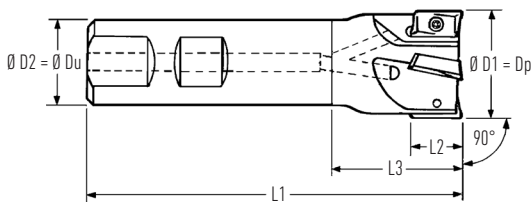


# Rohová fréza F1200



- stabilní chod
- univerzální použití
- vnitřní chlazení
- dlouhá životnost díky optimalizované konstrukci



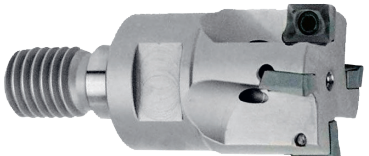
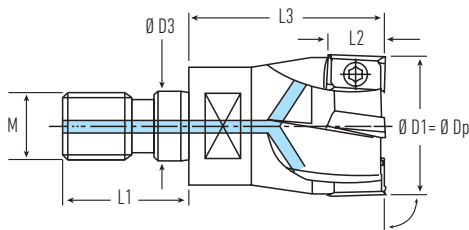
## Weldon provedení



| Objednací číslo          | Rozměry (mm) |    |     |    |    |   | Maximální úhel<br>zanoření | Břítové destičky<br>typ | Náhradní díly                               |                                             | Utahovací<br>moment v Nm |
|--------------------------|--------------|----|-----|----|----|---|----------------------------|-------------------------|---------------------------------------------|---------------------------------------------|--------------------------|
|                          | D1           | D2 | L1  | L2 | L3 | Z |                            |                         | šroubek                                     | klíč                                        |                          |
| F1200.25.W25.100.17.Z2.C | 25           | 25 | 100 | 17 | 44 | 2 | 3,5°                       | APHX1604..              | VT40                                        | BT15                                        | 3                        |
| F1200.32.W32.110.17.Z3.C | 32           | 32 | 110 | 17 | 50 | 3 | 2,0°                       | APKT1604..              | <a href="#">objednací číslo</a><br>TG003862 | <a href="#">objednací číslo</a><br>TG003800 |                          |
| F1200.40.W32.115.17.Z4.C | 40           | 32 | 115 | 17 | 45 | 4 | 1,5°                       | APHT1604..              |                                             |                                             |                          |

## Weldon provedení - prodloužení

| Objednací číslo          | Rozměry (mm) |    |     |    |     |   | Maximální úhel<br>zanoření | Břítové destičky<br>typ                | Náhradní díly                                       |                                                     | Utahovací<br>moment v Nm |
|--------------------------|--------------|----|-----|----|-----|---|----------------------------|----------------------------------------|-----------------------------------------------------|-----------------------------------------------------|--------------------------|
|                          | D1           | D2 | L1  | L2 | L3  | Z |                            |                                        | šroubek                                             | klíč                                                |                          |
| F1200.22.W20.200.17.Z2.C | 22           | 20 | 200 | 17 | 145 | 2 | 3,3°                       | APHX1604..<br>APKT1604..<br>APHT1604.. | VT40<br><a href="#">objednací číslo</a><br>TG003860 | BT15<br><a href="#">objednací číslo</a><br>TG003800 | 3                        |
| F1200.25.W25.200.17.Z2.C | 25           | 25 | 200 | 17 | 140 | 2 | 3,5°                       |                                        |                                                     |                                                     |                          |
| F1200.32.W32.200.17.Z3.C | 32           | 32 | 200 | 17 | 140 | 3 | 2,0°                       |                                        |                                                     |                                                     |                          |
| F1200.40.W32.200.17.Z4.C | 40           | 32 | 200 | 17 | 60  | 4 | 1,5°                       |                                        |                                                     |                                                     |                          |



## Modulární provedení

| Objednací číslo         | Rozměry (mm) |      |    |    |    |     | Maximální úhel<br>zanoření | Břítové destičky<br>typ | Náhradní díly                                       |                                                     | Utahovací<br>moment v Nm |
|-------------------------|--------------|------|----|----|----|-----|----------------------------|-------------------------|-----------------------------------------------------|-----------------------------------------------------|--------------------------|
|                         | D1           | D3   | L1 | L2 | L3 | M   |                            |                         | šroubek                                             | klíč                                                |                          |
| F1200.25.M12.40.17.Z2.C | 25           | 12,5 | 22 | 17 | 40 | M12 | 2                          | 3,5°                    | VT40<br><a href="#">objednací číslo</a><br>TG003860 | BT15<br><a href="#">objednací číslo</a><br>TG003800 | 3                        |
| F1200.32.M16.46.17.Z3.C | 32           | 17   | 24 | 17 | 46 | M16 | 3                          | 2,0°                    |                                                     |                                                     |                          |
| F1200.40.M16.46.17.Z4.C | 40           | 17   | 24 | 17 | 46 | M16 | 4                          | 1,5°                    |                                                     |                                                     |                          |

# Rohová fréza F1200



## Přehled vhodných břitových destiček

|                   | P     |       |      |      |      |        |          | M     |       |      |        |          | K     |       |      |          | N    |
|-------------------|-------|-------|------|------|------|--------|----------|-------|-------|------|--------|----------|-------|-------|------|----------|------|
|                   | PMK20 | PMK19 | PK19 | PM19 | P250 | PMK19T | PMK19TAN | PMK20 | PMK19 | PM19 | PMK19T | PMK19TAN | PMK20 | PMK19 | PK19 | PMK19TAN | AL19 |
| APKT1604PDR-M     | .     |       |      |      |      |        |          | .     |       |      |        |          | .     |       |      |          |      |
| APKT1604PDR-S     |       | .     | .    | .    |      |        |          |       | .     | .    |        |          |       | .     | .    |          |      |
| APKT160408 PDF IT |       |       |      |      |      |        |          |       |       |      |        |          |       |       |      |          | .    |
| APHT1604PDR       |       |       |      |      | .    | .      | .        |       |       |      | .      | .        |       |       |      | .        |      |
| APHX1604FR-IT     |       |       |      |      |      |        |          |       |       |      |        |          |       |       |      |          | .    |

### Doporučené

#### řezné podmínky

#### Řezná rychlost Vc (m/min)

|               | PMK20   | PMK19   | PK19    | PM19    | P250   | PMK19T  | PMK19TAN | AL19    |
|---------------|---------|---------|---------|---------|--------|---------|----------|---------|
| P10 - P20     |         |         | 180-280 |         |        |         |          |         |
| P20 - P25     |         |         |         |         |        |         | 120-280  |         |
| P25           |         |         |         |         | 70-200 |         |          |         |
| P20 - P40     |         |         |         |         |        | 110-220 |          |         |
| P25 - P40     | 100-170 | 100-170 |         |         |        |         |          |         |
| P30 - P40     |         |         |         | 110-120 |        |         |          |         |
| M20 - M35     |         |         |         |         |        |         | 80-200   |         |
| M20 - M40     |         | 70-130  |         |         |        | 70-130  |          |         |
| M30 - M40     |         |         |         | 90-160  |        |         |          |         |
| K10 - K20     |         |         | 160-270 |         |        |         |          |         |
| K20 - K30     |         |         |         |         |        |         | 120-230  |         |
| K20 - K40     |         | 120-230 |         |         |        |         |          |         |
| N (K10 - K15) |         |         |         |         |        |         |          | 200-700 |

#### Fz (mm/zub) / Ap (mm)

|           | P250      |       | PMK19T    |       | PMK19TAN  |       | PMK20     |       | PMK19     |       |
|-----------|-----------|-------|-----------|-------|-----------|-------|-----------|-------|-----------|-------|
|           | Fz        | Ap    | Fz        | Ap    | Fz        | Ap    | Fz        | Ap    | Fz        | Ap    |
| P20 - P25 |           |       |           |       | 0,05-0,20 | 0,5-7 |           |       |           |       |
| P25       | 0,10-0,18 | 0,1-7 |           |       |           |       |           |       |           |       |
| P20 - P40 |           |       | 0,10-0,20 | 0,1-7 |           |       |           |       |           |       |
| P25 - P40 |           |       |           |       |           |       | 0,10-0,30 | 0,1-7 | 0,10-0,30 | 0,1-7 |
| M20 - M35 |           |       |           |       | 0,05-0,20 | 0,5-7 |           |       |           |       |
| M20 - M40 |           |       | 0,08-0,18 | 0,1-7 |           |       | 0,10-0,30 | 0,1-7 | 0,10-0,30 | 0,1-7 |
| K20 - K30 |           |       |           |       | 0,05-0,20 | 0,5-7 |           |       |           |       |
| K20 - K40 |           |       |           |       |           |       | 0,10-0,30 | 0,1-7 | 0,10-0,30 | 0,1-7 |

#### Fz (mm/zub) / Ap (mm)

|               | PK19      |       | PM19      |       | APKT160408 PDF IT AL19 |          | APHX1604FR AL19 |       |
|---------------|-----------|-------|-----------|-------|------------------------|----------|-----------------|-------|
|               | Fz        | Ap    | Fz        | Ap    | Fz                     | Ap       | Fz              | Ap    |
| P10 - P20     | 0,05-0,20 | 0,1-7 |           |       |                        |          |                 |       |
| P30 - P40     |           |       | 0,05-0,25 | 0,1-7 |                        |          |                 |       |
| M30 - M40     |           |       | 0,05-0,25 | 0,1-7 |                        |          |                 |       |
| K10 - K20     | 0,05-0,20 | 0,1-7 |           |       |                        |          |                 |       |
| N (K10 - K15) |           |       |           |       | 0,10-0,40              | 0,1-11,2 | 0,10-0,20       | 0,1-8 |