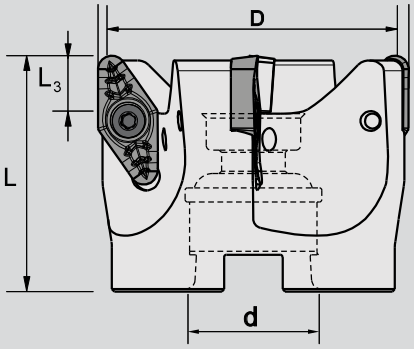
Square shoulder milling tools · Eckfräser

Kr:90°

EMPX



Specification of tools · Werkzeug Beschreibung

Type Typ		Stock Lager	Dimensions (mm) Abmessungen				No. of teeth Zähne	Coupling Aufnahme	Weight Gewicht (kg)
			Ø D	Ø d	L	L3			
EMPX	042-A16-VC22-03C	○	42	16	55	15	3	A	0,20
	052-A22-VC22-03C	○	52	22	55	15	3	A	0,35
	066-A27-VC22-04C	○	66	27	56	15	4	A	0,55
	080-A27-VC22-04C	○	80	27	56	15	4	A	0,90

Spare parts · Ersatzteile

Diameter Durchmesser Ø D	No of teeth Zähne (Z)	Clamp Screw Schraube	Wrench Schlüssel
42-52	3	I60M4.5*10	WT20IP
66-80	4	I60M4.5*10	WT20IP

Square shoulder milling tools · Eckfräser

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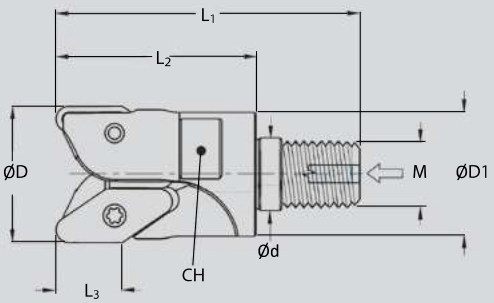
QCH



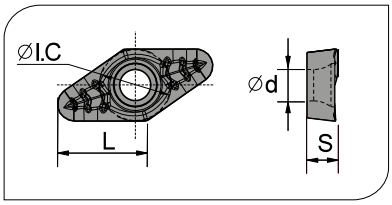
Specification of tools · Werkzeug Beschreibung

Type Typ		Stock Lager	Dimensions (mm) Abmessungen				L1	L3	No. of teeth Zähne (Z)	Weight Gewicht (kg)
			ØD	Ød	L2	M				
QCH	32-VC22-M16-02	●	32	17	47	16	71	15	2	0,15
	42-VC22-M16-03	●	42	17	47	16	71	15	3	0,20

Spare parts · Ersatzteile

Clamp screw Schraube	Wrench Schlüssel
I60M4.5*10	WT20IP

VC** Positive Insert/ Positive WSP



● Ideal Machining Condition / Gute Bearbeitungsbedingungen
◐ Normal Machining Condition / Normale Bearbeitungsbedingungen
○ Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

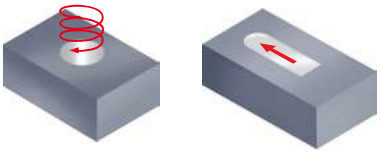
Workpiece Material / Werkstoffe																								
P	Steel / *Stahl*																							
M	Steinless Steel / *Rostfreier Stahl*																							
K	Cast iron / *Gusseisen*																							
N	Non-ferrite material / *Ne Metalle*	◐	◐						◐			○				●								
S	Heat-resistant steel / *Warmfester Stahl*																							

Insert Shape Plattenform	Type Typ	Dimension Abmessungen						PVD Coated Carbide PVD Beschichtetet						Uncoated Carbide Unbesch. Hartmetall						Diamant-coat. Carbide Diamantbesch. Hart-metall						PCD brazed PKD bestückt					
		L	I.C	S	d	r	a_p max	YBG101	YBG102					YD101				YD201		YCD110						YCD421					
	VCGX220530-LC	22	12,7	5,56	5,5	3	7	●	○					●				●		○											
	VCGX220530-LH	22	12,7	5,56	5,5	3	7		○					●				○		○											
	VCGX220530-1	22	12,7	5,56	5,5	3	5																			●					

Recommended cutting data VCGX · Empfohlene Schnittdaten VCGX

Workpiece material Werkstück Material	Grade Sorte	Vc(m/min)	fz (mm/t)
Aluminium Legierung Si<12% Aluminium Alloys Si<12%	YD101, YD201, YBG101, YCD421	800-3500	0,05-0,3
hochsiliziumhaltiges Aluminium >12% Aluminium with silicon >12%	YD101, YD201, YBG101, YBG102, YCD421	400-1000	0,05-0,3
Kupferlegierungen Copper alloys	YD101, YD201 YBG102, YCD421	700-1200	0,1-0,3
Kunststoff, Graphit, CFK/GFK Plastic, graphite, CFK/GFK	YBG102, YCD110, YCD421	200-1000	0,1-0,3
Epoxidharz Blockmaterial Epoxy resin	YCD110, YCD421	900-1500	0,18-0,5
Holzverbundstoffe Wood composite	YBG102, YCD110, YCD421	2000-5000	0,05-1,0

Ramp milling, helical interpolation milling
Tauchfräsen, Spiral Interpolationsfräsen



Recommended cutting data · Empfohlene Schnittdaten

Tool Werkzeug	Diameter Ø D (mm)	Ramp milling Tauchfräsen	Helical interpolation milling Spiral-Interpolationsfräsen	
		Max. cutting depth Schnitttiefe a_p(mm)	Min. diameter Durchmesser Ø D_1(mm)	Max. pitch Steigung (mm)
EMPX	42	5	78	5
	52	5	98	5
	66	5	126	5
	80	-	-	-
QCH	32	5	58	5
	42	5	78	5