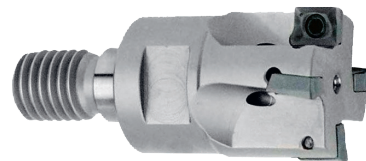
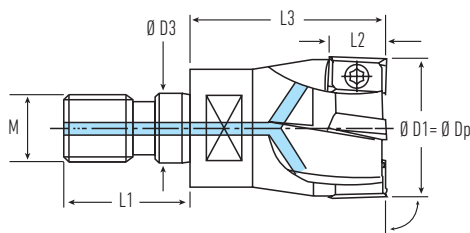


# Rohová fréza F1110

- stabilní výkon
- vnitřní chlazení



čelní frézování   boční frézování   drážkování   rampování



## Modulární provedení

| Objednací číslo         | Rozměry (mm) |      |      |    |    |     | Z | Maximální úhel<br>zanoření | Břítové destičky<br>typ                | Náhradní díly                       |                                     | Utahovací<br>moment v Nm |
|-------------------------|--------------|------|------|----|----|-----|---|----------------------------|----------------------------------------|-------------------------------------|-------------------------------------|--------------------------|
|                         | D1           | D3   | L1   | L2 | L3 | M   |   |                            |                                        | šroubek                             | klíč                                |                          |
| F1110.10.M6.20.10.Z1.C  | 10           | 6,5  | 14,5 | 10 | 20 | M6  | 1 | 11°                        | APHT1003..<br>APHX1003..<br>APKT1003.. | VT25<br>objednací číslo<br>TG003860 | BT08<br>objednací číslo<br>TG003799 | 1,5                      |
| F1110.12.M6.20.10.Z1.C  | 12           | 6,5  | 14,5 | 10 | 20 | M6  | 1 | 9°                         |                                        |                                     |                                     |                          |
| F1110.16.M8.25.10.Z2.C  | 16           | 8,5  | 17,5 | 10 | 25 | M8  | 2 | 3,5°                       |                                        |                                     |                                     |                          |
| F1110.20.M10.30.10.Z3.C | 20           | 10,5 | 20   | 10 | 30 | M10 | 3 | 1,5°                       |                                        |                                     |                                     |                          |
| F1110.25.M12.35.10.Z3.C | 25           | 12,5 | 22   | 10 | 35 | M12 | 3 | 0,9°                       |                                        |                                     |                                     |                          |
| F1110.25.M12.35.10.Z4.C | 25           | 12,5 | 22   | 10 | 35 | M12 | 4 | 0,9°                       |                                        |                                     |                                     |                          |
| F1110.28.M12.35.10.Z4.C | 28           | 12,5 | 22   | 10 | 35 | M12 | 4 | 0,9°                       |                                        |                                     |                                     |                          |
| F1110.30.M16.43.10.Z4.C | 30           | 17   | 24   | 10 | 43 | M16 | 4 | 0,6°                       |                                        |                                     |                                     |                          |
| F1110.32.M16.43.10.Z5.C | 32           | 17   | 24   | 10 | 43 | M16 | 5 | 0,6°                       |                                        |                                     |                                     |                          |

## Přehled vhodných břitových destiček

|                 | P    |        |          |       |       |      |      | M      |          |       |       |      | K        |       |       |      | N    |
|-----------------|------|--------|----------|-------|-------|------|------|--------|----------|-------|-------|------|----------|-------|-------|------|------|
|                 | P250 | PMK19T | PMK19TAN | PMK20 | PMK19 | PK19 | PM19 | PMK19T | PMK19TAN | PMK20 | PMK19 | PM19 | PMK19TAN | PMK20 | PMK19 | PK19 | AL19 |
| APHT100304      | •    | •      | •        |       |       |      |      | •      | •        |       |       |      | •        |       |       |      |      |
| APHX1003FR-IT   |      |        |          |       |       |      |      |        |          |       |       |      |          |       |       |      | •    |
| APKT1003PDR-M   |      |        |          | •     |       |      |      |        |          | •     |       |      |          | •     |       |      |      |
| APKT1003PDR-S   |      |        |          |       | •     | •    | •    |        |          |       | •     | •    |          |       | •     | •    |      |
| APKT1003 PDF IT |      |        |          |       |       |      |      |        |          |       |       |      |          |       |       |      | •    |

# Rohová fréza F1110



## Doporučené řezné podmínky

### Řezná rychlost Vc (m/min)

| řezné podmínky | P250    | PMK19T | PMK19TAN | PMK20   | PMK19   | PK19    | PM19    | AL19 |
|----------------|---------|--------|----------|---------|---------|---------|---------|------|
| P10 - P20      | 180-280 |        |          |         |         |         |         |      |
| P25 - P40      | 110-220 |        |          |         |         |         |         |      |
| P25            | 70-200  |        |          |         |         |         |         |      |
| P20-P40        | 120-250 |        |          |         |         |         |         |      |
| P25-P40        |         |        |          | 100-170 | 100-170 |         |         |      |
| P30 - P40      |         |        |          |         |         |         | 110-120 |      |
| M20 - M35      | 70-130  |        |          |         |         |         |         |      |
| M20-M40        | 80-200  |        |          |         | 70-130  | 70-130  |         |      |
| M30 - M40      |         |        |          |         |         |         | 90-160  |      |
| K10 - K20      |         |        |          |         |         | 160-270 |         |      |
| K20-K30        | 120-230 |        |          |         |         |         |         |      |
| K20 - K40      |         |        |          | 120-230 | 120-230 |         |         |      |
| N (K10 - K15)  | 200-700 |        |          |         |         |         |         |      |

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

|           | P250      |       | PMK19T    |       | PMK19TAN  |       | PMK20     |       |
|-----------|-----------|-------|-----------|-------|-----------|-------|-----------|-------|
|           | Fz        | Ap    | Fz        | Ap    | Fz        | Ap    | Fz        | Ap    |
| P20 - P25 |           |       |           |       | 0,07-0,20 | 0,5-4 |           |       |
| P25       | 0,07-0,15 | 0,1-4 |           |       |           |       |           |       |
| P20 - P40 |           |       | 0,07-0,18 | 0,1-4 |           |       |           |       |
| P25 - P40 |           |       |           |       |           |       | 0,10-0,30 | 0,1-4 |
| M20 - M35 |           |       |           |       | 0,07-0,20 | 0,5-4 |           |       |
| M20 - M40 |           |       | 0,07-0,18 | 0,1-4 |           |       |           |       |
| K20 - K30 |           |       |           |       | 0,07-0,30 | 0,1-4 |           |       |
| K20 - K40 |           |       |           |       |           |       | 0,10-0,30 | 0,1-4 |

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

|               | PMK19     |       | PK19      |       | PM19      |       | AL19      |         |
|---------------|-----------|-------|-----------|-------|-----------|-------|-----------|---------|
|               | Fz        | Ap    | Fz        | Ap    | Fz        | Ap    | Fz        | Ap      |
| P20 - P25     |           |       | 0,05-0,30 | 0,1-4 |           |       |           |         |
| P25 - P40     | 0,10-0,30 | 0,1-4 |           |       |           |       |           |         |
| P30 - P40     |           |       |           |       | 0,05-0,25 | 0,1-4 |           |         |
| M20 - M40     | 0,10-0,30 | 0,1-4 |           |       |           |       |           |         |
| M30 - M40     |           |       |           |       | 0,05-0,25 | 0,1-4 |           |         |
| K10 - K20     |           |       | 0,05-0,30 | 0,1-4 |           |       |           |         |
| K20 - K40     | 0,10-0,30 | 0,1-4 |           |       |           |       |           |         |
| N (K10 - K15) |           |       |           |       |           |       | 0,10-0,40 | 0,1-0,7 |