

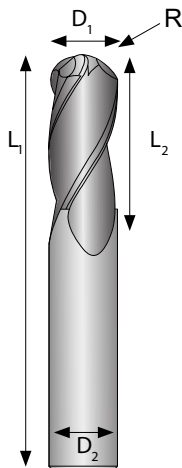
Softcut 2.0 BN VHM BN-Fräser, 2-schneidig



JD 62102



Softcut 2.0 bis 55 HRC



| Bezeichnung Part Number | Bestellnummer Order number | Maße Dimensions [mm] | | | | | | z Flutes | DN 8130 (TiSiN) |
|----------------------------|-------------------------------|-------------------------|---------------|-----|-------|-------|---|-------------|--------------------|
| | | D_1 , j_s , j_9 | D_2 , h_6 | R | L_1 | L_2 | | | |
| JD 62102 040 BN HA | 10006863058 | 4 | 4 | 2.0 | 50 | 8 | 2 | • | |
| JD 62102 050 BN HA | 10006864058 | 5 | 5 | 2.5 | 50 | 10 | | • | |
| JD 62102 060 BN HA | 10006865058 | 6 | 6 | 3.0 | 50 | 12 | | • | |
| JD 62102 080 BN HA | 10006866058 | 8 | 8 | 4.0 | 60 | 16 | | • | |
| JD 62102 100 BN HA | 10006867058 | 10 | 10 | 5.0 | 75 | 20 | | • | |
| JD 62102 120 BN HA | 10006868058 | 12 | 12 | 6.0 | 75 | 24 | | • | |
| JD 62102 160 BN HA | 10006869058 | 16 | 16 | 8.0 | 100 | 32 | | • | |



Schnittdaten-Empfehlungen

Cutting Data Recommendations

| Werkstück Workpiece | | | Durchmesser / Diameter [mm] | | | | | | | | | |
|---|--|---|-----------------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| | | | 1.0 | 2.0 | 3.0 | 4.0 | 5.0 | 6.0 | 8.0 | 10.0 | 12.0 | 16.0 |
| A (P) Baustahl, Einsatzstahl, Automatenstahl, Vergütungsstahl <i>Structural Steel, Case Hardening Steel, Free Cutting Steel, Tempering steel</i> | < 750 N/mm ² | Umdrehungen / revolutions n [1/min] | 40000 | 24000 | 15500 | 11500 | 9500 | 8000 | 6000 | 4800 | 4000 | 3000 |
| | | Zahnvorschub / feed fz [mm] | 0.010 | 0.020 | 0.030 | 0.040 | 0.055 | 0.065 | 0.110 | 0.120 | 0.140 | 0.170 |
| | 750 - 1000 N/mm ² | Umdrehungen / revolutions n [1/min] | 38000 | 19000 | 12750 | 9550 | 7650 | 6400 | 4800 | 3800 | 3200 | 2400 |
| | | Zahnvorschub / feed fz [mm] | 0.009 | 0.020 | 0.030 | 0.040 | 0.050 | 0.063 | 0.100 | 0.120 | 0.130 | 0.160 |
| | 1000 - 1400 N/mm ² | Umdrehungen / revolutions n [1/min] | 32000 | 16000 | 10600 | 8000 | 6400 | 5300 | 4000 | 3200 | 2650 | 2000 |
| | | Zahnvorschub / feed fz [mm] | 0.005 | 0.012 | 0.021 | 0.035 | 0.043 | 0.054 | 0.085 | 0.100 | 0.120 | 0.150 |
| R (M) Rostfreier Stahl <i>Stainless steel</i> | austenitisch, martensitisch <i>austenitic, martensitic</i> | Umdrehungen / revolutions n [1/min] | 22300 | 11150 | 7400 | 5550 | 4450 | 3700 | 2750 | 2200 | 1850 | 1350 |
| | | Zahnvorschub / feed fz [mm] | 0.005 | 0.010 | 0.020 | 0.033 | 0.042 | 0.052 | 0.080 | 0.098 | 0.115 | 0.140 |
| F (K) Grauguss, Sphäroguss, Temperguss <i>Flake cast iron, Nodular cast iron, Malleable cast iron</i> | | Umdrehungen / revolutions n [1/min] | 40000 | 24000 | 1550 | 11500 | 9500 | 8000 | 6000 | 4800 | 4000 | 3000 |
| | | Zahnvorschub / feed fz [mm] | 0.010 | 0.018 | 0.030 | 0.041 | 0.055 | 0.065 | 0.110 | 0.125 | 0.140 | 0.180 |
| H Gehärteter Stahl <i>Hardened steel</i> | <55 HRc | Umdrehungen / revolutions n [1/min] | 25000 | 13000 | 8500 | 6500 | 5000 | 4200 | 3200 | 2500 | 2100 | 1600 |
| | | Zahnvorschub / feed fz [mm] | 0.005 | 0.010 | 0.016 | 0.028 | 0.037 | 0.046 | 0.070 | 0.090 | 0.100 | 0.120 |



Technische Änderungen vorbehalten, keine Haftung für Druckfehler. Abbildungen ähnlich.
 Technical changes reserved, we bear no liability for misprints. Drawings/pictures similar.



Jörn Detjens Zerspanungstechnik GmbH
 Bookkoppel 3
 DE-22926 Ahrensburg

Tel.: +49-(0)41 07 - 90 73-0
 Fax.: +49-(0)41 07 - 90 73-22
 E-Mail: info@jd-tools.de

