055	.0022	0.09	.0035	0.089	.0035	0.161	.0063
	19.05	.750 (3/4")	0.073	.0029	0.105	.0041	0.097	.0038	0.175	.0069
	20	.787	0.078	.0031	0.11	.0043	0.1	.0039	0.18	.0071
	25	.787	0.11	.0043	0.11	.0043	0.11	.0043	-	-

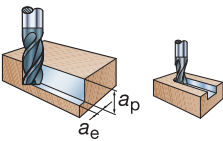
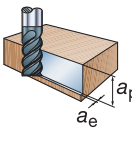
Plura Guide

Erste Wahl: Verwenden Sie Plura Guide. Bestellnummer C-2948-063

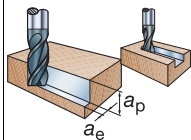
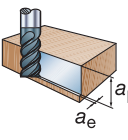


CoroMill® Plura Schnittdaten

Schnittdatenempfehlungen

GC1640								
					$a_p \times a_e \leq D_c$		$a_p \times a_e < 0.5 \times D_c$	
ISO	MC	CMC-Nr.	HB	HRC	v_e m/min	v_c Fuß/min	v_e m/min	v_c Fuß/min
P	P1.1.Z.AN	01.1	125		145	475	160	525
	P1.2.Z.AN	01.2	150		135	445	145	475
	P1.3.Z.AN	01.4	200		100	330	110	360
	P2.5.Z.HT	02.2	250		85	280	95	310
	P2.5.Z.HT	02.2	300		80	260	85	280
	P3.0.Z.HT	03.22	350		75	245	80	260
M	P5.0.Z.AN	05.11	200		65	215	70	230
	M1.0.Z.AQ	05.21	200		50	165	55	180
	M3.1.Z.AQ	05.51	230		35	115	40	130
K	K3.3.C.UT	07.1	150		130	425	140	450
	K2.2.C.UT	09.2	200		105	345	115	375
	K2.2.C.UT	08.2	250		70	230	75	245
S	S2.0.Z.AG	20.22	350		25	60	25	80
	S4.3.Z.AG	23.22	350		40	130	45	150

Vorschubempfehlungen

GC1640							
Metrisch		D_c mm	D_c Zoll	f_z mm/Zahn	f_z Zoll/Zahn	f_z mm/Zahn	f_z Zoll/Zahn
$n = \frac{v_c \times 1000}{\pi \times D_c}$ (U/min)		6	.236	0.013	.0005	0.019	.0007
$v_f = n \times f_z \times Z_n$ (mm/min)		6.35	.250 (1/4")	0.013	.0005	0.022	.0009
Zoll		8	.315	0.016	.0006	0.035	.0014
$n = \frac{v_c \times 12}{\pi \times D_e}$ (U/min)		9.525	.375 (3/8")	0.023	.0009	0.041	.0016
$v_f = n \times f_z \times Z_n$ (zoll/min)		10	.394	0.025	.0010	0.043	.0017
		12	.472	0.031	.0012	0.055	.0022
		12.7	.500 (1/2")	0.035	.0014	0.057	.0023
		15.875	.625 (5/8")	0.052	.0020	0.068	.0027
		16	.630	0.053	.0021	0.069	.0027
		19.05	.750 (3/4")	0.065	.0026	0.081	.0032
		20	.787	0.069	.0027	0.085	.0033

Plura Guide



Erste Wahl: Verwenden Sie Plura Guide. Bestellnummer C-2948-063