

Universal Vollhartmetall Fräser

Fraise carbure monobloc universel

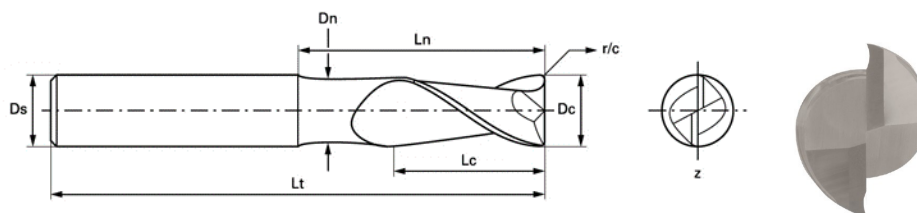
40 **Jahre** Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità





Universal VHM - Fräser

Fraise - MD universel



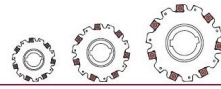
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10000	STF2A0301230.0	-	-	3,0	3	12	-	-	40	-	2
ST10001	STF2A0401230.0	-	-	4,0	4	12	-	-	40	-	2
ST10002	STF2A0501430.0	-	-	5,0	5	14	-	-	50	-	2
ST10003	STF2A0601630.0	-	-	6,0	6	16	-	-	50	-	2
ST10004	STF2A0802030.0	-	-	8,0	8	20	-	-	60	-	2
ST10005	STF2A1002230.0	-	-	10,0	10	22	-	-	70	-	2
ST10006	STF2A1202230.0	-	-	12,0	12	22	-	-	70	-	2
ST10007	STF2A1602530.0	-	-	16,0	16	25	-	-	75	-	2
ST10008	STF2A2003230.0	-	-	20,0	20	32	-	-	100	-	2



Schnittwerte / vitesses de coupe

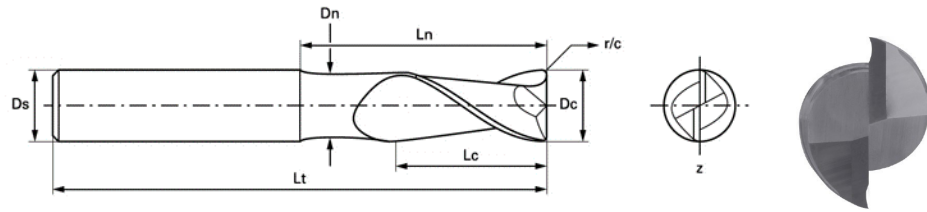
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	1*Dc	0,0025*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	130	70	60	-	-	-	100	70	65	60	-	50



Universal VHM - Fräser

Fraise - MD universel



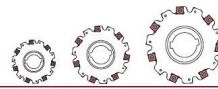
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10011	STF2A0301230.6	-	-	3,0	3	12	-	-	40	-	2
ST10012	STF2A0401230.6	-	-	4,0	4	12	-	-	40	-	2
ST10013	STF2A0501430.6	-	-	5,0	5	14	-	-	50	-	2
ST10014	STF2A0601630.6	-	-	6,0	6	16	-	-	50	-	2
ST10015	STF2A0802030.6	-	-	8,0	8	20	-	-	60	-	2
ST10016	STF2A1002230.6	-	-	10,0	10	22	-	-	70	-	2
ST10017	STF2A1202230.6	-	-	12,0	12	22	-	-	70	-	2
ST10018	STF2A1602530.6	-	-	16,0	16	25	-	-	75	-	2
ST10019	STF2A2003230.6	-	-	20,0	20	32	-	-	100	-	2



Schnittwerte / vitesses de coupe

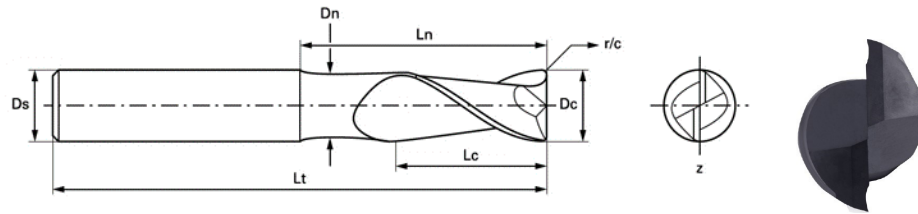
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	[min]	[max]	[max]	
	0,3*Dc	Lc	1*Dc	0,003*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	165	90	75	-	-	-	130	90	85	75	-	65



Universal VHM - Fräser

Fraise - MD universel



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10022	STF2A0300430.5	ST10038	STF2W0300430.5	3,0	6	4	-	-	50	-	2
ST10023	STF2A0350430.5	ST10039	STF2W0350430.5	3,5	6	4	-	-	50	-	2
ST10024	STF2A0400530.5	ST10040	STF2W0400530.5	4,0	6	5	-	-	54	-	2
ST10025	STF2A0450530.5	ST10041	STF2W0450530.5	4,5	6	5	-	-	54	-	2
ST10026	STF2A0500630.5	ST10042	STF2W0500630.5	5,0	6	6	-	-	54	-	2
ST10027	STF2A0600730.5	ST10043	STF2W0600730.5	6,0	6	7	-	-	54	-	2
ST10028	STF2A0700830.5	ST10044	STF2W0700830.5	7,0	8	8	-	-	58	-	2
ST10029	STF2A0800930.5	ST10045	STF2W0800930.5	8,0	8	9	-	-	58	-	2
ST10030	STF2A0901030.5	ST10046	STF2W0901030.5	9,0	10	10	-	-	66	-	2
ST10031	STF2A1001130.5	ST10047	STF2W1001130.5	10,0	10	11	-	-	66	-	2
ST10032	STF2A1201230.5	ST10048	STF2W1201230.5	12,0	12	12	-	-	73	-	2
ST10033	STF2A1401430.5	ST10049	STF2W1401430.5	14,0	14	14	-	-	73	-	2
ST10034	STF2A1601630.5	ST10050	STF2W1601630.5	16,0	16	16	-	-	82	-	2
ST10035	STF2A1801830.5	ST10051	STF2W1801830.5	18,0	18	18	-	-	84	-	2
ST10036	STF2A2002030.5	ST10052	STF2W2002030.5	20,0	20	20	-	-	92	-	2



Schnittwerte / vitesses de coupe

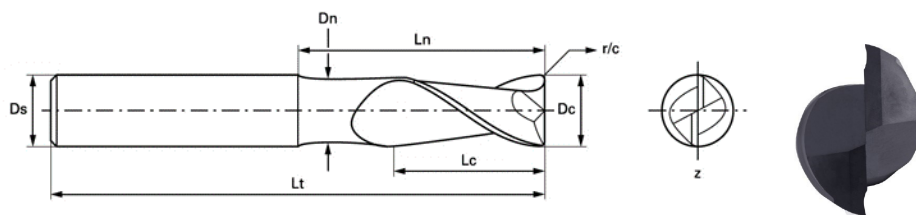
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	[min]	[max]	[max]	
	0,3*Dc	Lc	1*Dc	0,0035*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



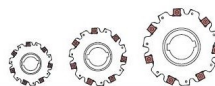
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10055	STF2A0300730.5	ST10071	STF2W0300730.5	3,0	6	7	-	-	57	-	2
ST10056	STF2A0350730.5	ST10072	STF2W0350730.5	3,5	6	7	-	-	57	-	2
ST10057	STF2A0400830.5	ST10073	STF2W0400830.5	4,0	6	8	-	-	57	-	2
ST10058	STF2A0450830.5	ST10074	STF2W0450830.5	4,5	6	8	-	-	57	-	2
ST10059	STF2A0501030.5	ST10075	STF2W0501030.5	5,0	6	10	-	-	57	-	2
ST10060	STF2A0601030.5	ST10076	STF2W0601030.5	6,0	6	10	-	-	57	-	2
ST10061	STF2A0701330.5	ST10077	STF2W0701330.5	7,0	8	13	-	-	63	-	2
ST10062	STF2A0801630.5	ST10078	STF2W0801630.5	8,0	8	16	-	-	63	-	2
ST10063	STF2A0901630.5	ST10079	STF2W0901630.5	9,0	10	16	-	-	72	-	2
ST10064	STF2A1001930.5	ST10080	STF2W1001930.5	10,0	10	19	-	-	72	-	2
ST10065	STF2A1202230.5	ST10081	STF2W1202230.5	12,0	12	22	-	-	83	-	2
ST10066	STF2A1402230.5	ST10082	STF2W1402230.5	14,0	14	22	-	-	83	-	2
ST10067	STF2A1602630.5	ST10083	STF2W1602630.5	16,0	16	26	-	-	92	-	2
ST10068	STF2A1802630.5	ST10084	STF2W1802630.5	18,0	18	26	-	-	92	-	2
ST10069	STF2A2003230.5	ST10085	STF2W2003230.5	20,0	20	32	-	-	104	-	2



Schnittwerte / vitesses de coupe

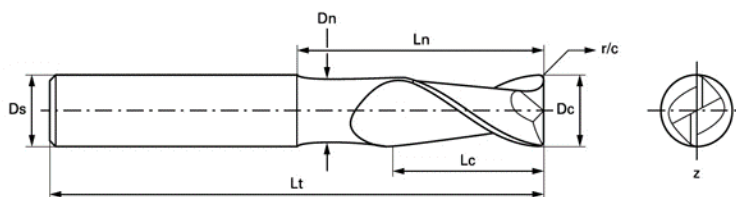
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	1*Dc	0,0035*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10180	STF3A00501530.0	-	-	0,5	3	1,5	-	-	40	-	3
ST10181	STF3A00601530.0	-	-	0,6	3	1,5	-	-	40	-	3
ST10182	STF3A0080230.0	-	-	0,8	3	2	-	-	40	-	3
ST10183	STF3A0100230.0	-	-	1,0	3	2	-	-	40	-	3
ST10184	STF3A0120230.0	-	-	1,2	3	2	-	-	40	-	3
ST10185	STF3A0150230.0	-	-	1,5	3	2	-	-	40	-	3
ST10186	STF3A0180230.0	-	-	1,8	3	2	-	-	40	-	3
ST10187	STF3A0200430.0	-	-	2,0	6	4	-	-	40	-	3
ST10188	STF3A0250530.0	-	-	2,5	6	5	-	-	40	-	3
ST10189	STF3A0300530.0	-	-	3,0	6	5	-	-	40	-	3
ST10190	STF3A0350630.0	-	-	3,5	6	6	-	-	40	-	3
ST10191	STF3A0400730.0	-	-	4,0	6	7	-	-	40	-	3
ST10192	STF3A0450830.0	-	-	4,5	6	8	-	-	40	-	3
ST10193	STF3A0500830.0	-	-	5,0	6	8	-	-	40	-	3
ST10194	STF3A0550830.0	-	-	5,5	6	8	-	-	40	-	3
ST10195	STF3A0580830.0	-	-	5,8	6	8	-	-	40	-	3
ST10196	STF3A0600830.0	-	-	6,0	6	8	-	-	40	-	3
ST10197	STF3A0681030.0	-	-	6,8	8	10	-	-	45	-	3



Schnittwerte / vitesses de coupe

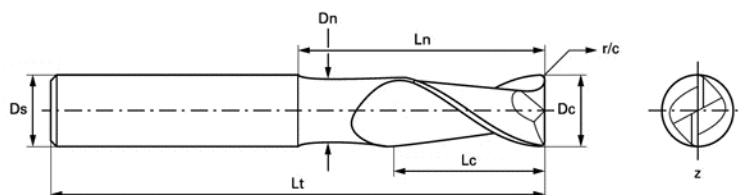
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0030*Dc
	0,3*Dc	Lc	1*Dc	0,0025*Dc
	-	1*Dc	1*Dc	0,0010*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	130	70	60	-	-	-	100	70	65	60	-	50



Universal VHM - Fräser

Fraise - MD universel



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10198	STF3A0701030.0	-	-	7,0	8	10	-	-	45	-	3
ST10199	STF3A0781030.0	-	-	7,8	8	10	-	-	45	-	3
ST10200	STF3A0801130.0	-	-	8,0	8	11	-	-	45	-	3
ST10201	STF3A0871130.0	-	-	8,7	10	11	-	-	50	-	3
ST10202	STF3A0901130.0	-	-	9,0	10	11	-	-	50	-	3
ST10203	STF3A0971130.0	-	-	9,7	10	11	-	-	50	-	3
ST10204	STF3A1001330.0	-	-	10,0	10	13	-	-	50	-	3
ST10205	STF3A1201530.0	-	-	12,0	12	15	-	-	55	-	3



Schnittwerte / vitesses de coupe

	Ap [min]	Ap [max]	Ae [max]	fz
	0,3*Dc	Lc	0,5*Dc	0,0030*Dc
	0,3*Dc	Lc	1*Dc	0,0025*Dc
	-	1*Dc	1*Dc	0,0010*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	130	70	60	-	-	-	100	70	65	60	-	50



Einwegfräser VHM - Fräser

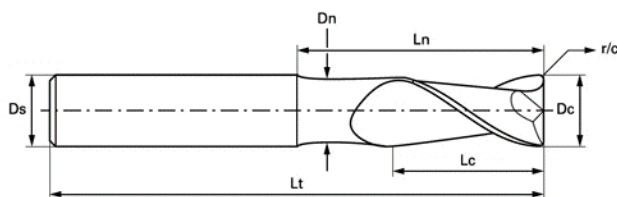
Fraise - MD à jeter



DS = ø3



DS = ø6



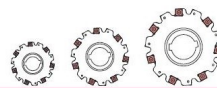
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10208	STF3A00501530.6	-	-	0,5	3	1,5	-	-	40	-	3
ST10209	STF3A00601530.6	-	-	0,6	3	1,5	-	-	40	-	3
ST10210	STF3A0080230.6	-	-	0,8	3	2	-	-	40	-	3
ST10211	STF3A0100230.6	-	-	1,0	3	2	-	-	40	-	3
ST10212	STF3A0120230.6	-	-	1,2	3	2	-	-	40	-	3
ST10213	STF3A0150230.6	-	-	1,5	3	2	-	-	40	-	3
ST10214	STF3A0180230.6	-	-	1,8	3	2	-	-	40	-	3
-	-	ST10215	STF3A0200430.6	2,0	6	4	-	-	40	-	3
-	-	ST10216	STF3A0250530.6	2,5	6	5	-	-	40	-	3
-	-	ST10217	STF3A0300530.6	3,0	6	5	-	-	40	-	3
-	-	ST10218	STF3A0350630.6	3,5	6	6	-	-	40	-	3
-	-	ST10219	STF3A0400730.6	4,0	6	7	-	-	40	-	3
-	-	ST10220	STF3A0450830.6	4,5	6	8	-	-	40	-	3
-	-	ST10221	STF3A0500830.6	5,0	6	8	-	-	40	-	3
-	-	ST10222	STF3A0550830.6	5,5	6	8	-	-	40	-	3
-	-	ST10223	STF3A0580830.6	5,8	6	8	-	-	40	-	3



Schnittwerte / vitesses de coupe

	Ap [min]	Ap [max]	Ae [max]	fz
	0,3*Dc	Lc	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	1*Dc	0,0030*Dc
	-	1*Dc	1*Dc	0,0015*Dc

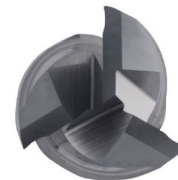
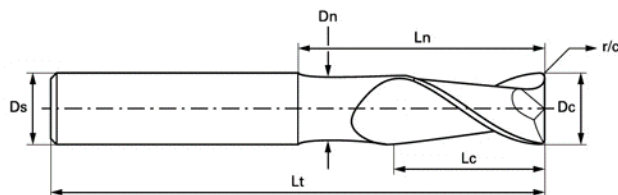
	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	165	90	75	-	-	-	130	90	85	75	-	65



DS = ø6

Einwegfräser VHM - Fräser

Fraise - MD à jeter



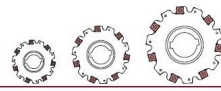
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
-	-	ST10224	STF3A0600830.6	6,0	6	8	-	-	40	-	3
-	-	ST10225	STF3A0681030.6	6,8	8	10	-	-	45	-	3
-	-	ST10226	STF3A0701030.6	7,0	8	10	-	-	45	-	3
-	-	ST10227	STF3A0781030.6	7,8	8	10	-	-	45	-	3
-	-	ST10228	STF3A0801130.6	8,0	8	11	-	-	45	-	3
-	-	ST10229	STF3A0871130.6	8,7	10	11	-	-	50	-	3
-	-	ST10230	STF3A0901130.6	9,0	10	11	-	-	50	-	3
-	-	ST10231	STF3A0971130.6	9,7	10	11	-	-	50	-	3
-	-	ST10232	STF3A1001330.6	10,0	10	13	-	-	50	-	3
-	-	ST10233	STF3A1201530.6	12,0	12	15	-	-	55	-	3



Schnittwerte / vitesses de coupe

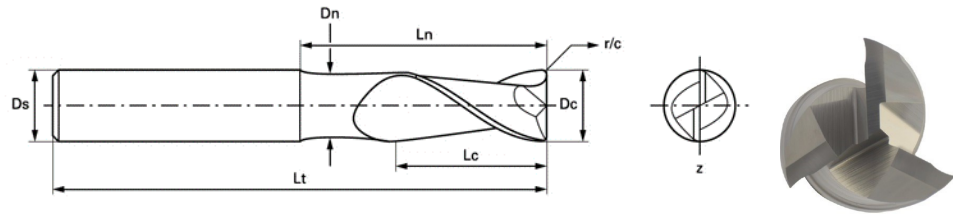
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	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0030*Dc
	-	1*Dc	1*Dc	0,0015*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	165	90	75	-	-	-	130	90	85	75	-	65



Universal VHM - Fräser

Fraise - MD universel



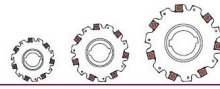
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10236	STF3A0301230.0	-	-	3,0	3	12	-	-	40	-	3
ST10237	STF3A0401230.0	-	-	4,0	4	12	-	-	40	-	3
ST10238	STF3A0501430.0	-	-	5,0	5	14	-	-	50	-	3
ST10239	STF3A0601630.0	-	-	6,0	6	16	-	-	50	-	3
ST10240	STF3A0802030.0	-	-	8,0	8	20	-	-	60	-	3
ST10241	STF3A1002230.0	-	-	10,0	10	22	-	-	70	-	3
ST10242	STF3A1202230.0	-	-	12,0	12	22	-	-	70	-	3
ST10243	STF3A1602530.0	-	-	16,0	16	25	-	-	75	-	3
ST10244	STF3A2003230.0	-	-	20,0	20	32	-	-	100	-	3



Schnittwerte / vitesses de coupe

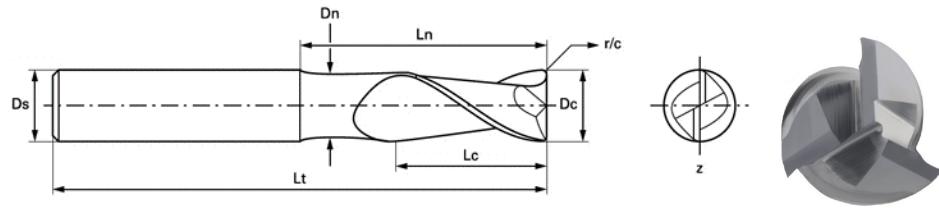
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	0,3*Dc	Lc	1*Dc	0,0025*Dc
	-	1*Dc	1*Dc	0,0010*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	130	70	60	-	-	-	100	70	65	60	-	50



Universal VHM - Fräser




Fraise - MD universel



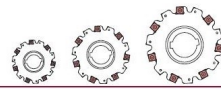
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10247	STF3A0301230.6	-	-	3,0	3	12	-	-	40	-	3
ST10248	STF3A0401230.6	-	-	4,0	4	12	-	-	40	-	3
ST10249	STF3A0501430.6	-	-	5,0	5	14	-	-	50	-	3
ST10250	STF3A0601630.6	-	-	6,0	6	16	-	-	50	-	3
ST10251	STF3A0802030.6	-	-	8,0	8	20	-	-	60	-	3
ST10252	STF3A1002230.6	-	-	10,0	10	22	-	-	70	-	3
ST10253	STF3A1202230.6	-	-	12,0	12	22	-	-	70	-	3
ST10254	STF3A1602530.6	-	-	16,0	16	25	-	-	75	-	3
ST10255	STF3A2003230.6	-	-	20,0	20	32	-	-	100	-	3



Schnittwerte / vitesses de coupe

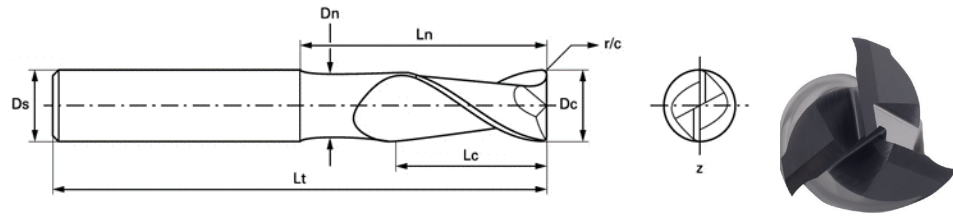
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	0,3*Dc	Lc	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	1*Dc	0,0030*Dc
	-	1*Dc	1*Dc	0,0015*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	165	90	75	-	-	-	130	90	85	75	-	65



Universal VHM - Fräser

Fraise - MD universel



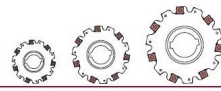
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10258	STF3A0300430.5	ST10272	STF3W0300430.5	3,0	6	4	-	-	50	-	3
ST10259	STF3A0350430.5	ST10273	STF3W0350430.5	3,5	6	4	-	-	50	-	3
ST10260	STF3A0400530.5	ST10274	STF3W0400530.5	4,0	6	5	-	-	54	-	3
ST10261	STF3A0450530.5	ST10275	STF3W0450530.5	4,5	6	5	-	-	54	-	3
ST10262	STF3A0500630.5	ST10276	STF3W0500630.5	5,0	6	6	-	-	54	-	3
ST10263	STF3A0600730.5	ST10277	STF3W0600730.5	6,0	6	7	-	-	54	-	3
ST10264	STF3A0800930.5	ST10278	STF3W0800930.5	8,0	8	9	-	-	58	-	3
ST10265	STF3A1001130.5	ST10279	STF3W1001130.5	10,0	10	11	-	-	66	-	3
ST10266	STF3A1201230.5	ST10280	STF3W1201230.5	12,0	12	12	-	-	73	-	3
ST10267	STF3A1401430.5	ST10281	STF3W1401430.5	14,0	14	14	-	-	73	-	3
ST10268	STF3A1601630.5	ST10282	STF3W1601630.5	16,0	16	16	-	-	82	-	3
ST10269	STF3A1801830.5	ST10283	STF3W1801830.5	18,0	18	18	-	-	84	-	3
ST10270	STF3A2002030.5	ST10284	STF3W2002030.5	20,0	20	20	-	-	92	-	3



Schnittwerte / vitesses de coupe

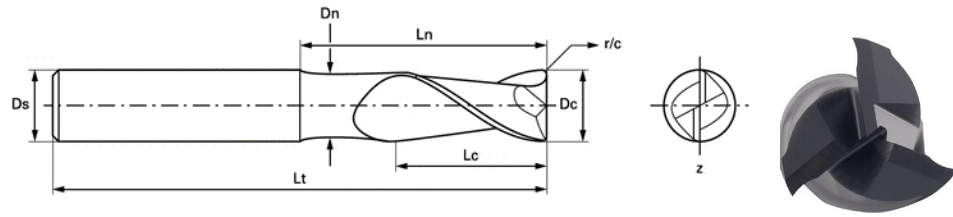
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	0,3*Dc	Lc	1*Dc	0,0035*Dc
	-	1*Dc	1*Dc	0,0020*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser




Fraise - MD universel



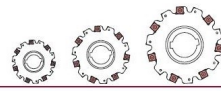
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10287	STF3A0300730.5	ST10301	STF3W0300730.5	3,0	6	7	-	-	57	-	3
ST10288	STF3A0350730.5	ST10302	STF3W0350730.5	3,5	6	7	-	-	57	-	3
ST10289	STF3A0400830.5	ST10303	STF3W0400830.5	4,0	6	8	-	-	57	-	3
ST10290	STF3A0450830.5	ST10304	STF3W0450830.5	4,5	6	8	-	-	57	-	3
ST10291	STF3A0501030.5	ST10305	STF3W0501030.5	5,0	6	10	-	-	57	-	3
ST10292	STF3A0601030.5	ST10306	STF3W0601030.5	6,0	6	10	-	-	57	-	3
ST10293	STF3A0801630.5	ST10307	STF3W0801630.5	8,0	8	16	-	-	63	-	3
ST10294	STF3A1001930.5	ST10308	STF3W1001930.5	10,0	10	19	-	-	72	-	3
ST10295	STF3A1202230.5	ST10309	STF3W1202230.5	12,0	12	22	-	-	83	-	3
ST10296	STF3A1402230.5	ST10310	STF3W1402230.5	14,0	14	22	-	-	83	-	3
ST10297	STF3A1602630.5	ST10311	STF3W1602630.5	16,0	16	26	-	-	92	-	3
ST10298	STF3A1802630.5	ST10312	STF3W1802630.5	18,0	18	26	-	-	92	-	3
ST10299	STF3A2003230.5	ST10313	STF3W2003230.5	20,0	20	32	-	-	104	-	3



Schnittwerte / vitesses de coupe

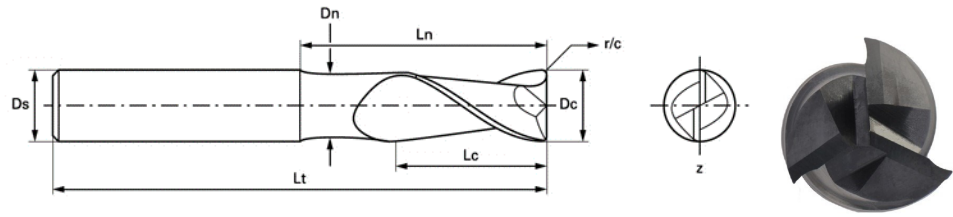
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	0,3*Dc	Lc	1*Dc	0,0035*Dc
	-	1*Dc	1*Dc	0,0020*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



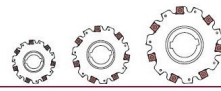
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10316	STF3A0300445.5	ST10330	STF3W0300445.5	3,0	6	4	-	-	50	-	3
ST10317	STF3A0350445.5	ST10331	STF3W0350445.5	3,5	6	4	-	-	50	-	3
ST10318	STF3A0400545.5	ST10332	STF3W0400545.5	4,0	6	5	-	-	54	-	3
ST10319	STF3A0450545.5	ST10333	STF3W0450545.5	4,5	6	5	-	-	54	-	3
ST10320	STF3A0500645.5	ST10334	STF3W0500645.5	5,0	6	6	-	-	54	-	3
ST10321	STF3A0600745.5	ST10335	STF3W0600745.5	6,0	6	7	-	-	54	-	3
ST10322	STF3A0800945.5	ST10336	STF3W0800945.5	8,0	8	9	-	-	58	-	3
ST10323	STF3A1001145.5	ST10337	STF3W1001145.5	10,0	10	11	-	-	66	-	3
ST10324	STF3A1201245.5	ST10338	STF3W1201245.5	12,0	12	12	-	-	73	-	3
ST10325	STF3A1401445.5	ST10339	STF3W1401445.5	14,0	14	14	-	-	73	-	3
ST10326	STF3A1601645.5	ST10340	STF3W1601645.5	16,0	16	16	-	-	82	-	3
ST10327	STF3A1801845.5	ST10341	STF3W1801845.5	18,0	18	18	-	-	84	-	3
ST10328	STF3A2002045.5	ST10342	STF3W2002045.5	20,0	20	20	-	-	92	-	3



Schnittwerte / vitesses de coupe

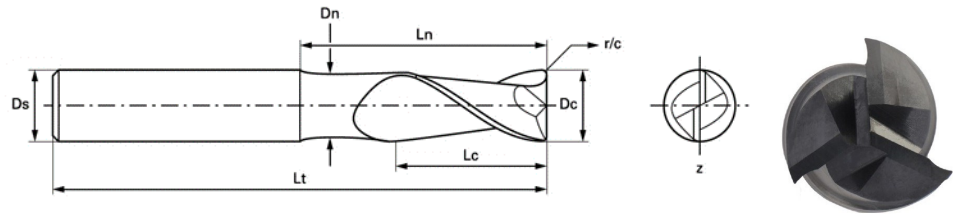
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	0,3*Dc	Lc	1*Dc	0,0035*Dc
	-	1*Dc	1*Dc	0,0020*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



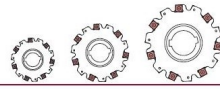
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10345	STF3A0300745.5	ST10359	STF3W0300745.5	3,0	6	7	-	-	57	-	3
ST10346	STF3A0350745.5	ST10360	STF3W0350745.5	3,5	6	7	-	-	57	-	3
ST10347	STF3A0400845.5	ST10361	STF3W0400845.5	4,0	6	8	-	-	57	-	3
ST10348	STF3A0450845.5	ST10362	STF3W0450845.5	4,5	6	8	-	-	57	-	3
ST10349	STF3A0501045.5	ST10363	STF3W0501045.5	5,0	6	10	-	-	57	-	3
ST10350	STF3A0601045.5	ST10364	STF3W0601045.5	6,0	6	10	-	-	57	-	3
ST10351	STF3A0801645.5	ST10365	STF3W0801645.5	8,0	8	16	-	-	63	-	3
ST10352	STF3A1001945.5	ST10366	STF3W1001945.5	10,0	10	19	-	-	72	-	3
ST10353	STF3A1202245.5	ST10367	STF3W1202245.5	12,0	12	22	-	-	83	-	3
ST10354	STF3A1402245.5	ST10368	STF3W1402245.5	14,0	14	22	-	-	83	-	3
ST10355	STF3A1602645.5	ST10369	STF3W1602645.5	16,0	16	26	-	-	92	-	3
ST10356	STF3A1802645.5	ST10370	STF3W1802645.5	18,0	18	26	-	-	92	-	3
ST10357	STF3A2003245.5	ST10371	STF3W2003245.5	20,0	20	32	-	-	104	-	3



Schnittwerte / vitesses de coupe

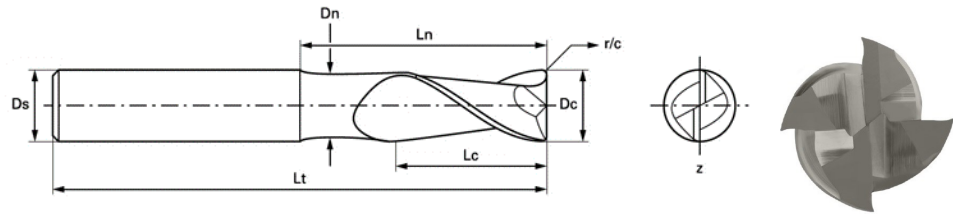
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	0,3*Dc	Lc	1*Dc	0,0035*Dc
	-	1*Dc	1*Dc	0,0020*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



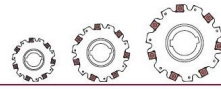
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10436	STF4A0301230.0	-	-	3,0	3	12	-	-	40	-	4
ST10437	STF4A0401230.0	-	-	4,0	4	12	-	-	40	-	4
ST10438	STF4A0501430.0	-	-	5,0	5	14	-	-	50	-	4
ST10439	STF4A0601630.0	-	-	6,0	6	16	-	-	50	-	4
ST10440	STF4A0802030.0	-	-	8,0	8	20	-	-	60	-	4
ST10441	STF4A1002230.0	-	-	10,0	10	22	-	-	70	-	4
ST10442	STF4A1202230.0	-	-	12,0	12	22	-	-	70	-	4
ST10443	STF4A1602530.0	-	-	16,0	16	25	-	-	75	-	4
ST10444	STF4A2003230.0	-	-	20,0	20	32	-	-	100	-	4



Schnittwerte / vitesses de coupe

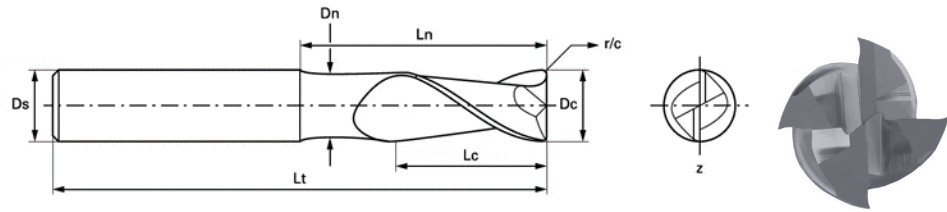
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	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	130	70	60	-	-	-	100	70	65	60	-	50



Universal VHM - Fräser

Fraise - MD universel



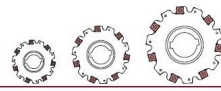
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10447	STF4A0301230.6	-	-	3,0	3	12	-	-	40	-	4
ST10448	STF4A0401230.6	-	-	4,0	4	12	-	-	40	-	4
ST10449	STF4A0501430.6	-	-	5,0	5	14	-	-	50	-	4
ST10450	STF4A0601630.6	-	-	6,0	6	16	-	-	50	-	4
ST10451	STF4A0802030.6	-	-	8,0	8	20	-	-	60	-	4
ST10452	STF4A1002230.6	-	-	10,0	10	22	-	-	70	-	4
ST10453	STF4A1202230.6	-	-	12,0	12	22	-	-	70	-	4
ST10454	STF4A1602530.6	-	-	16,0	16	25	-	-	75	-	4
ST10455	STF4A2003230.6	-	-	20,0	20	32	-	-	100	-	4



Schnittwerte / vitesses de coupe

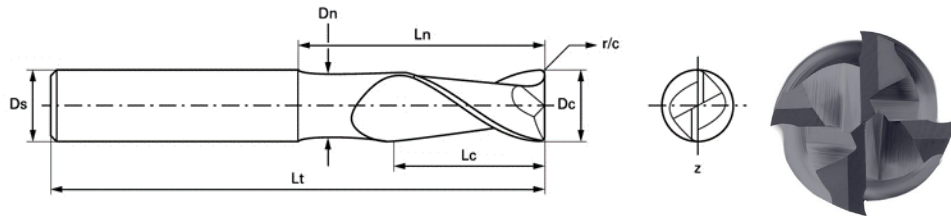
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	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	165	90	75	-	-	-	130	90	85	75	-	65



Universal VHM - Fräser

Fraise - MD universel



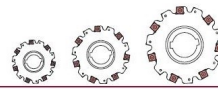
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10458	STF4A0300530.5	ST10472	STF4W0300530.5	3,0	6	5	-	-	50	-	4
ST10459	STF4A0350630.5	ST10473	STF4W0350630.5	3,5	6	6	-	-	50	-	4
ST10460	STF4A0400830.5	ST10474	STF4W0400830.5	4,0	6	8	-	-	54	-	4
ST10461	STF4A0450830.5	ST10475	STF4W0450830.5	4,5	6	8	-	-	54	-	4
ST10462	STF4A0500930.5	ST10476	STF4W0500930.5	5,0	6	9	-	-	54	-	4
ST10463	STF4A0601030.5	ST10477	STF4W0601030.5	6,0	6	10	-	-	54	-	4
ST10464	STF4A0801230.5	ST10478	STF4W0801230.5	8,0	8	12	-	-	58	-	4
ST10465	STF4A1001430.5	ST10479	STF4W1001430.5	10,0	10	14	-	-	66	-	4
ST10466	STF4A1201630.5	ST10480	STF4W1201630.5	12,0	12	16	-	-	73	-	4
ST10467	STF4A1401830.5	ST10481	STF4W1401830.5	14,0	14	18	-	-	73	-	4
ST10468	STF4A1602230.5	ST10482	STF4W1602230.5	16,0	16	22	-	-	82	-	4
ST10469	STF4A1802430.5	ST10483	STF4W1802430.5	18,0	18	24	-	-	84	-	4
ST10470	STF4A2002630.5	ST10484	STF4W2002630.5	20,0	20	26	-	-	92	-	4



Schnittwerte / vitesses de coupe

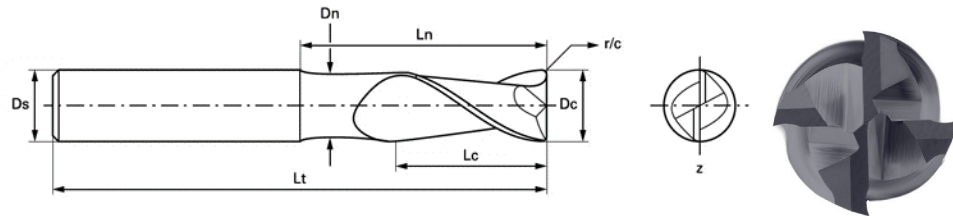
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	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



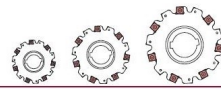
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
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ST10488	STF4A0351030.5	ST10502	STF4W0351030.5	3,5	6	10	-	-	57	-	4
ST10489	STF4A0401130.5	ST10503	STF4W0401130.5	4,0	6	11	-	-	57	-	4
ST10490	STF4A0451130.5	ST10504	STF4W0451130.5	4,5	6	11	-	-	57	-	4
ST10491	STF4A0501330.5	ST10505	STF4W0501330.5	5,0	6	13	-	-	57	-	4
ST10492	STF4A0601330.5	ST10506	STF4W0601330.5	6,0	6	13	-	-	57	-	4
ST10493	STF4A0801930.5	ST10507	STF4W0801930.5	8,0	8	19	-	-	63	-	4
ST10494	STF4A1002230.5	ST10508	STF4W1002230.5	10,0	10	22	-	-	72	-	4
ST10495	STF4A1202630.5	ST10509	STF4W1202630.5	12,0	12	26	-	-	83	-	4
ST10496	STF4A1402630.5	ST10510	STF4W1402630.5	14,0	14	26	-	-	83	-	4
ST10497	STF4A1603230.5	ST10511	STF4W1603230.5	16,0	16	32	-	-	92	-	4
ST10498	STF4A1803230.5	ST10512	STF4W1803230.5	18,0	18	32	-	-	92	-	4
ST10499	STF4A2003830.5	ST10513	STF4W2003830.5	20,0	20	38	-	-	104	-	4



Schnittwerte / vitesses de coupe

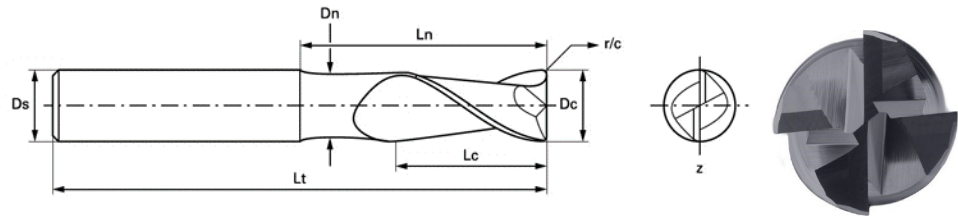
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	0,3*Dc	Lc	0,5*Dc	0,0050*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



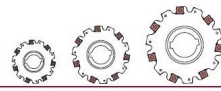
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10516	STF4A0300838C005.5	ST10530	STF4W0300838C005.5	3,0	6	8	-	-	57	0,05	4
ST10517	STF4A0351038C005.5	ST10531	STF4W0351038C005.5	3,5	6	10	-	-	57	0,05	4
ST10518	STF4A0401138C005.5	ST10532	STF4W0401138C005.5	4,0	6	11	-	-	57	0,05	4
ST10519	STF4A0451138C007.5	ST10533	STF4W0451138C007.5	4,5	6	11	-	-	57	0,07	4
ST10520	STF4A0501338C010.5	ST10534	STF4W0501338C010.5	5,0	6	13	-	-	57	0,10	4
ST10521	STF4A0601338C010.5	ST10535	STF4W0601338C010.5	6,0	6	13	-	-	57	0,10	4
ST10522	STF4A0801938C020.5	ST10536	STF4W0801938C020.5	8,0	8	19	-	-	63	0,20	4
ST10523	STF4A1002238C025.5	ST10537	STF4W1002238C025.5	10,0	10	22	-	-	72	0,25	4
ST10524	STF4A1202638C030.5	ST10538	STF4W1202638C030.5	12,0	12	26	-	-	83	0,30	4
ST10525	STF4A1402638C035.5	ST10539	STF4W1402638C035.5	14,0	14	26	-	-	83	0,35	4
ST10526	STF4A1603238C040.5	ST10540	STF4W1603238C040.5	16,0	16	32	-	-	92	0,40	4
ST10527	STF4A1803238C045.5	ST10541	STF4W1803238C045.5	18,0	18	32	-	-	92	0,45	4
ST10528	STF4A2003838C050.5	ST10542	STF4W2003838C050.5	20,0	20	38	-	-	104	0,50	4



Schnittwerte / vitesses de coupe

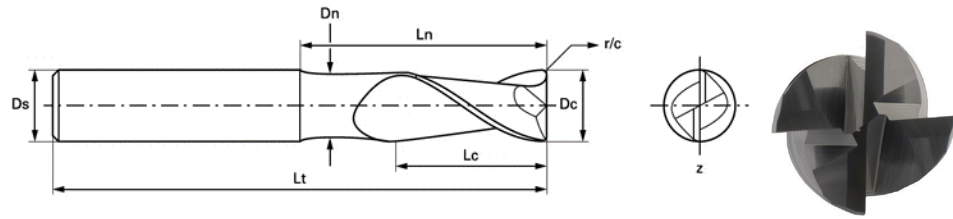
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	0,3*Dc	Lc	1*Dc	0,0040*Dc
	1°	5°	0,5*Dc	0,0030*Dc
	0,3*Dc	Lc	0,25*Dc	0,0065*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



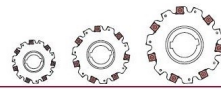
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10545	STF4A03005H00938C005.2	ST10559	STF4W03005H00938C005.2	3,0	6	5	9	2,8	50	0,05	4
ST10546	STF4A03506H01038C005.2	ST10560	STF4W03506H01038C005.2	3,5	6	6	10	3,3	50	0,05	4
ST10547	STF4A04008H01338C005.2	ST10561	STF4W04008H01338C005.2	4,0	6	8	13	3,8	54	0,05	4
ST10548	STF4A04508H01538C007.2	ST10562	STF4W04508H01538C007.2	4,5	6	8	15	4,3	54	0,07	4
ST10549	STF4A05009H01638C010.2	ST10563	STF4W05009H01638C010.2	5,0	6	9	16	4,8	54	0,10	4
ST10550	STF4A06010H01738C010.2	ST10564	STF4W06010H01738C010.2	6,0	6	10	17	5,7	54	0,10	4
ST10551	STF4A08012H02238C020.2	ST10565	STF4W08012H02238C020.2	8,0	8	12	22	7,6	58	0,20	4
ST10552	STF4A10014H02638C025.2	ST10566	STF4W10014H02638C025.2	10,0	10	14	26	9,5	66	0,25	4
ST10553	STF4A12016H02838C030.2	ST10567	STF4W12016H02838C030.2	12,0	12	16	28	11,5	73	0,30	4
ST10554	STF4A14018H03038C035.2	ST10568	STF4W14018H03038C035.2	14,0	14	18	30	13,5	73	0,35	4
ST10555	STF4A16022H03438C040.2	ST10569	STF4W16022H03438C040.2	16,0	16	22	34	15,5	82	0,40	4
ST10556	STF4A18024H03638C045.2	ST10570	STF4W18024H03638C045.2	18,0	18	24	36	17,5	84	0,45	4
ST10557	STF4A20026H04238C050.2	ST10571	STF4W20026H04238C050.2	20,0	20	26	42	19,5	92	0,50	4



Schnittwerte / vitesses de coupe

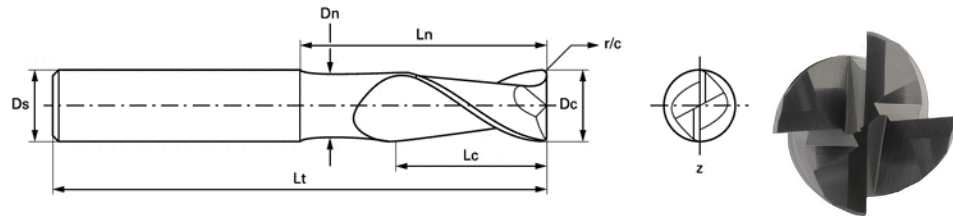
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	5°	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	0,25*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM - Fräser

Fraise - MD universel



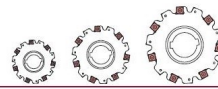
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10574	STF4A03008H01438C005.2	ST10588	STF4W03008H01438C005.2	3,0	6	8	14	2,8	57	0,05	4
ST10575	STF4A03510H01638C005.2	ST10589	STF4W03510H01638C005.2	3,5	6	10	16	3,3	57	0,05	4
ST10576	STF4A04011H01638C005.2	ST10590	STF4W04011H01638C005.2	4,0	6	11	16	3,8	57	0,05	4
ST10577	STF4A04511H01838C007.2	ST10591	STF4W04511H01838C007.2	4,5	6	11	18	4,3	57	0,07	4
ST10578	STF4A05013H01838C010.2	ST10592	STF4W05013H01838C010.2	5,0	6	13	18	4,8	57	0,10	4
ST10579	STF4A06013H01938C010.2	ST10593	STF4W06013H01938C010.2	6,0	6	13	19	5,7	57	0,10	4
ST10580	STF4A08019H02538C020.2	ST10594	STF4W08019H02538C020.2	8,0	8	19	25	7,6	63	0,20	4
ST10581	STF4A10022H03038C025.2	ST10595	STF4W10022H03038C025.2	10,0	10	22	30	9,5	72	0,25	4
ST10582	STF4A12026H03638C030.2	ST10596	STF4W12026H03638C030.2	12,0	12	26	36	11,5	83	0,30	4
ST10583	STF4A14026H03638C035.2	ST10597	STF4W14026H03638C035.2	14,0	14	26	36	13,5	83	0,35	4
ST10584	STF4A16032H04238C040.2	ST10598	STF4W16032H04238C040.2	16,0	16	32	42	15,5	92	0,40	4
ST10585	STF4A18032H04238C045.2	ST10599	STF4W18032H04238C045.2	18,0	18	32	42	17,5	92	0,45	4
ST10586	STF4A20038H05238C050.2	ST10600	STF4W20038H05238C050.2	20,0	20	38	52	19,5	104	0,50	4



Schnittwerte / vitesses de coupe

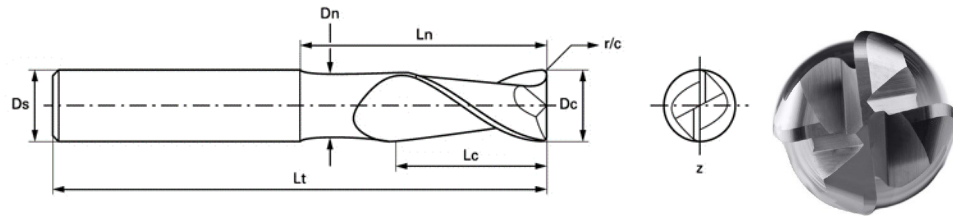
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	5°	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	0,25*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM - Fräser

Fraise - MD universel



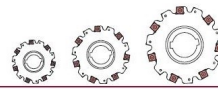
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10603	STF4A06013H01938R050.2	ST10617	STF4W06013H01938R050.2	6,0	6	13	19	5,7	57	0,5	4
ST10604	STF4A06013H01938R100.2	ST10618	STF4W06013H01938R100.2	6,0	6	13	19	5,7	57	1,0	4
ST10605	STF4A08019H02538R050.2	ST10619	STF4W08019H02538R050.2	8,0	8	19	25	7,6	63	0,5	4
ST10606	STF4A08019H02538R100.2	ST10620	STF4W08019H02538R100.2	8,0	8	19	25	7,6	63	1,0	4
ST10607	STF4A10022H03038R050.2	ST10621	STF4W10022H03038R050.2	10,0	10	22	30	9,5	72	0,5	4
ST10608	STF4A10022H03038R100.2	ST10622	STF4W10022H03038R100.2	10,0	10	22	30	9,5	72	1,0	4
ST10609	STF4A10022H03038R200.2	ST10623	STF4W10022H03038R200.2	10,0	10	22	30	9,5	72	2,0	4
ST10610	STF4A12026H03638R050.2	ST10624	STF4W12026H03638R050.2	12,0	12	26	36	11,5	83	0,5	4
ST10611	STF4A12026H03638R100.2	ST10625	STF4W12026H03638R100.2	12,0	12	26	36	11,5	83	1,0	4
ST10612	STF4A12026H03638R200.2	ST10626	STF4W12026H03638R200.2	12,0	12	26	36	11,5	83	2,0	4
ST10613	STF4A16032H04238R050.2	ST10627	STF4W16032H04238R050.2	16,0	16	32	42	15,5	92	0,5	4
ST10614	STF4A16032H04238R100.2	ST10628	STF4W16032H04238R100.2	16,0	16	32	42	15,5	92	1,0	4
ST10615	STF4A16032H04238R200.2	ST10629	STF4W16032H04238R200.2	16,0	16	32	42	15,5	92	2,0	4



Schnittwerte / vitesses de coupe

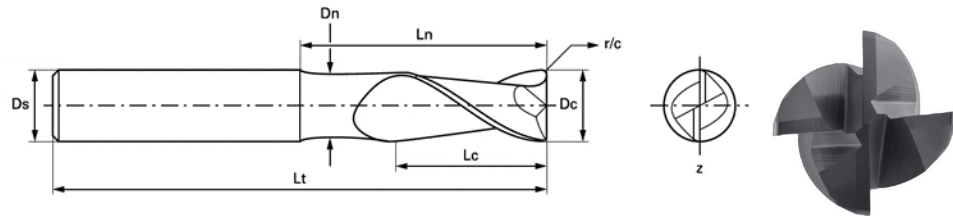
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	5°	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	0,25*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM - Fräser

Fraise - MD universel



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10632	STF4A03008H01438R020.2	ST10646	STF4W03008H01438R020.2	3,0	6	8	14	2,8	62	0,2	4
ST10633	STF4A03510H01638R020.2	ST10647	STF4W03510H01638R020.2	3,5	6	10	16	3,3	62	0,2	4
ST10634	STF4A04011H01838R020.2	ST10648	STF4W04011H01838R020.2	4,0	6	11	18	3,8	62	0,2	4
ST10635	STF4A04511H02038R020.2	ST10649	STF4W04511H02038R020.2	4,5	6	11	20	4,3	62	0,2	4
ST10636	STF4A05013H02238R020.2	ST10650	STF4W05013H02238R020.2	5,0	6	13	22	4,8	62	0,2	4
ST10637	STF4A06013H02638R020.2	ST10651	STF4W06013H02638R020.2	6,0	6	13	26	5,7	62	0,2	4
ST10638	STF4A08019H03438R030.2	ST10652	STF4W08019H03438R030.2	8,0	8	19	34	7,6	68	0,3	4
ST10639	STF4A10022H04238R050.2	ST10653	STF4W10022H04238R050.2	10,0	10	22	42	9,5	80	0,5	4
ST10640	STF4A12026H05038R050.2	ST10654	STF4W12026H05038R050.2	12,0	12	26	50	11,5	100	0,5	4
ST10641	STF4A14026H05038R050.2	ST10655	STF4W14026H05038R050.2	14,0	14	26	50	13,5	110	0,5	4
ST10642	STF4A16032H06638R100.2	ST10656	STF4W16032H06638R100.2	16,0	16	32	66	15,5	120	1,0	4
ST10643	STF4A18032H06638R100.2	ST10657	STF4W18032H06638R100.2	18,0	18	32	66	17,5	125	1,0	4
ST10644	STF4A20038H08238R100.2	ST10658	STF4W20038H08238R100.2	20,0	20	38	82	19,5	140	1,0	4



Schnittwerte / vitesses de coupe

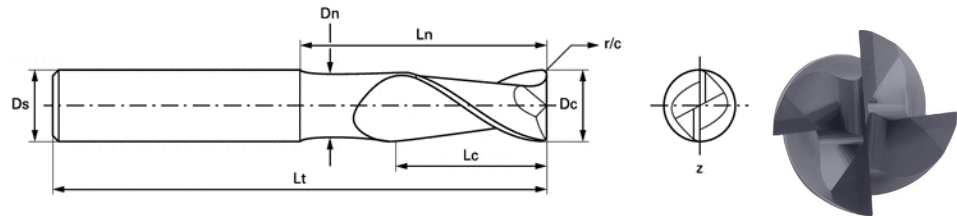
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	5°	0,5*Dc	0,0035*Dc
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc
	0,3*Dc	Lc	0,25*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM - Fräser

Fraise - MD universel



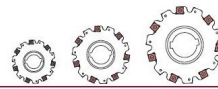
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10661	STF4A05713H01938C005.3	ST10676	STF4W05713H01938C005.3	5,7	6	13	19	5,4	57	0,05	4
ST10662	STF4A06013H01938C006.3	ST10677	STF4W06013H01938C006.3	6,0	6	13	19	5,7	57	0,06	4
ST10663	STF4A07719H02538C007.3	ST10678	STF4W07719H02538C007.3	7,7	8	19	25	7,3	63	0,07	4
ST10664	STF4A08019H02538C008.3	ST10679	STF4W08019H02538C008.3	8,0	8	19	25	7,6	63	0,08	4
ST10665	STF4A09722H03038C009.3	ST10680	STF4W09722H03038C009.3	9,7	10	22	30	9,2	72	0,09	4
ST10666	STF4A10022H03038C010.3	ST10681	STF4W10022H03038C010.3	10,0	10	22	30	9,5	72	0,10	4
ST10667	STF4A11726H03638C011.3	ST10682	STF4W11726H03638C011.3	11,7	12	26	36	11,2	83	0,11	4
ST10668	STF4A12026H03638C012.3	ST10683	STF4W12026H03638C012.3	12,0	12	26	36	11,5	83	0,12	4
ST10669	STF4A13726H03638C013.3	ST10684	STF4W13726H03638C013.3	13,7	14	26	36	13,2	83	0,13	4
ST10670	STF4A14026H03638C014.3	ST10685	STF4W14026H03638C014.3	14,0	14	26	36	13,5	83	0,14	4
ST10671	STF4A15632H04238C015.3	ST10686	STF4W15632H04238C015.3	15,6	16	32	42	15,1	92	0,15	4
ST10672	STF4A16032H04238C016.3	ST10687	STF4W16032H04238C016.3	16,0	16	32	42	15,5	92	0,16	4
ST10673	STF4A19538H05238C019.3	ST10688	STF4W19538H05238C019.3	19,5	20	38	52	19,0	104	0,19	4
ST10674	STF4A20038H05238C020.3	ST10689	STF4W20038H05238C020.3	20,0	20	38	52	19,5	104	0,20	4



Schnittwerte / vitesses de coupe

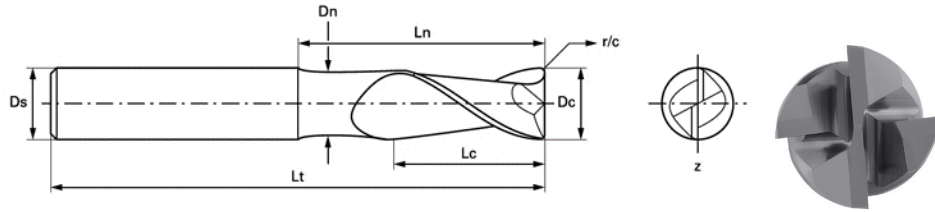
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	45°	0,5*Dc	0,0035*Dc
	-	2*Dc	1*Dc	0,0028*Dc
	0,3*Dc	Lc	0,25*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM HPC Fräser

Fraise HPC MD universel



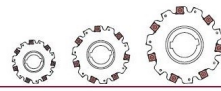
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12950	STF4A03008H01438C005.4	ST12961	STF4W03008H01438C005.4	3	6	8	14	2,8	57	0,05	4
ST12951	STF4A04011H01638C005.4	ST12962	STF4W04011H01638C005.4	4	6	11	16	3,8	57	0,05	4
ST12952	STF4A05013H01838C010.4	ST12963	STF4W05013H01838C010.4	5	6	13	18	4,8	57	0,10	4
ST12953	STF4A06013H01938C010.4	ST12964	STF4W06013H01938C010.4	6	6	13	19	5,7	57	0,10	4
ST12954	STF4A08021H02538C020.4	ST12965	STF4W08021H02538C020.4	8	8	21	25	7,6	63	0,20	4
ST12955	STF4A10022H03038C025.4	ST12966	STF4W10022H03038C025.4	10	10	22	30	9,5	72	0,25	4
ST12956	STF4A12026H03638C030.4	ST12967	STF4W12026H03638C030.4	12	12	26	36	11,5	83	0,30	4
ST12957	STF4A14026H03638C035.4	ST12968	STF4W14026H03638C035.4	14	14	26	36	13,5	83	0,35	4
ST12958	STF4A16036H04238C040.4	ST12969	STF4W16036H04238C040.4	16	16	36	42	15,5	92	0,40	4
ST12959	STF4A18036H04238C045.4	ST12970	STF4W18036H04238C045.4	18	18	36	42	17,5	92	0,45	4
ST12960	STF4A20041H05238C050.4	ST12971	STF4W20041H05238C050.4	20	20	41	52	19,5	104	0,50	4



Schnittwerte / vitesses de coupe

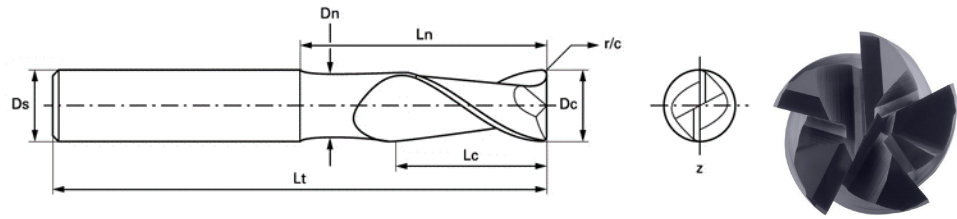
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	0,3*Dc	Lc	0,4*Dc	0,0060*Dc
	0,3*Dc	Lc	1*Dc	0,0040*Dc
	1°	5°	0,5*Dc	0,0030*Dc
	0,3*Dc	Lc	0,25*Dc	0,0065*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



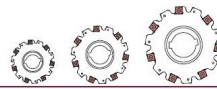
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10795	STF5A0300838C005.5	ST10807	STF5W0300838C005.5	3,0	6	8	-	-	57	0,05	5
ST10796	STF5A0401138C005.5	ST10808	STF5W0401138C005.5	4,0	6	11	-	-	57	0,05	5
ST10797	STF5A0501338C010.5	ST10809	STF5W0501338C010.5	5,0	6	13	-	-	57	0,10	5
ST10798	STF5A0601338C010.5	ST10810	STF5W0601338C010.5	6,0	6	13	-	-	57	0,10	5
ST10799	STF5A0801938C020.5	ST10811	STF5W0801938C020.5	8,0	8	19	-	-	63	0,20	5
ST10800	STF5A1002238C025.5	ST10812	STF5W1002238C025.5	10,0	10	22	-	-	72	0,25	5
ST10801	STF5A1202638C030.5	ST10813	STF5W1202638C030.5	12,0	12	26	-	-	83	0,30	5
ST10802	STF5A1402638C035.5	ST10814	STF5W1402638C035.5	14,0	14	26	-	-	83	0,35	5
ST10803	STF5A1603238C040.5	ST10815	STF5W1603238C040.5	16,0	16	32	-	-	92	0,40	5
ST10804	STF5A1803238C045.5	ST10816	STF5W1803238C045.5	18,0	18	32	-	-	92	0,45	5
ST10805	STF5A2003838C050.5	ST10817	STF5W2003838C050.5	20,0	20	38	-	-	104	0,50	5



Schnittwerte / vitesses de coupe

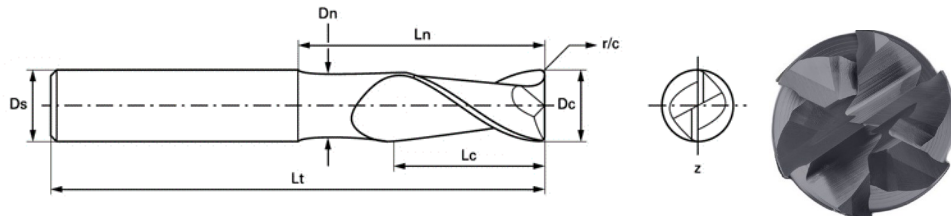
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	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0040*Dc
	1°	5°	0,5*Dc	0,0030*Dc
	0,3*Dc	Lc	0,25*Dc	0,0065*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



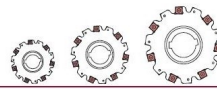
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11006	STF6A0601345C006.5	ST11015	STF6W0601345C006.5	6,0	6	13	-	-	57	0,06	6
ST11007	STF6A0801945C008.5	ST11016	STF6W0801945C008.5	8,0	8	19	-	-	63	0,08	6
ST11008	STF6A1002245C010.5	ST11017	STF6W1002245C010.5	10,0	10	22	-	-	72	0,10	6
ST11009	STF6A1202645C012.5	ST11018	STF6W1202645C012.5	12,0	12	26	-	-	83	0,12	6
ST11010	STF6A1402645C014.5	ST11019	STF6W1402645C014.5	14,0	14	26	-	-	83	0,14	6
ST11011	STF6A1603245C016.5	ST11020	STF6W1603245C016.5	16,0	16	32	-	-	92	0,16	6
ST11012	STF8A1803245C018.5	ST11021	STF8W1803245C018.5	18,0	18	32	-	-	92	0,18	8
ST11013	STF8A2003845C020.5	ST11022	STF8W2003845C020.5	20,0	20	38	-	-	104	0,20	8



Schnittwerte / vitesses de coupe

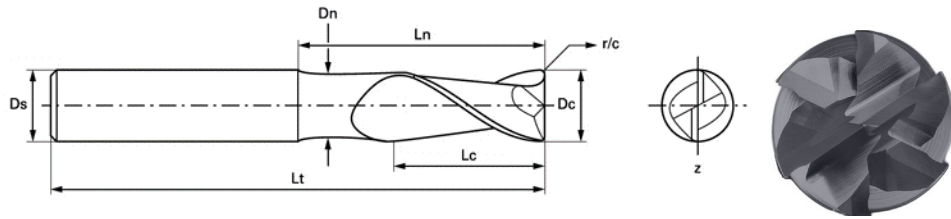
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	0,3*Dc	Lc	0,2*Dc	0,0040*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



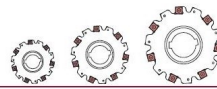
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11025	STF6A0601845C006.5	ST11034	STF6W0601845C006.5	6,0	6	18	-	-	62	0,06	6
ST11026	STF6A0802445C008.5	ST11035	STF6W0802445C008.5	8,0	8	24	-	-	68	0,08	6
ST11027	STF6A1003045C010.5	ST11036	STF6W1003045C010.5	10,0	10	30	-	-	80	0,10	6
ST11028	STF6A1203645C012.5	ST11037	STF6W1203645C012.5	12,0	12	36	-	-	93	0,12	6
ST11029	STF6A1404545C014.5	ST11038	STF6W1404545C014.5	14,0	14	45	-	-	100	0,14	6
ST11030	STF6A1604845C016.5	ST11039	STF6W1604845C016.5	16,0	16	48	-	-	108	0,16	6
ST11031	STF8A1805545C018.5	ST11040	STF8W1805545C018.5	18,0	18	55	-	-	115	0,18	8
ST11032	STF8A2006045C020.5	ST11041	STF8W2006045C020.5	20,0	20	60	-	-	126	0,20	8



Schnittwerte / vitesses de coupe

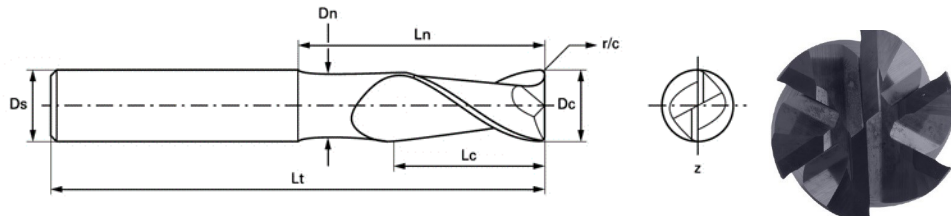
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	[min]	[max]	[max]	
	0,3*Dc	Lc	0,2*Dc	0,0040*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



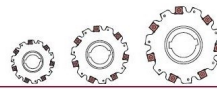
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11044	STF6A0603645C006.5	ST11051	STF6W0603645C006.5	6,0	6	36	-	-	80	0,06	6
ST11045	STF6A0804645C008.5	ST11052	STF6W0804645C008.5	8,0	8	46	-	-	90	0,08	6
ST11046	STF6A1005045C010.5	ST11053	STF6W1005045C010.5	10,0	10	50	-	-	100	0,10	6
ST11047	STF6A1206545C012.5	ST11054	STF6W1206545C012.5	12,0	12	65	-	-	120	0,12	6
ST11048	STF6A1608045C016.5	ST11055	STF6W1608045C016.5	16,0	16	80	-	-	140	0,16	6
ST11049	STF8A2009445C020.5	ST11056	STF8W2009445C020.5	20,0	20	94	-	-	160	0,20	8



Schnittwerte / vitesses de coupe

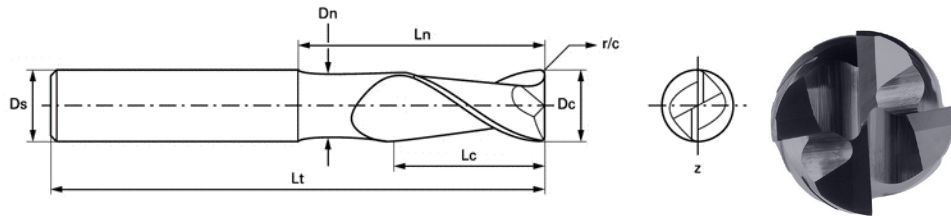
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	0,3*Dc	Lc	0,2*Dc	0,0040*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



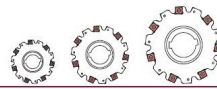
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11155	STF4A0401145C010SU.5	ST11166	STF4W0401145C010SU.5	4,0	6	11	-	-	57	0,10	4
ST11156	STF4A0501345C012SU.5	ST11167	STF4W0501345C012SU.5	5,0	6	13	-	-	57	0,12	4
ST11157	STF4A0601345C015SU.5	ST11168	STF4W0601345C015SU.5	6,0	6	13	-	-	57	0,15	4
ST11158	STF4A0801945C020SU.5	ST11169	STF4W0801945C020SU.5	8,0	8	19	-	-	63	0,20	4
ST11159	STF4A1002245C025SU.5	ST11170	STF4W1002245C025SU.5	10,0	10	22	-	-	72	0,25	4
ST11160	STF4A1202645C030SU.5	ST11171	STF4W1202645C030SU.5	12,0	12	26	-	-	83	0,30	4
ST11161	STF4A1402645C035SU.5	ST11172	STF4W1402645C035SU.5	14,0	14	26	-	-	83	0,35	4
ST11162	STF4A1603245C040SU.5	ST11173	STF4W1603245C040SU.5	16,0	16	32	-	-	92	0,40	4
ST11163	STF4A1803245C045SU.5	ST11174	STF4W1803245C045SU.5	18,0	18	32	-	-	92	0,45	4
ST11164	STF4A2003845C050SU.5	ST11175	STF4W2003845C050SU.5	20,0	20	38	-	-	104	0,50	4



Schnittwerte / vitesses de coupe

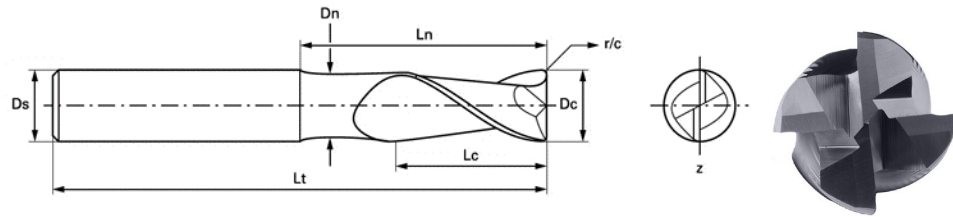
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	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0040*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



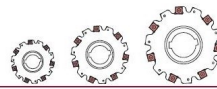
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11178	STF3A0601320C030S.5	ST11187	STF3W0601320C030S.5	6,0	6	13	-	-	57	0,30	3
ST11179	STF3A0801920C035S.5	ST11188	STF3W0801920C035S.5	8,0	8	19	-	-	63	0,35	3
ST11180	STF4A1002220C035S.5	ST11189	STF4W1002220C035S.5	10,0	10	22	-	-	72	0,35	4
ST11181	STF4A1202620C040S.5	ST11190	STF4W1202620C040S.5	12,0	12	26	-	-	83	0,40	4
ST11182	STF4A1402620C045S.5	ST11191	STF4W1402620C045S.5	14,0	14	26	-	-	83	0,45	4
ST11183	STF4A1603220C050S.5	ST11192	STF4W1603220C050S.5	16,0	16	32	-	-	92	0,50	4
ST11184	STF4A1803220C055S.5	ST11193	STF4W1803220C055S.5	18,0	18	32	-	-	92	0,55	4
ST11185	STF4A2003820C060S.5	ST11194	STF4W2003820C060S.5	20,0	20	38	-	-	104	0,60	4



Schnittwerte / vitesses de coupe

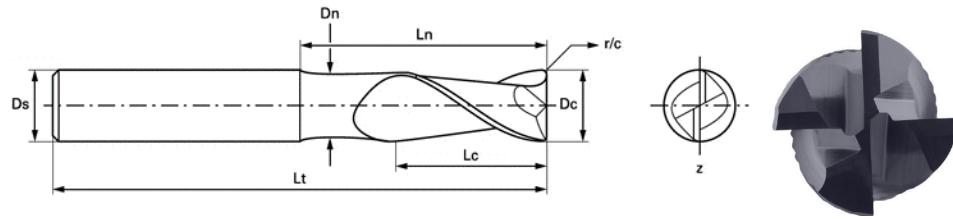
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	0,3*Dc	Lc	1*Dc	0,0020*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



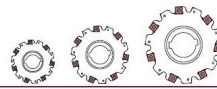
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11197	STF3A0401145C015S.5	ST11210	STF3W0401145C015S.5	4,0	6	11	-	-	57	0,15	3
ST11198	STF4A0501345C020S.5	ST11211	STF4W0501345C020S.5	5,0	6	13	-	-	57	0,20	4
ST11199	STF4A0601345C030S.5	ST11212	STF4W0601345C030S.5	6,0	6	13	-	-	57	0,30	4
ST11200	STF4A0801945C030S.5	ST11213	STF4W0801945C030S.5	8,0	8	19	-	-	63	0,30	4
ST11201	STF4A1002245C030S.5	ST11214	STF4W1002245C030S.5	10,0	10	22	-	-	72	0,30	4
ST11202	STF4A1202645C030S.5	ST11215	STF4W1202645C030S.5	12,0	12	26	-	-	83	0,30	4
ST11203	STF4A1402645C035S.5	ST11216	STF4W1402645C035S.5	14,0	14	26	-	-	83	0,35	4
ST11204	STF4A1603245C040S.5	ST11217	STF4W1603245C040S.5	16,0	16	32	-	-	92	0,40	4
ST11205	STF5A1603245C040S.5	ST11218	STF5W1603245C040S.5	16,0	16	32	-	-	92	0,40	5
ST11206	STF5A1803245C045S.5	ST11219	STF5W1803245C045S.5	18,0	18	32	-	-	92	0,45	5
ST11207	STF5A2003845C050S.5	ST11220	STF5W2003845C050S.5	20,0	20	38	-	-	104	0,50	5
ST11208	STF6A2003845C050S.5	ST11221	STF6W2003845C050S.5	20,0	20	38	-	-	104	0,50	6



Schnittwerte / vitesses de coupe

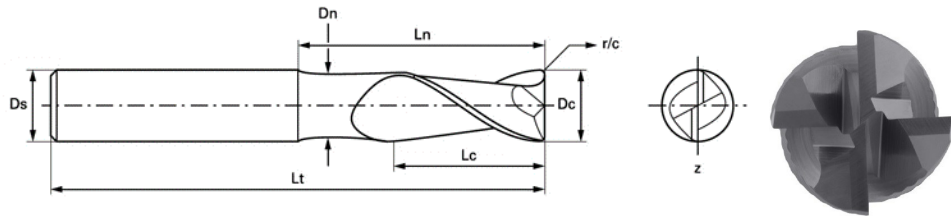
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	0,3*Dc	Lc	1*Dc	0,0040*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



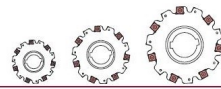
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11224	STF3A04008H01345C015.2	ST11237	STF3W04008H01345C015.2	4,0	6	8	13	3,8	54	0,15	3
ST11225	STF4A05009H01645C020.2	ST11238	STF4W05009H01645C020.2	5,0	6	9	16	4,8	54	0,20	4
ST11226	STF4A06010H01745C030.2	ST11239	STF4W06010H01745C030.2	6,0	6	10	17	5,7	54	0,30	4
ST11227	STF4A08012H02245C030.2	ST11240	STF4W08012H02245C030.2	8,0	8	12	22	7,6	58	0,30	4
ST11228	STF4A10014H02645C030.2	ST11241	STF4W10014H02645C030.2	10,0	10	14	26	9,5	66	0,30	4
ST11229	STF4A12016H02845C030.2	ST11242	STF4W12016H02845C030.2	12,0	12	16	28	11,5	73	0,30	4
ST11230	STF4A14018H03045C035.2	ST11243	STF4W14018H03045C035.2	14,0	14	18	30	13,5	73	0,35	4
ST11231	STF4A16022H03445C040.2	ST11244	STF4W16022H03445C040.2	16,0	16	22	34	15,5	82	0,40	4
ST11232	STF5A16022H03445C040.2	ST11245	STF5W16022H03445C040.2	16,0	16	22	34	15,5	82	0,40	5
ST11233	STF5A18024H03645C045.2	ST11246	STF5W18024H03645C045.2	18,0	18	24	36	17,5	84	0,45	5
ST11234	STF5A20026H04245C050.2	ST11247	STF5W20026H04245C050.2	20,0	20	26	42	19,5	92	0,50	5
ST11235	STF6A20026H04245C050.2	ST11248	STF6W20026H04245C050.2	20,0	20	26	42	19,5	92	0,50	6



Schnittwerte / vitesses de coupe

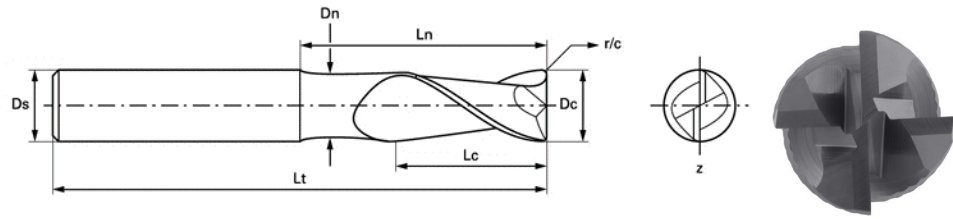
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	0,3*Dc	Lc	1*Dc	0,0060*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM - Fräser

Fraise - MD universel



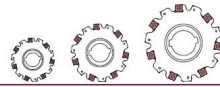
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11251	STF3A04011H01645C015.2	ST11264	STF3W04011H01645C015.2	4,0	6	11	16	3,8	57	0,15	3
ST11252	STF4A05013H01845C020.2	ST11265	STF4W05013H01845C020.2	5,0	6	13	18	4,8	57	0,20	4
ST11253	STF4A06013H01945C030.2	ST11266	STF4W06013H01945C030.2	6,0	6	13	19	5,7	57	0,30	4
ST11254	STF4A08019H02545C030.2	ST11267	STF4W08019H02545C030.2	8,0	8	19	25	7,6	63	0,30	4
ST11255	STF4A10022H03045C030.2	ST11268	STF4W10022H03045C030.2	10,0	10	22	30	9,5	72	0,30	4
ST11256	STF4A12026H03645C030.2	ST11269	STF4W12026H03645C030.2	12,0	12	26	36	11,5	83	0,30	4
ST11257	STF4A14026H03645C035.2	ST11270	STF4W14026H03645C035.2	14,0	14	26	36	13,5	83	0,35	4
ST11258	STF4A16032H04245C040.2	ST11271	STF4W16032H04245C040.2	16,0	16	32	42	15,5	92	0,40	4
ST11259	STF5A16032H04245C040.2	ST11272	STF5W16032H04245C040.2	16,0	16	32	42	15,5	92	0,40	5
ST11260	STF5A18032H04245C045.2	ST11273	STF5W18032H04245C045.2	18,0	18	32	42	17,5	92	0,45	5
ST11261	STF5A20038H05245C050.2	ST11274	STF5W20038H05245C050.2	20,0	20	38	52	19,5	104	0,50	5
ST11262	STF6A20038H05245C050.2	ST11275	STF6W20038H05245C050.2	20,0	20	38	52	19,5	104	0,50	6



Schnittwerte / vitesses de coupe

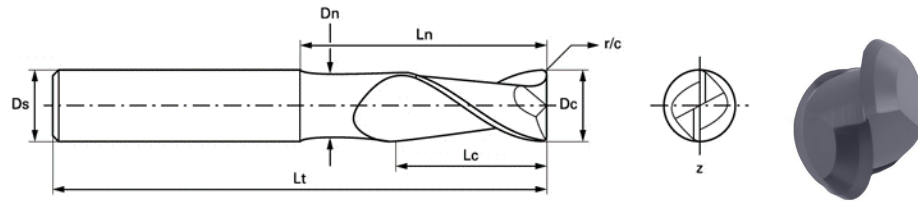
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	0,3*Dc	Lc	0,5*Dc	0,0070*Dc
	0,3*Dc	Lc	1*Dc	0,0060*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	110	90	-	70



Universal VHM - Fräser

Fraise - MD universel



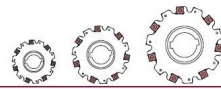
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11278	STF2A0300430R150.5	ST11290	STF2W0300430R150.5	3,0	6	4	-	-	50	1,5	2
ST11279	STF2A0400530R200.5	ST11291	STF2W0400530R200.5	4,0	6	5	-	-	54	2,0	2
ST11280	STF2A0500630R250.5	ST11292	STF2W0500630R250.5	5,0	6	6	-	-	54	2,5	2
ST11281	STF2A0600730R300.5	ST11293	STF2W0600730R300.5	6,0	6	7	-	-	54	3,0	2
ST11282	STF2A0800930R400.5	ST11294	STF2W0800930R400.5	8,0	8	9	-	-	58	4,0	2
ST11283	STF2A1001130R500.5	ST11295	STF2W1001130R500.5	10,0	10	11	-	-	66	5,0	2
ST11284	STF2A1201230R600.5	ST11296	STF2W1201230R600.5	12,0	12	12	-	-	73	6,0	2
ST11285	STF2A1401430R700.5	ST11297	STF2W1401430R700.5	14,0	14	14	-	-	73	7,0	2
ST11286	STF2A1601630R800.5	ST11298	STF2W1601630R800.5	16,0	16	16	-	-	82	8,0	2
ST11287	STF2A1801830R900.5	ST11299	STF2W1801830R900.5	18,0	18	18	-	-	84	9,0	2
ST11288	STF2A2002030R100.5	ST11300	STF2W2002030R100.5	20,0	20	20	-	-	92	10,0	2



Schnittwerte / vitesses de coupe

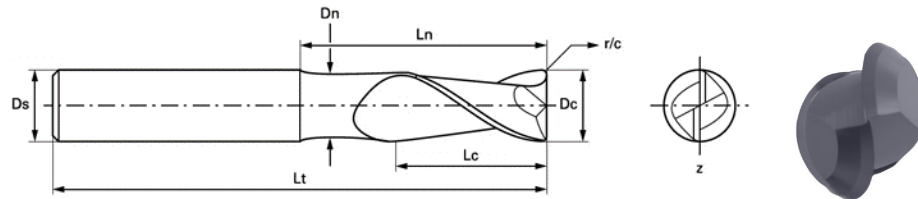
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	0,02*Dc	0,5+Dc	0,5*Dc	0,0150*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



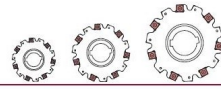
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ST11303	STF2A0300730R150.5	ST11315	STF2W0300730R150.5	3,0	6	7	-	-	57	1,5	2
ST11304	STF2A0400830R200.5	ST11316	STF2W0400830R200.5	4,0	6	8	-	-	57	2,0	2
ST11305	STF2A0501030R250.5	ST11317	STF2W0501030R250.5	5,0	6	10	-	-	57	2,5	2
ST11306	STF2A0601030R300.5	ST11318	STF2W0601030R300.5	6,0	6	10	-	-	57	3,0	2
ST11307	STF2A0801630R400.5	ST11319	STF2W0801630R400.5	8,0	8	16	-	-	63	4,0	2
ST11308	STF2A1001930R500.5	ST11320	STF2W1001930R500.5	10,0	10	19	-	-	72	5,0	2
ST11309	STF2A1202230R600.5	ST11321	STF2W1202230R600.5	12,0	12	22	-	-	83	6,0	2
ST11310	STF2A1402230R700.5	ST11322	STF2W1402230R700.5	14,0	14	22	-	-	83	7,0	2
ST11311	STF2A1602630R800.5	ST11323	STF2W1602630R800.5	16,0	16	26	-	-	92	8,0	2
ST11312	STF2A1802630R900.5	ST11324	STF2W1802630R900.5	18,0	18	26	-	-	92	9,0	2
ST11313	STF2A2003230R100.5	ST11325	STF2W2003230R100.5	20,0	20	32	-	-	104	10,0	2



Schnittwerte / vitesses de coupe

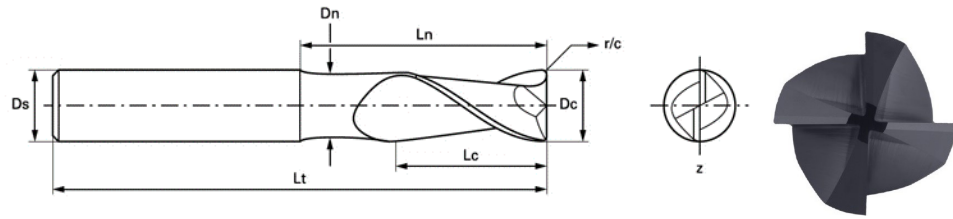
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	[min]	[max]	[max]	
	0,02*Dc	0,5+Dc	0,5*Dc	0,0150*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	-	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



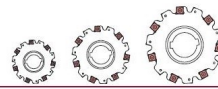
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11382	STF4A012C90.5	-	-	1,2	6	-	-	-	57	45°	4
ST11383	STF4A016C90.5	-	-	1,6	8	-	-	-	63	45°	4
ST11384	STF4A020C90.5	-	-	2,0	10	-	-	-	72	45°	4
ST11385	STF4A024C90.5	-	-	2,4	12	-	-	-	83	45°	4



Schnittwerte / vitesses de coupe

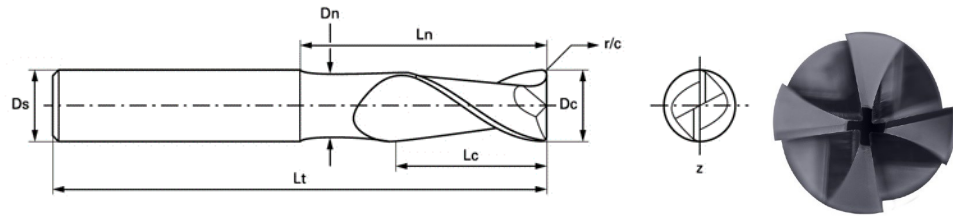
	Ap	Ap	c	fz
	[min]	[max]	[max]	
	-	-	45°	0,010*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



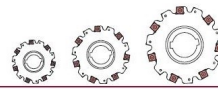
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11388	STF4A012C60.5	-	-	1,2	6	-	-	-	57	30°	4
ST11389	STF4A016C60.5	-	-	1,6	8	-	-	-	63	30°	4
ST11390	STF4A020C60.5	-	-	2,0	10	-	-	-	72	30°	4
ST11391	STF4A024C60.5	-	-	2,4	12	-	-	-	83	30°	4



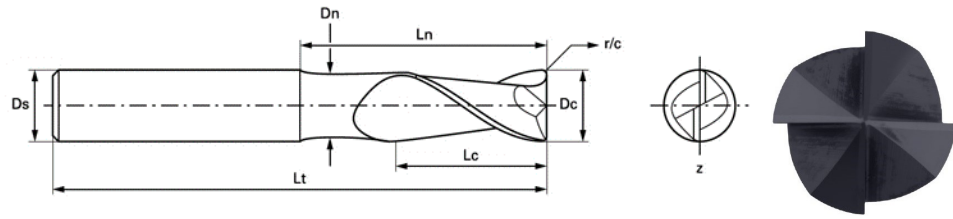
Schnittwerte / vitesses de coupe

	Ap	Ap	c	fz
	[min]	[max]	[max]	
	-	-	30°	0,007*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser Fraise - MD universel



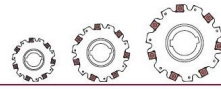
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11394	STF4A060C90.5	-	-	-	6	-	-	-	57	45°	4
ST11395	STF4A080C90.5	-	-	-	8	-	-	-	63	45°	4
ST11396	STF4A100C90.5	-	-	-	10	-	-	-	72	45°	4
ST11397	STF4A120C90.5	-	-	-	12	-	-	-	83	45°	4



Schnittwerte / vitesses de coupe

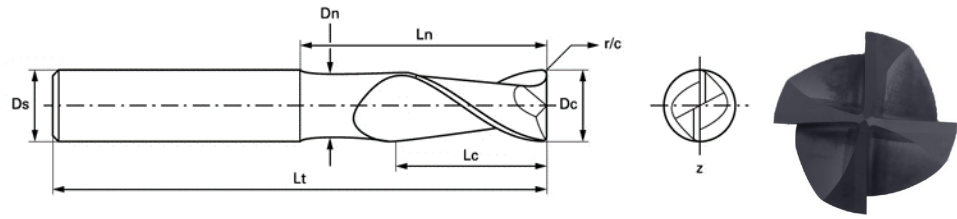
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	[min]	[max]	[max]	
	-	-	45°	0,010*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



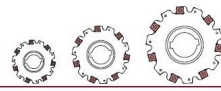
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ST11400	STF4A060C60.5	-	-	-	6	-	-	-	57	30°	4
ST11401	STF4A080C60.5	-	-	-	8	-	-	-	63	30°	4
ST11402	STF4A100C60.5	-	-	-	10	-	-	-	72	30°	4
ST11403	STF4A120C60.5	-	-	-	12	-	-	-	83	30°	4



Schnittwerte / vitesses de coupe

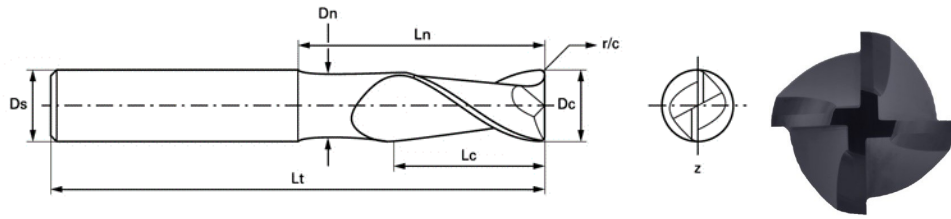
	Ap	Ap	c	fz
	[min]	[max]	[max]	
	-	-	30°	0,007*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



Universal VHM - Fräser

Fraise - MD universel



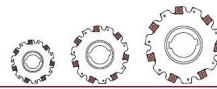
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11406	STF4A0500R050.5	-	-	5,0	6	-	-	-	57	0,5	4
ST11407	STF4A0400R100.5	-	-	4,0	6	-	-	-	57	1,0	4
ST11408	STF4A0500R150.5	-	-	5,0	8	-	-	-	63	1,5	4
ST11409	STF4A0400R200.5	-	-	4,0	8	-	-	-	63	2,0	4
ST11410	STF4A0500R250.5	-	-	5,0	10	-	-	-	72	2,5	4
ST11411	STF4A0400R300.5	-	-	4,0	10	-	-	-	72	3,0	4
ST11412	STF4A0500R350.5	-	-	5,0	12	-	-	-	83	3,5	4
ST11413	STF4A0400R400.5	-	-	4,0	12	-	-	-	83	4,0	4
ST11414	STF4A0400R500.5	-	-	4,0	14	-	-	-	83	5,0	4



Schnittwerte / vitesses de coupe

	Ap	Ap	r	fz
	[min]	[max]	[max]	
	-	-	0,5 - 5,0	0,0085*Dc

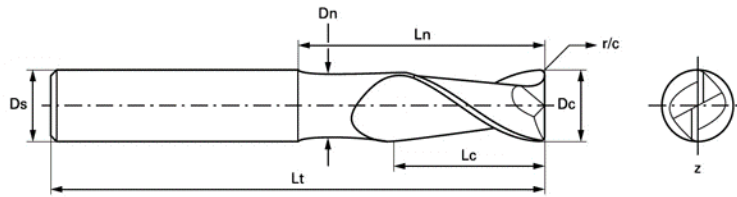
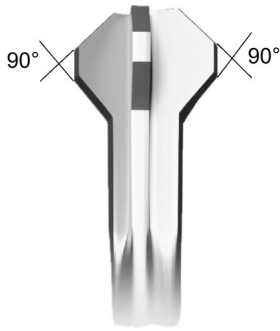
	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



New-24

Universal VHM - Fräser

Fraise - MD universel



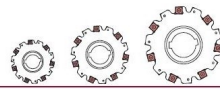
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12900	STF5A04001H016C90.2	-	-	4	4	1,0	16	2	54	45°	5
ST12901	STF5A060015H024C90.2	-	-	6	6	1,5	24	3	62	45°	5
ST12902	STF5A080015H032C90.2	-	-	8	8	1,5	32	5	70	45°	5
ST12903	STF5A100015H040C90.2	-	-	10	10	1,5	40	7	82	45°	5
ST12904	STF5A12002H048C90.2	-	-	12	12	2,0	48	8	95	45°	5



Schnittwerte / vitesses de coupe

	Ap	Ap	c	fz
	[min]	[max]	[max]	
	-	-	45°	0,010*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	180	100	80	60	-	-	140	100	90	80	-	70



VHM-Fräser **Stahl, Guss und**
gehärtete Stähle

Fraise-MD **Acier, Fontes et**
Aciers trempés

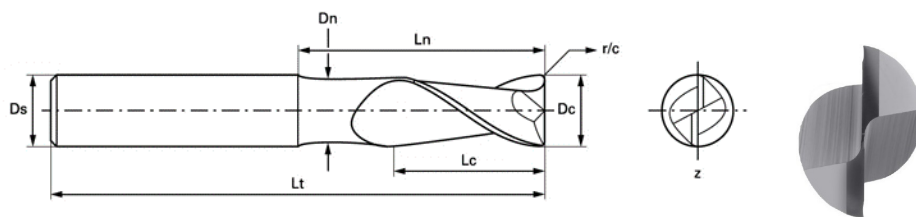
40 **Jahre** Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità





VHM - Fräser P / K / H

Fraise - MD P / K / H



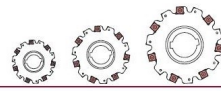
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10088	STF2A02003H00930.2	ST10110	STF2W02003H00930.2	2,0	6	3	9	1,8	54	-	2
ST10089	STF2A02504H00930.2	ST10111	STF2W02504H00930.2	2,5	6	4	9	2,2	54	-	2
ST10090	STF2A03004H01130.2	ST10112	STF2W03004H01130.2	3,0	6	4	11	2,7	54	-	2
ST10091	STF2A03505H01130.2	ST10113	STF2W03505H01130.2	3,5	6	5	11	3,1	57	-	2
ST10092	STF2A04005H01530.2	ST10114	STF2W04005H01530.2	4,0	6	5	15	3,6	57	-	2
ST10093	STF2A04506H01530.2	ST10115	STF2W04506H01530.2	4,5	6	6	15	4,1	57	-	2
ST10094	STF2A05006H02330.2	ST10116	STF2W05006H02330.2	5,0	6	6	23	4,5	62	-	2
ST10095	STF2A05507H02330.2	ST10117	STF2W05507H02330.2	5,5	6	7	23	5,0	62	-	2
ST10096	STF2A06007H02430.2	ST10118	STF2W06007H02430.2	6,0	6	7	24	5,4	62	-	2
ST10097	STF2A07008H02830.2	ST10119	STF2W07008H02830.2	7,0	8	8	28	6,3	68	-	2
ST10098	STF2A08009H03030.2	ST10120	STF2W08009H03030.2	8,0	8	9	30	7,2	68	-	2
ST10099	STF2A09010H03630.2	ST10121	STF2W09010H03630.2	9,0	10	10	36	8,2	80	-	2
ST10100	STF2A10011H03830.2	ST10122	STF2W10011H03830.2	10,0	10	11	38	9,0	80	-	2
ST10101	STF2A11012H04430.2	ST10123	STF2W11012H04430.2	11,0	12	12	44	10,0	93	-	2
ST10102	STF2A12013H04630.2	ST10124	STF2W12013H04630.2	12,0	12	13	46	11,0	93	-	2
ST10103	STF2A13014H04430.2	ST10125	STF2W13014H04430.2	13,0	14	14	44	12,0	93	-	2
ST10104	STF2A14015H04630.2	ST10126	STF2W14015H04630.2	14,0	14	15	46	13,0	93	-	2
ST10105	STF2A15016H05630.2	ST10127	STF2W15016H05630.2	15,0	16	16	56	14,0	108	-	2
ST10106	STF2A16017H05830.2	ST10128	STF2W16017H05830.2	16,0	16	17	58	15,0	108	-	2
ST10107	STF2A18019H05830.2	ST10129	STF2W18019H05830.2	18,0	18	19	58	17,0	108	-	2
ST10108	STF2A20021H07430.2	ST10130	STF2W20021H07430.2	20,0	20	21	74	19,0	126	-	2



Schnittwerte / vitesses de coupe

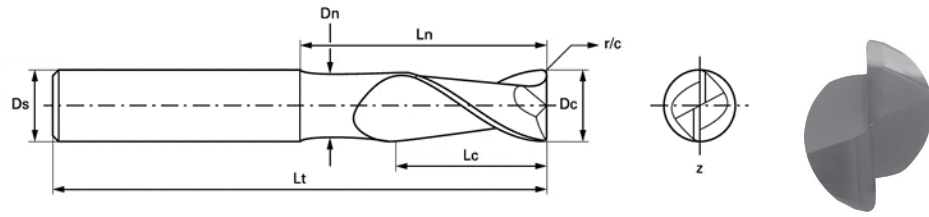
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	0,3*Dc	Lc	1*Dc	0,0050*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



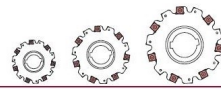
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10133	STF2A04005H01630R030.2	ST10156	STF2W04005H01630R030.2	4,0	6	5	16	3,6	57	0,3	2
ST10134	STF2A04005H01630R050.2	ST10157	STF2W04005H01630R050.2	4,0	6	5	16	3,6	57	0,5	2
ST10135	STF2A06007H02430R030.2	ST10158	STF2W06007H02430R030.2	6,0	6	7	24	5,4	62	0,3	2
ST10136	STF2A06007H02430R050.2	ST10159	STF2W06007H02430R050.2	6,0	6	7	24	5,4	62	0,5	2
ST10137	STF2A06007H02430R100.2	ST10160	STF2W06007H02430R100.2	6,0	6	7	24	5,4	62	1,0	2
ST10138	STF2A06007H02430R150.2	ST10161	STF2W06007H02430R150.2	6,0	6	7	24	5,4	62	1,5	2
ST10139	STF2A08009H03030R030.2	ST10162	STF2W08009H03030R030.2	8,0	8	9	30	7,2	68	0,3	2
ST10140	STF2A08009H03030R050.2	ST10163	STF2W08009H03030R050.2	8,0	8	9	30	7,2	68	0,5	2
ST10141	STF2A08009H03030R100.2	ST10164	STF2W08009H03030R100.2	8,0	8	9	30	7,2	68	1,0	2
ST10142	STF2A08009H03030R150.2	ST10165	STF2W08009H03030R150.2	8,0	8	9	30	7,2	68	1,5	2
ST10143	STF2A10011H03830R050.2	ST10166	STF2W10011H03830R050.2	10,0	10	11	38	9,0	80	0,5	2
ST10144	STF2A10011H03830R100.2	ST10167	STF2W10011H03830R100.2	10,0	10	11	38	9,0	80	1,0	2
ST10145	STF2A10011H03830R150.2	ST10168	STF2W10011H03830R150.2	10,0	10	11	38	9,0	80	1,5	2
ST10146	STF2A10011H03830R200.2	ST10169	STF2W10011H03830R200.2	10,0	10	11	38	9,0	80	2,0	2
ST10147	STF2A12013H04630R050.2	ST10170	STF2W12013H04630R050.2	12,0	12	13	46	11,0	93	0,5	2
ST10148	STF2A12013H04630R100.2	ST10171	STF2W12013H04630R100.2	12,0	12	13	46	11,0	93	1,0	2
ST10149	STF2A12013H04630R150.2	ST10172	STF2W12013H04630R150.2	12,0	12	13	46	11,0	93	1,5	2
ST10150	STF2A12013H04630R200.2	ST10173	STF2W12013H04630R200.2	12,0	12	13	46	11,0	93	2,0	2
ST10151	STF2A16017H05830R100.2	ST10174	STF2W16017H05830R100.2	16,0	16	17	58	15,0	108	1,0	2
ST10152	STF2A16017H05830R200.2	ST10175	STF2W16017H05830R200.2	16,0	16	17	58	15,0	108	2,0	2
ST10153	STF2A16017H05830R300.2	ST10176	STF2W16017H05830R300.2	16,0	16	17	58	15,0	108	3,0	2
ST10154	STF2A16017H05830R400.2	ST10177	STF2W16017H05830R400.2	16,0	16	17	58	15,0	108	4,0	2



Schnittwerte / vitesses de coupe

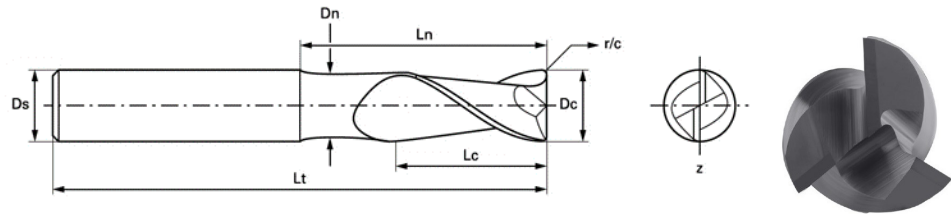
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	0,3*Dc	Lc	1*Dc	0,0050*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



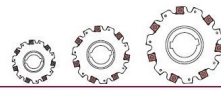
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10374	STF3A03005H00938.2	ST10389	STF3W03005H00938.2	3,0	6	5	9	2,8	50	-	3
ST10375	STF3A03506H01038.2	ST10390	STF3W03506H01038.2	3,5	6	6	10	3,3	50	-	3
ST10376	STF3A04008H01338.2	ST10391	STF3W04008H01338.2	4,0	6	8	13	3,8	54	-	3
ST10377	STF3A04508H01338.2	ST10392	STF3W04508H01338.2	4,5	6	8	13	4,3	54	-	3
ST10378	STF3A05009H01538.2	ST10393	STF3W05009H01538.2	5,0	6	9	15	4,8	54	-	3
ST10379	STF3A05509H01538.2	ST10394	STF3W05509H01538.2	5,5	6	9	15	5,3	54	-	3
ST10380	STF3A06010H01638.2	ST10395	STF3W06010H01638.2	6,0	6	10	16	5,7	54	-	3
ST10381	STF3A08012H02038.2	ST10396	STF3W08012H02038.2	8,0	8	12	20	7,6	58	-	3
ST10382	STF3A10014H02438.2	ST10397	STF3W10014H02438.2	10,0	10	14	24	9,5	66	-	3
ST10383	STF3A12016H02638.2	ST10398	STF3W12016H02638.2	12,0	12	16	26	11,5	73	-	3
ST10384	STF3A14016H02638.2	ST10399	STF3W14016H02638.2	14,0	14	16	26	13,5	73	-	3
ST10385	STF3A16022H03238.2	ST10400	STF3W16022H03238.2	16,0	16	22	32	15,5	82	-	3
ST10386	STF3A18022H03238.2	ST10401	STF3W18022H03238.2	18,0	18	22	32	17,5	82	-	3
ST10387	STF3A20026H04038.2	ST10402	STF3W20026H04038.2	20,0	20	26	40	19,5	92	-	3



Schnittwerte / vitesses de coupe

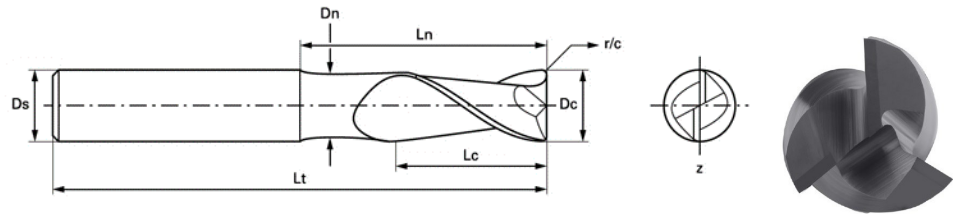
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	0,3*Dc	Lc	1*Dc	0,0050*Dc
	-	1*Dc	1*Dc	0,0025*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



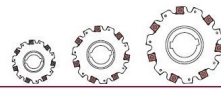
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10405	STF3A03008H01438.2	ST10420	STF3W03008H01438.2	3,0	6	8	14	2,8	57	-	3
ST10406	STF3A03508H01438.2	ST10421	STF3W03508H01438.2	3,5	6	8	14	3,3	57	-	3
ST10407	STF3A04011H01638.2	ST10422	STF3W04011H01638.2	4,0	6	11	16	3,8	57	-	3
ST10408	STF3A04511H01638.2	ST10423	STF3W04511H01638.2	4,5	6	11	16	4,3	57	-	3
ST10409	STF3A05013H01838.2	ST10424	STF3W05013H01838.2	5,0	6	13	18	4,8	57	-	3
ST10410	STF3A05513H01838.2	ST10425	STF3W05513H01838.2	5,5	6	13	18	5,3	57	-	3
ST10411	STF3A06013H01938.2	ST10426	STF3W06013H01938.2	6,0	6	13	19	5,7	57	-	3
ST10412	STF3A08019H02538.2	ST10427	STF3W08019H02538.2	8,0	8	19	25	7,6	63	-	3
ST10413	STF3A10022H03038.2	ST10428	STF3W10022H03038.2	10,0	10	22	30	9,5	72	-	3
ST10414	STF3A12026H03638.2	ST10429	STF3W12026H03638.2	12,0	12	26	36	11,5	83	-	3
ST10415	STF3A14026H03638.2	ST10430	STF3W14026H03638.2	14,0	14	26	36	13,5	83	-	3
ST10416	STF3A16032H04238.2	ST10431	STF3W16032H04238.2	16,0	16	32	42	15,5	92	-	3
ST10417	STF3A18032H04238.2	ST10432	STF3W18032H04238.2	18,0	18	32	42	17,5	92	-	3
ST10418	STF3A20038H05238.2	ST10433	STF3W20038H05238.2	20,0	20	38	52	19,5	104	-	3



Schnittwerte / vitesses de coupe

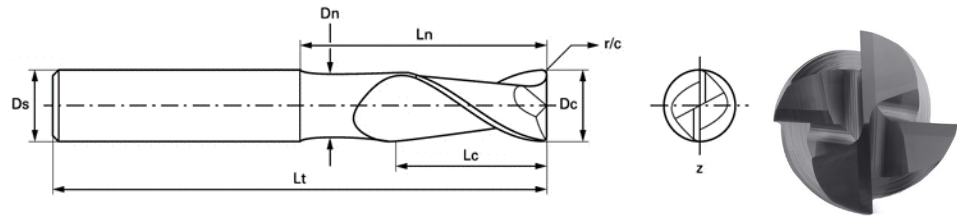
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	0,3*Dc	Lc	1*Dc	0,0050*Dc
	-	1*Dc	1*Dc	0,0025*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST10692	STF4A03008H01445.2	ST10708	STF4W03008H01445.2	3,0	6	8	14	2,8	57	-	4
ST10693	STF4A03511H01645.2	ST10709	STF4W03511H01645.2	3,5	6	11	16	3,3	57	-	4
ST10694	STF4A04011H01645.2	ST10710	STF4W04011H01645.2	4,0	6	11	16	3,8	57	-	4
ST10695	STF4A04513H01845.2	ST10711	STF4W04513H01845.2	4,5	6	13	18	4,3	57	-	4
ST10696	STF4A05013H01845.2	ST10712	STF4W05013H01845.2	5,0	6	13	18	4,8	57	-	4
ST10697	STF4A05513H01845.2	ST10713	STF4W05513H01845.2	5,5	6	13	18	5,3	57	-	4
ST10698	STF4A06013H01945.2	ST10714	STF4W06013H01945.2	6,0	6	13	19	5,7	57	-	4
ST10699	STF4A08019H02545.2	ST10715	STF4W08019H02545.2	8,0	8	19	25	7,6	63	-	4
ST10700	STF4A10022H03045.2	ST10716	STF4W10022H03045.2	10,0	10	22	30	9,5	72	-	4
ST10701	STF4A12026H03645.2	ST10717	STF4W12026H03645.2	12,0	12	26	36	11,5	83	-	4
ST10702	STF4A14026H03645.2	ST10718	STF4W14026H03645.2	14,0	14	26	36	13,5	83	-	4
ST10703	STF4A16032H04245.2	ST10719	STF4W16032H04245.2	16,0	16	32	42	15,5	92	-	4
ST10704	STF4A18032H04245.2	ST10720	STF4W18032H04245.2	18,0	18	32	42	17,5	92	-	4
ST10705	STF4A20038H05245.2	ST10721	STF4W20038H05245.2	20,0	20	38	52	19,5	104	-	4
ST10706	STF4A25045H06245.2	ST10722	STF4W25045H06245.2	25,0	25	45	62	24,0	120	-	4



Schnittwerte / vitesses de coupe

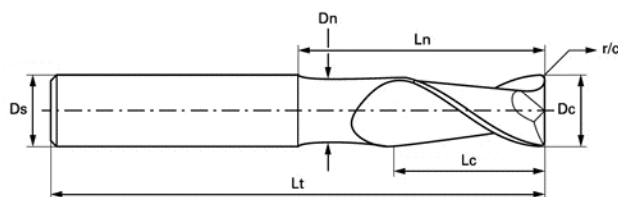
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	0,3*Dc	Lc	1*Dc	0,0050*Dc
	1°	5°	0,5*Dc	0,0040*Dc
	0,3*Dc	Lc	0,25*Dc	0,0075*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



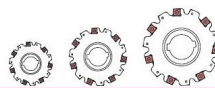
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10725	STF4A04005H01645R030.2	ST10748	STF4W04005H01645R030.2	4,0	6	5	16	3,6	57	0,3	4
ST10726	STF4A04005H01645R050.2	ST10749	STF4W04005H01645R050.2	4,0	6	5	16	3,6	57	0,5	4
ST10727	STF4A06007H02445R030.2	ST10750	STF4W06007H02445R030.2	6,0	6	7	24	5,4	62	0,3	4
ST10728	STF4A06007H02445R050.2	ST10751	STF4W06007H02445R050.2	6,0	6	7	24	5,4	62	0,5	4
ST10729	STF4A06007H02445R100.2	ST10752	STF4W06007H02445R100.2	6,0	6	7	24	5,4	62	1,0	4
ST10730	STF4A06007H02445R150.2	ST10753	STF4W06007H02445R150.2	6,0	6	7	24	5,4	62	1,5	4
ST10731	STF4A08009H03045R030.2	ST10754	STF4W08009H03045R030.2	8,0	8	9	30	7,2	68	0,3	4
ST10732	STF4A08009H03045R050.2	ST10755	STF4W08009H03045R050.2	8,0	8	9	30	7,2	68	0,5	4
ST10733	STF4A08009H03045R100.2	ST10756	STF4W08009H03045R100.2	8,0	8	9	30	7,2	68	1,0	4
ST10734	STF4A08009H03045R150.2	ST10757	STF4W08009H03045R150.2	8,0	8	9	30	7,2	68	1,5	4
ST10735	STF4A10011H03845R050.2	ST10758	STF4W10011H03845R050.2	10,0	10	11	38	9,0	80	0,5	4
ST10736	STF4A10011H03845R100.2	ST10759	STF4W10011H03845R100.2	10,0	10	11	38	9,0	80	1,0	4
ST10737	STF4A10011H03845R150.2	ST10760	STF4W10011H03845R150.2	10,0	10	11	38	9,0	80	1,5	4
ST10738	STF4A10011H03845R200.2	ST10761	STF4W10011H03845R200.2	10,0	10	11	38	9,0	80	2,0	4



Schnittwerte / vitesses de coupe

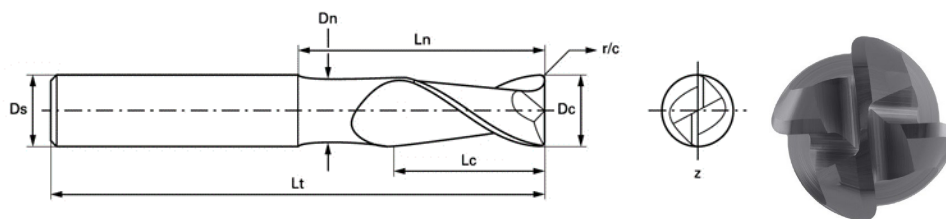
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	0,3*Dc	Lc	1*Dc	0,0050*Dc
	1°	5°	0,5*Dc	0,0040*Dc
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc
	0,3*Dc	Lc	0,25*Dc	0,0075*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



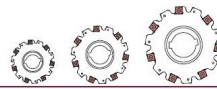
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10739	STF4A12013H04645R050.2	ST10762	STF4W12013H04645R050.2	12,0	12	13	46	11,0	93	0,5	4
ST10740	STF4A12013H04645R100.2	ST10763	STF4W12013H04645R100.2	12,0	12	13	46	11,0	93	1,0	4
ST10741	STF4A12013H04645R150.2	ST10764	STF4W12013H04645R150.2	12,0	12	13	46	11,0	93	1,5	4
ST10742	STF4A12013H04645R200.2	ST10765	STF4W12013H04645R200.2	12,0	12	13	46	11,0	93	2,0	4
ST10743	STF4A16017H05845R100.2	ST10766	STF4W16017H05845R100.2	16,0	16	17	58	15,0	108	1,0	4
ST10744	STF4A16017H05845R200.2	ST10767	STF4W16017H05845R200.2	16,0	16	17	58	15,0	108	2,0	4
ST10745	STF4A16017H05845R300.2	ST10768	STF4W16017H05845R300.2	16,0	16	17	58	15,0	108	3,0	4
ST10746	STF4A16017H05845R400.2	ST10769	STF4W16017H05845R400.2	16,0	16	17	58	15,0	108	4,0	4



Schnittwerte / vitesses de coupe

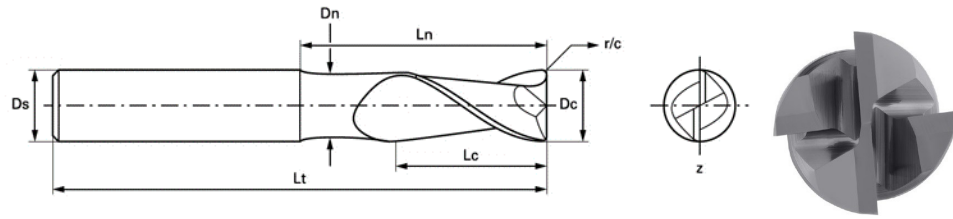
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	0,3*Dc	Lc	1*Dc	0,0050*Dc
	1°	5°	0,5*Dc	0,0040*Dc
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc
	0,3*Dc	Lc	0,25*Dc	0,0075*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



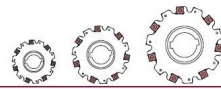
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ST10772	STF4A04011H01655C006.2	ST10783	STF4W04011H01655C006.2	4,0	6	11	16	3,7	57	0,06	4
ST10773	STF4A05013H01855C008.2	ST10784	STF4W05013H01855C008.2	5,0	6	13	18	4,7	57	0,08	4
ST10774	STF4A06013H01955C010.2	ST10785	STF4W06013H01955C010.2	6,0	6	13	19	5,7	57	0,10	4
ST10775	STF4A08019H02555C013.2	ST10786	STF4W08019H02555C013.2	8,0	8	19	25	7,6	63	0,13	4
ST10776	STF4A10022H03055C016.2	ST10787	STF4W10022H03055C016.2	10,0	10	22	30	9,5	72	0,16	4
ST10777	STF4A12026H03655C020.2	ST10788	STF4W12026H03655C020.2	12,0	12	26	36	11,5	83	0,20	4
ST10778	STF4A14026H03655C025.2	ST10789	STF4W14026H03655C025.2	14,0	14	26	36	13,5	83	0,25	4
ST10779	STF4A16032H04255C030.2	ST10790	STF4W16032H04255C030.2	16,0	16	32	42	15,5	92	0,30	4
ST10780	STF4A18032H04255C035.2	ST10791	STF4W18032H04255C035.2	18,0	18	32	42	17,5	92	0,35	4
ST10781	STF4A20038H05255C040.2	ST10792	STF4W20038H05255C040.2	20,0	20	38	52	19,5	104	0,40	4



Schnittwerte / vitesses de coupe

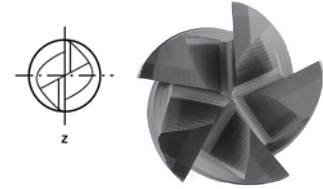
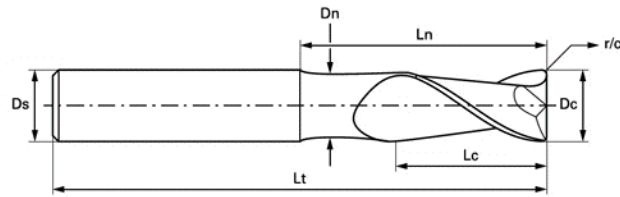
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	0,3*Dc	Lc	0,5*Dc	0,0070*Dc
	0,3*Dc	Lc	1*Dc	0,0050*Dc
	1°	5°	0,5*Dc	0,0040*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser Trochoidal P / K / H

Fraise - MD Trochoidal P / K / H



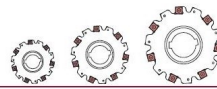
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10820	STF5A03006H01438C006.2	ST10833	STF5W03006H01438C006.2	3,0	6	6	14	2,8	57	0,06	5
ST10821	STF5A04008H01638C008.2	ST10834	STF5W04008H01638C008.2	4,0	6	8	16	3,8	57	0,08	5
ST10822	STF5A05010H01838C010.2	ST10835	STF5W05010H01838C010.2	5,0	6	10	18	4,8	57	0,10	5
ST10823	STF5A06012H01938C012.2	ST10836	STF5W06012H01938C012.2	6,0	6	12	19	5,7	57	0,12	5
ST10824	STF5A08016H02538C016.2	ST10837	STF5W08016H02538C016.2	8,0	8	16	25	7,6	63	0,16	5
ST10825	STF5A10020H03038C020.2	ST10838	STF5W10020H03038C020.2	10,0	10	20	30	9,5	72	0,20	5
ST10826	STF5A12024H03638C024.2	ST10839	STF5W12024H03638C024.2	12,0	12	24	36	11,5	83	0,24	5
ST10827	STF5A14028H03638C028.2	ST10840	STF5W14028H03638C028.2	14,0	14	28	36	13,5	83	0,28	5
ST10828	STF5A16032H04238C032.2	ST10841	STF5W16032H04238C032.2	16,0	16	32	42	15,5	92	0,32	5
ST10829	STF5A18036H04238C036.2	ST10842	STF5W18036H04238C036.2	18,0	18	36	42	17,5	92	0,36	5
ST10830	STF5A20040H05238C040.2	ST10843	STF5W20040H05238C040.2	20,0	20	40	52	19,5	104	0,40	5
ST10831	STF5A25050H06238C050.2	ST10844	STF5W25050H06238C050.2	25,0	25	50	62	24,0	120	0,50	5



Schnittwerte / vitesses de coupe

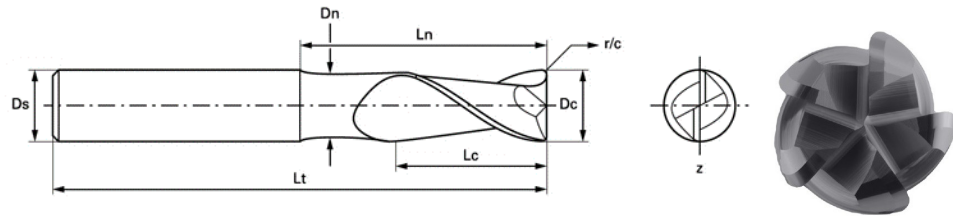
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,15-0,25*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser Trochoidal P / K / H

Fraise - MD Trochoidal P / K / H



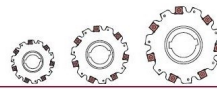
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10847	STF5A06012H01938R050.2	ST10864	STF5W06012H01938R050.2	6,0	6	12	19	5,7	57	0,5	5
ST10848	STF5A06012H01938R100.2	ST10865	STF5W06012H01938R100.2	6,0	6	12	19	5,7	57	1,0	5
ST10849	STF5A08016H02538R050.2	ST10866	STF5W08016H02538R050.2	8,0	8	16	25	7,6	63	0,5	5
ST10850	STF5A08016H02538R100.2	ST10867	STF5W08016H02538R100.2	8,0	8	16	25	7,6	63	1,0	5
ST10851	STF5A10020H03038R050.2	ST10868	STF5W10020H03038R050.2	10,0	10	20	30	9,5	72	0,5	5
ST10852	STF5A10020H03038R100.2	ST10869	STF5W10020H03038R100.2	10,0	10	20	30	9,5	72	1,0	5
ST10853	STF5A10020H03038R200.2	ST10870	STF5W10020H03038R200.2	10,0	10	20	30	9,5	72	2,0	5
ST10854	STF5A12024H03638R050.2	ST10871	STF5W12024H03638R050.2	12,0	12	24	36	11,5	83	0,5	5
ST10855	STF5A12024H03638R100.2	ST10872	STF5W12024H03638R100.2	12,0	12	24	36	11,5	83	1,0	5
ST10856	STF5A12024H03638R200.2	ST10873	STF5W12024H03638R200.2	12,0	12	24	36	11,5	83	2,0	5
ST10857	STF5A16032H04238R050.2	ST10874	STF5W16032H04238R050.2	16,0	16	32	42	15,5	92	0,5	5
ST10858	STF5A16032H04238R100.2	ST10875	STF5W16032H04238R100.2	16,0	16	32	42	15,5	92	1,0	5
ST10859	STF5A16032H04238R200.2	ST10876	STF5W16032H04238R200.2	16,0	16	32	42	15,5	92	2,0	5
ST10860	STF5A20040H05238R100.2	ST10877	STF5W20040H05238R100.2	20,0	20	40	52	19,5	104	1,0	5
ST10861	STF5A20040H05238R200.2	ST10878	STF5W20040H05238R200.2	20,0	20	40	52	19,5	104	2,0	5
ST10862	STF5A20040H05238R300.2	ST10879	STF5W20040H05238R300.2	20,0	20	40	52	19,5	104	3,0	5



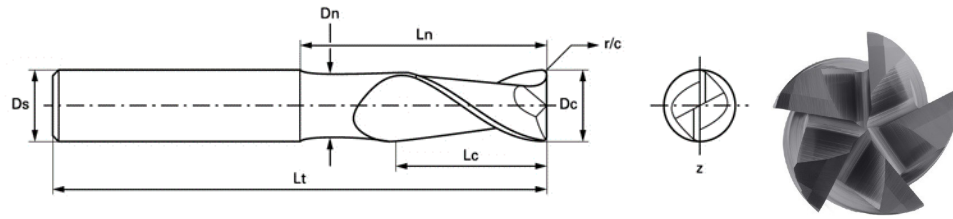
Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,15-0,25*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser Trochoidal P / K / H
Fraise - MD Trochoidal P / K / H



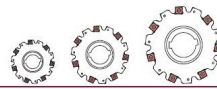
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10882	STF5A03009H01438C006.2	ST10895	STF5W03009H01438C006.2	3,0	6	9	14	2,8	62	0,06	5
ST10883	STF5A04012H01838C008.2	ST10896	STF5W04012H01838C008.2	4,0	6	12	18	3,8	62	0,08	5
ST10884	STF5A05015H02138C010.2	ST10897	STF5W05015H02138C010.2	5,0	6	15	21	4,8	62	0,10	5
ST10885	STF5A06018H02438C012.2	ST10898	STF5W06018H02438C012.2	6,0	6	18	24	5,7	62	0,12	5
ST10886	STF5A08024H03038C016.2	ST10899	STF5W08024H03038C016.2	8,0	8	24	30	7,6	68	0,16	5
ST10887	STF5A10030H03838C020.2	ST10900	STF5W10030H03838C020.2	10,0	10	30	38	9,5	80	0,20	5
ST10888	STF5A12036H04638C024.2	ST10901	STF5W12036H04638C024.2	12,0	12	36	46	11,5	93	0,24	5
ST10889	STF5A14042H05038C028.2	ST10902	STF5W14042H05038C028.2	14,0	14	42	50	13,5	100	0,28	5
ST10890	STF5A16048H05838C032.2	ST10903	STF5W16048H05838C032.2	16,0	16	48	58	15,5	108	0,32	5
ST10891	STF5A18054H06738C036.2	ST10904	STF5W18054H06738C036.2	18,0	18	54	67	17,5	115	0,36	5
ST10892	STF5A20060H07438C040.2	ST10905	STF5W20060H07438C040.2	20,0	20	60	74	19,5	126	0,40	5
ST10893	STF5A25075H09238C050.2	ST10906	STF5W25075H09238C050.2	25,0	25	75	92	24,0	150	0,50	5



Schnittwerte / vitesses de coupe

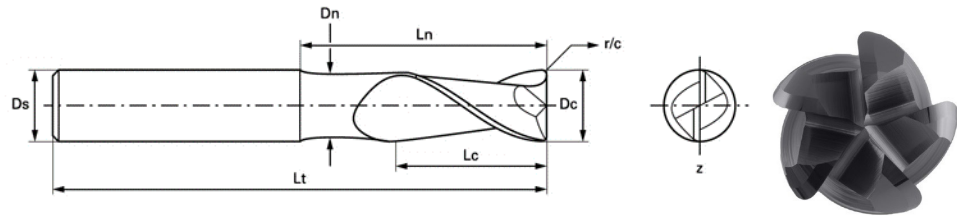
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,10-0,20*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser Trochoidal P / K / H

Fraise - MD Trochoidal P / K / H



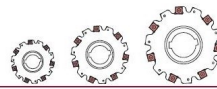
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10909	STF5A06018H02438R050.2	ST10926	STF5W06018H02438R050.2	6,0	6	18	24	5,7	62	0,5	5
ST10910	STF5A06018H02438R100.2	ST10927	STF5W06018H02438R100.2	6,0	6	18	24	5,7	62	1,0	5
ST10911	STF5A08024H03038R050.2	ST10928	STF5W08024H03038R050.2	8,0	8	24	30	7,6	68	0,5	5
ST10912	STF5A08024H03038R100.2	ST10929	STF5W08024H03038R100.2	8,0	8	24	30	7,6	68	1,0	5
ST10913	STF5A10030H03838R050.2	ST10930	STF5W10030H03838R050.2	10,0	10	30	38	9,5	80	0,5	5
ST10914	STF5A10030H03838R100.2	ST10931	STF5W10030H03838R100.2	10,0	10	30	38	9,5	80	1,0	5
ST10915	STF5A10030H03838R200.2	ST10932	STF5W10030H03838R200.2	10,0	10	30	38	9,5	80	2,0	5
ST10916	STF5A12036H04638R050.2	ST10933	STF5W12036H04638R050.2	12,0	12	36	46	11,5	93	0,5	5
ST10917	STF5A12036H04638R100.2	ST10934	STF5W12036H04638R100.2	12,0	12	36	46	11,5	93	1,0	5
ST10918	STF5A12036H04638R200.2	ST10935	STF5W12036H04638R200.2	12,0	12	36	46	11,5	93	2,0	5
ST10919	STF5A16048H05838R050.2	ST10936	STF5W16048H05838R050.2	16,0	16	48	58	15,5	108	0,5	5
ST10920	STF5A16048H05838R100.2	ST10937	STF5W16048H05838R100.2	16,0	16	48	58	15,5	108	1,0	5
ST10921	STF5A16048H05838R200.2	ST10938	STF5W16048H05838R200.2	16,0	16	48	58	15,5	108	2,0	5
ST10922	STF5A20060H07438R100.2	ST10939	STF5W20060H07438R100.2	20,0	20	60	74	19,5	126	1,0	5
ST10923	STF5A20060H07438R200.2	ST10940	STF5W20060H07438R200.2	20,0	20	60	74	19,5	126	2,0	5
ST10924	STF5A20060H07438R300.2	ST10941	STF5W20060H07438R300.2	20,0	20	60	74	19,5	126	3,0	5



Schnittwerte / vitesses de coupe

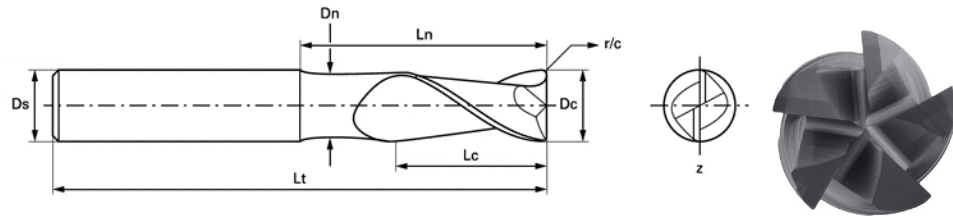
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,10-0,20*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser Trochoidal P / K / H

Fraise - MD Trochoidal P / K / H



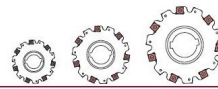
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST10944	STF5A03012H01838C006.2	ST10957	STF5W03012H01838C006.2	3,0	6	12	18	2,8	62	0,06	5
ST10945	STF5A04016H02138C008.2	ST10958	STF5W04016H02138C008.2	4,0	6	16	21	3,8	62	0,08	5
ST10946	STF5A05020H02538C010.2	ST10959	STF5W05020H02538C010.2	5,0	6	20	25	4,8	70	0,10	5
ST10947	STF5A06024H03038C012.2	ST10960	STF5W06024H03038C012.2	6,0	6	24	30	5,7	70	0,12	5
ST10948	STF5A08032H03838C016.2	ST10961	STF5W08032H03838C016.2	8,0	8	32	38	7,6	80	0,16	5
ST10949	STF5A10040H04838C020.2	ST10962	STF5W10040H04838C020.2	10,0	10	40	48	9,5	90	0,20	5
ST10950	STF5A12048H05838C024.2	ST10963	STF5W12048H05838C024.2	12,0	12	48	58	11,5	110	0,24	5
ST10951	STF5A14056H06438C028.2	ST10964	STF5W14056H06438C028.2	14,0	14	56	64	13,5	110	0,28	5
ST10952	STF5A16064H07438C032.2	ST10965	STF5W16064H07438C032.2	16,0	16	64	74	15,5	130	0,32	5
ST10953	STF5A18072H08538C036.2	ST10966	STF5W18072H08538C036.2	18,0	18	72	85	17,5	140	0,36	5
ST10954	STF5A20080H09438C040.2	ST10967	STF5W20080H09438C040.2	20,0	20	80	94	19,5	150	0,40	5
ST10955	STF5A250100H11738C050.2	ST10968	STF5W250100H11738C050.2	25,0	25	100	117	24,0	180	0,50	5



Schnittwerte / vitesses de coupe

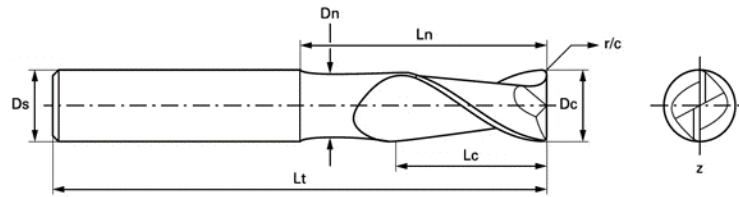
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,05-0,15*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser Trochoidal P / K / H

Fraise - MD Trochoidal P / K / H



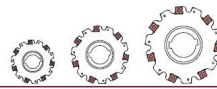
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12888	STF7A03009H01438C006.2	ST12918	STF7W03009H01438C006.2	3,0	6	9	14	2,8	62	0,06	7
ST12889	STF7A04012H01838C008.2	ST12919	STF7W04012H01838C008.2	4,0	6	12	18	3,8	62	0,08	7
ST12890	STF7A05015H02138C010.2	ST12920	STF7W05015H02138C010.2	5,0	6	15	21	4,8	62	0,10	7
ST12891	STF7A06018H02438C012.2	ST12921	STF7W06018H02438C012.2	6,0	6	18	24	5,7	62	0,12	7
ST12892	STF7A08024H03038C016.2	ST12922	STF7W08024H03038C016.2	8,0	8	24	30	7,6	68	0,16	7
ST12893	STF7A10030H03838C020.2	ST12923	STF7W10030H03838C020.2	10,0	10	30	38	9,5	80	0,20	7
ST12894	STF7A12036H04638C024.2	ST12924	STF7W12036H04638C024.2	12,0	12	36	46	11,5	93	0,24	7
ST12895	STF7A14042H05038C028.2	ST12925	STF7W14042H05038C028.2	14,0	14	42	50	13,5	100	0,28	7
ST12896	STF7A16048H05838C032.2	ST12926	STF7W16048H05838C032.2	16,0	16	48	58	15,5	108	0,32	7
ST12897	STF7A18054H06738C036.2	ST12927	STF7W18054H06738C036.2	18,0	18	54	67	17,5	115	0,36	7
ST12898	STF7A20060H07438C040.2	ST12928	STF7W20060H07438C040.2	20,0	20	60	74	19,5	126	0,40	7
ST12899	STF7A25075H09238C050.2	ST12929	STF7W25075H09238C050.2	25,0	25	75	92	24,0	150	0,50	7



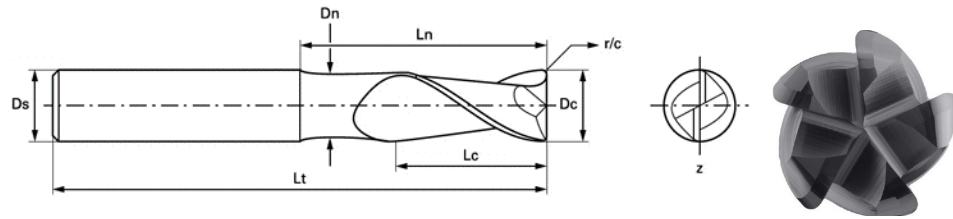
Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,05-0,15*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser Trochoidal P / K / H
Fraise - MD Trochoidal P / K / H



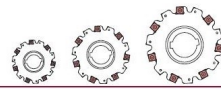
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST10971	STF5A06024H03038R050.2	ST10988	STF5W06024H03038R050.2	6,0	6	24	30	5,7	70	0,5	5
ST10972	STF5A06024H03038R100.2	ST10989	STF5W06024H03038R100.2	6,0	6	24	30	5,7	70	1,0	5
ST10973	STF5A08032H03838R050.2	ST10990	STF5W08032H03838R050.2	8,0	8	32	38	7,6	80	0,5	5
ST10974	STF5A08032H03838R100.2	ST10991	STF5W08032H03838R100.2	8,0	8	32	38	7,6	80	1,0	5
ST10975	STF5A10040H04838R050.2	ST10992	STF5W10040H04838R050.2	10,0	10	40	48	9,5	90	0,5	5
ST10976	STF5A10040H04838R100.2	ST10993	STF5W10040H04838R100.2	10,0	10	40	48	9,5	90	1,0	5
ST10977	STF5A10040H04838R200.2	ST10994	STF5W10040H04838R200.2	10,0	10	40	48	9,5	90	2,0	5
ST10978	STF5A12048H05838R050.2	ST10995	STF5W12048H05838R050.2	12,0	12	48	58	11,5	110	0,5	5
ST10979	STF5A12048H05838R100.2	ST10996	STF5W12048H05838R100.2	12,0	12	48	58	11,5	110	1,0	5
ST10980	STF5A12048H05838R200.2	ST10997	STF5W12048H05838R200.2	12,0	12	48	58	11,5	110	2,0	5
ST10981	STF5A16064H07438R050.2	ST10998	STF5W16064H07438R050.2	16,0	16	64	74	15,5	130	0,5	5
ST10982	STF5A16064H07438R100.2	ST10999	STF5W16064H07438R100.2	16,0	16	64	74	15,5	130	1,0	5
ST10983	STF5A16064H07438R200.2	ST11000	STF5W16064H07438R200.2	16,0	16	64	74	15,5	130	2,0	5
ST10984	STF5A20080H09438R100.2	ST11001	STF5W20080H09438R100.2	20,0	20	80	94	19,5	150	1,0	5
ST10985	STF5A20080H09438R200.2	ST11002	STF5W20080H09438R200.2	20,0	20	80	94	19,5	150	2,0	5
ST10986	STF5A20080H09438R300.2	ST11003	STF5W20080H09438R300.2	20,0	20	80	94	19,5	150	3,0	5



Schnittwerte / vitesses de coupe

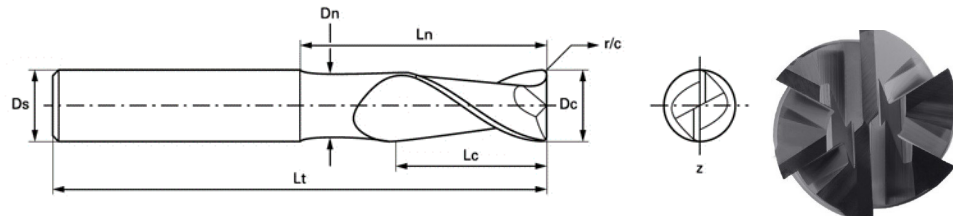
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,05-0,15*Dc	0,0046*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	300	250	210	100	90	-	250	-	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



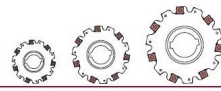
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST11059	STF6A06013H01945.2	ST11066	STF6W06013H01945.2	6,0	6	13	19	5,7	57	-	6
ST11060	STF6A08019H02545.2	ST11067	STF6W08019H02545.2	8,0	8	19	25	7,6	63	-	6
ST11061	STF6A10022H03045.2	ST11068	STF6W10022H03045.2	10,0	10	22	30	9,5	72	-	6
ST11062	STF6A12026H03645.2	ST11069	STF6W12026H03645.2	12,0	12	26	36	11,5	83	-	6
ST11063	STF6A16032H04245.2	ST11070	STF6W16032H04245.2	16,0	16	32	42	15,5	92	-	6
ST11064	STF8A20038H05245.2	ST11071	STF8W20038H05245.2	20,0	20	38	52	19,5	104	-	8



Schnittwerte / vitesses de coupe

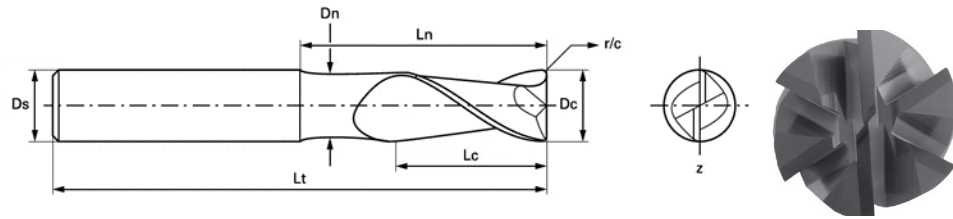
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,2*Dc	0,0060*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	-	175	120	180	150	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



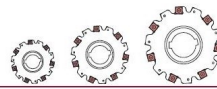
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST11074	STF6A0601350.2	ST11084	STF6W0601350.2	6,0	6	13	-	-	57	-	6
ST11075	STF6A0801950.2	ST11085	STF6W0801950.2	8,0	8	19	-	-	63	-	6
ST11076	STF6A1002250.2	ST11086	STF6W1002250.2	10,0	10	22	-	-	72	-	6
ST11077	STF6A1202650.2	ST11087	STF6W1202650.2	12,0	12	26	-	-	83	-	6
ST11078	STF6A1402650.2	ST11088	STF6W1402650.2	14,0	14	26	-	-	83	-	6
ST11079	STF6A1603250.2	ST11089	STF6W1603250.2	16,0	16	32	-	-	92	-	6
ST11080	STF8A1803250.2	ST11090	STF8W1803250.2	18,0	18	32	-	-	92	-	8
ST11081	STF8A2003850.2	ST11091	STF8W2003850.2	20,0	20	38	-	-	104	-	8
ST11082	STF8A2504550.2	ST11092	STF8W2504550.2	25,0	25	45	-	-	120	-	8



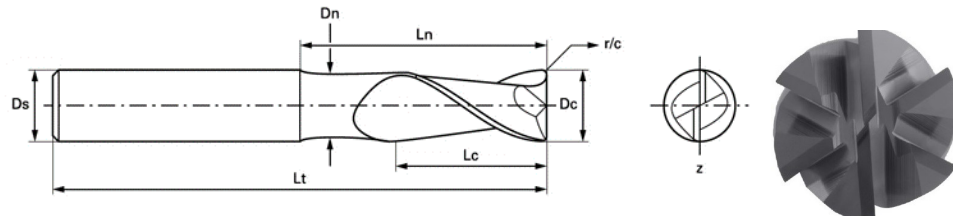
Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,2*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H
Fraise - MD P / K / H



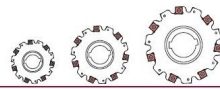
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST11095	STF6A0601850.2	ST11103	STF6W0601850.2	6,0	6	18	-	-	62	-	6
ST11096	STF6A0802450.2	ST11104	STF6W0802450.2	8,0	8	24	-	-	68	-	6
ST11097	STF6A1003050.2	ST11105	STF6W1003050.2	10,0	10	30	-	-	80	-	6
ST11098	STF6A1203650.2	ST11106	STF6W1203650.2	12,0	12	36	-	-	93	-	6
ST11099	STF6A1604850.2	ST11107	STF6W1604850.2	16,0	16	48	-	-	108	-	6
ST11100	STF8A2006050.2	ST11108	STF8W2006050.2	20,0	20	60	-	-	126	-	8
ST11101	STF8A2508550.2	ST11109	STF8W2508550.2	25,0	25	85	-	-	150	-	8



Schnittwerte / vitesses de coupe

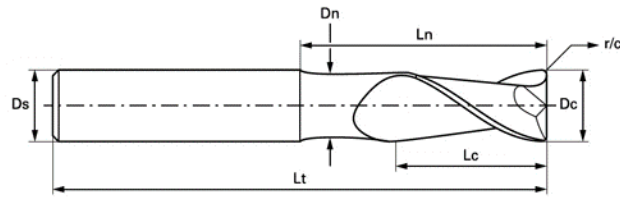
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,2*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



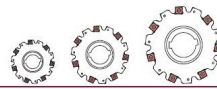
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11112	STF6A0601350R050.2	ST11133	STF6W0601350R050.2	6,0	6	13	-	-	62	0,5	6
ST11113	STF6A0601350R100.2	ST11134	STF6W0601350R100.2	6,0	6	13	-	-	62	1,0	6
ST11114	STF6A0801950R050.2	ST11135	STF6W0801950R050.2	8,0	8	19	-	-	68	0,5	6
ST11115	STF6A0801950R100.2	ST11136	STF6W0801950R100.2	8,0	8	19	-	-	68	1,0	6
ST11116	STF6A1002250R050.2	ST11137	STF6W1002250R050.2	10,0	10	22	-	-	80	0,5	6
ST11117	STF6A1002250R100.2	ST11138	STF6W1002250R100.2	10,0	10	22	-	-	80	1,0	6
ST11118	STF6A1002250R150.2	ST11139	STF6W1002250R150.2	10,0	10	22	-	-	80	1,5	6
ST11119	STF6A1002250R200.2	ST11140	STF6W1002250R200.2	10,0	10	22	-	-	80	2,0	6
ST11120	STF6A1202650R050.2	ST11141	STF6W1202650R050.2	12,0	12	26	-	-	93	0,5	6
ST11121	STF6A1202650R100.2	ST11142	STF6W1202650R100.2	12,0	12	26	-	-	93	1,0	6
ST11122	STF6A1202650R150.2	ST11143	STF6W1202650R150.2	12,0	12	26	-	-	93	1,5	6
ST11123	STF6A1202650R200.2	ST11144	STF6W1202650R200.2	12,0	12	26	-	-	93	2,0	6
ST11124	STF6A1603250R050.2	ST11145	STF6W1603250R050.2	16,0	16	32	-	-	108	0,5	6
ST11125	STF6A1603250R100.2	ST11146	STF6W1603250R100.2	16,0	16	32	-	-	108	1,0	6
ST11126	STF6A1603250R150.2	ST11147	STF6W1603250R150.2	16,0	16	32	-	-	108	1,5	6
ST11127	STF6A1603250R200.2	ST11148	STF6W1603250R200.2	16,0	16	32	-	-	108	2,0	6
ST11128	STF8A2003850R050.2	ST11149	STF8W2003850R050.2	20,0	20	38	-	-	126	0,5	8
ST11129	STF8A2003850R100.2	ST11150	STF8W2003850R100.2	20,0	20	38	-	-	126	1,0	8
ST11130	STF8A2003850R150.2	ST11151	STF8W2003850R150.2	20,0	20	38	-	-	126	1,5	8
ST11131	STF8A2003850R200.2	ST11152	STF8W2003850R200.2	20,0	20	38	-	-	126	2,0	8



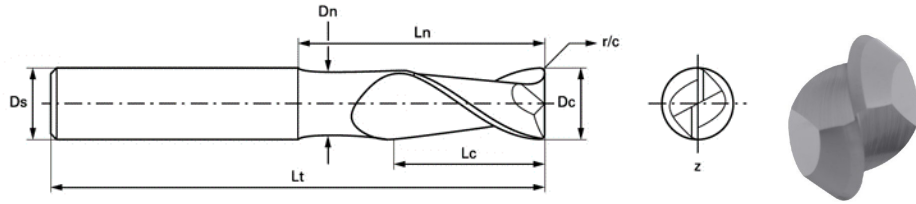
Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,2*Dc	0,0070*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H
Fraise - MD P / K / H



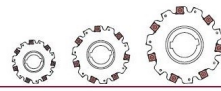
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11328	STF2A02003H00730R100.2	ST11341	STF2W02003H00730R100.2	2,0	6	3	7	1,9	62	1,0	2
ST11329	STF2A03004H00930R150.2	ST11342	STF2W03004H00930R150.2	3,0	6	4	9	2,8	62	1,5	2
ST11330	STF2A04005H01230R200.2	ST11343	STF2W04005H01230R200.2	4,0	6	5	12	4,8	62	2,0	2
ST11331	STF2A05006H01430R250.2	ST11344	STF2W05006H01430R250.2	5,0	6	6	14	4,8	80	2,5	2
ST11332	STF2A06007H01730R300.2	ST11345	STF2W06007H01730R300.2	6,0	6	7	17	5,7	80	3,0	2
ST11333	STF2A08009H02230R400.2	ST11346	STF2W08009H02230R400.2	8,0	8	9	22	7,6	90	4,0	2
ST11334	STF2A10011H02730R500.2	ST11347	STF2W10011H02730R500.2	10,0	10	11	27	9,5	100	5,0	2
ST11335	STF2A12013H03230R600.2	ST11348	STF2W12013H03230R600.2	12,0	12	13	32	11,5	120	6,0	2
ST11336	STF2A14015H03730R700.2	ST11349	STF2W14015H03730R700.2	14,0	14	15	37	13,5	120	7,0	2
ST11337	STF2A16017H04230R800.2	ST11350	STF2W16017H04230R800.2	16,0	16	17	42	15,5	140	8,0	2
ST11338	STF2A18019H04730R900.2	ST11351	STF2W18019H04730R900.2	18,0	18	19	47	17,5	140	9,0	2
ST11339	STF2A20021H05230R100.2	ST11352	STF2W20021H05230R100.2	20,0	20	21	52	19,5	160	10,0	2



Schnittwerte / vitesses de coupe

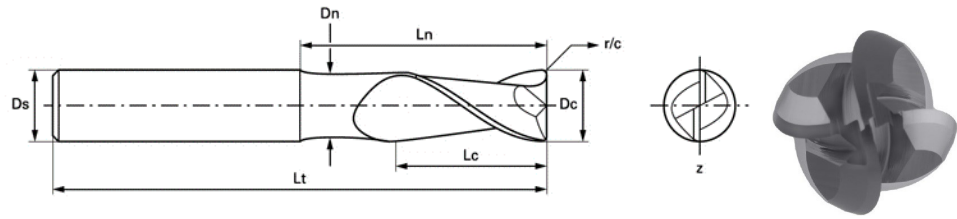
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,02*Dc	0,5+Dc	0,5*Dc	0,0200*Dc

	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser P / K / H

Fraise - MD P / K / H



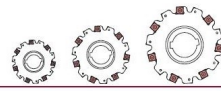
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11355	STF4A02003H00730R100.2	ST11368	STF4W02003H00730R100.2	2,0	6	3	7	1,9	62	1,0	4
ST11356	STF4A03004H00930R150.2	ST11369	STF4W03004H00930R150.2	3,0	6	4	9	2,8	62	1,5	4
ST11357	STF4A04005H01230R200.2	ST11370	STF4W04005H01230R200.2	4,0	6	5	12	3,8	62	2,0	4
ST11358	STF4A05006H01430R250.2	ST11371	STF4W05006H01430R250.2	5,0	6	6	14	4,8	80	2,5	4
ST11359	STF4A06007H01730R300.2	ST11372	STF4W06007H01730R300.2	6,0	6	7	17	5,7	80	3,0	4
ST11360	STF4A08009H02230R400.2	ST11373	STF4W08009H02230R400.2	8,0	8	9	22	7,6	90	4,0	4
ST11361	STF4A10011H02730R500.2	ST11374	STF4W10011H02730R500.2	10,0	10	11	27	9,5	100	5,0	4
ST11362	STF4A12013H03230R600.2	ST11375	STF4W12013H03230R600.2	12,0	12	13	32	11,5	120	6,0	4
ST11363	STF4A14015H03730R700.2	ST11376	STF4W14015H03730R700.2	14,0	14	15	37	13,5	120	7,0	4
ST11364	STF4A16017H04230R800.2	ST11377	STF4W16017H04230R800.2	16,0	16	17	42	15,5	140	8,0	4
ST11365	STF4A18019H04730R900.2	ST11378	STF4W18019H04730R900.2	18,0	18	19	47	17,5	140	9,0	4
ST11366	STF4A20021H05230R100.2	ST11379	STF4W20021H05230R100.2	20,0	20	21	52	19,5	160	10,0	4



Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,02*Dc	0,5+Dc	0,5*Dc	0,0200*Dc

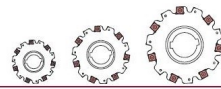
	P1	P2	P3	H1	H2	H3	K1	K2	M1	M2	S1	S2
Vc	210	175	120	120	100	-	150	110	-	-	-	-



VHM - Fräser **Inox & Superlegierung**
Fraise - MD **Inox & Superalliage**

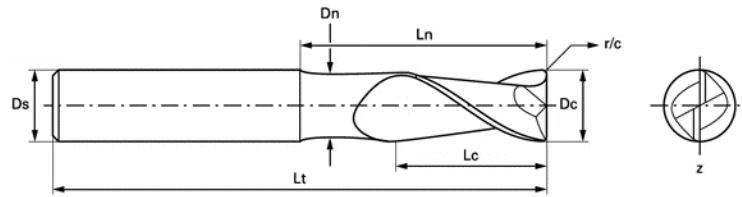
40 **Jahre** Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità





VHM - Fräser M + S

Fraise - MD M + S



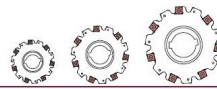
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11625	STF3A03008H01455C005.1	ST11637	STF3W03008H01455C005.1	3,0	6	8	14	2,8	57	0,05	3
ST11626	STF3A04011H01655C006.1	ST11638	STF3W04011H01655C006.1	4,0	6	11	16	3,8	57	0,06	3
ST11627	STF3A05013H01855C008.1	ST11639	STF3W05013H01855C008.1	5,0	6	13	18	4,8	57	0,08	3
ST11628	STF3A06013H01955C010.1	ST11640	STF3W06013H01955C010.1	6,0	6	13	19	5,7	57	0,10	3
ST11629	STF3A08019H02555C013.1	ST11641	STF3W08019H02555C013.1	8,0	8	19	25	7,6	63	0,13	3
ST11630	STF3A10022H03055C016.1	ST11642	STF3W10022H03055C016.1	10,0	10	22	30	9,5	72	0,16	3
ST11631	STF3A12026H03655C020.1	ST11643	STF3W12026H03655C020.1	12,0	12	26	36	11,5	83	0,20	3
ST11632	STF3A14026H03655C025.1	ST11644	STF3W14026H03655C025.1	14,0	14	26	36	13,5	83	0,25	3
ST11633	STF3A16032H04255C030.1	ST11645	STF3W16032H04255C030.1	16,0	16	32	42	15,5	92	0,30	3
ST11634	STF3A18032H04255C030.1	ST11646	STF3W18032H04255C030.1	18,0	18	32	42	17,5	92	0,30	3
ST11635	STF3A20038H05255C030.1	ST11647	STF3W20038H05255C030.1	20,0	20	38	52	19,5	104	0,30	3



Schnittwerte / vitesses de coupe

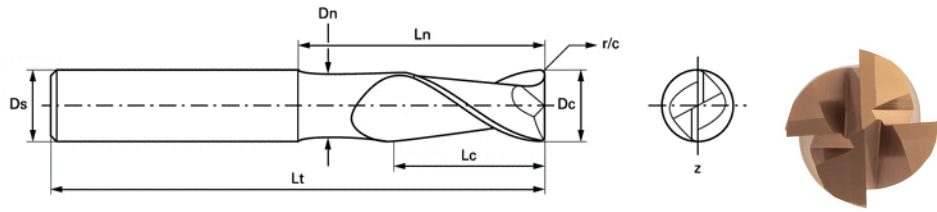
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0070*Dc
	0,3*Dc	Lc	1*Dc	0,0050*Dc

	M1	M2	S1	S2
Vc	120	100	40	90



VHM - Fräser M + S

Fraise - MD M + S



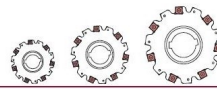
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11650	STF4A03008H01442C005.1	ST11664	STF4W03008H01442C005.1	3,0	6	8	14	2,8	57	0,05	4
ST11651	STF4A03510H01642C005.1	ST11665	STF4W03510H01642C005.1	3,5	6	10	16	3,3	57	0,05	4
ST11652	STF4A04011H01642C005.1	ST11666	STF4W04011H01642C005.1	4,0	6	11	16	3,8	57	0,05	4
ST11653	STF4A04511H01842C007.1	ST11667	STF4W04511H01842C007.1	4,5	6	11	18	4,3	57	0,07	4
ST11654	STF4A05013H01842C010.1	ST11668	STF4W05013H01842C010.1	5,0	6	13	18	4,8	57	0,10	4
ST11655	STF4A06013H01942C010.1	ST11669	STF4W06013H01942C010.1	6,0	6	13	19	5,7	57	0,10	4
ST11656	STF4A08019H02542C020.1	ST11670	STF4W08019H02542C020.1	8,0	8	19	25	7,6	63	0,20	4
ST11657	STF4A10022H03042C025.1	ST11671	STF4W10022H03042C025.1	10,0	10	22	30	9,5	72	0,25	4
ST11658	STF4A12026H03642C030.1	ST11672	STF4W12026H03642C030.1	12,0	12	26	36	11,5	83	0,30	4
ST11659	STF4A14026H03642C035.1	ST11673	STF4W14026H03642C035.1	14,0	14	26	36	13,5	83	0,35	4
ST11660	STF4A16032H04242C040.1	ST11674	STF4W16032H04242C040.1	16,0	16	32	42	15,5	92	0,40	4
ST11661	STF4A18032H04242C045.1	ST11675	STF4W18032H04242C045.1	18,0	18	32	42	17,5	92	0,45	4
ST11662	STF4A20038H05242C050.1	ST11676	STF4W20038H05242C050.1	20,0	20	38	52	19,5	104	0,50	4



Schnittwerte / vitesses de coupe

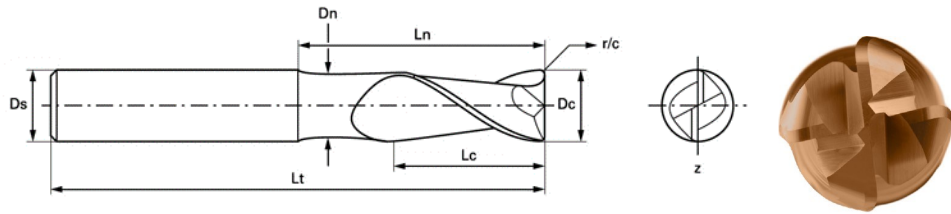
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	5°	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	0,15*Dc	0,0070*Dc

	M1	M2	S1	S2
Vc	120	100	40	90



VHM - Fräser M + S

Fraise - MD M + S



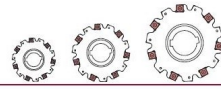
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11679	STF4A06013H01942R050.1	ST11693	STF4W06013H01942R050.1	6,0	6	13	19	5,7	57	0,5	4
ST11680	STF4A06013H01942R100.1	ST11694	STF4W06013H01942R100.1	6,0	6	13	19	5,7	57	1,0	4
ST11681	STF4A08019H02542R050.1	ST11695	STF4W08019H02542R050.1	8,0	8	19	25	7,6	63	0,5	4
ST11682	STF4A08019H02542R100.1	ST11696	STF4W08019H02542R100.1	8,0	8	19	25	7,6	63	1,0	4
ST11683	STF4A10022H03042R050.1	ST11697	STF4W10022H03042R050.1	10,0	10	22	30	9,5	72	0,5	4
ST11684	STF4A10022H03042R100.1	ST11698	STF4W10022H03042R100.1	10,0	10	22	30	9,5	72	1,0	4
ST11685	STF4A10022H03042R200.1	ST11699	STF4W10022H03042R200.1	10,0	10	22	30	9,5	72	2,0	4
ST11686	STF4A12026H03642R050.1	ST11700	STF4W12026H03642R050.1	12,0	12	26	36	11,5	83	0,5	4
ST11687	STF4A12026H03642R100.1	ST11701	STF4W12026H03642R100.1	12,0	12	26	36	11,5	83	1,0	4
ST11688	STF4A12026H03642R200.1	ST11702	STF4W12026H03642R200.1	12,0	12	26	36	11,5	83	2,0	4
ST11689	STF4A16032H04242R050.1	ST11703	STF4W16032H04242R050.1	16,0	16	32	42	15,5	92	0,5	4
ST11690	STF4A16032H04242R100.1	ST11704	STF4W16032H04242R100.1	16,0	16	32	42	15,5	92	1,0	4
ST11691	STF4A16032H04242R200.1	ST11705	STF4W16032H04242R200.1	16,0	16	32	42	15,5	92	2,0	4



Schnittwerte / vitesses de coupe

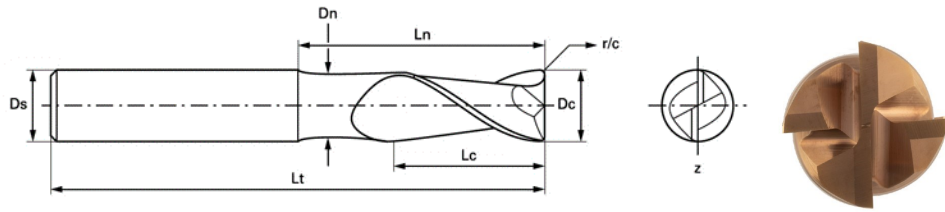
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	0,3*Dc	Lc	1*Dc	0,0045*Dc
	1°	5°	0,5*Dc	0,0035*Dc
	0,3*Dc	Lc	0,15*Dc	0,0070*Dc

	M1	M2	S1	S2
Vc	120	100	40	90



VHM - Fräser M + S

Fraise - MD M + S



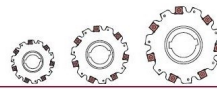
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11708	STF4A06013H01955C010.1	ST11717	STF4W06013H01955C010.1	6,0	6	13	19	5,7	57	0,10	4
ST11709	STF4A08019H02555C013.1	ST11718	STF4W08019H02555C013.1	8,0	8	19	25	7,6	63	0,13	4
ST11710	STF4A10022H03055C016.1	ST11719	STF4W10022H03055C016.1	10,0	10	22	30	9,5	72	0,16	4
ST11711	STF4A12026H03655C020.1	ST11720	STF4W12026H03655C020.1	12,0	12	26	36	11,5	83	0,20	4
ST11712	STF4A14026H03655C025.1	ST11721	STF4W14026H03655C025.1	14,0	14	26	36	13,5	83	0,25	4
ST11713	STF4A16032H04255C030.1	ST11722	STF4W16032H04255C030.1	16,0	16	32	42	15,5	92	0,30	4
ST11714	STF4A18032H04255C030.1	ST11723	STF4W18032H04255C030.1	18,0	18	32	42	17,5	92	0,30	4
ST11715	STF4A20038H05255C030.1	ST11724	STF4W20038H05255C030.1	20,0	20	38	52	19,5	104	0,30	4



Schnittwerte / vitesses de coupe

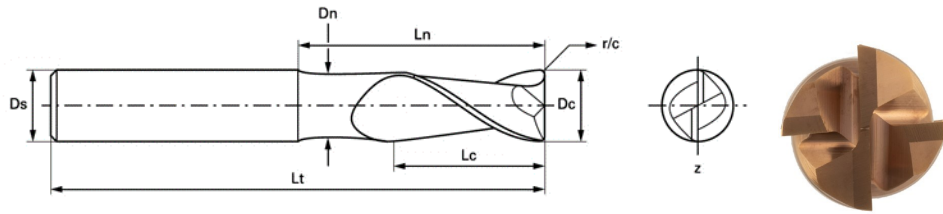
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0050*Dc

	M1	M2	S1	S2
Vc	120	100	40	90



VHM - Fräser M + S

Fraise - MD M + S



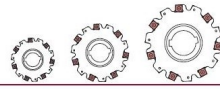
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11727	STF4A06007H02455C010.1	ST11736	STF4W06007H02455C010.1	6,0	6	7	24	5,4	62	0,10	4
ST11728	STF4A08009H03055C013.1	ST11737	STF4W08009H03055C013.1	8,0	8	9	30	7,2	68	0,13	4
ST11729	STF4A10011H03855C016.1	ST11738	STF4W10011H03855C016.1	10,0	10	11	38	9,0	80	0,16	4
ST11730	STF4A12013H04655C020.1	ST11739	STF4W12013H04655C020.1	12,0	12	13	46	11,0	93	0,20	4
ST11731	STF4A14015H04655C025.1	ST11740	STF4W14015H04655C025.1	14,0	14	15	46	13,0	93	0,25	4
ST11732	STF4A16017H05855C030.1	ST11741	STF4W16017H05855C030.1	16,0	16	17	58	15,0	108	0,30	4
ST11733	STF4A18019H05955C030.1	ST11742	STF4W18019H05955C030.1	18,0	18	19	59	17,0	108	0,30	4
ST11734	STF4A20021H07455C030.1	ST11743	STF4W20021H07455C030.1	20,0	20	21	74	19,0	126	0,30	4



Schnittwerte / vitesses de coupe

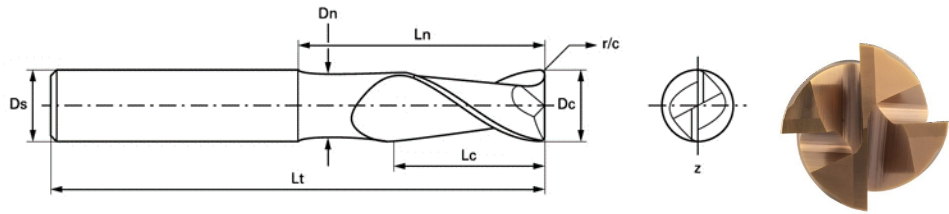
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0070*Dc
	0,3*Dc	Lc	1*Dc	0,0050*Dc

	M1	M2	S1	S2
Vc	120	100	40	90



VHM - Fräser M + S

Fraise - MD M + S



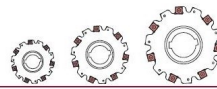
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11746	STF4A03008H01441R010.1	ST11756	STF4W03008H01441R010.1	3,0	6	8	14	2,8	57	0,10	4
ST11747	STF4A04011H01641R010.1	ST11757	STF4W04011H01641R010.1	4,0	6	11	16	3,8	57	0,10	4
ST11748	STF4A05013H01841R015.1	ST11758	STF4W05013H01841R015.1	5,0	6	13	18	4,8	57	0,15	4
ST11749	STF4A06013H01941R015.1	ST11759	STF4W06013H01941R015.1	6,0	6	13	19	5,7	57	0,15	4
ST11750	STF4A08019H02541R015.1	ST11760	STF4W08019H02541R015.1	8,0	8	19	25	7,6	63	0,15	4
ST11751	STF4A10022H03041R020.1	ST11761	STF4W10022H03041R020.1	10,0	10	22	30	9,5	72	0,20	4
ST11752	STF4A12026H03641R020.1	ST11762	STF4W12026H03641R020.1	12,0	12	26	36	11,5	83	0,20	4
ST11753	STF4A16032H04241R030.1	ST11763	STF4W16032H04241R030.1	16,0	16	32	42	15,5	92	0,30	4
ST11754	STF4A20038H05241R030.1	ST11764	STF4W20038H05241R030.1	20,0	20	38	52	19,5	104	0,30	4



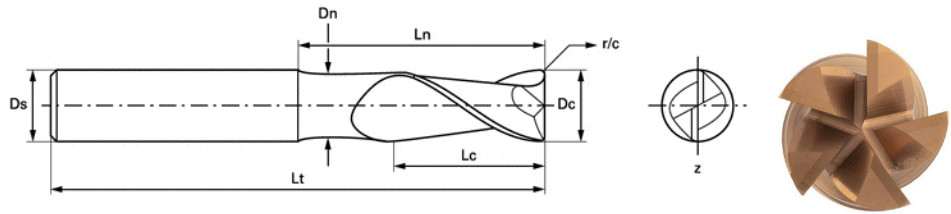
Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0025*Dc

	M1	M2	S1	S2
Vc	-	-	50	-



VHM - Fräser Trochoidal M + S
Fraise - MD Trochoidal M + S



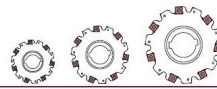
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11767	STF5A03006H01442C006.1	ST11780	STF5W03006H01442C006.1	3,0	6	6	14	2,8	57	0,06	5
ST11768	STF5A04008H01642C008.1	ST11781	STF5W04008H01642C008.1	4,0	6	8	16	3,8	57	0,08	5
ST11769	STF5A05010H01842C010.1	ST11782	STF5W05010H01842C010.1	5,0	6	10	18	4,8	57	0,10	5
ST11770	STF5A06012H01942C012.1	ST11783	STF5W06012H01942C012.1	6,0	6	12	19	5,7	57	0,12	5
ST11771	STF5A08016H02542C016.1	ST11784	STF5W08016H02542C016.1	8,0	8	16	25	7,6	63	0,16	5
ST11772	STF5A10020H03042C020.1	ST11785	STF5W10020H03042C020.1	10,0	10	20	30	9,5	72	0,20	5
ST11773	STF5A12024H03642C024.1	ST11786	STF5W12024H03642C024.1	12,0	12	24	36	11,5	83	0,24	5
ST11774	STF5A14028H03642C028.1	ST11787	STF5W14028H03642C028.1	14,0	14	28	36	13,5	83	0,28	5
ST11775	STF5A16032H04242C032.1	ST11788	STF5W16032H04242C032.1	16,0	16	32	42	15,5	92	0,32	5
ST11776	STF5A18036H04242C036.1	ST11789	STF5W18036H04242C036.1	18,0	18	36	42	17,5	92	0,36	5
ST11777	STF5A20040H05242C040.1	ST11790	STF5W20040H05242C040.1	20,0	20	40	52	19,5	104	0,40	5
ST11778	STF5A25050H06242C050.1	ST11791	STF5W25050H06242C050.1	25,0	25	50	62	24,0	120	0,50	5



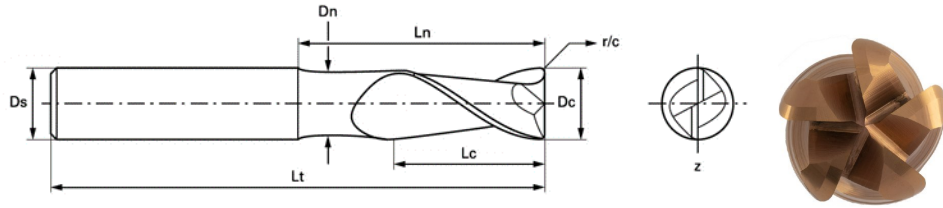
Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,09*Dc - 0,15*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser Trochoidal M + S
Fraise - MD Trochoidal M + S



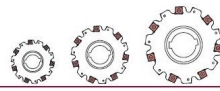
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11794	STF5A06012H01942R010.1	ST11817	STF5W06012H01942R010.1	6,0	6	12	19	5,7	57	0,1	5
ST11795	STF5A06012H01942R050.1	ST11818	STF5W06012H01942R050.1	6,0	6	12	19	5,7	57	0,5	5
ST11796	STF5A06012H01942R100.1	ST11819	STF5W06012H01942R100.1	6,0	6	12	19	5,7	57	1,0	5
ST11797	STF5A08016H02542R020.1	ST11820	STF5W08016H02542R020.1	8,0	8	16	25	7,6	63	0,2	5
ST11798	STF5A08016H02542R050.1	ST11821	STF5W08016H02542R050.1	8,0	8	16	25	7,6	63	0,5	5
ST11799	STF5A08016H02542R100.1	ST11822	STF5W08016H02542R100.1	8,0	8	16	25	7,6	63	1,0	5
ST11800	STF5A10020H03042R020.1	ST11823	STF5W10020H03042R020.1	10,0	10	20	30	9,5	72	0,2	5
ST11801	STF5A10020H03042R050.1	ST11824	STF5W10020H03042R050.1	10,0	10	20	30	9,5	72	0,5	5
ST11802	STF5A10020H03042R100.1	ST11825	STF5W10020H03042R100.1	10,0	10	20	30	9,5	72	1,0	5
ST11803	STF5A10020H03042R200.1	ST11826	STF5W10020H03042R200.1	10,0	10	20	30	9,5	72	2,0	5
ST11804	STF5A12024H03642R030.1	ST11827	STF5W12024H03642R030.1	12,0	12	24	36	11,5	83	0,3	5
ST11805	STF5A12024H03642R050.1	ST11828	STF5W12024H03642R050.1	12,0	12	24	36	11,5	83	0,5	5
ST11806	STF5A12024H03642R100.1	ST11829	STF5W12024H03642R100.1	12,0	12	24	36	11,5	83	1,0	5
ST11807	STF5A12024H03642R200.1	ST11830	STF5W12024H03642R200.1	12,0	12	24	36	11,5	83	2,0	5
ST11808	STF5A16032H04242R030.1	ST11831	STF5W16032H04242R030.1	16,0	16	32	42	15,5	92	0,3	5
ST11809	STF5A16032H04242R050.1	ST11832	STF5W16032H04242R050.1	16,0	16	32	42	15,5	92	0,5	5
ST11810	STF5A16032H04242R100.1	ST11833	STF5W16032H04242R100.1	16,0	16	32	42	15,5	92	1,0	5
ST11811	STF5A16032H04242R200.1	ST11834	STF5W16032H04242R200.1	16,0	16	32	42	15,5	92	2,0	5
ST11812	STF5A20040H05242R030.1	ST11835	STF5W20040H05242R030.1	20,0	20	40	52	19,5	104	0,3	5
ST11813	STF5A20040H05242R100.1	ST11836	STF5W20040H05242R100.1	20,0	20	40	52	19,5	104	1,0	5
ST11814	STF5A20040H05242R200.1	ST11837	STF5W20040H05242R200.1	20,0	20	40	52	19,5	104	2,0	5
ST11815	STF5A20040H05242R300.1	ST11838	STF5W20040H05242R300.1	20,0	20	40	52	19,5	104	3,0	5



Schnittwerte / vitesses de coupe

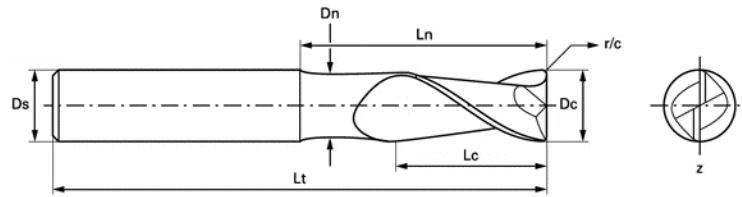
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,09*Dc - 0,15*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser Trochoidal M + S

Fraise - MD Trochoidal M + S



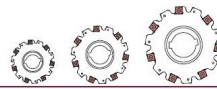
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11841	STF5A03009H01442C006.1	ST11854	STF5W03009H01442C006.1	3,0	6	9	14	2,8	62	0,06	5
ST11842	STF5A04012H01842C008.1	ST11855	STF5W04012H01842C008.1	4,0	6	12	18	3,8	62	0,08	5
ST11843	STF5A05015H02142C010.1	ST11856	STF5W05015H02142C010.1	5,0	6	15	21	4,8	62	0,10	5
ST11844	STF5A06018H02442C012.1	ST11857	STF5W06018H02442C012.1	6,0	6	18	24	5,7	62	0,12	5
ST11845	STF5A08024H03042C016.1	ST11858	STF5W08024H03042C016.1	8,0	8	24	30	7,6	68	0,16	5
ST11846	STF5A10030H03842C020.1	ST11859	STF5W10030H03842C020.1	10,0	10	30	38	9,5	80	0,20	5
ST11847	STF5A12036H04642C024.1	ST11860	STF5W12036H04642C024.1	12,0	12	36	46	11,5	93	0,24	5
ST11848	STF5A14042H05042C028.1	ST11861	STF5W14042H05042C028.1	14,0	14	42	50	13,5	100	0,28	5
ST11849	STF5A16048H05842C032.1	ST11862	STF5W16048H05842C032.1	16,0	16	48	58	15,5	108	0,32	5
ST11850	STF5A18054H06742C036.1	ST11863	STF5W18054H06742C036.1	18,0	18	54	67	17,5	115	0,36	5
ST11851	STF5A20060H07442C040.1	ST11864	STF5W20060H07442C040.1	20,0	20	60	74	19,5	126	0,40	5
ST11852	STF5A25075H09242C050.1	ST11865	STF5W25075H09242C050.1	25,0	25	75	92	24,0	150	0,50	5



Schnittwerte / vitesses de coupe

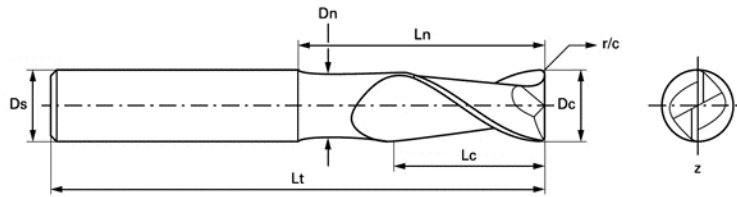
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,06*Dc - 0,12*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser Trochoidal M + S

Fraise - MD Trochoidal M + S



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11868	STF5A06018H02442R010.1	ST11891	STF5W06018H02442R010.1	6,0	6	18	24	5,7	62	0,1	5
ST11869	STF5A06018H02442R050.1	ST11892	STF5W06018H02442R050.1	6,0	6	18	24	5,7	62	0,5	5
ST11870	STF5A06018H02442R100.1	ST11893	STF5W06018H02442R100.1	6,0	6	18	24	5,7	62	1,0	5
ST11871	STF5A08024H03042R020.1	ST11894	STF5W08024H03042R020.1	8,0	8	24	30	7,6	68	0,2	5
ST11872	STF5A08024H03042R050.1	ST11895	STF5W08024H03042R050.1	8,0	8	24	30	7,6	68	0,5	5
ST11873	STF5A08024H03042R100.1	ST11896	STF5W08024H03042R100.1	8,0	8	24	30	7,6	68	1,0	5
ST11874	STF5A10030H03842R020.1	ST11897	STF5W10030H03842R020.1	10,0	10	30	38	9,5	80	0,2	5
ST11875	STF5A10030H03842R050.1	ST11898	STF5W10030H03842R050.1	10,0	10	30	38	9,5	80	0,5	5
ST11876	STF5A10030H03842R100.1	ST11899	STF5W10030H03842R100.1	10,0	10	30	38	9,5	80	1,0	5
ST11877	STF5A10030H03842R200.1	ST11900	STF5W10030H03842R200.1	10,0	10	30	38	9,5	80	2,0	5
ST11878	STF5A12036H04642R030.1	ST11901	STF5W12036H04642R030.1	12,0	12	36	46	11,5	93	0,3	5
ST11879	STF5A12036H04642R050.1	ST11902	STF5W12036H04642R050.1	12,0	12	36	46	11,5	93	0,5	5
ST11880	STF5A12036H04642R100.1	ST11903	STF5W12036H04642R100.1	12,0	12	36	46	11,5	93	1,0	5
ST11881	STF5A12036H04642R200.1	ST11904	STF5W12036H04642R200.1	12,0	12	36	46	11,5	93	2,0	5
ST11882	STF5A16048H05842R030.1	ST11905	STF5W16048H05842R030.1	16,0	16	48	58	15,5	108	0,3	5
ST11883	STF5A16048H05842R050.1	ST11906	STF5W16048H05842R050.1	16,0	16	48	58	15,5	108	0,5	5
ST11884	STF5A16048H05842R100.1	ST11907	STF5W16048H05842R100.1	16,0	16	48	58	15,5	108	1,0	5
ST11885	STF5A16048H05842R200.1	ST11908	STF5W16048H05842R200.1	16,0	16	48	58	15,5	108	2,0	5
ST11886	STF5A20060H07442R030.1	ST11909	STF5W20060H07442R030.1	20,0	20	60	74	19,5	126	0,3	5
ST11887	STF5A20060H07442R100.1	ST11910	STF5W20060H07442R100.1	20,0	20	60	74	19,5	126	1,0	5
ST11888	STF5A20060H07442R200.1	ST11911	STF5W20060H07442R200.1	20,0	20	60	74	19,5	126	2,0	5
ST11889	STF5A20060H07442R300.1	ST11912	STF5W20060H07442R300.1	20,0	20	60	74	19,5	126	3,0	5



Schnittwerte / vitesses de coupe

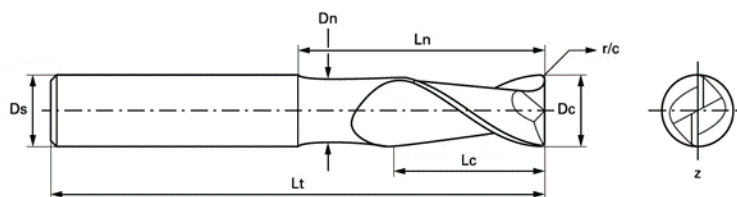
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,06*Dc - 0,12*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser Trochoidal M + S

Fraise - MD Trochoidal M + S



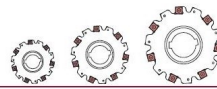
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11915	STF5A03012H01842C006.1	ST11928	STF5W03012H01842C006.1	3,0	6	12	18	2,8	62	0,06	5
ST11916	STF5A04016H02142C008.1	ST11929	STF5W04016H02142C008.1	4,0	6	16	21	3,8	62	0,08	5
ST11917	STF5A05020H02542C010.1	ST11930	STF5W05020H02542C010.1	5,0	6	20	25	4,8	70	0,10	5
ST11918	STF5A06024H03042C012.1	ST11931	STF5W06024H03042C012.1	6,0	6	24	30	5,7	70	0,12	5
ST11919	STF5A08032H03842C016.1	ST11932	STF5W08032H03842C016.1	8,0	8	32	38	7,6	80	0,16	5
ST11920	STF5A10040H04842C020.1	ST11933	STF5W10040H04842C020.1	10,0	10	40	48	9,5	90	0,20	5
ST11921	STF5A12048H05842C024.1	ST11934	STF5W12048H05842C024.1	12,0	12	48	58	11,5	110	0,24	5
ST11922	STF5A14056H06442C028.1	ST11935	STF5W14056H06442C028.1	14,0	14	56	64	13,5	110	0,28	5
ST11923	STF5A16064H07442C032.1	ST11936	STF5W16064H07442C032.1	16,0	16	64	74	15,5	130	0,32	5
ST11924	STF5A18072H08542C036.1	ST11937	STF5W18072H08542C036.1	18,0	18	72	85	17,5	140	0,36	5
ST11925	STF5A20080H09442C040.1	ST11938	STF5W20080H09442C040.1	20,0	20	80	94	19,5	150	0,40	5
ST11926	STF5A250100H11742C050.1	ST11939	STF5W250100H11742C050.1	25,0	25	100	117	24,0	180	0,50	5



Schnittwerte / vitesses de coupe

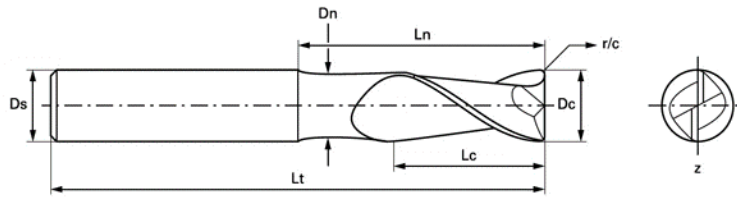
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,03*Dc - 0,09*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser Trochoidal M + S

Fraise - MD Trochoidal M + S



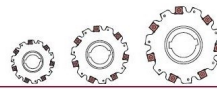
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12905	STF7A03009H01442C006.1	ST12930	STF7W03009H01442C006.1	3,0	6	9	14	2,8	62	0,06	7
ST12906	STF7A04012H01842C008.1	ST12931	STF7W04012H01842C008.1	4,0	6	12	18	3,8	62	0,08	7
ST12907	STF7A05015H02142C010.1	ST12932	STF7W05015H02142C010.1	5,0	6	15	21	4,8	62	0,10	7
ST12908	STF7A06018H02442C012.1	ST12933	STF7W06018H02442C012.1	6,0	6	18	24	5,7	62	0,12	7
ST12909	STF7A08024H03042C016.1	ST12934	STF7W08024H03042C016.1	8,0	8	24	30	7,6	68	0,16	7
ST12910	STF7A10030H03842C020.1	ST12935	STF7W10030H03842C020.1	10,0	10	30	38	9,5	80	0,20	7
ST12911	STF7A12036H04642C024.1	ST12936	STF7W12036H04642C024.1	12,0	12	36	46	11,5	93	0,24	7
ST12912	STF7A14042H05042C028.1	ST12937	STF7W14042H05042C028.1	14,0	14	42	50	13,5	100	0,28	7
ST12913	STF7A16048H05842C032.1	ST12938	STF7W16048H05842C032.1	16,0	16	48	58	15,5	108	0,32	7
ST12914	STF7A18054H06742C036.1	ST12939	STF7W18054H06742C036.1	18,0	18	54	67	17,5	115	0,36	7
ST12915	STF7A20060H07442C040.1	ST12940	STF7W20060H07442C040.1	20,0	20	60	74	19,5	126	0,40	7
ST12916	STF7A25075H09242C050.1	ST12941	STF7W25075H09242C050.1	25,0	25	75	92	24	150	0,50	7



Schnittwerte / vitesses de coupe

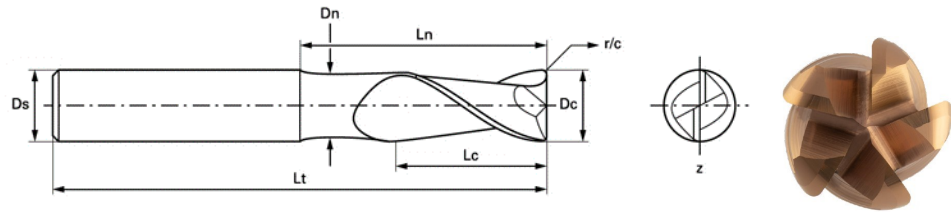
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	[min]	[max]	[max]	
	0,3*Dc	Lc	0,06*Dc - 0,12*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser Trochoidal M + S

Fraise - MD Trochoidal M + S



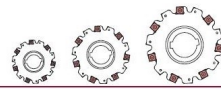
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11942	STF5A06024H03042R010.1	ST11965	STF5W06024H03042R010.1	6,0	6	24	30	5,7	70	0,1	5
ST11943	STF5A06024H03042R050.1	ST11966	STF5W06024H03042R050.1	6,0	6	24	30	5,7	70	0,5	5
ST11944	STF5A06024H03042R100.1	ST11967	STF5W06024H03042R100.1	6,0	6	24	30	5,7	70	1,0	5
ST11945	STF5A08032H03842R020.1	ST11968	STF5W08032H03842R020.1	8,0	8	32	38	7,6	80	0,2	5
ST11946	STF5A08032H03842R050.1	ST11969	STF5W08032H03842R050.1	8,0	8	32	38	7,6	80	0,5	5
ST11947	STF5A08032H03842R100.1	ST11970	STF5W08032H03842R100.1	8,0	8	32	38	7,6	80	1,0	5
ST11948	STF5A10040H04842R020.1	ST11971	STF5W10040H04842R020.1	10,0	10	40	48	9,5	90	0,2	5
ST11949	STF5A10040H04842R050.1	ST11972	STF5W10040H04842R050.1	10,0	10	40	48	9,5	90	0,5	5
ST11950	STF5A10040H04842R100.1	ST11973	STF5W10040H04842R100.1	10,0	10	40	48	9,5	90	1,0	5
ST11951	STF5A10040H04842R200.1	ST11974	STF5W10040H04842R200.1	10,0	10	40	48	9,5	90	2,0	5
ST11952	STF5A12048H05842R030.1	ST11975	STF5W12048H05842R030.1	12,0	12	48	58	11,5	110	0,3	5
ST11953	STF5A12048H05842R050.1	ST11976	STF5W12048H05842R050.1	12,0	12	48	58	11,5	110	0,5	5
ST11954	STF5A12048H05842R100.1	ST11977	STF5W12048H05842R100.1	12,0	12	48	58	11,5	110	1,0	5
ST11955	STF5A12048H05842R200.1	ST11978	STF5W12048H05842R200.1	12,0	12	48	58	11,5	110	2,0	5
ST11956	STF5A16064H07442R030.1	ST11979	STF5W16064H07442R030.1	16,0	16	64	74	15,5	130	0,3	5
ST11957	STF5A16064H07442R050.1	ST11980	STF5W16064H07442R050.1	16,0	16	64	74	15,5	130	0,5	5
ST11958	STF5A16064H07442R100.1	ST11981	STF5W16064H07442R100.1	16,0	16	64	74	15,5	130	1,0	5
ST11959	STF5A16064H07442R200.1	ST11982	STF5W16064H07442R200.1	16,0	16	64	74	15,5	130	2,0	5
ST11960	STF5A20080H09442R030.1	ST11983	STF5W20080H09442R030.1	20,0	20	80	94	19,5	150	0,3	5
ST11961	STF5A20080H09442R100.1	ST11984	STF5W20080H09442R100.1	20,0	20	80	94	19,5	150	1,0	5
ST11962	STF5A20080H09442R200.1	ST11985	STF5W20080H09442R200.1	20,0	20	80	94	19,5	150	2,0	5
ST11963	STF5A20080H09442R300.1	ST11986	STF5W20080H09442R300.1	20,0	20	80	94	19,5	150	3,0	5



Schnittwerte / vitesses de coupe

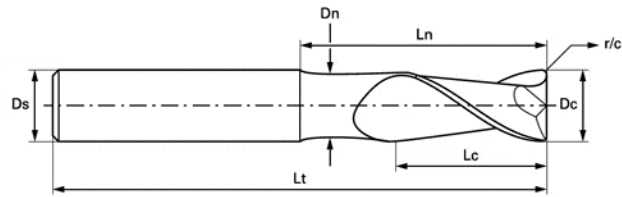
	Ap	Ap	Ae	hm
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,03*Dc - 0,09*Dc	0,0030*Dc

	M1	M2	S1	S2
Vc	190	170	-	130



VHM - Fräser M + S

Fraise - MD M + S



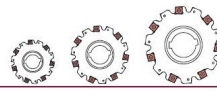
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11989	STF5A03008H01442R010.7	ST11999	STF5W03008H01442R010.7	3,0	6	8	14	2,8	57	0,10	5
ST11990	STF5A04011H01642R010.7	ST12000	STF5W04011H01642R010.7	4,0	6	11	16	3,8	57	0,10	5
ST11991	STF5A05013H01842R015.7	ST12001	STF5W05013H01842R015.7	5,0	6	13	18	4,8	57	0,15	5
ST11992	STF5A06013H01942R015.7	ST12002	STF5W06013H01942R015.7	6,0	6	13	19	5,7	57	0,15	5
ST11993	STF5A08019H02542R015.7	ST12003	STF5W08019H02542R015.7	8,0	8	19	25	7,6	63	0,15	5
ST11994	STF5A10022H03042R020.7	ST12004	STF5W10022H03042R020.7	10,0	10	22	30	9,5	72	0,20	5
ST11995	STF5A12026H03642R020.7	ST12005	STF5W12026H03642R020.7	12,0	12	26	36	11,5	83	0,20	5
ST11996	STF5A16032H04242R030.7	ST12006	STF5W16032H04242R030.7	16,0	16	32	42	15,5	92	0,30	5
ST11997	STF5A20038H05242R030.7	ST12007	STF5W20038H05242R030.7	20,0	20	38	52	19,5	104	0,30	5



Schnittwerte / vitesses de coupe

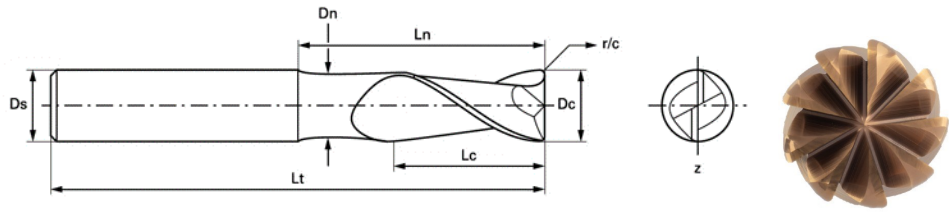
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	0,3*Dc	Lc	0,5*Dc	0,0033*Dc
	0,3*Dc	Lc	0,06*Dc - 0,12*DC	0,0050*Dc

	M1	M2	S1	S2
Vc	-	-	80	-



VHM - Fräser M + S

Fraise - MD M + S



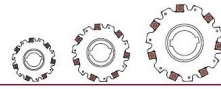
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12010	STF8A06013H01936R050.7	ST12023	STF8W06013H01936R050.7	6,0	6	13	19	5,7	57	0,5	8
ST12011	STF8A06013H01936R100.7	ST12024	STF8W06013H01936R100.7	6,0	6	13	19	5,7	57	1,0	8
ST12012	STF9A08019H02536R050.7	ST12025	STF9W08019H02536R050.7	8,0	8	19	25	7,6	63	0,5	9
ST12013	STF9A08019H02536R100.7	ST12026	STF9W08019H02536R100.7	8,0	8	19	25	7,6	63	1,0	9
ST12014	STF9A10022H03036R050.7	ST12027	STF9W10022H03036R050.7	10,0	10	22	30	9,5	72	0,5	9
ST12015	STF9A10022H03036R100.7	ST12028	STF9W10022H03036R100.7	10,0	10	22	30	9,5	72	1,0	9
ST12016	STF9A12026H03636R050.7	ST12029	STF9W12026H03636R050.7	12,0	12	26	36	11,5	83	0,5	9
ST12017	STF9A12026H03636R100.7	ST12030	STF9W12026H03636R100.7	12,0	12	26	36	11,5	83	1,0	9
ST12018	STF11A16032H04236R050.7	ST12031	STF11W16032H04236R050.7	16,0	16	32	42	15,5	92	0,5	11
ST12019	STF11A16032H04236R100.7	ST12032	STF11W16032H04236R100.7	16,0	16	32	42	15,5	92	1,0	11
ST12020	STF11A20038H05236R050.7	ST12033	STF11W20038H05236R050.7	20,0	20	38	52	19,5	104	0,5	11
ST12021	STF11A20038H05236R100.7	ST12034	STF11W20038H05236R100.7	20,0	20	38	52	19,5	104	1,0	11



Schnittwerte / vitesses de coupe

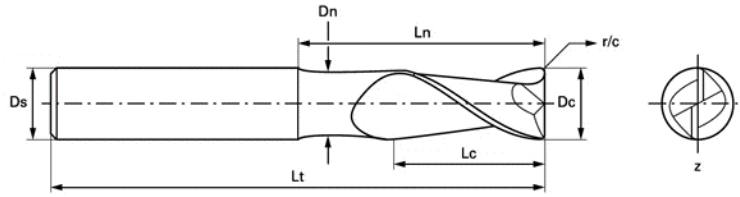
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	[min]	[max]	[max]	
	0,3*Dc	Lc	0,15*Dc	0,0060*Dc

	M1	M2	S1	S2
Vc	-	-	80	-



VHM - Fräser M + S

Fraise - MD M + S



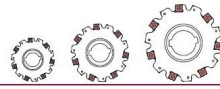
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12037	STF3A06013H01935C030.1	ST12044	STF3W06013H01935C030.1	6,0	6	13	19	5,7	57	0,3	3
ST12038	STF3A08019H02535C040.1	ST12045	STF3W08019H02535C040.1	8,0	8	19	25	7,6	63	0,4	3
ST12039	STF3A10022H03035C050.1	ST12046	STF3W10022H03035C050.1	10,0	10	22	30	9,5	72	0,5	3
ST12040	STF3A12026H03635C060.1	ST12047	STF3W12026H03635C060.1	12,0	12	26	36	11,5	83	0,6	3
ST12041	STF3A16032H04235C080.1	ST12048	STF3W16032H04235C080.1	16,0	16	32	42	15,5	92	0,8	3
ST12042	STF3A20038H05235C100.1	ST12049	STF3W20038H05235C100.1	20,0	20	38	52	19,5	104	1,0	3



Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0045*Dc
	0,3*Dc	Lc	1*Dc	0,0035*Dc

	M1	M2	S1	S2
Vc	120	100	40	90



VHM - Fräser Nichteisenmetalle
Fraise - MD Matériaux non ferreux

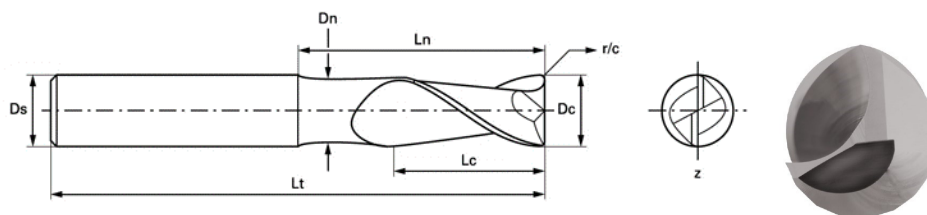
40 Jahre Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità





VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12052	STF1A0300820C005.0	-	-	3,0	6	8	-	-	57	0,05	1
ST12053	STF1A0401120C005.0	-	-	4,0	6	11	-	-	57	0,05	1
ST12054	STF1A0501320C005.0	-	-	5,0	6	13	-	-	62	0,05	1
ST12055	STF1A0601320C006.0	-	-	6,0	6	13	-	-	62	0,06	1
ST12056	STF1A0801920C008.0	-	-	8,0	8	19	-	-	70	0,08	1
ST12057	STF1A1002220C010.0	-	-	10,0	10	22	-	-	80	0,10	1
ST12058	STF1A1202620C012.0	-	-	12,0	12	26	-	-	93	0,12	1



Schnittwerte / vitesses de coupe

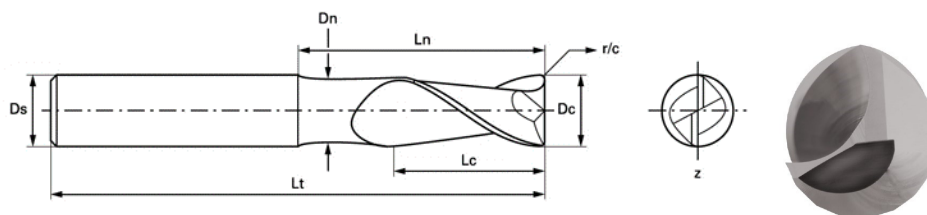
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	0,3*Dc	Lc	0,5*Dc	0,0110*Dc
	0,3*Dc	Lc	1*Dc	0,0075*Dc
	-	1*Lc	1*Dc	0,0040*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



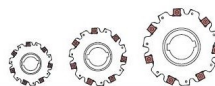
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12061	STF1A0300825C005.0	-	-	3,0	6	8	-	-	50	0,05	1
ST12062	STF1A0401125C005.0	-	-	4,0	6	11	-	-	54	0,05	1
ST12063	STF1A0501325C005.0	-	-	5,0	6	13	-	-	54	0,05	1
ST12064	STF1A0601325C006.0	-	-	6,0	6	13	-	-	54	0,06	1
ST12065	STF1A0801925C008.0	-	-	8,0	8	19	-	-	58	0,08	1
ST12066	STF1A1002225C010.0	-	-	10,0	10	22	-	-	66	0,10	1
ST12067	STF1A1202625C012.0	-	-	12,0	12	26	-	-	73	0,12	1



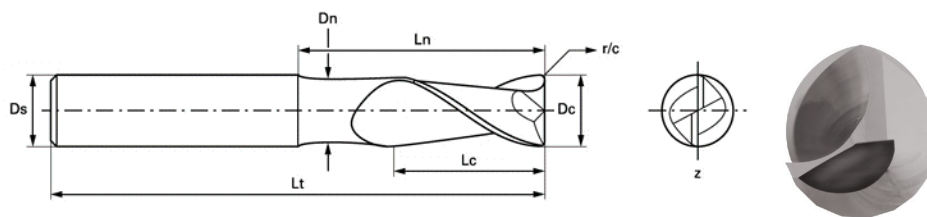
Schnittwerte / vitesses de coupe

	Ap [min]	Ap [max]	Ae [max]	fz
	0,3*Dc	Lc	0,5*Dc	0,0110*Dc
	0,3*Dc	Lc	1*Dc	0,0075*Dc
	-	1*Lc	1*Dc	0,0040*Dc

	N1	N2
Vc	250	200



VHM - Fräser N
Fraise - MD N



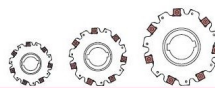
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12070	STF1A0300830C005.0	-	-	3,0	6	8	-	-	50	0,05	1
ST12071	STF1A0401130C005.0	-	-	4,0	6	11	-	-	54	0,05	1
ST12072	STF1A0501330C005.0	-	-	5,0	6	13	-	-	54	0,05	1
ST12073	STF1A0601330C006.0	-	-	6,0	6	13	-	-	54	0,06	1
ST12074	STF1A0801930C008.0	-	-	8,0	8	19	-	-	58	0,08	1
ST12075	STF1A1002230C010.0	-	-	10,0	10	22	-	-	66	0,10	1
ST12076	STF1A1202630C012.0	-	-	12,0	12	26	-	-	73	0,12	1



Schnittwerte / vitesses de coupe

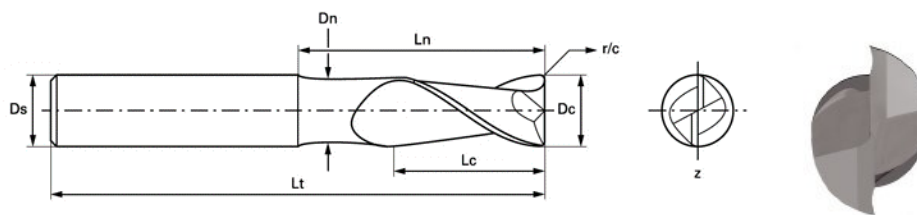
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	0,3*Dc	Lc	1*Dc	0,0075*Dc
	-	1*Lc	1*Dc	0,0040*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST12079	STF2A0300820.0	ST12095	STF2W0300820.0	3,0	6	8	-	-	57	-	2
ST12080	STF2A0351020.0	ST12096	STF2W0351020.0	3,5	6	10	-	-	57	-	2
ST12081	STF2A0401120.0	ST12097	STF2W0401120.0	4,0	6	11	-	-	57	-	2
ST12082	STF2A0451120.0	ST12098	STF2W0451120.0	4,5	6	11	-	-	57	-	2
ST12083	STF2A0501320.0	ST12099	STF2W0501320.0	5,0	6	13	-	-	57	-	2
ST12084	STF2A0601320.0	ST12100	STF2W0601320.0	6,0	6	13	-	-	57	-	2
ST12085	STF2A0701620.0	ST12101	STF2W0701620.0	7,0	8	16	-	-	63	-	2
ST12086	STF2A0801920.0	ST12102	STF2W0801920.0	8,0	8	19	-	-	63	-	2
ST12087	STF2A0901920.0	ST12103	STF2W0901920.0	9,0	10	19	-	-	72	-	2
ST12088	STF2A1002220.0	ST12104	STF2W1002220.0	10,0	10	22	-	-	72	-	2
ST12089	STF2A1202620.0	ST12105	STF2W1202620.0	12,0	12	26	-	-	83	-	2
ST12090	STF2A1402620.0	ST12106	STF2W1402620.0	14,0	14	26	-	-	83	-	2
ST12091	STF2A1603220.0	ST12107	STF2W1603220.0	16,0	16	32	-	-	92	-	2
ST12092	STF2A1803220.0	ST12108	STF2W1803220.0	18,0	18	32	-	-	92	-	2
ST12093	STF2A2003820.0	ST12109	STF2W2003820.0	20,0	20	38	-	-	104	-	2



Schnittwerte / vitesses de coupe

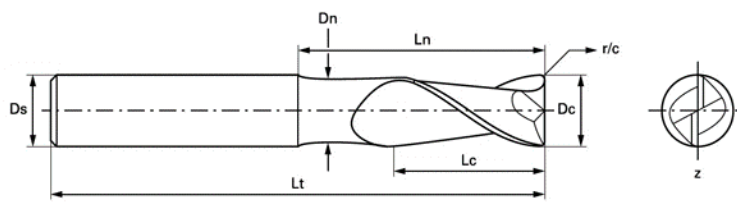
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	0,3*Dc	Lc	0,5*Dc	0,0110*Dc
	0,3*Dc	Lc	1*Dc	0,0075*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12112	STF2A0300845C005.0	ST12128	STF2W0300845C005.0	3,0	6	8	-	-	57	0,05	2
ST12113	STF2A0351045C005.0	ST12129	STF2W0351045C005.0	3,5	6	10	-	-	57	0,05	2
ST12114	STF2A0401145C005.0	ST12130	STF2W0401145C005.0	4,0	6	11	-	-	57	0,05	2
ST12115	STF2A0451145C005.0	ST12131	STF2W0451145C005.0	4,5	6	11	-	-	57	0,05	2
ST12116	STF2A0501345C005.0	ST12132	STF2W0501345C005.0	5,0	6	13	-	-	57	0,05	2
ST12117	STF2A0601345C006.0	ST12133	STF2W0601345C006.0	6,0	6	13	-	-	57	0,06	2
ST12118	STF2A0701645C007.0	ST12134	STF2W0701645C007.0	7,0	8	16	-	-	63	0,07	2
ST12119	STF2A0801945C008.0	ST12135	STF2W0801945C008.0	8,0	8	19	-	-	63	0,08	2
ST12120	STF2A0901945C009.0	ST12136	STF2W0901945C009.0	9,0	10	19	-	-	72	0,09	2
ST12121	STF2A1002245C010.0	ST12137	STF2W1002245C010.0	10,0	10	22	-	-	72	0,10	2
ST12122	STF2A1202645C012.0	ST12138	STF2W1202645C012.0	12,0	12	26	-	-	83	0,12	2
ST12123	STF2A1402645C014.0	ST12139	STF2W1402645C014.0	14,0	14	26	-	-	83	0,14	2
ST12124	STF2A1603245C016.0	ST12140	STF2W1603245C016.0	16,0	16	32	-	-	92	0,16	2
ST12125	STF2A1803245C018.0	ST12141	STF2W1803245C018.0	18,0	18	32	-	-	92	0,18	2
ST12126	STF2A2003845C020.0	ST12142	STF2W2003845C020.0	20,0	20	38	-	-	104	0,20	2



Schnittwerte / vitesses de coupe

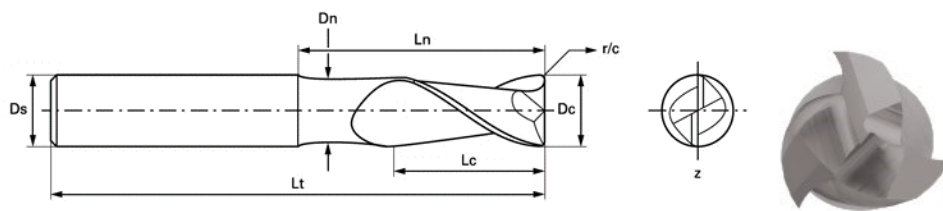
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	0,3*Dc	Lc	1*Dc	0,0075*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



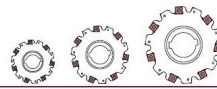
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST12145	STF3A0300820.0	ST12159	STF3W0300820.0	3,0	6	8	-	-	57	-	3
ST12146	STF3A0351020.0	ST12160	STF3W0351020.0	3,5	6	10	-	-	57	-	3
ST12147	STF3A0401020.0	ST12161	STF3W0401020.0	4,0	6	10	-	-	57	-	3
ST12148	STF3A0451120.0	ST12162	STF3W0451120.0	4,5	6	11	-	-	57	-	3
ST12149	STF3A0501320.0	ST12163	STF3W0501320.0	5,0	6	13	-	-	57	-	3
ST12150	STF3A0601320.0	ST12164	STF3W0601320.0	6,0	6	13	-	-	57	-	3
ST12151	STF3A0801920.0	ST12165	STF3W0801920.0	8,0	8	19	-	-	63	-	3
ST12152	STF3A1002220.0	ST12166	STF3W1002220.0	10,0	10	22	-	-	72	-	3
ST12153	STF3A1202620.0	ST12167	STF3W1202620.0	12,0	12	26	-	-	83	-	3
ST12154	STF3A1402620.0	ST12168	STF3W1402620.0	14,0	14	26	-	-	83	-	3
ST12155	STF3A1603220.0	ST12169	STF3W1603220.0	16,0	16	32	-	-	92	-	3
ST12156	STF3A1803220.0	ST12170	STF3W1803220.0	18,0	18	32	-	-	92	-	3
ST12157	STF3A2003820.0	ST12171	STF3W2003820.0	20,0	20	38	-	-	104	-	3



Schnittwerte / vitesses de coupe

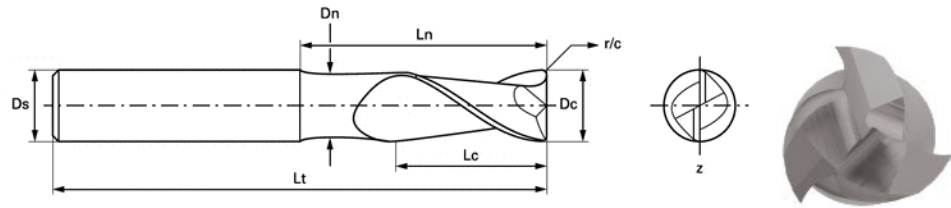
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	0,3*Dc	Lc	1*Dc	0,0075*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12174	STF3A0300845C005.0	ST12188	STF3W0300845C005.0	3,0	6	8	-	-	57	0,05	3
ST12175	STF3A0351045C005.0	ST12189	STF3W0351045C005.0	3,5	6	10	-	-	57	0,05	3
ST12176	STF3A0401145C005.0	ST12190	STF3W0401145C005.0	4,0	6	11	-	-	57	0,05	3
ST12177	STF3A0451145C005.0	ST12191	STF3W0451145C005.0	4,5	6	11	-	-	57	0,05	3
ST12178	STF3A0501345C005.0	ST12192	STF3W0501345C005.0	5,0	6	13	-	-	57	0,05	3
ST12179	STF3A0601345C006.0	ST12193	STF3W0601345C006.0	6,0	6	13	-	-	57	0,06	3
ST12180	STF3A0801945C008.0	ST12194	STF3W0801945C008.0	8,0	8	19	-	-	63	0,08	3
ST12181	STF3A1002245C010.0	ST12195	STF3W1002245C010.0	10,0	10	22	-	-	72	0,10	3
ST12182	STF3A1202645C012.0	ST12196	STF3W1202645C012.0	12,0	12	26	-	-	83	0,12	3
ST12183	STF3A1402645C014.0	ST12197	STF3W1402645C014.0	14,0	14	26	-	-	83	0,14	3
ST12184	STF3A1603245C016.0	ST12198	STF3W1603245C016.0	16,0	16	32	-	-	92	0,16	3
ST12185	STF3A1803245C018.0	ST12199	STF3W1803245C018.0	18,0	18	32	-	-	92	0,18	3
ST12186	STF3A2003845C020.0	ST12200	STF3W2003845C020.0	20,0	20	38	-	-	104	0,20	3



Schnittwerte / vitesses de coupe

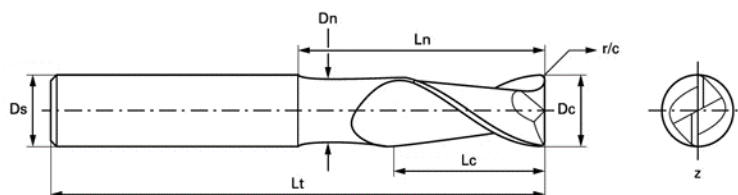
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	0,3*Dc	Lc	1*Dc	0,0075*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



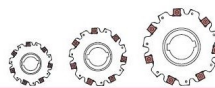
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST12203	STF3A03007H01245.0	ST12214	STF3W03007H01245.0	3,0	6	7	12	2,7	50	-	3
ST12204	STF3A04009H01645.0	ST12215	STF3W04009H01645.0	4,0	6	9	16	3,6	54	-	3
ST12205	STF3A05011H02045.0	ST12216	STF3W05011H02045.0	5,0	6	11	20	4,5	58	-	3
ST12206	STF3A06014H02445.0	ST12217	STF3W06014H02445.0	6,0	6	14	24	5,4	62	-	3
ST12207	STF3A08018H03245.0	ST12218	STF3W08018H03245.0	8,0	8	18	32	7,2	70	-	3
ST12208	STF3A10022H04045.0	ST12219	STF3W10022H04045.0	10,0	10	22	40	9,0	82	-	3
ST12209	STF3A12027H04845.0	ST12220	STF3W12027H04845.0	12,0	12	27	48	11,0	95	-	3
ST12210	STF3A16036H06445.0	ST12221	STF3W16036H06445.0	16,0	16	36	64	15,0	115	-	3
ST12211	STF3A20044H08045.0	ST12222	STF3W20044H08045.0	20,0	20	44	80	19,0	132	-	3
ST12212	STF3A25055H10045.0	ST12223	STF3W25055H10045.0	25,0	25	55	100	24,0	160	-	3



Schnittwerte / vitesses de coupe

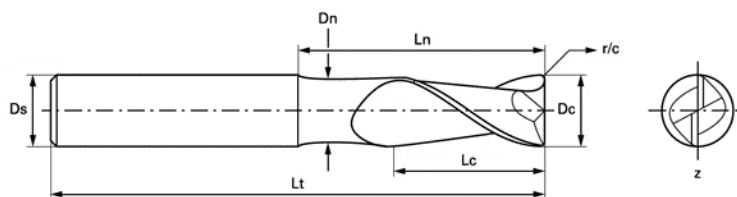
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12226	STF3A03007H01245R010.0	ST12259	STF3W03007H01245R010.0	3,0	6	7	12	2,7	50	0,10	3
ST12227	STF3A04009H01645R020.0	ST12260	STF3W04009H01645R020.0	4,0	6	9	16	3,6	54	0,20	3
ST12228	STF3A05011H02045R020.0	ST12261	STF3W05011H02045R020.0	5,0	6	11	20	4,5	58	0,20	3
ST12229	STF3A06014H02445R020.0	ST12262	STF3W06014H02445R020.0	6,0	6	14	24	5,4	62	0,20	3
ST12230	STF3A06014H02445R040.0	ST12263	STF3W06014H02445R040.0	6,0	6	14	24	5,4	62	0,40	3
ST12231	STF3A06014H02445R080.0	ST12264	STF3W06014H02445R080.0	6,0	6	14	24	5,4	62	0,80	3
ST12232	STF3A08018H03245R020.0	ST12265	STF3W08018H03245R020.0	8,0	8	18	32	7,2	70	0,20	3
ST12233	STF3A08018H03245R040.0	ST12266	STF3W08018H03245R040.0	8,0	8	18	32	7,2	70	0,40	3
ST12234	STF3A08018H03245R080.0	ST12267	STF3W08018H03245R080.0	8,0	8	18	32	7,2	70	0,80	3
ST12235	STF3A10022H04045R020.0	ST12268	STF3W10022H04045R020.0	10,0	10	22	40	9,0	82	0,20	3
ST12236	STF3A10022H04045R040.0	ST12269	STF3W10022H04045R040.0	10,0	10	22	40	9,0	82	0,40	3
ST12237	STF3A10022H04045R080.0	ST12270	STF3W10022H04045R080.0	10,0	10	22	40	9,0	82	0,80	3
ST12238	STF3A10022H04045R160.0	ST12271	STF3W10022H04045R160.0	10,0	10	22	40	9,0	82	1,60	3
ST12239	STF3A12027H04845R020.0	ST12272	STF3W12027H04845R020.0	12,0	12	27	48	11,0	95	0,20	3
ST12240	STF3A12027H04845R040.0	ST12273	STF3W12027H04845R040.0	12,0	12	27	48	11,0	95	0,40	3
ST12241	STF3A12027H04845R080.0	ST12274	STF3W12027H04845R080.0	12,0	12	27	48	11,0	95	0,80	3



Schnittwerte / vitesses de coupe

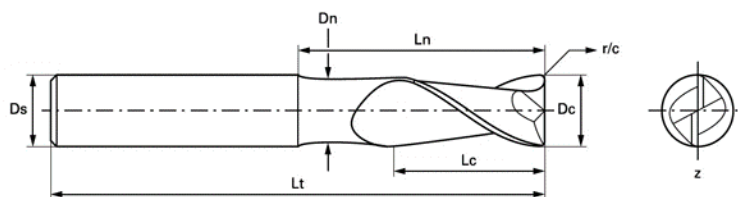
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	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



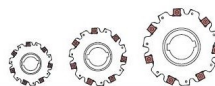
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12242	STF3A12027H04845R160.0	ST12275	STF3W12027H04845R160.0	12,0	12	27	48	11,0	95	1,60	3
ST12243	STF3A12027H04845R200.0	ST12276	STF3W12027H04845R200.0	12,0	12	27	48	11,0	95	2,00	3
ST12244	STF3A12027H04845R250.0	ST12277	STF3W12027H04845R250.0	12,0	12	27	48	11,0	95	2,50	3
ST12245	STF3A16036H06445R020.0	ST12278	STF3W16036H06445R020.0	16,0	16	36	64	15,0	115	0,20	3
ST12246	STF3A16036H06445R040.0	ST12279	STF3W16036H06445R040.0	16,0	16	36	64	15,0	115	0,40	3
ST12247	STF3A16036H06445R080.0	ST12280	STF3W16036H06445R080.0	16,0	16	36	64	15,0	115	0,80	3
ST12248	STF3A16036H06445R160.0	ST12281	STF3W16036H06445R160.0	16,0	16	36	64	15,0	115	1,60	3
ST12249	STF3A16036H06445R200.0	ST12282	STF3W16036H06445R200.0	16,0	16	36	64	15,0	115	2,00	3
ST12250	STF3A16036H06445R250.0	ST12283	STF3W16036H06445R250.0	16,0	16	36	64	15,0	115	2,50	3
ST12251	STF3A16036H06445R320.0	ST12284	STF3W16036H06445R320.0	16,0	16	36	64	15,0	115	3,20	3
ST12252	STF3A16036H06445R400.0	ST12285	STF3W16036H06445R400.0	16,0	16	36	64	15,0	115	4,00	3
ST12253	STF3A16036H06445R500.0	ST12286	STF3W16036H06445R500.0	16,0	16	36	64	15,0	115	5,00	3
ST12254	STF3A20044H08045R020.0	ST12287	STF3W20044H08045R020.0	20,0	20	44	80	19,0	132	0,20	3
ST12255	STF3A20044H08045R040.0	ST12288	STF3W20044H08045R040.0	20,0	20	44	80	19,0	132	0,40	3
ST12256	STF3A20044H08045R080.0	ST12289	STF3W20044H08045R080.0	20,0	20	44	80	19,0	132	0,80	3
ST12257	STF3A20044H08045R160.0	ST12290	STF3W20044H08045R160.0	20,0	20	44	80	19,0	132	1,60	3



Schnittwerte / vitesses de coupe

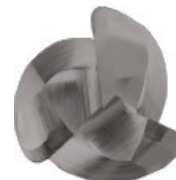
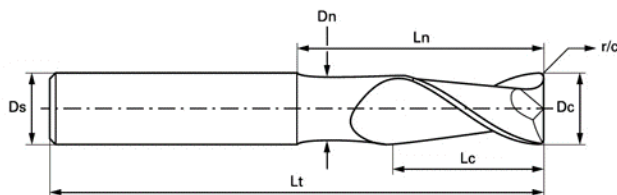
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12293	STF3A20044H08045R200.0	ST12308	STF3W20044H08045R200.0	20,0	20	44	80	19,0	132	2,00	3
ST12294	STF3A20044H08045R320.0	ST12309	STF3W20044H08045R320.0	20,0	20	44	80	19,0	132	3,20	3
ST12295	STF3A20044H08045R400.0	ST12310	STF3W20044H08045R400.0	20,0	20	44	80	19,0	132	4,00	3
ST12296	STF3A20044H08045R500.0	ST12311	STF3W20044H08045R500.0	20,0	20	44	80	19,0	132	5,00	3
ST12297	STF3A20044H08045R600.0	ST12312	STF3W20044H08045R600.0	20,0	20	44	80	19,0	132	6,00	3
ST12298	STF3A25055H10045R020.0	ST12313	STF3W25055H10045R020.0	25,0	25	55	100	24,0	160	0,20	3
ST12299	STF3A25055H10045R040.0	ST12314	STF3W25055H10045R040.0	25,0	25	55	100	24,0	160	0,40	3
ST12300	STF3A25055H10045R160.0	ST12315	STF3W25055H10045R160.0	25,0	25	55	100	24,0	160	1,60	3
ST12301	STF3A25055H10045R200.0	ST12316	STF3W25055H10045R200.0	25,0	25	55	100	24,0	160	2,00	3
ST12302	STF3A25055H10045R320.0	ST12317	STF3W25055H10045R320.0	25,0	25	55	100	24,0	160	3,20	3
ST12303	STF3A25055H10045R400.0	ST12318	STF3W25055H10045R400.0	25,0	25	55	100	24,0	160	4,00	3
ST12304	STF3A25055H10045R500.0	ST12319	STF3W25055H10045R500.0	25,0	25	55	100	24,0	160	5,00	3
ST12305	STF3A25055H10045R600.0	ST12320	STF3W25055H10045R600.0	25,0	25	55	100	24,0	160	6,00	3
ST12306	STF3A25055H10045R635.0	ST12321	STF3W25055H10045R635.0	25,0	25	55	100	24,0	160	6,35	3



Schnittwerte / vitesses de coupe

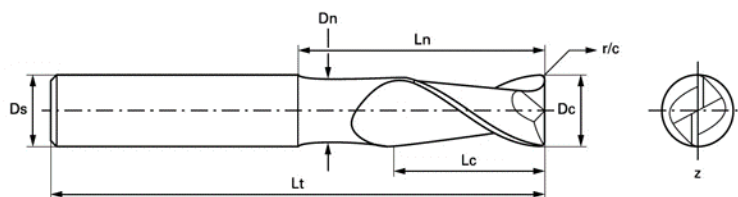
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



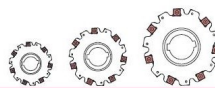
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST12324	STF3A03005H01545.0	ST12335	STF3W03005H01545.0	3,0	6	5	15	2,7	54	-	3
ST12325	STF3A04007H02045.0	ST12336	STF3W04007H02045.0	4,0	6	7	20	3,6	58	-	3
ST12326	STF3A05009H02545.0	ST12337	STF3W05009H02545.0	5,0	6	9	25	4,5	62	-	3
ST12327	STF3A06010H03045.0	ST12338	STF3W06010H03045.0	6,0	6	10	30	5,4	70	-	3
ST12328	STF3A08014H04045.0	ST12339	STF3W08014H04045.0	8,0	8	14	40	7,2	80	-	3
ST12329	STF3A10017H05045.0	ST12340	STF3W10017H05045.0	10,0	10	17	50	9,0	92	-	3
ST12330	STF3A12020H06045.0	ST12341	STF3W12020H06045.0	12,0	12	20	60	11,0	110	-	3
ST12331	STF3A16027H08045.0	ST12342	STF3W16027H08045.0	16,0	16	27	80	15,0	130	-	3
ST12332	STF3A20033H10045.0	ST12343	STF3W20033H10045.0	20,0	20	33	100	19,0	152	-	3
ST12333	STF3A25042H12545.0	ST12344	STF3W25042H12545.0	25,0	25	42	125	24,0	185	-	3



Schnittwerte / vitesses de coupe

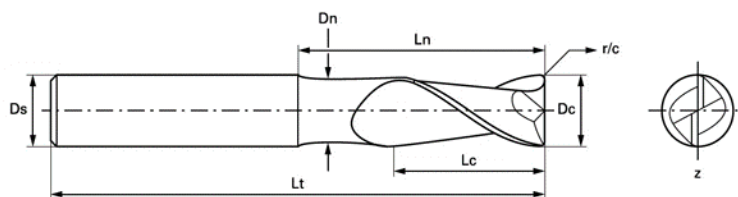
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



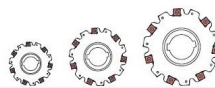
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12347	STF3A03005H01545R010.0	ST12380	STF3W03005H01545R010.0	3,0	6	5	15	2,7	54	0,10	3
ST12348	STF3A04007H02045R020.0	ST12381	STF3W04007H02045R020.0	4,0	6	7	20	3,6	58	0,20	3
ST12349	STF3A05009H02545R020.0	ST12382	STF3W05009H02545R020.0	5,0	6	9	25	4,5	62	0,20	3
ST12350	STF3A06010H03045R020.0	ST12383	STF3W06010H03045R020.0	6,0	6	10	30	5,4	70	0,20	3
ST12351	STF3A06010H03045R040.0	ST12384	STF3W06010H03045R040.0	6,0	6	10	30	5,4	70	0,40	3
ST12352	STF3A06010H03045R080.0	ST12385	STF3W06010H03045R080.0	6,0	6	10	30	5,4	70	0,80	3
ST12353	STF3A08014H04045R020.0	ST12386	STF3W08014H04045R020.0	8,0	8	14	40	7,2	80	0,20	3
ST12354	STF3A08014H04045R040.0	ST12387	STF3W08014H04045R040.0	8,0	8	14	40	7,2	80	0,40	3
ST12355	STF3A08014H04045R080.0	ST12388	STF3W08014H04045R080.0	8,0	8	14	40	7,2	80	0,80	3
ST12356	STF3A10017H05045R020.0	ST12389	STF3W10017H05045R020.0	10,0	10	17	50	9,0	92	0,20	3
ST12357	STF3A10017H05045R040.0	ST12390	STF3W10017H05045R040.0	10,0	10	17	50	9,0	92	0,40	3
ST12358	STF3A10017H05045R080.0	ST12391	STF3W10017H05045R080.0	10,0	10	17	50	9,0	92	0,80	3
ST12359	STF3A10017H05045R160.0	ST12392	STF3W10017H05045R160.0	10,0	10	17	50	9,0	92	1,60	3
ST12360	STF3A12020H06045R020.0	ST12393	STF3W12020H06045R020.0	12,0	12	20	60	11,0	110	0,20	3
ST12361	STF3A12020H06045R040.0	ST12394	STF3W12020H06045R040.0	12,0	12	20	60	11,0	110	0,40	3
ST12362	STF3A12020H06045R080.0	ST12395	STF3W12020H06045R080.0	12,0	12	20	60	11,0	110	0,80	3



Schnittwerte / vitesses de coupe

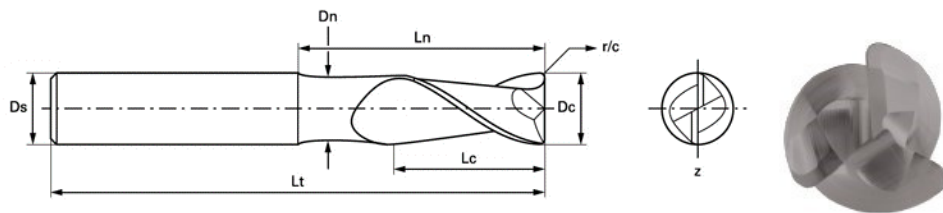
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



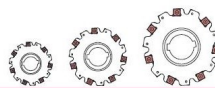
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12363	STF3A12020H06045R160.0	ST12396	STF3W12020H06045R160.0	12,0	12	20	60	11,0	110	1,60	3
ST12364	STF3A12020H06045R200.0	ST12397	STF3W12020H06045R200.0	12,0	12	20	60	11,0	110	2,00	3
ST12365	STF3A12020H06045R250.0	ST12398	STF3W12020H06045R250.0	12,0	12	20	60	11,0	110	2,50	3
ST12366	STF3A16027H08045R020.0	ST12399	STF3W16027H08045R020.0	16,0	16	27	80	15,0	130	0,20	3
ST12367	STF3A16027H08045R040.0	ST12400	STF3W16027H08045R040.0	16,0	16	27	80	15,0	130	0,40	3
ST12368	STF3A16027H08045R080.0	ST12401	STF3W16027H08045R080.0	16,0	16	27	80	15,0	130	0,80	3
ST12369	STF3A16027H08045R160.0	ST12402	STF3W16027H08045R160.0	16,0	16	27	80	15,0	130	1,60	3
ST12370	STF3A16027H08045R200.0	ST12403	STF3W16027H08045R200.0	16,0	16	27	80	15,0	130	2,00	3
ST12371	STF3A16027H08045R250.0	ST12404	STF3W16027H08045R250.0	16,0	16	27	80	15,0	130	2,50	3
ST12372	STF3A16027H08045R320.0	ST12405	STF3W16027H08045R320.0	16,0	16	27	80	15,0	130	3,20	3
ST12373	STF3A16027H08045R400.0	ST12406	STF3W16027H08045R400.0	16,0	16	27	80	15,0	130	4,00	3
ST12374	STF3A16027H08045R500.0	ST12407	STF3W16027H08045R500.0	16,0	16	27	80	15,0	130	5,00	3
ST12375	STF3A20033H10045R020.0	ST12408	STF3W20033H10045R020.0	20,0	20	33	100	19,0	152	0,20	3
ST12376	STF3A20033H10045R040.0	ST12409	STF3W20033H10045R040.0	20,0	20	33	100	19,0	152	0,40	3
ST12377	STF3A20033H10045R080.0	ST12410	STF3W20033H10045R080.0	20,0	20	33	100	19,0	152	0,80	3
ST12378	STF3A20033H10045R160.0	ST12411	STF3W20033H10045R160.0	20,0	20	33	100	19,0	152	1,60	3



Schnittwerte / vitesses de coupe

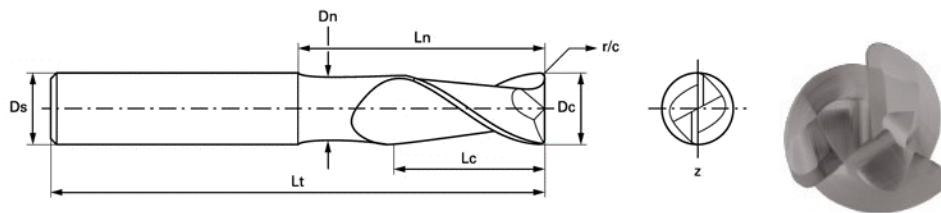
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



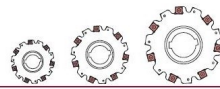
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12414	STF3A20033H10045R200.0	ST12429	STF3W20033H10045R200.0	20,0	20	33	100	19,0	152	2,00	3
ST12415	STF3A20033H10045R320.0	ST12430	STF3W20033H10045R320.0	20,0	20	33	100	19,0	152	3,20	3
ST12416	STF3A20033H10045R400.0	ST12431	STF3W20033H10045R400.0	20,0	20	33	100	19,0	152	4,00	3
ST12417	STF3A20033H10045R500.0	ST12432	STF3W20033H10045R500.0	20,0	20	33	100	19,0	152	5,00	3
ST12418	STF3A20033H10045R600.0	ST12433	STF3W20033H10045R600.0	20,0	20	33	100	19,0	152	6,00	3
ST12419	STF3A25042H12545R020.0	ST12434	STF3W25042H12545R020.0	25,0	25	42	125	24,0	185	0,20	3
ST12420	STF3A25042H12545R040.0	ST12435	STF3W25042H12545R040.0	25,0	25	42	125	24,0	185	0,40	3
ST12421	STF3A25042H12545R160.0	ST12436	STF3W25042H12545R160.0	25,0	25	42	125	24,0	185	1,60	3
ST12422	STF3A25042H12545R200.0	ST12437	STF3W25042H12545R200.0	25,0	25	42	125	24,0	185	2,00	3
ST12423	STF3A25042H12545R320.0	ST12438	STF3W25042H12545R320.0	25,0	25	42	125	24,0	185	3,20	3
ST12424	STF3A25042H12545R400.0	ST12439	STF3W25042H12545R400.0	25,0	25	42	125	24,0	185	4,00	3
ST12425	STF3A25042H12545R500.0	ST12440	STF3W25042H12545R500.0	25,0	25	42	125	24,0	185	5,00	3
ST12426	STF3A25042H12545R600.0	ST12441	STF3W25042H12545R600.0	25,0	25	42	125	24,0	185	6,00	3
ST12427	STF3A25042H12545R635.0	ST12442	STF3W25042H12545R635.0	25,0	25	42	125	24,0	185	6,35	3



Schnittwerte / vitesses de coupe

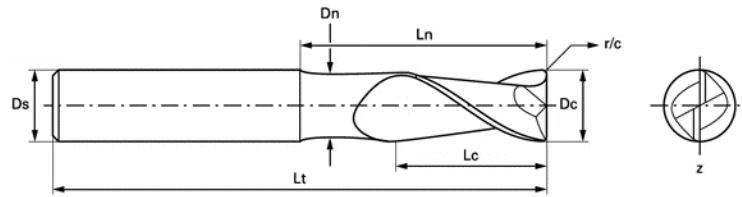
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	0,3*Dc	Lc	1*Dc	0,0100*Dc
	1°	5°	0,5*Dc	0,0075*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



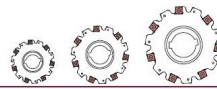
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12445	STF3A06015H01945R020.0	ST12455	STF3W06015H01945R020.0	6,0	6	15	19	5,7	57	0,2	3
ST12446	STF3A08021H02545R020.0	ST12456	STF3W08021H02545R020.0	8,0	8	21	25	7,6	63	0,2	3
ST12447	STF3A10024H03245R030.0	ST12457	STF3W10024H03245R030.0	10,0	10	24	32	9,5	72	0,3	3
ST12448	STF3A12028H03645R040.0	ST12458	STF3W12028H03645R040.0	12,0	12	28	36	11,5	83	0,4	3
ST12449	STF3A14030H03645R040.0	ST12459	STF3W14030H03645R040.0	14,0	14	30	36	13,5	83	0,4	3
ST12450	STF3A16035H04245R050.0	ST12460	STF3W16035H04245R050.0	16,0	16	35	42	15,5	92	0,5	3
ST12451	STF3A18038H04245R050.0	ST12461	STF3W18038H04245R050.0	18,0	18	38	42	17,5	92	0,5	3
ST12452	STF3A20042H05245R060.0	ST12462	STF3W20042H05245R060.0	20,0	20	42	52	19,5	104	0,6	3
ST12453	STF3A25050H06245R060.0	ST12463	STF3W25050H06245R060.0	25,0	25	50	62	24,0	120	0,6	3



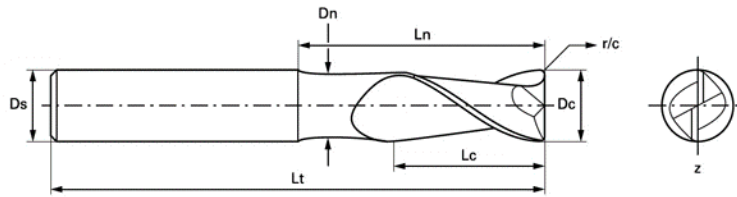
Schnittwerte / vitesses de coupe

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	0,3*Dc	Lc	1*Dc	0,0115*Dc
	1°	5°	0,5*Dc	0,0090*Dc

	N1	N2
Vc	350	300



VHM - Fräser N
Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12466	STF3A06007H02445R020.8	ST12476	STF3W06007H02445R020.8	6,0	6	7	24	5,4	62	0,2	3
ST12467	STF3A08009H03045R020.8	ST12477	STF3W08009H03045R020.8	8,0	8	9	30	7,2	68	0,2	3
ST12468	STF3A10011H03845R030.8	ST12478	STF3W10011H03845R030.8	10,0	10	11	38	9,0	80	0,3	3
ST12469	STF3A12013H04645R040.8	ST12479	STF3W12013H04645R040.8	12,0	12	13	46	11,0	93	0,4	3
ST12470	STF3A14015H04645R040.8	ST12480	STF3W14015H04645R040.8	14,0	14	15	46	13,0	93	0,4	3
ST12471	STF3A16017H05845R050.8	ST12481	STF3W16017H05845R050.8	16,0	16	17	58	15,0	108	0,5	3
ST12472	STF3A18019H05845R050.8	ST12482	STF3W18019H05845R050.8	18,0	18	19	58	17,0	108	0,5	3
ST12473	STF3A20021H07445R060.8	ST12483	STF3W20021H07445R060.8	20,0	20	21	74	19,0	126	0,6	3
ST12474	STF3A25026H09245R060.8	ST12484	STF3W25026H09245R060.8	25,0	25	26	92	24,0	150	0,6	3



Schnittwerte / vitesses de coupe

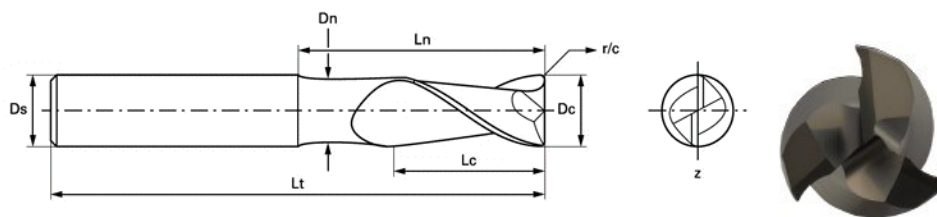
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	0,3*Dc	Lc	1*Dc	0,0115*Dc
	1°	5°	0,5*Dc	0,0090*Dc

	N1	N2
Vc	350	300



VHM - Fräser N

Fraise - MD N



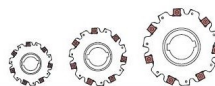
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12487	STF3A06015H01945R010IK.4	ST12497	STF3W06015H01945R010IK.4	6,0	6	15	19	5,7	57	0,1	3
ST12488	STF3A08021H02545R010IK.4	ST12498	STF3W08021H02545R010IK.4	8,0	8	21	25	7,6	63	0,1	3
ST12489	STF3A10024H03245R010IK.4	ST12499	STF3W10024H03245R010IK.4	10,0	10	24	32	9,5	72	0,1	3
ST12490	STF3A12028H03645R020IK.4	ST12500	STF3W12028H03645R020IK.4	12,0	12	28	36	11,5	83	0,2	3
ST12491	STF3A14030H03645R020IK.4	ST12501	STF3W14030H03645R020IK.4	14,0	14	30	36	13,5	83	0,2	3
ST12492	STF3A16035H04245R020IK.4	ST12502	STF3W16035H04245R020IK.4	16,0	16	35	42	15,5	92	0,2	3
ST12493	STF3A18038H04245R020IK.4	ST12503	STF3W18038H04245R020IK.4	18,0	18	38	42	17,5	92	0,2	3
ST12494	STF3A20042H05245R020IK.4	ST12504	STF3W20042H05245R020IK.4	20,0	20	42	52	19,5	104	0,2	3
ST12495	STF3A25050H06245R020IK.4	ST12505	STF3W25050H06245R020IK.4	25,0	25	50	62	24,0	120	0,2	3



Schnittwerte / vitesses de coupe

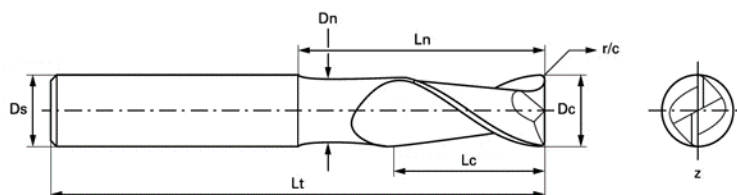
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	0,3*Dc	Lc	1*Dc	0,0130*Dc
	1°	5°	0,5*Dc	0,0100*Dc

	N1	N2
Vc	400	350



VHM - Fräser N

Fraise - MD N



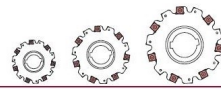
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12508	STF3A06007H02445R010IK.4	ST12518	STF3W06007H02445R010IK.4	6,0	6	7	24	5,4	62	0,1	3
ST12509	STF3A08009H03045R010IK.4	ST12519	STF3W08009H03045R010IK.4	8,0	8	9	30	7,2	68	0,1	3
ST12510	STF3A10011H03845R010IK.4	ST12520	STF3W10011H03845R010IK.4	10,0	10	11	38	9,0	80	0,1	3
ST12511	STF3A12013H04645R020IK.4	ST12521	STF3W12013H04645R020IK.4	12,0	12	13	46	11,0	93	0,2	3
ST12512	STF3A14015H04645R020IK.4	ST12522	STF3W14015H04645R020IK.4	14,0	14	15	46	13,0	93	0,2	3
ST12513	STF3A16017H05845R020IK.4	ST12523	STF3W16017H05845R020IK.4	16,0	16	17	58	15,0	108	0,2	3
ST12514	STF3A18019H05945R020IK.4	ST12524	STF3W18019H05945R020IK.4	18,0	18	19	59	17,0	108	0,2	3
ST12515	STF3A20021H07445R020IK.4	ST12525	STF3W20021H07445R020IK.4	20,0	20	21	74	19,0	126	0,2	3
ST12516	STF3A25026H09245R020IK.4	ST12526	STF3W25026H09245R020IK.4	25,0	25	26	92	24,0	150	0,2	3



Schnittwerte / vitesses de coupe

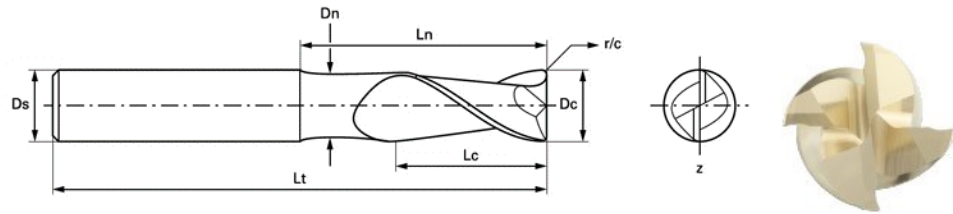
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	0,3*Dc	Lc	1*Dc	0,0130*Dc
	1°	5°	0,5*Dc	0,0100*Dc

	N1	N2
Vc	400	350



VHM - Fräser N

Fraise - MD N



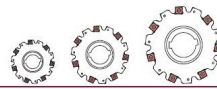
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12529	STF4A04012H01837R010.8	ST12538	STF4W04012H01837R010.8	4,0	6	12	18	3,8	62	0,1	4
ST12530	STF4A05015H02137R010.8	ST12539	STF4W05015H02137R010.8	5,0	6	15	21	4,8	62	0,1	4
ST12531	STF4A06018H02437R010.8	ST12540	STF4W06018H02437R010.8	6,0	6	18	24	5,7	62	0,1	4
ST12532	STF4A08024H03037R010.8	ST12541	STF4W08024H03037R010.8	8,0	8	24	30	7,6	68	0,1	4
ST12533	STF4A10030H03837R010.8	ST12542	STF4W10030H03837R010.8	10,0	10	30	38	9,5	80	0,1	4
ST12534	STF4A12036H04637R020.8	ST12543	STF4W12036H04637R020.8	12,0	12	36	46	11,5	93	0,2	4
ST12535	STF4A16048H05837R020.8	ST12544	STF4W16048H05837R020.8	16,0	16	48	58	15,5	108	0,2	4
ST12536	STF4A20060H07437R020.8	ST12545	STF4W20060H07437R020.8	20,0	20	60	74	19,5	126	0,2	4



Schnittwerte / vitesses de coupe

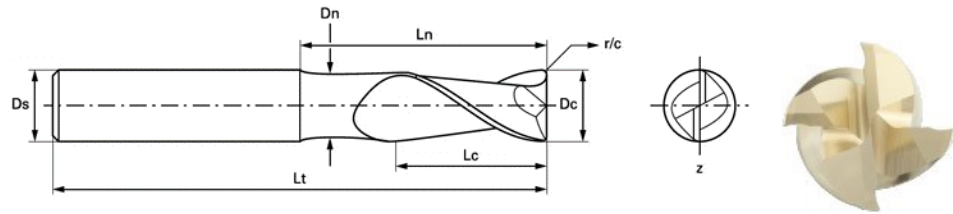
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	N1	N2
Vc	480	400



VHM - Fräser Trochoidal N

Fraise - MD Trochoidal N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12548	STF4A04016H02137R010.8	ST12557	STF4W04016H02137R010.8	4,0	6	16	21	3,8	62	0,1	4
ST12549	STF4A05020H02537R010.8	ST12558	STF4W05020H02537R010.8	5,0	6	20	25	4,8	70	0,1	4
ST12550	STF4A06024H03037R010.8	ST12559	STF4W06024H03037R010.8	6,0	6	24	30	5,7	70	0,1	4
ST12551	STF4A08032H03837R010.8	ST12560	STF4W08032H03837R010.8	8,0	8	32	38	7,6	80	0,1	4
ST12552	STF4A10040H04837R010.8	ST12561	STF4W10040H04837R010.8	10,0	10	40	48	9,5	90	0,1	4
ST12553	STF4A12048H05837R020.8	ST12562	STF4W12048H05837R020.8	12,0	12	48	58	11,5	110	0,2	4
ST12554	STF4A16064H07437R020.8	ST12563	STF4W16064H07437R020.8	16,0	16	64	74	15,5	130	0,2	4
ST12555	STF4A20080H09437R020.8	ST12564	STF4W20080H09437R020.8	20,0	20	80	94	19,5	150	0,2	4



Schnittwerte / vitesses de coupe

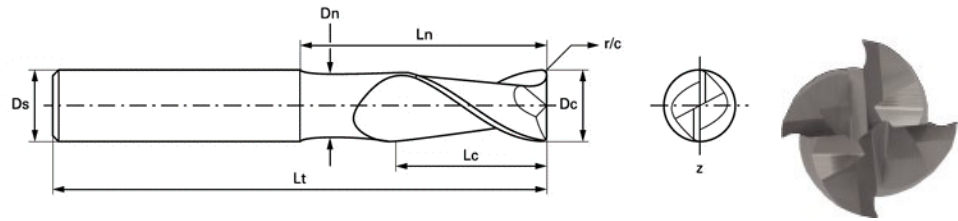
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	N1	N2
Vc	480	400



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12567	STF4A0401538C005.0	ST12576	STF4W0401538C005.0	4,0	6	15	-	-	62	0,05	4
ST12568	STF4A0501838C005.0	ST12577	STF4W0501838C005.0	5,0	6	18	-	-	62	0,05	4
ST12569	STF4A0601838C006.0	ST12578	STF4W0601838C006.0	6,0	6	18	-	-	62	0,06	4
ST12570	STF4A0802438C008.0	ST12579	STF4W0802438C008.0	8,0	8	24	-	-	68	0,08	4
ST12571	STF4A1003038C010.0	ST12580	STF4W1003038C010.0	10,0	10	30	-	-	80	0,10	4
ST12572	STF4A1203638C012.0	ST12581	STF4W1203638C012.0	12,0	12	36	-	-	93	0,12	4
ST12573	STF4A1604838C015.0	ST12582	STF4W1604838C015.0	16,0	16	48	-	-	108	0,15	4
ST12574	STF4A2006038C020.0	ST12583	STF4W2006038C020.0	20,0	20	60	-	-	126	0,20	4



Schnittwerte / vitesses de coupe

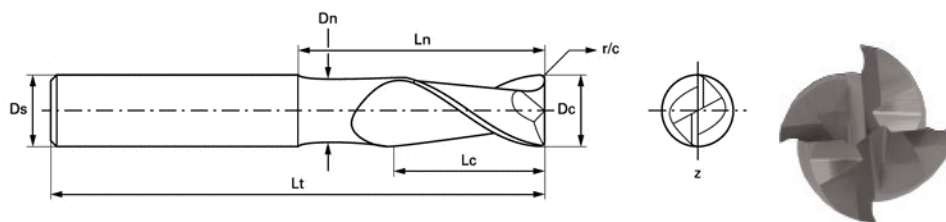
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	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



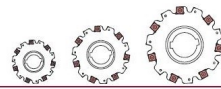
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12586	STF4A04016H02138R010.0	ST12595	STF4W04016H02138R010.0	4,0	6	16	21	3,8	62	0,1	4
ST12587	STF4A05020H02538R010.0	ST12596	STF4W05020H02538R010.0	5,0	6	20	25	4,8	70	0,1	4
ST12588	STF4A06024H03038R010.0	ST12597	STF4W06024H03038R010.0	6,0	6	24	30	5,7	70	0,1	4
ST12589	STF4A08032H03838R010.0	ST12598	STF4W08032H03838R010.0	8,0	8	32	38	7,6	80	0,1	4
ST12590	STF4A10040H04838R010.0	ST12599	STF4W10040H04838R010.0	10,0	10	40	48	9,5	90	0,1	4
ST12591	STF4A12048H05838R020.0	ST12600	STF4W12048H05838R020.0	12,0	12	48	58	11,5	110	0,2	4
ST12592	STF4A16064H07438R020.0	ST12601	STF4W16064H07438R020.0	16,0	16	64	74	15,5	130	0,2	4
ST12593	STF4A20080H09438R020.0	ST12602	STF4W20080H09438R020.0	20,0	20	80	94	19,5	150	0,2	4



Schnittwerte / vitesses de coupe

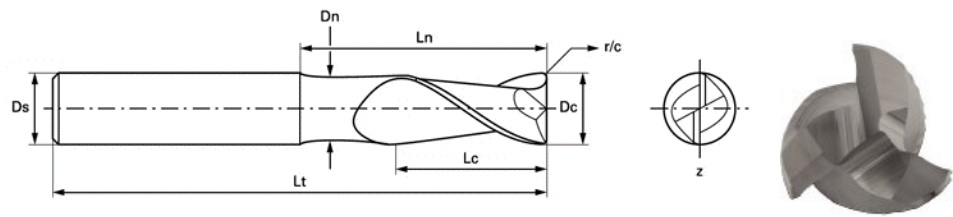
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	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12605	STF3A0601325C030S.0	ST12614	STF3W0601325C030S.0	6,0	6	13	-	-	57	0,3	3
ST12606	STF3A0801925C040S.0	ST12615	STF3W0801925C040S.0	8,0	8	19	-	-	63	0,4	3
ST12607	STF3A1002225C050S.0	ST12616	STF3W1002225C050S.0	10,0	10	22	-	-	72	0,5	3
ST12608	STF3A1202625C060S.0	ST12617	STF3W1202625C060S.0	12,0	12	26	-	-	83	0,6	3
ST12609	STF3A1402625C070S.0	ST12618	STF3W1402625C070S.0	14,0	14	26	-	-	83	0,7	3
ST12610	STF3A1603225C080S.0	ST12619	STF3W1603225C080S.0	16,0	16	32	-	-	92	0,8	3
ST12611	STF3A1803225C090S.0	ST12620	STF3W1803225C090S.0	18,0	18	32	-	-	92	0,9	3
ST12612	STF3A2003825C100S.0	ST12621	STF3W2003825C100S.0	20,0	20	38	-	-	104	1,0	3



Schnittwerte / vitesses de coupe

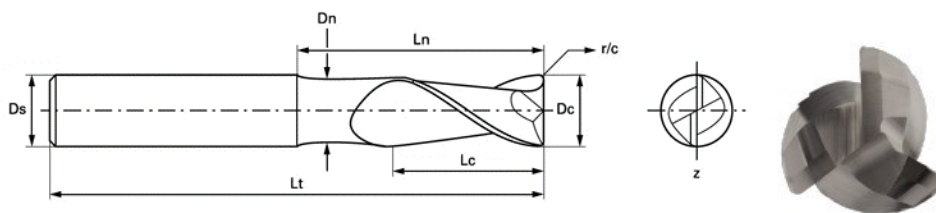
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	0,3*Dc	Lc	1*Dc	0,0075*Dc

	N1	N2
Vc	250	200



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12624	STF3A03007H01235R010.0	ST12657	STF3W03007H01235R010.0	3,0	6	7	12	2,7	54	0,10	3
ST12625	STF3A04009H01635R020.0	ST12658	STF3W04009H01635R020.0	4,0	6	9	16	3,6	57	0,20	3
ST12626	STF3A05011H02035R020.0	ST12659	STF3W05011H02035R020.0	5,0	6	11	20	4,5	62	0,20	3
ST12627	STF3A06014H02435R020.0	ST12660	STF3W06014H02435R020.0	6,0	6	14	24	5,4	70	0,20	3
ST12628	STF3A06014H02435R040.0	ST12661	STF3W06014H02435R040.0	6,0	6	14	24	5,4	70	0,40	3
ST12629	STF3A06014H02435R080.0	ST12662	STF3W06014H02435R080.0	6,0	6	14	24	5,4	70	0,80	3
ST12630	STF3A08018H03235R020.0	ST12663	STF3W08018H03235R020.0	8,0	8	18	32	7,2	80	0,20	3
ST12631	STF3A08018H03235R040.0	ST12664	STF3W08018H03235R040.0	8,0	8	18	32	7,2	80	0,40	3
ST12632	STF3A08018H03235R080.0	ST12665	STF3W08018H03235R080.0	8,0	8	18	32	7,2	80	0,80	3
ST12633	STF3A10022H04035R020.0	ST12666	STF3W10022H04035R020.0	10,0	10	22	40	9,0	90	0,20	3
ST12634	STF3A10022H04035R040.0	ST12667	STF3W10022H04035R040.0	10,0	10	22	40	9,0	90	0,40	3
ST12635	STF3A10022H04035R080.0	ST12668	STF3W10022H04035R080.0	10,0	10	22	40	9,0	90	0,80	3
ST12636	STF3A10022H04035R160.0	ST12669	STF3W10022H04035R160.0	10,0	10	22	40	9,0	90	1,60	3
ST12637	STF3A12027H04835R020.0	ST12670	STF3W12027H04835R020.0	12,0	12	27	48	11,0	110	0,20	3
ST12638	STF3A12027H04835R040.0	ST12671	STF3W12027H04835R040.0	12,0	12	27	48	11,0	110	0,40	3
ST12639	STF3A12027H04835R080.0	ST12672	STF3W12027H04835R080.0	12,0	12	27	48	11,0	110	0,80	3
ST12640	STF3A12027H04835R160.0	ST12673	STF3W12027H04835R160.0	12,0	12	27	48	11,0	110	1,60	3
ST12641	STF3A12027H04835R200.0	ST12674	STF3W12027H04835R200.0	12,0	12	27	48	11,0	110	2,00	3
ST12642	STF3A12027H04835R250.0	ST12675	STF3W12027H04835R250.0	12,0	12	27	48	11,0	110	2,50	3



Schnittwerte / vitesses de coupe

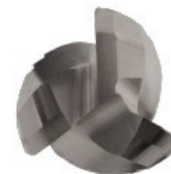
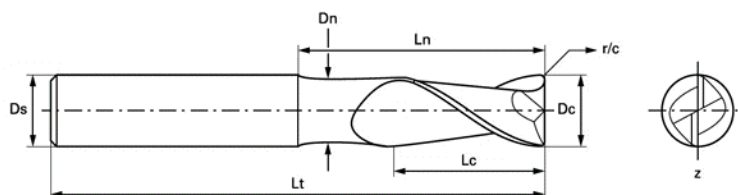
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	0,3*Dc	Lc	1*Dc	0,0100*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



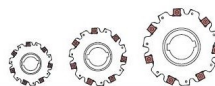
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12643	STF3A16036H06435R020.0	ST12676	STF3W16036H06435R020.0	16,0	16	36	64	15,0	130	0,20	3
ST12644	STF3A16036H06435R040.0	ST12677	STF3W16036H06435R040.0	16,0	16	36	64	15,0	130	0,40	3
ST12645	STF3A16036H06435R080.0	ST12678	STF3W16036H06435R080.0	16,0	16	36	64	15,0	130	0,80	3
ST12646	STF3A16036H06435R160.0	ST12679	STF3W16036H06435R160.0	16,0	16	36	64	15,0	130	1,60	3
ST12647	STF3A16036H06435R200.0	ST12680	STF3W16036H06435R200.0	16,0	16	36	64	15,0	130	2,00	3
ST12648	STF3A16036H06435R250.0	ST12681	STF3W16036H06435R250.0	16,0	16	36	64	15,0	130	2,50	3
ST12649	STF3A16036H06435R320.0	ST12682	STF3W16036H06435R320.0	16,0	16	36	64	15,0	130	3,20	3
ST12650	STF3A16036H06435R400.0	ST12683	STF3W16036H06435R400.0	16,0	16	36	64	15,0	130	4,00	3
ST12651	STF3A16036H06435R500.0	ST12684	STF3W16036H06435R500.0	16,0	16	36	64	15,0	130	5,00	3
ST12652	STF3A20044H08035R020.0	ST12685	STF3W20044H08035R020.0	20,0	20	44	80	19,0	150	0,20	3
ST12653	STF3A20044H08035R040.0	ST12686	STF3W20044H08035R040.0	20,0	20	44	80	19,0	150	0,40	3
ST12654	STF3A20044H08035R080.0	ST12687	STF3W20044H08035R080.0	20,0	20	44	80	19,0	150	0,80	3
ST12655	STF3A20044H08035R160.0	ST12688	STF3W20044H08035R160.0	20,0	20	44	80	19,0	150	1,60	3



Schnittwerte / vitesses de coupe

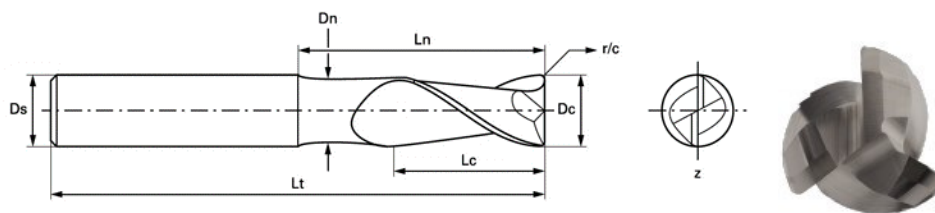
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	0,3*Dc	Lc	1*Dc	0,0100*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12691	STF3A20044H08035R200.0	ST12706	STF3W20044H08035R200.0	20,0	20	44	80	19,0	150	2,00	3
ST12692	STF3A20044H08035R320.0	ST12707	STF3W20044H08035R320.0	20,0	20	44	80	19,0	150	3,20	3
ST12693	STF3A20044H08035R400.0	ST12708	STF3W20044H08035R400.0	20,0	20	44	80	19,0	150	4,00	3
ST12694	STF3A20044H08035R500.0	ST12709	STF3W20044H08035R500.0	20,0	20	44	80	19,0	150	5,00	3
ST12695	STF3A20044H08035R600.0	ST12710	STF3W20044H08035R600.0	20,0	20	44	80	19,0	150	6,00	3
ST12696	STF3A25055H10035R020.0	ST12711	STF3W25055H10035R020.0	25,0	25	55	100	24,0	185	0,20	3
ST12697	STF3A25055H10035R040.0	ST12712	STF3W25055H10035R040.0	25,0	25	55	100	24,0	185	0,40	3
ST12698	STF3A25055H10035R160.0	ST12713	STF3W25055H10035R160.0	25,0	25	55	100	24,0	185	1,60	3
ST12699	STF3A25055H10035R200.0	ST12714	STF3W25055H10035R200.0	25,0	25	55	100	24,0	185	2,00	3
ST12700	STF3A25055H10035R320.0	ST12715	STF3W25055H10035R320.0	25,0	25	55	100	24,0	185	3,20	3
ST12701	STF3A25055H10035R400.0	ST12716	STF3W25055H10035R400.0	25,0	25	55	100	24,0	185	4,00	3
ST12702	STF3A25055H10035R500.0	ST12717	STF3W25055H10035R500.0	25,0	25	55	100	24,0	185	5,00	3
ST12703	STF3A25055H10035R600.0	ST12718	STF3W25055H10035R600.0	25,0	25	55	100	24,0	185	6,00	3
ST12704	STF3A25055H10035R635.0	ST12719	STF3W25055H10035R635.0	25,0	25	55	100	24,0	185	6,35	3



Schnittwerte / vitesses de coupe

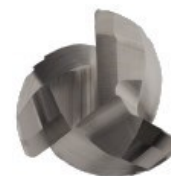
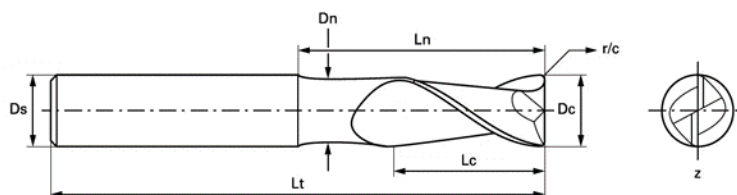
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	0,3*Dc	Lc	1*Dc	0,0100*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12722	STF3A03005H01535R010.0	ST12755	STF3W03005H01535R010.0	3,0	6	5	15	2,7	54	0,10	3
ST12723	STF3A04007H02035R020.0	ST12756	STF3W04007H02035R020.0	4,0	6	7	20	3,6	57	0,20	3
ST12724	STF3A05009H02535R020.0	ST12757	STF3W05009H02535R020.0	5,0	6	9	25	4,5	62	0,20	3
ST12725	STF3A06010H03035R020.0	ST12758	STF3W06010H03035R020.0	6,0	6	10	30	5,4	70	0,20	3
ST12726	STF3A06010H03035R040.0	ST12759	STF3W06010H03035R040.0	6,0	6	10	30	5,4	70	0,40	3
ST12727	STF3A06010H03035R080.0	ST12760	STF3W06010H03035R080.0	6,0	6	10	30	5,4	70	0,80	3
ST12728	STF3A08014H04035R020.0	ST12761	STF3W08014H04035R020.0	8,0	8	14	40	7,2	80	0,20	3
ST12729	STF3A08014H04035R040.0	ST12762	STF3W08014H04035R040.0	8,0	8	14	40	7,2	80	0,40	3
ST12730	STF3A08014H04035R080.0	ST12763	STF3W08014H04035R080.0	8,0	8	14	40	7,2	80	0,80	3
ST12731	STF3A10017H05035R020.0	ST12764	STF3W10017H05035R020.0	10,0	10	17	50	9,0	90	0,20	3
ST12732	STF3A10017H05035R040.0	ST12765	STF3W10017H05035R040.0	10,0	10	17	50	9,0	90	0,40	3
ST12733	STF3A10017H05035R080.0	ST12766	STF3W10017H05035R080.0	10,0	10	17	50	9,0	90	0,80	3
ST12734	STF3A10017H05035R160.0	ST12767	STF3W10017H05035R160.0	10,0	10	17	50	9,0	90	1,60	3
ST12735	STF3A12020H06035R020.0	ST12768	STF3W12020H06035R020.0	12,0	12	20	60	11,0	110	0,20	3
ST12736	STF3A12020H06035R040.0	ST12769	STF3W12020H06035R040.0	12,0	12	20	60	11,0	110	0,40	3
ST12737	STF3A12020H06035R080.0	ST12770	STF3W12020H06035R080.0	12,0	12	20	60	11,0	110	0,80	3
ST12738	STF3A12020H06035R160.0	ST12771	STF3W12020H06035R160.0	12,0	12	20	60	11,0	110	1,60	3
ST12739	STF3A12020H06035R200.0	ST12772	STF3W12020H06035R200.0	12,0	12	20	60	11,0	110	2,00	3
ST12740	STF3A12020H06035R250.0	ST12773	STF3W12020H06035R250.0	12,0	12	20	60	11,0	110	2,50	3



Schnittwerte / vitesses de coupe

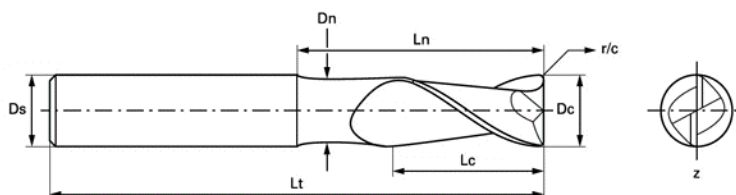
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	0,3*Dc	Lc	1*Dc	0,0100*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12741	STF3A16027H08035R020.0	ST12774	STF3W16027H08035R020.0	16,0	16	27	80	15,0	130	0,20	3
ST12742	STF3A16027H08035R040.0	ST12775	STF3W16027H08035R040.0	16,0	16	27	80	15,0	130	0,40	3
ST12743	STF3A16027H08035R080.0	ST12776	STF3W16027H08035R080.0	16,0	16	27	80	15,0	130	0,80	3
ST12744	STF3A16027H08035R160.0	ST12777	STF3W16027H08035R160.0	16,0	16	27	80	15,0	130	1,60	3
ST12745	STF3A16027H08035R200.0	ST12778	STF3W16027H08035R200.0	16,0	16	27	80	15,0	130	2,00	3
ST12746	STF3A16027H08035R250.0	ST12779	STF3W16027H08035R250.0	16,0	16	27	80	15,0	130	2,50	3
ST12747	STF3A16027H08035R320.0	ST12780	STF3W16027H08035R320.0	16,0	16	27	80	15,0	130	3,20	3
ST12748	STF3A16027H08035R400.0	ST12781	STF3W16027H08035R400.0	16,0	16	27	80	15,0	130	4,00	3
ST12749	STF3A16027H08035R500.0	ST12782	STF3W16027H08035R500.0	16,0	16	27	80	15,0	130	5,00	3
ST12750	STF3A20033H10035R020.0	ST12783	STF3W20033H10035R020.0	20,0	20	33	100	19,0	150	0,20	3
ST12751	STF3A20033H10035R040.0	ST12784	STF3W20033H10035R040.0	20,0	20	33	100	19,0	150	0,40	3
ST12752	STF3A20033H10035R080.0	ST12785	STF3W20033H10035R080.0	20,0	20	33	100	19,0	150	0,80	3
ST12753	STF3A20033H10035R160.0	ST12786	STF3W20033H10035R160.0	20,0	20	33	100	19,0	150	1,60	3



Schnittwerte / vitesses de coupe

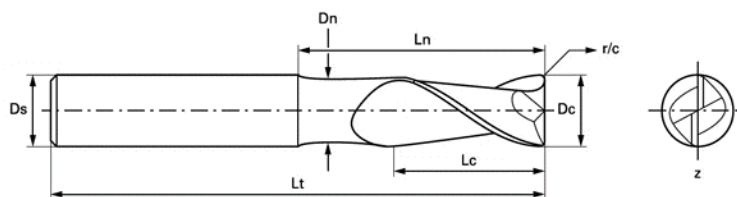
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	0,3*Dc	Lc	1*Dc	0,0100*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12789	STF3A20033H10035R200.0	ST12804	STF3W20033H10035R200.0	20,0	20	33	100	19,0	150	2,00	3
ST12790	STF3A20033H10035R320.0	ST12805	STF3W20033H10035R320.0	20,0	20	33	100	19,0	150	3,20	3
ST12791	STF3A20033H10035R400.0	ST12806	STF3W20033H10035R400.0	20,0	20	33	100	19,0	150	4,00	3
ST12792	STF3A20033H10035R500.0	ST12807	STF3W20033H10035R500.0	20,0	20	33	100	19,0	150	5,00	3
ST12793	STF3A20033H10035R600.0	ST12808	STF3W20033H10035R600.0	20,0	20	33	100	19,0	150	6,00	3
ST12794	STF3A25042H12535R020.0	ST12809	STF3W25042H12535R020.0	25,0	25	42	125	24,0	185	0,20	3
ST12795	STF3A25042H12535R040.0	ST12810	STF3W25042H12535R040.0	25,0	25	42	125	24,0	185	0,40	3
ST12796	STF3A25042H12535R160.0	ST12811	STF3W25042H12535R160.0	25,0	25	42	125	24,0	185	1,60	3
ST12797	STF3A25042H12535R200.0	ST12812	STF3W25042H12535R200.0	25,0	25	42	125	24,0	185	2,00	3
ST12798	STF3A25042H12535R320.0	ST12813	STF3W25042H12535R320.0	25,0	25	42	125	24,0	185	3,20	3
ST12799	STF3A25042H12535R400.0	ST12814	STF3W25042H12535R400.0	25,0	25	42	125	24,0	185	4,00	3
ST12800	STF3A25042H12535R500.0	ST12815	STF3W25042H12535R500.0	25,0	25	42	125	24,0	185	5,00	3
ST12801	STF3A25042H12535R600.0	ST12816	STF3W25042H12535R600.0	25,0	25	42	125	24,0	185	6,00	3
ST12802	STF3A25042H12535R635.0	ST12817	STF3W25042H12535R635.0	25,0	25	42	125	24,0	185	6,35	3



Schnittwerte / vitesses de coupe

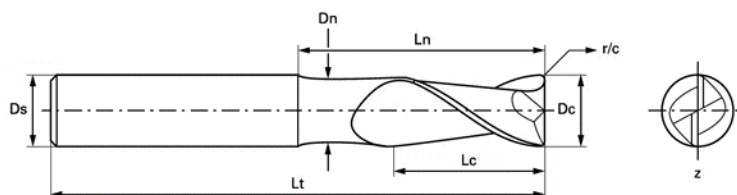
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	0,3*Dc	Lc	1*Dc	0,0100*Dc

	N1	N2
Vc	300	250



VHM - Fräser N

Fraise - MD N



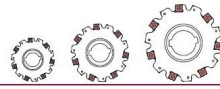
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST12820	STF3A06013H01935C030.8	ST12830	STF3W06013H01935C030.8	6,0	6	13	19	5,7	57	0,30	3
ST12821	STF3A08019H02535C040.8	ST12831	STF3W08019H02535C040.8	8,0	8	19	25	7,6	63	0,40	3
ST12822	STF3A10023H03235C050.8	ST12832	STF3W10023H03235C050.8	10,0	10	23	32	9,5	72	0,50	3
ST12823	STF3A12028H03635C060.8	ST12833	STF3W12028H03635C060.8	12,0	12	28	36	11,5	83	0,60	3
ST12824	STF3A14028H03635C070.8	ST12834	STF3W14028H03635C070.8	14,0	14	28	36	13,5	83	0,70	3
ST12825	STF3A16034H04235C080.8	ST12835	STF3W16034H04235C080.8	16,0	16	34	42	15,5	92	0,80	3
ST12826	STF3A18034H04235C090.8	ST12836	STF3W18034H04235C090.8	18,0	18	34	42	17,5	92	0,90	3
ST12827	STF3A20042H05235C100.8	ST12837	STF3W20042H05235C100.8	20,0	20	42	52	19,5	104	1,00	3
ST12828	STF3A25052H06235C125.8	ST12838	STF3W25052H06235C125.8	25,0	25	52	62	24,0	120	1,25	3



Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
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	0,3*Dc	Lc	1*Dc	0,0115*Dc

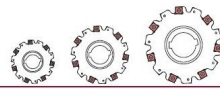
	N1	N2
Vc	350	300



VHM - Fräser **Gehärtete Stähle**
Fraise - MD **Aciers trempés**

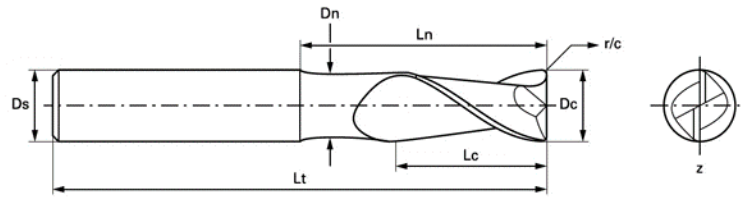
40 **Jahre** Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità





VHM - Fräser H

Fraise - MD H



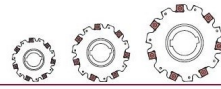
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11417	STF4A03004H00910R075.7	-	-	3,0	6	4	9	2,7	50	0,75	4
ST11418	STF4A04005H01310R100.7	-	-	4,0	6	5	13	3,6	54	1,00	4
ST11419	STF4A06007H01710R150.7	-	-	6,0	6	7	17	5,4	54	1,50	4
ST11420	STF4A08009H02210R200.7	-	-	8,0	8	9	22	7,2	58	2,00	4
ST11421	STF4A10011H02610R200.7	-	-	10,0	10	11	26	9,0	66	2,00	4
ST11422	STF4A12013H02810R300.7	-	-	12,0	12	13	28	11,0	73	3,00	4



Schnittwerte / vitesses de coupe

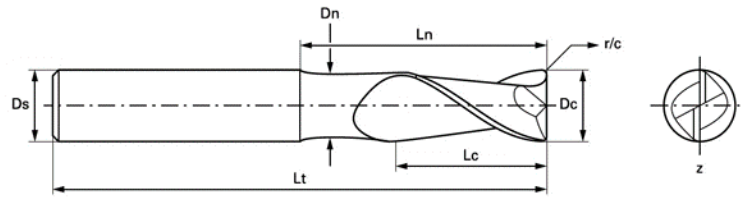
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	[min]	[max]	[max]	
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	170	150	100	-	-



VHM - Fräser H

Fraise - MD H



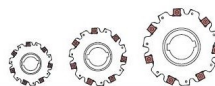
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11425	STF4A03004H01110R075.7	-	-	3,0	6	4	11	2,7	57	0,75	4
ST11426	STF4A04005H01610R100.7	-	-	4,0	6	5	16	3,6	57	1,00	4
ST11427	STF4A06007H02410R150.7	-	-	6,0	6	7	24	5,4	62	1,50	4
ST11428	STF4A08009H03010R200.7	-	-	8,0	8	9	30	7,2	68	2,00	4
ST11429	STF4A10011H03810R200.7	-	-	10,0	10	11	38	9,0	80	2,00	4
ST11430	STF4A12013H04610R300.7	-	-	12,0	12	13	46	11,0	93	3,00	4



Schnittwerte / vitesses de coupe

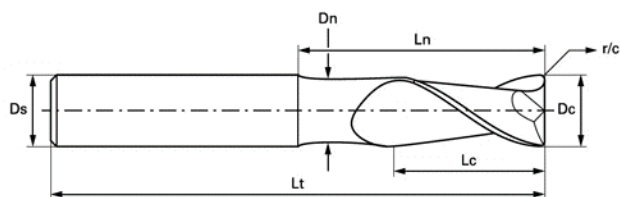
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	170	150	100	-	-



VHM - Fräser H

Fraise - MD H



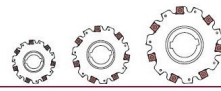
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11433	STF4A03004H00930R030.7	-	-	3,0	6	4	9	2,8	50	0,3	4
ST11434	STF4A04005H01330R050.7	-	-	4,0	6	5	13	3,8	54	0,5	4
ST11435	STF4A05006H01630R050.7	-	-	5,0	6	6	16	4,8	54	0,5	4
ST11436	STF4A06007H01730R050.7	-	-	6,0	6	7	17	5,7	54	0,5	4
ST11437	STF4A06007H01730R100.7	-	-	6,0	6	7	17	5,7	54	1,0	4
ST11438	STF4A08009H02130R050.7	-	-	8,0	8	9	21	7,6	58	0,5	4
ST11439	STF4A08009H02130R100.7	-	-	8,0	8	9	21	7,6	58	1,0	4
ST11440	STF4A10011H02530R050.7	-	-	10,0	10	11	25	9,5	66	0,5	4
ST11441	STF4A10011H02530R100.7	-	-	10,0	10	11	25	9,5	66	1,0	4
ST11442	STF4A12013H02730R050.7	-	-	12,0	12	13	27	11,5	73	0,5	4
ST11443	STF4A12013H02730R100.7	-	-	12,0	12	13	27	11,5	73	1,0	4



Schnittwerte / vitesses de coupe

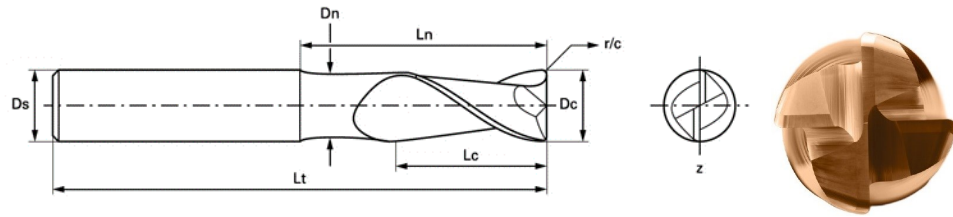
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	0,3*Dc	Lc	0,5*Dc	0,0140*Dc
	0,3*Dc	Lc	1*Dc	0,0120*Dc
	1°	5°	0,5*Dc	0,0100*Dc
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	170	150	100	-	-



VHM - Fräser H

Fraise - MD H



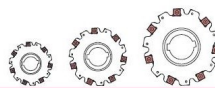
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11446	STF4A03004H01530R030.7	-	-	3,0	6	4	15	2,8	57	0,3	4
ST11447	STF4A04005H01630R050.7	-	-	4,0	6	5	16	3,8	57	0,5	4
ST11448	STF4A05006H02030R050.7	-	-	5,0	6	6	20	4,8	57	0,5	4
ST11449	STF4A06007H02430R050.7	-	-	6,0	6	7	24	5,7	62	0,5	4
ST11450	STF4A06007H02430R100.7	-	-	6,0	6	7	24	5,7	62	1,0	4
ST11451	STF4A08009H03030R050.7	-	-	8,0	8	9	30	7,6	68	0,5	4
ST11452	STF4A08009H03030R100.7	-	-	8,0	8	9	30	7,6	68	1,0	4
ST11453	STF4A10011H03830R050.7	-	-	10,0	10	11	38	9,5	80	0,5	4
ST11454	STF4A10011H03830R100.7	-	-	10,0	10	11	38	9,5	80	1,0	4
ST11455	STF4A12013H04630R050.7	-	-	12,0	12	13	46	11,5	93	0,5	4
ST11456	STF4A12013H04630R100.7	-	-	12,0	12	13	46	11,5	93	1,0	4



Schnittwerte / vitesses de coupe

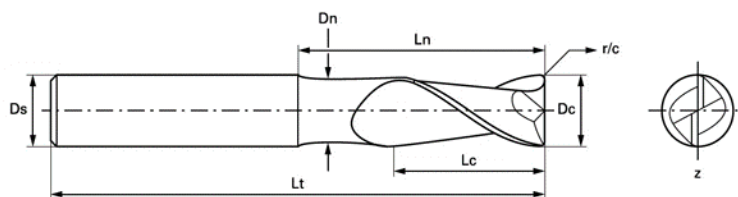
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	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0140*Dc
	0,3*Dc	Lc	1*Dc	0,0120*Dc
	1°	5°	0,5*Dc	0,0100*Dc
	0,01*Dc	0,06*Dc	Dc - (2*r)	0,0300*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	170	150	100	-	-



VHM - Fräser H

Fraise - MD H



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11459	STF6A03008H01450R030.7	-	-	3,0	6	8	14	2,8	57	0,3	6
ST11460	STF6A04011H01650R030.7	-	-	4,0	6	11	16	3,8	57	0,3	6
ST11461	STF6A05013H01850R030.7	-	-	5,0	6	13	18	4,8	57	0,3	6
ST11462	STF6A06013H01950R050.7	-	-	6,0	6	13	19	5,7	57	0,5	6
ST11463	STF6A08019H02550R050.7	-	-	8,0	8	19	25	7,6	63	0,5	6
ST11464	STF6A10022H03050R100.7	-	-	10,0	10	22	30	9,5	72	1,0	6
ST11465	STF6A12026H03650R100.7	-	-	12,0	12	26	36	11,5	83	1,0	6
ST11466	STF8A16032H04250R100.7	-	-	16,0	16	32	42	15,5	92	1,0	8
ST11467	STF10A20038H05250R200.7	-	-	20,0	20	38	52	19,5	104	2,0	10



Schnittwerte / vitesses de coupe

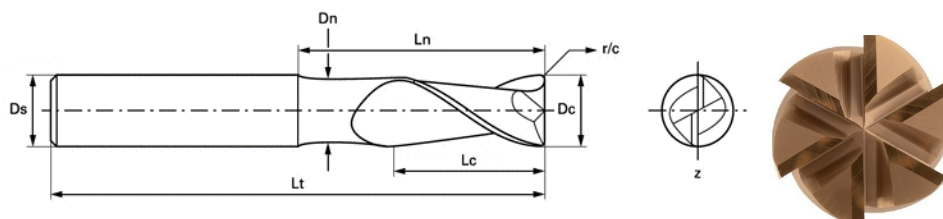
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	0,3*Dc	Lc	0,2*Dc	0,0100*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	220	190	160	-	-



VHM - Fräser H

Fraise - MD H



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	c	Z
ST11470	STF6A0601850C010.7	-	-	6,0	6	18	-	-	62	0,10	6
ST11471	STF6A0802450C010.7	-	-	8,0	8	24	-	-	68	0,10	6
ST11472	STF6A1003050C010.7	-	-	10,0	10	30	-	-	80	0,10	6
ST11473	STF6A1203650C015.7	-	-	12,0	12	36	-	-	93	0,15	6
ST11474	STF8A1604850C015.7	-	-	16,0	16	48	-	-	108	0,15	8
ST11475	STF10A2006050C015.7	-	-	20,0	20	60	-	-	126	0,15	10



Schnittwerte / vitesses de coupe

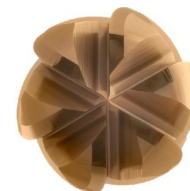
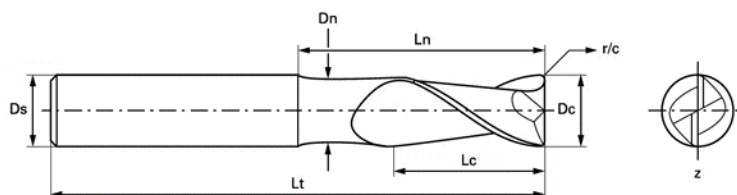
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,2*Dc	0,0100*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	220	190	160	-	-



VHM - Fräser H

Fraise - MD H



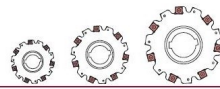
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11478	STF6A06007H02450R030.7	-	-	6,0	6	7	24	5,4	62	0,3	6
ST11479	STF6A06007H02450R050.7	-	-	6,0	6	7	24	5,4	62	0,5	6
ST11480	STF6A06007H02450R100.7	-	-	6,0	6	7	24	5,4	62	1,0	6
ST11481	STF6A08009H03050R030.7	-	-	8,0	8	9	30	7,2	68	0,3	6
ST11482	STF6A08009H03050R050.7	-	-	8,0	8	9	30	7,2	68	0,5	6
ST11483	STF6A08009H03050R100.7	-	-	8,0	8	9	30	7,2	68	1,0	6
ST11484	STF6A10011H03850R030.7	-	-	10,0	10	11	38	9,0	80	0,3	6
ST11485	STF6A10011H03850R050.7	-	-	10,0	10	11	38	9,0	80	0,5	6
ST11486	STF6A10011H03850R100.7	-	-	10,0	10	11	38	9,0	80	1,0	6
ST11487	STF6A10011H03850R200.7	-	-	10,0	10	11	38	9,0	80	2,0	6
ST11488	STF6A12013H04650R030.7	-	-	12,0	12	13	46	11,0	93	0,3	6
ST11489	STF6A12013H04650R050.7	-	-	12,0	12	13	46	11,0	93	0,5	6
ST11490	STF6A12013H04650R100.7	-	-	12,0	12	13	46	11,0	93	1,0	6
ST11491	STF6A12013H04650R200.7	-	-	12,0	12	13	46	11,0	93	2,0	6
ST11492	STF8A16017H05850R100.7	-	-	16,0	16	17	58	15,0	108	1,0	8
ST11493	STF8A16017H05850R200.7	-	-	16,0	16	17	58	15,0	108	2,0	8
ST11494	STF10A20021H07050R100.7	-	-	20,0	20	21	70	19,0	126	1,0	10
ST11495	STF10A20021H07050R200.7	-	-	20,0	20	21	70	19,0	126	2,0	10



Schnittwerte / vitesses de coupe

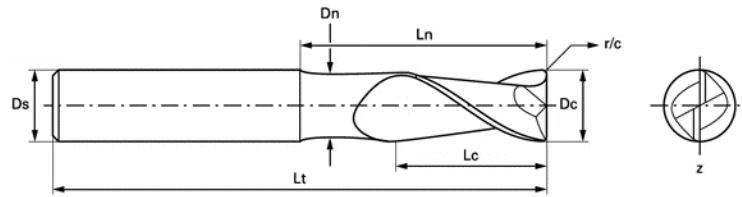
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	0,3*Dc	Lc	0,2*Dc	0,0100*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	220	190	160	-	-



VHM - Fräser H

Fraise - MD H



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11504	STF2A03004H00915R150.7	-	-	3,0	6	4	9	2,8	50	1,5	2
ST11505	STF2A04005H01315R200.7	-	-	4,0	6	5	13	3,8	54	2,0	2
ST11506	STF2A05006H01615R250.7	-	-	5,0	6	6	16	4,8	54	2,5	2
ST11507	STF2A06007H01715R300.7	-	-	6,0	6	7	17	5,7	54	3,0	2
ST11508	STF2A08009H02115R400.7	-	-	8,0	8	9	21	7,6	58	4,0	2
ST11509	STF2A10011H02515R500.7	-	-	10,0	10	11	25	9,5	66	5,0	2
ST11510	STF2A12013H02715R600.7	-	-	12,0	12	13	27	11,5	73	6,0	2



Schnittwerte / vitesses de coupe

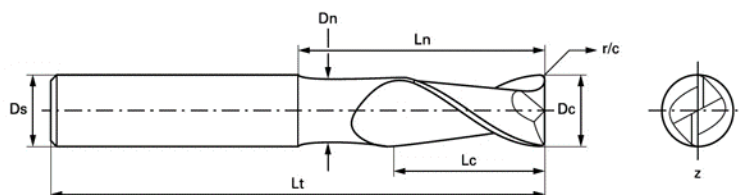
	Ap	Ap	Ae	fz
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	0,02*Dc	0,5+Dc	0,5*Dc	0,0200*Dc

	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	280	280	225	-	-



VHM - Fräser H

Fraise - MD H



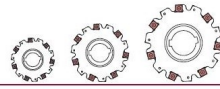
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST11513	STF2A03004H01515R150.7	-	-	3,0	6	4	15	2,8	57	1,5	2
ST11514	STF2A04005H01615R200.7	-	-	4,0	6	5	16	3,8	57	2,0	2
ST11515	STF2A05006H02015R250.7	-	-	5,0	6	6	20	4,8	57	2,5	2
ST11516	STF2A06007H02415R300.7	-	-	6,0	6	7	24	5,7	62	3,0	2
ST11517	STF2A08009H03015R400.7	-	-	8,0	8	9	30	7,6	68	4,0	2
ST11518	STF2A10011H03815R500.7	-	-	10,0	10	11	38	9,5	80	5,0	2
ST11519	STF2A12013H04615R600.7	-	-	12,0	12	13	46	11,5	93	6,0	2



Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,02*Dc	0,5+Dc	0,5*Dc	0,0200*Dc

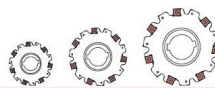
	P1	P2	P3	H1	H2	H3	K1	K2
Vc	-	-	-	280	280	225	-	-



VHM - Fräser Graphit
Fraise - MD Graphite

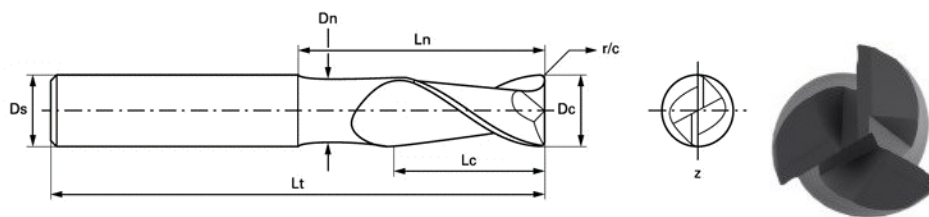
40 Jahre Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità





VHM - Fräser **G**

Fraise - MD **G**



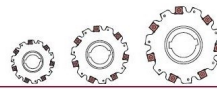
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12841	STF3A03010H01440R010.9	-	-	3,0	3	10	14	2,7	57	0,1	3
ST12842	STF3A04013H01640R020.9	-	-	4,0	4	13	16	3,6	57	0,2	3
ST12843	STF3A05015H01840R020.9	-	-	5,0	5	15	18	4,5	57	0,2	3
ST12844	STF3A06015H01940R030.9	-	-	6,0	6	15	19	5,0	57	0,3	3
ST12845	STF3A08021H02540R030.9	-	-	8,0	8	21	25	7,0	63	0,3	3
ST12846	STF3A10024H03040R030.9	-	-	10,0	10	24	30	9,0	72	0,3	3
ST12847	STF3A12028H03640R030.9	-	-	12,0	12	28	36	11,0	83	0,3	3



Schnittwerte / vitesses de coupe

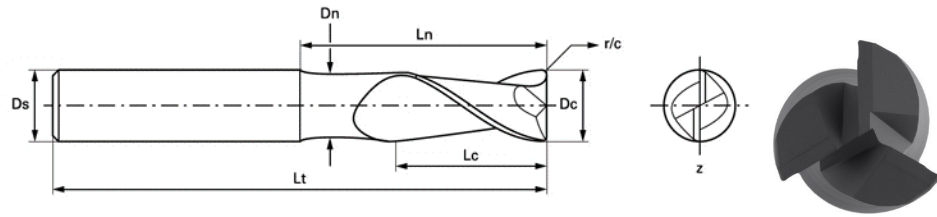
	Ap	Ap	Ae	fz
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	0,3*Dc	Lc	0,5*Dc	0,0120*Dc
	0,3*Dc	Lc	1*Dc	0,0100*Dc

	G
Vc	500



VHM - Fräser G

Fraise - MD G



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12850	STF3A03004H01140R010.9	-	-	3,0	3	4	11	2,7	62	0,1	3
ST12851	STF3A04005H01540R020.9	-	-	4,0	4	5	15	3,6	62	0,2	3
ST12852	STF3A05006H02340R020.9	-	-	5,0	5	6	23	4,5	62	0,2	3
ST12853	STF3A06007H02440R030.9	-	-	6,0	6	7	24	5,0	62	0,3	3
ST12854	STF3A08009H03040R030.9	-	-	8,0	8	9	30	7,0	68	0,3	3
ST12855	STF3A10011H03840R030.9	-	-	10,0	10	11	38	9,0	80	0,3	3
ST12856	STF3A12013H04640R030.9	-	-	12,0	12	13	46	11,0	93	0,3	3



Schnittwerte / vitesses de coupe

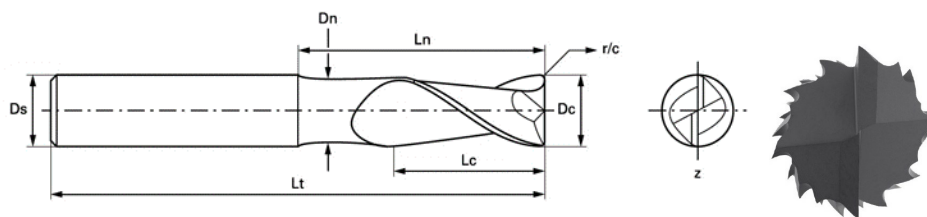
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	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0120*Dc
	0,3*Dc	Lc	1*Dc	0,0100*Dc

	G
Vc	500



VHM - Fräser **G**

Fraise - MD **G**



Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r/c	Z
ST12859	STF2A0300925S.9	-	-	3,0	3	9	-	-	62	-	2
ST12860	STF2A0401225S.9	-	-	4,0	4	12	-	-	62	-	2
ST12861	STF2A0501525S.9	-	-	5,0	5	15	-	-	62	-	2
ST12862	STF2A0601825S.9	-	-	6,0	6	18	-	-	62	-	2
ST12863	STF2A0802425S.9	-	-	8,0	8	24	-	-	68	-	2
ST12864	STF2A1003025S.9	-	-	10,0	10	30	-	-	80	-	2
ST12865	STF2A1203625S.9	-	-	12,0	12	36	-	-	93	-	2
ST12866	STF2A1604825S.9	-	-	16,0	16	48	-	-	108	-	2



Schnittwerte / vitesses de coupe

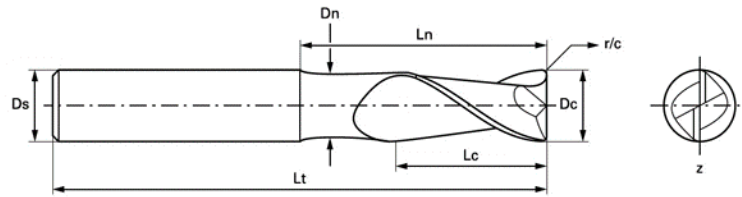
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,3*Dc	Lc	0,5*Dc	0,0310*Dc
	0,3*Dc	Lc	1*Dc	0,0240*Dc

	G
Vc	500



VHM - Fräser G

Fraise - MD G



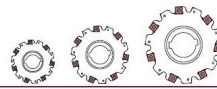
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12869	STF3A02003H00840R100.9	-	-	2,0	3	3	8	1,8	50	1,0	3
ST12870	STF3A03004H01040R150.9	-	-	3,0	3	4	10	2,7	50	1,5	3
ST12871	STF3A04005H01340R200.9	-	-	4,0	4	5	13	3,6	54	2,0	3
ST12872	STF3A05006H01640R250.9	-	-	5,0	5	6	16	4,5	54	2,5	3
ST12873	STF3A06007H01740R300.9	-	-	6,0	6	7	17	5,0	54	3,0	3
ST12874	STF3A08009H02240R400.9	-	-	8,0	8	9	22	7,0	58	4,0	3
ST12875	STF3A10011H02640R500.9	-	-	10,0	10	11	26	9,0	66	5,0	3
ST12876	STF3A12013H02840R600.9	-	-	12,0	12	13	28	11,0	73	6,0	3



Schnittwerte / vitesses de coupe

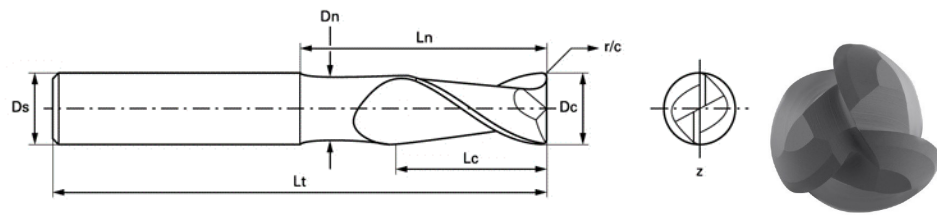
	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,02*Dc	0,5*Dc	0,5*Dc	0,0120*Dc

	G
Vc	500



VHM - Fräser G

Fraise - MD G



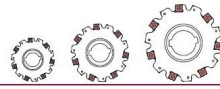
Artikel-Nr. No.-Article	Artikel / Article DIN6535 HA	Artikel-Nr. No.-Article	Artikel / Article DIN6535 HB	Dc	Ds	Lc	Ln	Dn	Lt	r	Z
ST12879	STF3A02003H00940R100.9	-	-	2,0	6	3	9	1,8	62	1,0	3
ST12880	STF3A03004H01140R150.9	-	-	3,0	6	4	11	2,7	62	1,5	3
ST12881	STF3A04005H01540R200.9	-	-	4,0	6	5	15	3,6	62	2,0	3
ST12882	STF3A05006H02340R250.9	-	-	5,0	6	6	23	4,5	80	2,5	3
ST12883	STF3A06007H02440R300.9	-	-	6,0	6	7	24	5,0	80	3,0	3
ST12884	STF3A08009H03040R400.9	-	-	8,0	8	9	30	7,0	90	4,0	3
ST12885	STF3A10011H03840R500.9	-	-	10,0	10	11	38	9,0	100	5,0	3
ST12886	STF3A12013H04640R600.9	-	-	12,0	12	13	46	11,0	120	6,0	3



Schnittwerte / vitesses de coupe

	Ap	Ap	Ae	fz
	[min]	[max]	[max]	
	0,02*Dc	0,5*Dc	0,5*Dc	0,0120*Dc

	G
Vc	500

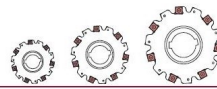


Technischer Anhang

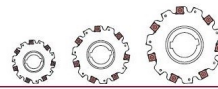
Annexe Technique

40 **Jahre** Kompetenz und Qualität
ans compétence et qualité
anni competenza e qualità

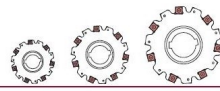










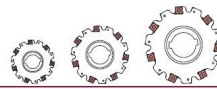
	Werkstoffgruppen	groupes de matières
ISO-P	Werkzeuge zur Bearbeitung von Stählen	Outils pour usinage de l'acier
P1	Unlegierter Stahl	Aciers non alliés
P2	Legierter Stahl	Aciers alliés
P3	Hochlegierter Stahl und Werkzeug stahl	Aciers fortement alliés et aciers à outils
ISO-H	Werkzeuge zur Bearbeitung von gehärteten Stählen	Outils pour usinage des aciers trempés
H1	Gehärtete Stähle < 54 HRC	Aciers trempés < 54 HRC
H2	Gehärtete Stähle < 54-60 HRC	Aciers trempés < 54-60 HRC
H3	Gehärtete Stähle HRC > 60	Aciers trempés HRC > 60
ISO-K	Werkzeuge zur Bearbeitung von Gusseisen	Outils pour usinage des fontes
K1	Grauguss	Fontes grises
K2	Sphäroguss	Fontes nodulaires
ISO-M	Werkzeuge zur Bearbeitung von Edelstahl	Outils pour usinagedes Inoxydables
M1	Aust. Und Ferr. rostfreie Stähle	Aciers Inoxydables Austénitiques et Ferritiques
M2	Mart. rostfreie Stähle	Inoxydables Martensitiques
ISO-S	Werkzeuge zur Bearbeitung von hitzebeständiger Materialien	Outils pour usinage des matières haute résistance
S1	Warmfeste Leg. Fe, Ni und Co-basiert	Alliages hautetempérature Fe, Ni et Co
S2	Titan und Titanlegierungen	Titane et Alliagesde Titane
ISO-N	Werkzeuge zur Bearbeitung von Nichteisenwerkstoffen	Outils pour usinagedes non ferreux
N1	Nichteisenmetalle (Al,Cu, Zi, Plastik, usw.)	Matériaux non ferreux (Al, Cu, Zi, plastic, etc.)
N2	Nichteisenlegierungen (Al >9% Si, legierter Kunststoff, usw.)	Alliages non ferreux(Al > 9% Si, alliagesplastic, etc..)
ISO-G	Werkzeuge zur Bearbeitung von Graphit	Outils pour usinagedes graphites
G1	Graphit	Graphite



	Symbolbeschreibung	Description de l'icône
	Drallwinkel	Angle d'Hélice
	Beschichtung	Revêtement
	90° Stirn Ausführung	Arête vive 90°
	Eckenfase	Chanfrein d'angle
	Entgratfräser	Fraise à ébavurer
	Eckenradius	Rayon d'angle
	Viertelkreisfräser	Fraise 1/4 de cercle
	Vollradiusfräser	Fraise boule
	Schrupfräser	Fraise d'ébauche
	mit Zentrumschnitt	Coupe au centre
	ohne Zentrumschnitt	Sans coupe au centre
	Gleich verteilt	Coupe frontale symétrique
	Ungleich verteilt	Coupe frontale décalée
	Vorschubrichtung	Sens de l'avance
	Öl-Kühlung	Lubrification à l'huile
	Luft-Kühlung	Refroidissement par air
	Minimalschmierung	Lubrification d'huile brouillard
	Innenkühlung	Trous d'huile
	Toleranz Schneiden Durchmesser	Tolerancede coupe diametre
	HPC-Fräser	Fraise HPC
	Schrupfräser	Fraise d'ébauche



	Symbolbeschreibung	Description de l'icône
	Umfangfräsen	Fraisage périphérique
	Vollnutfräsen	Rainurage
	Schräg eintauchen	Fraisage en pente
	3D-fräsen	Fraisage 3D
	Auskammern (Hochvorschubfräsen)	Fraisage de poches
	Trochoidal fräsen	Fraisage Trochoïdal



Schnittwerte für Trochoidalfräsen vitesses de coupe pour fraise Trochoidal

	Material	Matière	vc m/min
M1	Aust. Und Ferr. Rostfreie Stähle	Aciers Inoxydables Austénitiques et Ferritiques	190
M2	Mart. rostfreie Stähle	Inoxydables Martensitiques	170
S2	Titan und Titanlegierungen	Titane et Alliages de Titane	130
P1	Unlegierter Stahl	Aciers non alliés	300
P2	Legierter Stahl	Aciers alliés	250
P3	Hochlegierter Stahl und Werkzeug Stahl	Aciers fortement alliés et aciers à outils	210
N1	Nichteisenmetalle (Al, Cu, Zi, Plastik, usw.)	Matériaux non ferreux (Al, Cu, Zi, plastic, etc.)	480
N2	Nichteisenlegierungen (Al >9% Si, legierter Kunststoff, usw.)	Alliages non ferreux (Al >9% Si, alliages plastic, etc.)	400

Ap [min]	Ap [max]	Ae	hm
0,3*Dc	Lc	0,03*Dc - 0,09*Dc	0,0030*Dc
Ap [min]	Ap [max]	Ae	hm
0,3*Dc	Lc	0,03*Dc - 0,09*Dc	0,0030*Dc

Ap [min]	Ap [max]	Ae	hm
0,3*Dc	Lc	0,05*Dc - 0,15*Dc	0,0046*Dc
Ap [min]	Ap [max]	Ae	hm
0,3*Dc	Lc	0,10*Dc - 0, 20*Dc	0,0100 *Dc

Berechnen der mittleren Spandicke (hm)
für VHM-Fräser.

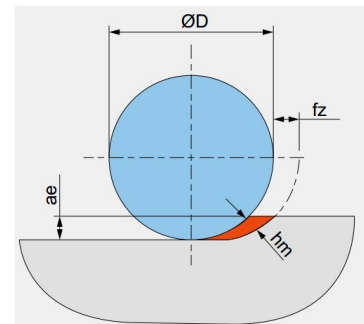
$$hm = 0.0030 \times DC$$

Calculer l'épaisseur moyenne de copeau (hm)
pour les fraises monobloc

Ae = seitliche Eingriffsbreite

Ae = Largeur de passe

$$Ae = 0.06 \times DC$$



Berechnen der mittleren Spandicke (hm)

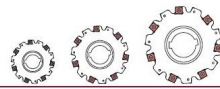
Calculer l'épaisseur moyenne de copeau (hm)

$$fz = hm \times \sqrt{\frac{D}{ae}}$$

Berechnungsbeispiel		Exemple de calcul	
Fräser typ:	STBLW5X16042VN	Fraise type:	STBLW5X16042VN
Fräserdurchmesser:	16	Diamètre de fraise:	16
Zähnezahl:	5	Nombre de dents:	5
Schnitttiefe Ap:	40	Profondeur de coupe Ap:	40

Berechnung von hm für VHM-Fräser Calcul de hm pour fraise MD	$0.003 \times 16 = 0.048$
Berechnung von Ae Calcul du Ae	$0.06 \times 16 = 0.96$
Berechnung von fz Calcul de fz	$fz = 0.048 \times \sqrt{\frac{16}{0.96}} = 0.19$
Berechnung der Drehzahl: Vitesse de rotation:	$n = \frac{170 \times 1000}{16 \times \pi} = 3382 \text{ min}^{-1}$

Schnittgeschwindigkeit Vitesse de coupe	170
Durchmesser Diamètre de fraise	16
Zähnezahl Nombre de dents	5
fz	0.19
Drehzahl Tours	3382
Vorschub Avance	3213



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