



**ALU-POWER  
END MILLS**

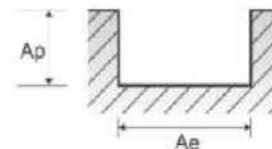
**РЕКОМЕНДУЕМЫЕ РЕЖИМЫ ОБРАБОТКИ**

**E5E47** СЕРИЯ

Vc = м/мин.  
fz = мм/зуб  
RPM = об./мин  
FEED = мм/мин.

**С 1 ЗУБОМ - ОБРАБОТКА ПАЗОВ**

| ISO  | VDI 3323 | Описание материала                  | Ae   | Ap   | Параметр | Диаметр фрезы (Ø) |       |       |       |       |       |       |       |
|------|----------|-------------------------------------|------|------|----------|-------------------|-------|-------|-------|-------|-------|-------|-------|
|      |          |                                     |      |      |          | 2.0               | 3.0   | 4.0   | 5.0   | 6.0   | 8.0   | 10.0  | 12.0  |
| N    | 21~22    | Алюминиевый сплав                   | 1.0D | 1.5D | Vc       | 145               | 170   | 190   | 190   | 190   | 195   | 190   | 190   |
|      |          |                                     |      |      | fz       | 0.065             | 0.094 | 0.120 | 0.150 | 0.180 | 0.244 | 0.333 | 0.440 |
|      |          |                                     |      |      | RPM      | 23077             | 18038 | 15120 | 12096 | 10080 | 7759  | 6048  | 5040  |
|      | 23~24    | Алюминиево-литиевый сплав           | 1.0D | 1.5D | Vc       | 94                | 111   | 124   | 124   | 124   | 127   | 124   | 124   |
|      |          |                                     |      |      | fz       | 0.065             | 0.094 | 0.120 | 0.150 | 0.180 | 0.244 | 0.333 | 0.440 |
|      |          |                                     |      |      | RPM      | 15000             | 11724 | 9828  | 7862  | 6552  | 5043  | 3931  | 3276  |
|      | 29.1     | Неметаллич. материалы (Duroplastic) | 1.0D | 1.5D | Vc       | 200               | 235   | 250   | 235   | 255   | 250   | 250   | 255   |
|      |          |                                     |      |      | fz       | 0.069             | 0.096 | 0.120 | 0.147 | 0.170 | 0.240 | 0.300 | 0.343 |
|      |          |                                     |      |      | RPM      | 31831             | 24934 | 19894 | 14961 | 13528 | 9947  | 7958  | 6764  |
| FEED | 1500     | 1696                                | 1814 | 1814 | 1814     | 1893              | 2014  | 2218  |       |       |       |       |       |
| FEED | 975      | 1102                                | 1179 | 1179 | 1179     | 1231              | 1309  | 1441  |       |       |       |       |       |
| FEED | 2196     | 2394                                | 2387 | 2199 | 2300     | 2387              | 2387  | 2320  |       |       |       |       |       |



**E5E48, E5522, E5521** СЕРИЯ

**С 2 ЗУБЬЯМИ - ОБРАБОТКА ПАЗОВ**

Vc = м/мин.  
fz = мм/зуб  
RPM = об./мин  
FEED = мм/мин.

| ISO  | VDI 3323 | Описание материала        | Ae   | Ap   | Параметр | Диаметр фрезы (Ø) |       |       |       |       |       |       |       |       |       |       |
|------|----------|---------------------------|------|------|----------|-------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|      |          |                           |      |      |          | 3.0               | 4.0   | 5.0   | 6.0   | 8.0   | 10.0  | 12.0  | 14.0  | 16.0  | 18.0  | 20.0  |
| N    | 21~22    | Алюминиевый сплав         | 1.0D | 0.5D | Vc       | 95                | 125   | 155   | 190   | 200   | 250   | 300   | 265   | 300   | 225   | 250   |
|      |          |                           |      |      | fz       | 0.035             | 0.045 | 0.050 | 0.060 | 0.088 | 0.106 | 0.131 | 0.150 | 0.158 | 0.175 | 0.200 |
|      |          |                           |      |      | RPM      | 10080             | 9947  | 9868  | 10080 | 7958  | 7958  | 7958  | 6025  | 5968  | 3979  | 3979  |
|      | 23~24    | Алюминиево-литиевый сплав | 1.0D | 0.5D | Vc       | 62                | 81    | 101   | 124   | 130   | 163   | 195   | 172   | 195   | 146   | 163   |
|      |          |                           |      |      | fz       | 0.035             | 0.045 | 0.050 | 0.060 | 0.088 | 0.106 | 0.131 | 0.150 | 0.158 | 0.175 | 0.200 |
|      |          |                           |      |      | RPM      | 6552              | 6466  | 6414  | 6552  | 5173  | 5173  | 5173  | 3916  | 3879  | 2586  | 2586  |
| FEED | 706      | 895                       | 987  | 1210 | 1401     | 1687              | 2085  | 1808  | 1886  | 1393  | 1592  |       |       |       |       |       |
| FEED | 459      | 582                       | 641  | 786  | 910      | 1097              | 1355  | 1175  | 1226  | 905   | 1035  |       |       |       |       |       |

**С 2 ЗУБЬЯМИ - БОКОВОЕ ФРЕЗЕРОВАНИЕ**

| ISO  | VDI 3323 | Описание материала        | Ae                           | Ap   | Параметр | Диаметр фрезы (Ø) |       |       |       |       |       |       |       |       |       |       |
|------|----------|---------------------------|------------------------------|------|----------|-------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
|      |          |                           |                              |      |          | 3.0               | 4.0   | 5.0   | 6.0   | 8.0   | 10.0  | 12.0  | 14.0  | 16.0  | 18.0  | 20.0  |
| N    | 21~22    | Алюминиевый сплав         | Ø3-Ø10=0.25D<br>Ø12-Ø20=0.5D | 1.0D | Vc       | 95                | 125   | 155   | 190   | 200   | 250   | 300   | 265   | 300   | 225   | 250   |
|      |          |                           |                              |      | fz       | 0.045             | 0.055 | 0.065 | 0.075 | 0.113 | 0.131 | 0.163 | 0.183 | 0.200 | 0.225 | 0.238 |
|      |          |                           |                              |      | RPM      | 10080             | 9947  | 9868  | 10080 | 7958  | 7958  | 7958  | 6025  | 5968  | 3979  | 3979  |
|      | 23~24    | Алюминиево-литиевый сплав | Ø3-Ø10=0.25D<br>Ø12-Ø20=0.5D | 1.0D | Vc       | 62                | 81    | 101   | 124   | 130   | 163   | 195   | 172   | 195   | 146   | 163   |
|      |          |                           |                              |      | fz       | 0.045             | 0.055 | 0.065 | 0.075 | 0.113 | 0.131 | 0.163 | 0.183 | 0.200 | 0.225 | 0.238 |
|      |          |                           |                              |      | RPM      | 6552              | 6466  | 6414  | 6552  | 5173  | 5173  | 5173  | 3916  | 3879  | 2586  | 2586  |
| FEED | 907      | 1094                      | 1283                         | 1512 | 1798     | 2085              | 2594  | 2205  | 2387  | 1790  | 1894  |       |       |       |       |       |
| FEED | 590      | 711                       | 834                          | 983  | 1169     | 1355              | 1686  | 1433  | 1552  | 1164  | 1231  |       |       |       |       |       |

