

Präziser Schulterfräser für die allgemeine Bearbeitung

Wavemill WEZ Serie

Der optimierte Universalfräser





■ Allgemeine Eigenschaften

- Ermöglicht die unterschiedlichsten Bearbeitungen

Geeignet für verschiedene Zerspanungsaufgaben. Die Fräserserie umfasst die Durchmesserbereiche von Ø 14 mm bis Ø 160 mm und erlaubt einen großen Eintauchwinkel.

- Sehr hohe Bearbeitungsqualität

Mit einer Kombination aus optimierter Schneidenform und hochpräziser Formgebungstechnologie werden sehr gute, rechtwinklige Schulterflächen und Oberflächenqualitäten erreicht.

- Hervorragende Schärfe mit reduzierten Schnittkräften

Geringere Bearbeitungsgeräusche und reduzierte Gratbildung. Das Portfolio beinhaltet geschliffene Fräsplatten mit besonderer Schärfe.

- Neue, universell einsetzbare Sorte

Die neue Universalsorte ACU2500 ermöglicht ein breites Anwendungsspektrum bei der Bearbeitung von Stahl, Edelstahl und Gusseisen.

■ Produktpalette WEZ (Standard)

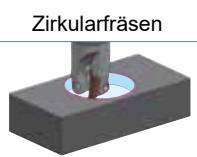
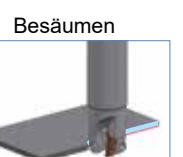
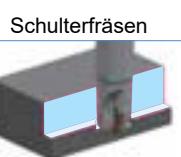
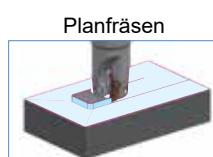
| Fräser- typ | Bezeichnung | Durchmesserbereich (mm) / Anzahl Zähne | | | | | | | | | | | | | | | | | |
|---------------------|-------------------|--|-----|-----|--------|-----|-----------|------|------|---------|-------------|------|------------|--------|--------|-------|-------|----------|----------|
| | | Ø14 | Ø16 | Ø18 | Ø20 | Ø22 | Ø25 | Ø26 | Ø28 | Ø30 | Ø32 | Ø35 | Ø40 | Ø50 | Ø63 | Ø80 | Ø100 | Ø125 | Ø160 |
| Aufsteck- fräser | WEZ 11000RS | | | | | | | | | | | | 4, 6 | 5, 7 | 6, 8 | 7, 10 | 9, 12 | | |
| | WEZ 11000R (Inch) | | | | | | | | | | | | | | | 7, 10 | 9, 12 | | |
| | WEZ 17000RS | | | | | | | | | | | | 3, 4 | 3, 5 | 4, 6 | 4, 7 | 5, 8 | 6, 9, 11 | 8, 10 12 |
| | WEZ 17000R (Inch) | | | | | | | | | | | | | | | 4, 7 | 5, 8 | 6, 9, 11 | 8, 10 12 |
| Schafffräser | WEZ 11000E | 1 | 2* | 2 | 2*, 3* | 3 | 2, 3*, 4* | | 4 | 4 | 2, 3, 4, 5* | 5 | 2, 4, 6 | 5, 7 | 8 | 10 | | | |
| | WEZ 11000ES | 1 | 2* | | 3* | | 4* | | | | | | | | | | | | |
| | WEZ 11000EL | 1 | 2* | 2 | 2* | 2 | 2*, 3 | | 2 | 2 | 2*, 3 | 2, 3 | 2 | 3 | | | | | |
| | WEZ 17000E | | | | | | 2* | | 2 | 3 | 2, 3* | 3 | 3, 4 | 3*, 5* | 4*, 6* | 7 | | | |
| | WEZ 17000ES | | | | | | 2 | | | | 3 | | | | | | | | |
| | WEZ 17000EL | | | | | | 2 | | 2 | 2 | 2*, 3 | 2 | 2, 3, 4 | 3*, 5* | 4*, 6* | | | | |
| Modu- lar | WEZ 11000M | | 2 | 2 | 2, 3 | 3 | 2, 3, 4 | 4, 5 | 4, 5 | 2, 4, 5 | 2, 3, 4, 5 | 2, 5 | 2, 4, 5, 6 | | | | | | |
| | WEZ 17000M | | | | | | 2, 3 | | 2 | 2, 3 | 2, 3, 4 | 2, 3 | 2, 3, 4 | | | | | | |

* Verschiedene Schaftdurchmesser auf Lager

■ Produktpalette WEZR (Walzenstirnfräser)

| Fräser- typ | Bezeichnung | Durchmesserbereich (mm) / Anzahl Zähne | | | | | | | | |
|---------------------|--------------|--|-----|-----|------|-----|------|---------|---------|-----|
| | | Ø20 | Ø25 | Ø30 | Ø32 | Ø35 | Ø40 | Ø50 | Ø63 | Ø80 |
| Aufsteck- fräser | WEZR 11000RS | | | | | | | 4 | 4 | |
| | WEZR 17000RS | | | | | | | 2, 3, 4 | 3, 4, 5 | 5 |
| Schafffräser | WEZR 11000E | 1,2 | 2 | 2 | 2, 3 | 3 | 3, 4 | | | |
| | WEZR 17000E | | | | | | 2, 3 | 2, 3 | | |
| Modu- lar | WEZR 11000M | | | | | 3 | | | | |
| | WEZR 17000M | | | | | | 3 | | | |

■ Vielseitige Anwendungen



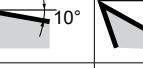
■ Optimiertes Design

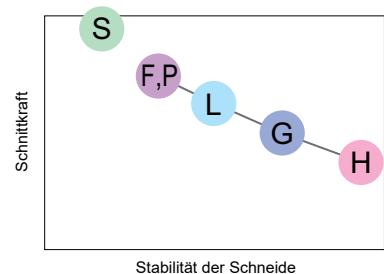
Breite Führungsflächen für eine stabile Schneidplattenspannung.



WEZ11-Typ

Spanbrechergeometrien

| Material | P | M | K | S | H | N |
|-----------------------------------|---|---|---|---|--|---|
| Spanbrecher-geometrie | L-Typ | G-Typ | H-Typ | F-Typ | P-Typ | S-Typ |
| AO_T11 Schneidkanten-geometrie | |  |  |  |  |  |
| AO_T17 Schneidkanten-geometrie |  |  |  |  |  |  |
| Anwendung | Leichte Bearbeitung, Fräsen in labilen Verhältnissen | Hauptspanbrecher, allgemeines Fräsen, unterbrochene Schnitte | Schwerer Schnitt, stark unterbrochene Bearbeitung, vergüteter Stahl | Leichte Bearbeitung, Schlichten, reduzierte Gratbildung | Leichte Bearbeitung, hochpräzise, erhöhte Schultergenauigkeit | Nichteisenmetalle |



Fräsplattenübersicht

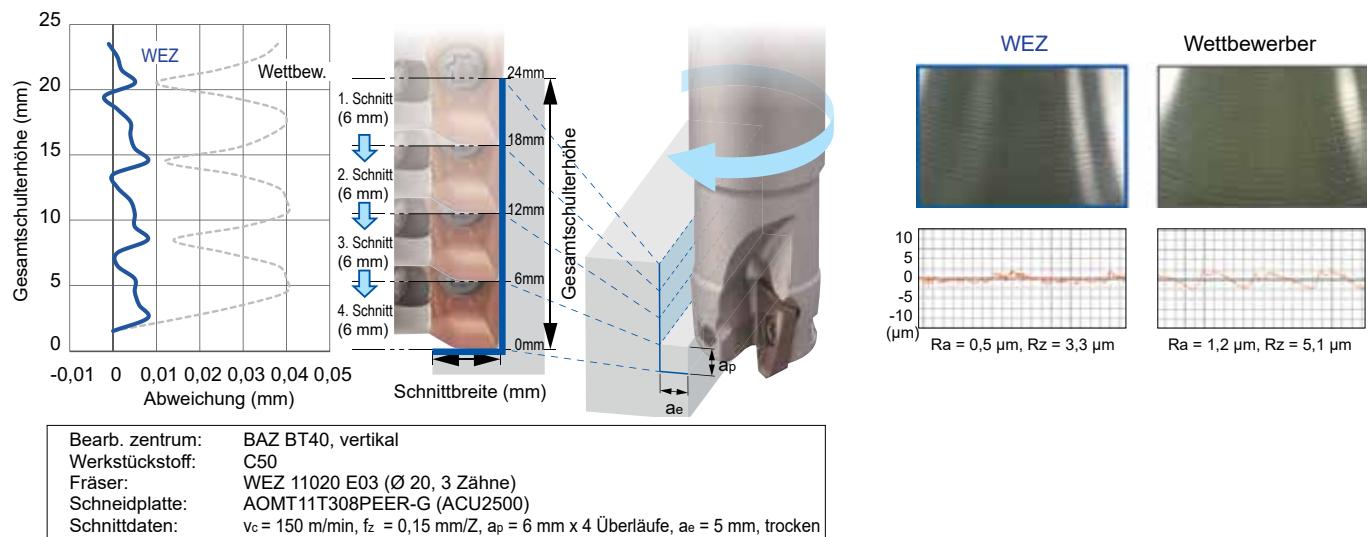
Universalsorte: ACU2500; S-Typ: H20, DL2000

| Bezeichnung | Eckenradius (mm) | | | | | | | | | | | | | |
|--------------------|------------------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | R0,2 | R0,4 | R0,5 | R0,8 | R1,0 | R1,2 | R1,6 | R2,0 | R2,4 | R3,0 | R3,2 | R4,0 | R5,0 | R6,4 |
| AOMT 11T3 PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| AOMT 11T3 PEER-H | | ● | | | ● | | | | | | | | | |
| AOET 11T3 PEER-F | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| AOET 11T3 PEER-P16 | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| AOET 11T3 PEER-P20 | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| AOET 11T3 PEER-P25 | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| AOET 11T3 PEFR-S | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| AOMT 1705 PEER-L | ● | ● | | | ● | | | ● | ● | | | | | |
| AOMT 1705 PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| AOMT 1705 PEER-H | | ● | ● | | ● | | ● | | ● | | ● | | | |
| AOET 1705 PEER-F | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| AOET 1705 PEER-P25 | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| AOET 1705 PEER-P32 | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |
| AOET 1705 PEFR-S | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● |

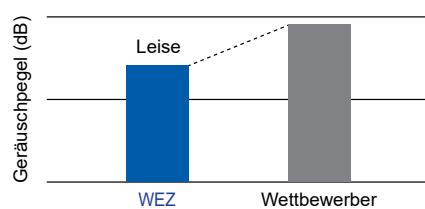
Verbesserte Fräsqualität

- Ausgezeichnete Rechtwinkligkeit

- Hervorragende Oberflächenqualität



- Geringere Schnittkraft trägt zur Reduzierung der Bearbeitungsgeräusche bei



| | |
|-----------------|---|
| Bearb. zentrum: | BAZ BT40, vertikal |
| Werkstückstoff: | C50 |
| Fräser: | WEZ 11020 E03 (Ø 20, 3 Zähne) |
| Schneidplatte: | AOMT11T308PEER-G (ACU2500) |
| Schnittdaten: | $v_c = 150$ m/min, $f_z = 0,15$ mm/Z, $a_p = 8$ mm, $a_e = 5$ mm, trocken |



■ Eigenschaften

Entwickelt für Multi-Tasking-Maschinen

Der kurze Schafttyp ist ideal für den Einsatz in Multi-Tasking-Maschinen mit geringer Steifigkeit.

Höchste Bearbeitungsqualität

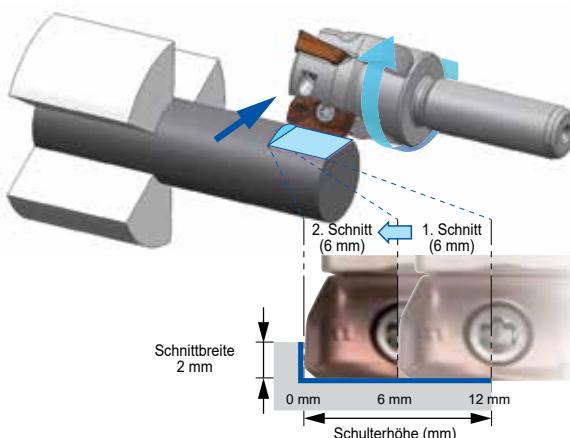
Das Schaftdesign ist ideal für ER-Spannzangen mit Stirnflächenkontakt, wodurch die Steifigkeit erhöht und eine hervorragende Schultergenauigkeit und Oberflächengüte erreicht wird.

Große Auswahl an Schneidplatten

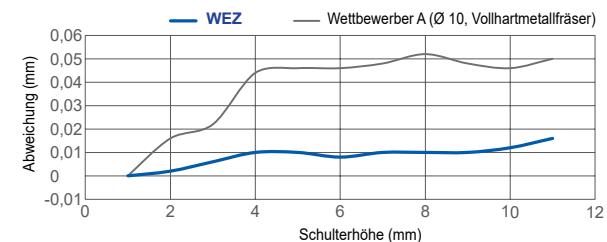
Für die unterschiedlichsten Anwendungen steht eine große Auswahl an Spanbrechern mit scharfen Schneiden, unterschiedlichen Eckenradien und speziellen Sorten für bestimmte Werkstoffe zur Verfügung.

■ Schnittleistung

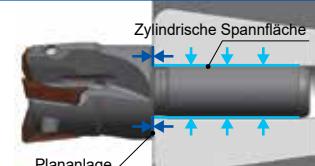
● Hervorragende Rechtwinkligkeit



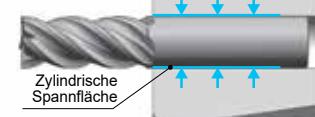
Maschine: NC-Drehmaschine
Werkstückstoff: X5CrNiS1810, Ø 16 Rundstab
Fräser: WEZ11020ES03-10 (Ø 20, 3 Zähne)
Schneidplatte: AOET11T308PEER-F (ACU2500)
Schnittdaten: $v_c = 100 \text{ m/min}$, $f_z = 0,08 \text{ mm/Z}$
 $a_p = 6 \text{ mm} \times 2$ Überläufe, $a_e = 2 \text{ mm}$, nass



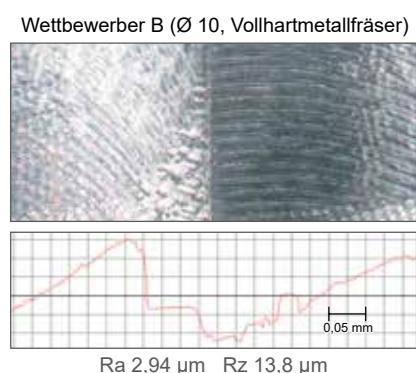
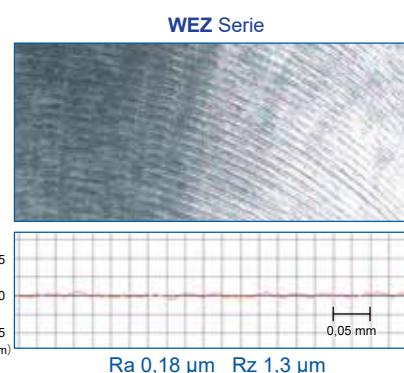
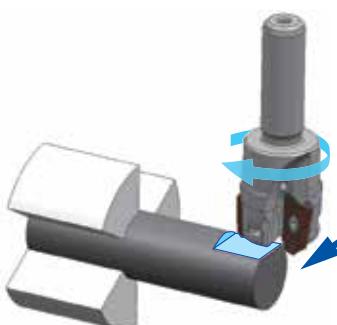
WEZ-Serie
Hohe Steifigkeit
durch
Plananlage



Vollhartmetall-
fräser



● Ausgezeichnete Oberflächengüte



Maschine: NC-Drehmaschine
Werkstückstoff: X5CrNiS1810, Ø 16 Rundstab
Fräser: WEZ11020ES03-10 (Ø 20, 3 Zähne)
Schneidplatte: AOET11T308PEER-F (ACU2500)
Schnittdaten: WEZ: $v_c = 100 \text{ m/min}$, $f_z = 0,05 \text{ mm/Z}$, $a_p = 2 \text{ mm}$, $a_e = 12 \text{ mm}$, nass
Wettbewerber: $v_c = 100 \text{ m/min}$, $f_z = 0,05 \text{ mm/Z}$, $a_p = 2 \text{ mm}$, $a_e = 6 \text{ mm} \times 2$ Überläufe, nass, (Vollhartmetallfräser)

Der größere Werkzeugdurchmesser als beim Vollhartmetallfräser ermöglicht eine verringerte Anzahl von Überläufen für eine hoch effiziente Bearbeitung.

Gute Schultergenauigkeit und bearbeitete Oberflächenqualität, so dass der Schlichtprozess entfallen kann.

■ Auswahlhilfe für Schulterfräswerkzeuge

TSX Serie – Genaugkeit

Geschliffene Schneidplattenanlage



Oberflächengüte

WEZ Serie – Hohe Schärfe

Stark wellenförmige Schneide



Schultergenauigkeit

Schnittkraft

Schneidkantenfestigkeit

Spankontrolle

Anzahl Schneidkanten



DFC Serie – Wirtschaftlich

Dreieckige doppelseitige Schneidplatte

WFX Serie – Allgemeine Anwendung

Quadratische einseitige Schneidplatte

★★★ Erste Empfehlung

| | Oberflächengüte | Schultergenauigkeit | Schnittkraft | Spankontrolle | Anzahl der Ecken | Schneidkantenfestigkeit |
|-----------|-----------------|---------------------|--------------|---------------|------------------|-------------------------|
| WEZ-Serie | ★★★ | ★★★ | ★★★ | ★★★ | ★ | ★★ |
| TSX-Serie | ★★★ | ★★★ | ★★ | ★★ | ★★ | ★★★ |
| DFC-Serie | ★★ | ★ | ★ | ★★ | ★★★ | ★★★ |
| WFX-Serie | ★★ | ★★ | ★★ | ★★★ | ★★ | ★★ |

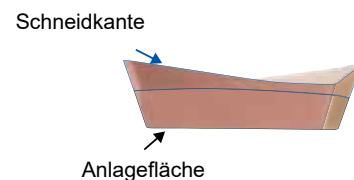
"WaveMill" Serie

WEZ - Typ

■ Geschliffene Präzisionsschneidplatten mit sehr hoher Schärfe

Geschliffene Schneidkante und Anlageflächen

Die Anlageflächen und die Schneidkante sind geschliffen, um die Präzision im eingebauten Zustand weiter zu verbessern. Somit wird eine erhöhte Qualität beim Planlauf und der bearbeiteten Oberfläche garantiert.



■ Spanleitstufen für geschliffene Schneidplatten

F-Typ

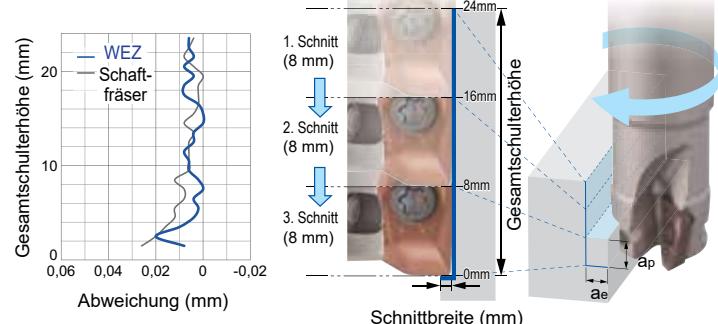
Sehr scharfe Schneide mit hoher Bearbeitungsgenauigkeit

| | | | | |
|---|---|---|---|-----------------------------|
|  | <p>Die Schärfe der geschliffenen Schneide verhindert Gratbildung.</p> |  |  | <p>WEZ Wettbewerber</p> |
| | <p>Ausgezeichnete Rechtwinkligkeit bei allen Durchmessern.</p> | | <p>Bearb. zentrum: BAZ BT50, vertikal Werkstückstoff: X5CrNi18 9 Fräser: WEZ 11050 RS07 (\varnothing 50, 7 Zähne) Schneidplatte: AOET11T308PEER-F (ACU2500) Schnittdaten: $v_c = 120$ m/min, $f_z = 0,12$ mm/Z, $a_p = 1$ mm, $a_e = 30$ mm, trocken</p> | |

P-Typ

Design für das Erzielen rechtwinkliger Flächen ähnlich wie bei Vollhartmetallschaftfräsern

| | |
|---|---|
|  | <p>Erstklassiger Spanbrecher mit einer für jeden Fräserdurchmesser optimierten Schneidkantenform und ebenso hoher Schärfe wie die des Spanbrechers vom Typ F.</p> |
| | <p>Die Schneide ermöglicht eine hohe Schulterwinkligkeit vergleichbar mit VHM-Schaftfräsern.</p> |



Auswahl je Fräserdurchmesser

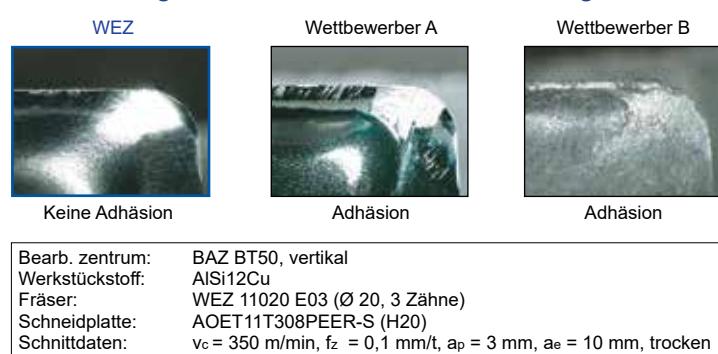
| Bezeichnung | Fräserdurchmesser (mm) | | | | | | | | | | |
|--------------------|------------------------|------|-----|------|------|-----|------|-----|-----|-----|----|
| | 014 | 016 | 018 | 020 | 022 | 025 | 028 | 030 | 032 | 035 | => |
| AOET11T3__PEER-P__ | -P16 | -P20 | — | -P25 | | | — | | | | |
| AOET1705__PEER-P__ | | — | | | -P25 | | -P32 | | | | |

| | |
|-----------------|--|
| Bearb. zentrum: | BAZ BT50, vertikal |
| Werkstückstoff: | C50 |
| Fräser: | WEZ 11020 E03 (\varnothing 20, 3 Zähne) |
| Schneidplatte: | AOET11T308PEER-P20 (ACU2500) |
| Schnittdaten: | $v_c = 150$ m/min, $f_z = 0,1$ mm/Z, $a_p = 8$ mm x 3 Überläufe, $ae = 1$ mm, trocken |

S-Typ

Scharfkantiger Spanbrecher für Nichteisenmetalle mit ausgezeichneter Adhäsionsbeständigkeit

| | |
|---|---|
|  | <p>Unterdrückt die Aufbauschneidenbildung durch geläppte Spanfläche.</p> <p>DLC Beschichtung verfügbar für noch geringere Aufbauschneidenbildung.</p> |
|---|---|



■ Schneidstoffauswahl

Die neuen, beschichteten Hartmetallsorten XCU2500/XCK2000 sind ab sofort verfügbar. Damit steht nun eine erweiterte Auswahl an Beschichtungen zum Fräsen von Stahl, Edelstahl, Gusseisen und Aluminiumlegierungen zur Verfügung.

| ISO | Schichten – Mittlere Zersp. | Mittlere Zespanung | Schruppen – schweres Schr. |
|---------------|-----------------------------|--------------------|----------------------------|
| P | ACU2500 | | |
| | XCU2500 | | |
| | ACP2000 | | ACP3000 |
| M | T2500A | | |
| | ACU2500 | | |
| K | XCU2500 | | |
| | ACM200 | | ACM300 |
| | ACU2500 | | |
| | XCK2000 | | |
| N | ACK2000 | | |
| | ACK3000 | | |
| | DL2000 | | |
| ▼: CVD ▲: PVD | | | |

■ Charakteristische Werte

CVD

| ISO | Schneidstoff | Härte (HRA) | TRS (GPa) | Beschichtungstyp | Beschichtungsdicke (µm) | Eigenschaften | Alte Schneidstoffe |
|-----|--------------|-------------|-----------|------------------|-------------------------|--|--------------------|
| P | ACP2000 | 89,5 | 3,2 | ABSOTECH | 10 | Für die Hochgeschwindigkeitsbearbeitung von Stahl. Stabile, lange Standzeit bei der Hochgeschwindigkeitsbearbeitung durch Verwendung eines zähen Hartmetallsubstrates und einer neuen Beschichtung mit ausgezeichneter Beständigkeit gegen Thermorisse. | ACP100 |
| | XCU2500 | 89,5 | 3,2 | ABSOTECH X | 6 | Allgemeine Sorte für eine Vielzahl von Werkstoffen wie Stahl, Gusseisen und rostfreien Stahl. Eine neue Beschichtung, die Verschleiß- und Bruchfestigkeit kombiniert, sorgt für lange Standzeiten bei der Bearbeitung bei mittleren und hohen Drehzahlen. | — |
| M | ACM200 | 89,8 | 3,4 | Super FF Coat | 6 | Ein Schneidstoff, der sich ideal für die Bearbeitung von gehärtetem Stahl eignet und durch die Verwendung eines neu entwickelten, ultra-harten Hartmetalls und der Super FF-Beschichtung über exzellente Verschleißfestigkeit und Hitzeständigkeit verfügt. | AC230 |
| | ACK2000 | 91,7 | 3,1 | ABSOTECH | 10 | Für das Hochgeschwindigkeitsfräsen von Grauguss. Stabile, lange Standzeit bei der Hochgeschwindigkeitsbearbeitung, durch Verwendung eines zähen Hartmetallsubstrates und einer neuen Beschichtung mit ausgezeichneter Beständigkeit gegen Thermorisse. | ACK100 ACK200 |
| K | XCK2000 | 91,7 | 2,5 | ABSOTECH X | 6 | Für das Hochgeschwindigkeitsfräsen von Gusseisen. In Verbindung mit einem hochharten Hartmetallsubstrat sorgt die neue Beschichtung, die eine hohe Verschleiß- und Bruchfestigkeit ausweist, für hervorragende Standzeiten bei der Bearbeitung bei mittleren und hohen Drehzahlen. | — |

PVD

| ISO | Schneidstoff | Härte (HRA) | TRS (GPa) | Beschichtungstyp | Beschichtungsdicke (µm) | Eigenschaften | Alte Schneidstoffe |
|-----|--------------|-------------|-----------|----------------------|-------------------------|---|--------------------|
| P | ACU2500 | 91,6 | 3,8 | ABSOTECH | 3 | Allroundsorte für die Bearbeitung von Stahl, Edelstahl und Gusseisen. Ein Hartmetallsubstrat mit ausgezeichneter Bruchfestigkeit und einer neuen Beschichtung mit ausgezeichneter Verschleißfestigkeit und Schichthaftung, wodurch eine lange Standzeit bei unterschiedlichen Werkstoffen erzielt wird. | — |
| | ACP3000 | 89,5 | 3,2 | ABSOTECH | 3 | Erste Empfehlung für die Fräsbearbeitung von Stahl. Hartmetallsubstrat mit ausgezeichneter Beständigkeit gegen thermische Risse und einer neuen Beschichtung mit verbesselter Verschleißfestigkeit und Schichthaftung, wodurch eine lange Standzeit bei unterschiedlichen Schnittbedingungen erreicht wird. | ACP200 ACP300 |
| M | ACM300 | 89,8 | 3,4 | (Neue) Super ZX Coat | 3 | Erste Empfehlung für die spanabhebende Bearbeitung von rostfreiem Stahl, der durch die Verwendung eines neu entwickelten, ultra-harten Hartmetalls und der neuen Super ZX-Beschichtung eine gut ausgewogene Verschleiß- und Bruchfestigkeit besitzt. | — |
| | ACK3000 | 91,7 | 3,1 | ABSOTECH | 3 | Erste Empfehlung für die Fräsbearbeitung von Gusseisen. Hartmetallsubstrat mit hoher Wärmefestigkeit und einer neuen Beschichtung mit exzellenter Verschleißfestigkeit und Schichthaftung. Erzielt stabile, lange Standzeiten bei der Bearbeitung von Gusseisen, bei unterschiedlichsten Anwendungen. | ACK300 |
| N | DL2000 | 91,6 | 3,8 | AURORA Coat (DLC) | 0,5 | Für das Fräsen von Nichteisenmetallen, wird eine DLC-Beschichtung mit niedrigem Reibungskoeffizienten und ausgezeichnetem Widerstand gegen Aufbauschneidenbildung eingesetzt. | — |

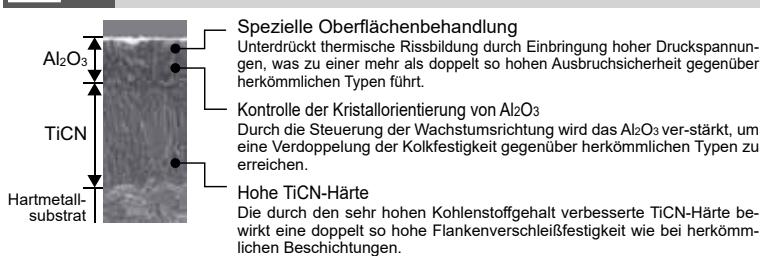
Cermet

| ISO | Schneidstoff | Härte (HRA) | TRS (GPa) | Beschichtungstyp | Beschichtungsdicke (µm) | Eigenschaften | Alte Schneidstoffe |
|-----|--------------|-------------|-----------|------------------|-------------------------|---|--------------------|
| P | M | T2500A | 91,8 | 2,4 | — | Für die Schlichtbearbeitung von Stahl und Edelstahl. Feines, gleichmäßiges Korngefüge sorgt für deutlich höhere Zähigkeit, eine lange Standzeit sowie ausgezeichnete Oberflächenbeschaffenheit. | T250A |

■ Beschichtungsmerkmale

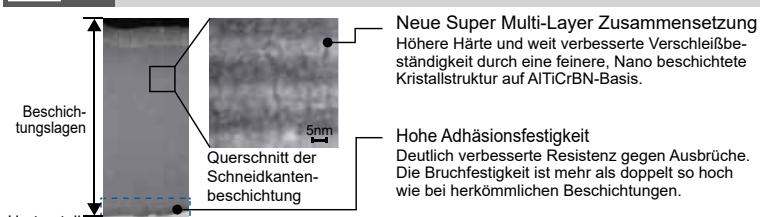
Neue Absotech™ Beschichtungstechnologie für erhöhte Stabilität der Schichthaftung

ABSOTECH



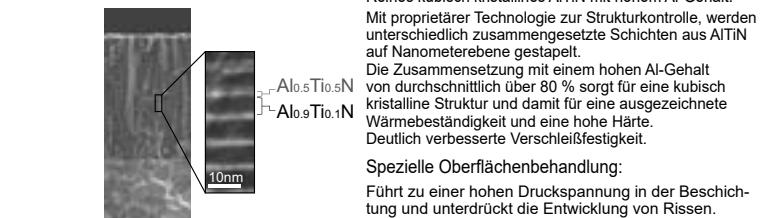
Schneidstoffe: ACP2000, ACK2000

ABSOTECH



Schneidstoffe: ACU2500, ACP3000, ACK3000

ABSOTECH X



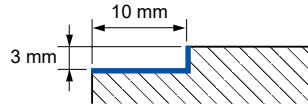
Geignete Schneidstoffe: XCU2500, XCK2000

■ Empfohlene Schnittdaten

● WEZ11-Typ

Fräser: WEZ 11020 E03
 Schneidplatte: AO_T11T3 Typ
 Schnittdaten: $a_p = 3 \text{ mm}$, $a_e = 10 \text{ mm}$, trocken

Min. - Optimum - Max.



| ISO | Material | HB | Schneidkantenausführung | Sorte | | | | | | | | | | | |
|--------------------------------------|--|-----|-------------------------|--------------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------|-------------|-------------|-------------|
| | | | | ACU2500 | XCU2500 | ACP2000 | ACP3000 | T2500A | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | DL2000 | |
| | | | | Vorschub (mm/Zahn) | | | | | | | | | | | |
| Schnittgeschwindigkeit v_c (m/min) | | | | | | | | | | | | | | | |
| P | Unlegierter Stahl, <0,15% C, vergütet | 125 | G | 270-320-370 | 300-350-400 | 300-350-400 | 250-300-350 | 230-280-330 | | | | | | | |
| | , <0,45% C, vergütet | 190 | G | 170-220-270 | 200-250-300 | 200-250-300 | 150-200-250 | 130-180-230 | | | | | | | |
| | , <0,45% C, angelassen | 250 | G | 140-180-220 | 160-200-245 | 160-200-245 | 120-160-200 | 105-145-185 | | | | | | | |
| | , <0,75% C, vergütet | 270 | G | 110-145-175 | 130-165-195 | 130-165-195 | 100-130-165 | 85-115-150 | | | | | | | |
| | , <0,75% C, angelassen | 300 | G | 70-90-110 | 80-100-120 | 80-100-120 | 60-80-100 | 50-70-90 | | | | | | | |
| P | Niedrig legierter Stahl, vergütet | 180 | G | 160-205-255 | 190-235-280 | 190-235-280 | 140-190-235 | 120-170-215 | | | | | | | |
| | , angelassen | 275 | G | 90-120-150 | 110-135-165 | 110-135-165 | 80-110-140 | 70-100-125 | | | | | | | |
| | , angelassen | 300 | G | 85-110-130 | 100-125-150 | 100-125-150 | 75-100-125 | 65-90-115 | | | | | | | |
| | , angelassen | 350 | G | 60-80-100 | 70-90-110 | 70-90-110 | 50-70-90 | 45-65-85 | | | | | | | |
| M | Hoch legierter und Werkzeugstahl, vergütet | 200 | G | 140-180-220 | 160-200-245 | 160-200-245 | 120-160-205 | | | | | | | | |
| | , angelassen | 325 | G | 55-70-85 | 60-80-100 | 60-80-100 | 50-65-80 | | | | | | | | |
| | Rostfreier Stahl, ferritisch/martensitisch, vergütet | 200 | G | 110-140-170 | 160-190-210 | | | | | | | | 140-170-190 | 90-110-140 | |
| M | , martensitisch, angelassen | 240 | G | 100-125-150 | 145-170-190 | | | | | | | | 125-150-170 | 80-100-125 | |
| | , austenitisch | 180 | G | 120-150-180 | 170-200-220 | | | | | | | | 150-180-200 | 100-120-150 | |
| K | Grauguss | | G | 150-200-250 | 250-300-350 | | | | 250-300-350 | 250-300-350 | 170-220-270 | | | | |
| | Kugelgraphitguss | | G | 90-120-150 | 150-180-210 | | | | 150-180-210 | 150-180-210 | 100-130-160 | | | | |
| S | Hitzebeständige Legierungen, Fe basierend, vergütet | | G | 30-40-55 | | | | | | | | | 35-45-60 | 25-35-50 | |
| | , angelassen | | G | 60-80-100 | | | | | | | | | 70-90-110 | 50-70-90 | |
| N | Aluminiumlegierung, Si < 12,6% | | S | | | | | | | | | | | | 500-750-100 |
| | , Si > 12,6% | | S | | | | | | | | | | | | 170-200-250 |
| | Kupferlegierung | | S | | | | | | | | | | | | 300-330-350 |

Die empfohlenen Schnittdaten dienen als Richtlinie. Die tatsächlichen Zerspanungsbedingungen variieren je nach Bearbeitungsmaschine, Anwendung und Einspannung.

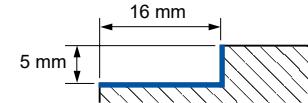
Die Werte sollten entsprechend der aktuellen Bedingungen angepasst werden.

Beim Nutfräsen ist der Vorschub um 70 % der in der Tabelle angegebenen Werte zu reduzieren.

● WEZ17-Typ

Fräser: WEZ 17032 E03
 Schneidplatte: AO_T1705 Typ
 Schnittdaten: $a_p = 5 \text{ mm}$, $a_e = 16 \text{ mm}$, trocken

Min. - Optimum - Max.



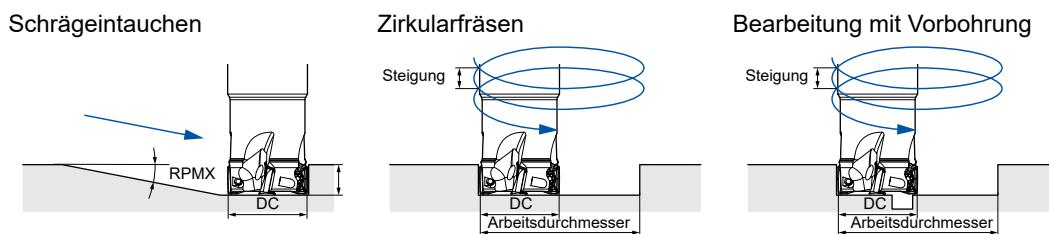
| ISO | Material | HB | Schneidkantenausführung | Sorte | | | | | | | | | | | |
|--------------------------------------|--|-----|-------------------------|--------------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--------|-------------|-------------|-------------|
| | | | | ACU2500 | XCU2500 | ACP2000 | ACP3000 | T2500A | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | DL2000 | |
| | | | | Vorschub (mm/Zahn) | | | | | | | | | | | |
| Schnittgeschwindigkeit v_c (m/min) | | | | | | | | | | | | | | | |
| P | Unlegierter Stahl, <0,15% C, vergütet | 125 | G | 285-335-390 | 315-360-420 | 315-360-420 | 265-315-370 | 240-295-345 | | | | | | | |
| | , <0,45% C, vergütet | 190 | G | 180-230-285 | 210-265-315 | 210-265-315 | 160-210-265 | 135-190-240 | | | | | | | |
| | , <0,45% C, angelassen | 250 | G | 145-190-230 | 170-210-255 | 170-210-255 | 130-170-215 | 110-155-195 | | | | | | | |
| | , <0,75% C, vergütet | 270 | G | 115-150-185 | 135-170-205 | 135-170-205 | 100-135-170 | 90-125-155 | | | | | | | |
| | , <0,75% C, angelassen | 300 | G | 70-90-115 | 85-105-125 | 85-105-125 | 65-85-105 | 55-75-95 | | | | | | | |
| P | Niedrig legierter Stahl, vergütet | 180 | G | 170-220-265 | 200-245-295 | 200-245-295 | 150-200-250 | 130-180-225 | | | | | | | |
| | , angelassen | 275 | G | 100-130-155 | 115-145-175 | 115-145-175 | 85-115-145 | 75-105-135 | | | | | | | |
| | , angelassen | 300 | G | 90-115-140 | 105-130-155 | 105-130-155 | 75-105-130 | 65-90-120 | | | | | | | |
| | , angelassen | 350 | G | 65-85-100 | 75-95-115 | 75-95-115 | 55-75-95 | 50-70-85 | | | | | | | |
| M | Hoch legierter und Werkzeugstahl, vergütet | 200 | G | 145-185-230 | 170-215-255 | 170-215-255 | 130-170-215 | 110-155-195 | | | | | | | |
| | , angelassen | 325 | G | 55-75-90 | 65-85-100 | 65-85-100 | 50-65-85 | | | | | | | | |
| | Rostfreier Stahl, ferritisch/martensitisch, vergütet | 200 | G | 115-145-175 | 165-195-215 | | | | | | | | 145-175-195 | 100-115-145 | |
| M | , martensitisch, angelassen | 240 | G | 105-130-155 | 150-175-195 | | | | | | | | 130-155-175 | 85-105-130 | |
| | , austenitisch | 180 | G | 125-155-190 | 180-210-230 | | | | | | | | 160-190-210 | 105-125-160 | |
| K | Grauguss | | G | 160-210-265 | 265-315-370 | | | | 265-315-370 | 265-315-370 | 180-230-285 | | | | |
| | Kugelgraphitguss | | G | 95-125-160 | 160-190-220 | | | | 160-190-220 | 160-190-220 | 105-140-170 | | | | |
| S | Hitzebeständige Legierungen, Fe basierend, vergütet | | G | 30-40-60 | | | | | | | | | 35-45-60 | 25-35-50 | |
| | , angelassen | | G | 60-85-105 | | | | | | | | | 75-95-115 | 50-75-95 | |
| N | Aluminiumlegierung, Si < 12,6% | | S | | | | | | | | | | | | 500-750-100 |
| | , Si > 12,6% | | S | | | | | | | | | | | | 170-200-250 |
| | Kupferlegierung | | S | | | | | | | | | | | | 300-330-350 |

Die empfohlenen Schnittdaten dienen als Richtlinie. Die tatsächlichen Zerspanungsbedingungen variieren je nach Bearbeitungsmaschine, Anwendung und Einspannung.

Die Werte sollten entsprechend der aktuellen Bedingungen angepasst werden.

Beim Nutfräsen ist der Vorschub um 70 % der in der Tabelle angegebenen Werte zu reduzieren.

■ Obergrenzen beim Schrägeintauchen / Zirkularfräsen



● WEZ11-Typ

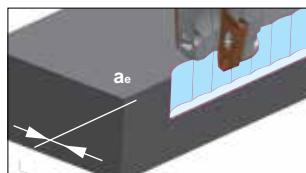
| DC Ø (mm) | Max. Eintauchwinkel RPMX (°) | Zirkularfräsen | | | | Bearbeitung mit Vorbohrung | |
|--------------|---------------------------------|--|-------------------------|--|-------------------------|--|-------------------------|
| | | Max. Bearbeitungs- durchmesser (mm) | Max. Steigung (mm/U) | Min. Bearbeitungs- durchmesser (mm) | Max. Steigung (mm/U) | Min. Bearbeitungs- durchmesser (mm) | Max. Steigung (mm/U) |
| 14 | 13,2 | 25,3 | 8,4 | 23,1 | 5,9 | 19,0 | 1,9 |
| 16 | 10,5 | 29,3 | 7,6 | 27,0 | 5,6 | 21,7 | 1,5 |
| 18 | 8,1 | 33,3 | 6,7 | 30,9 | 5,0 | 25,2 | 1,4 |
| 20 | 6,5 | 37,3 | 6,0 | 34,9 | 4,6 | 29,1 | 1,3 |
| 22 | 5,3 | 41,3 | 5,4 | 38,8 | 4,3 | 32,9 | 1,3 |
| 25 | 4,1 | 47,3 | 4,8 | 44,8 | 3,9 | 38,9 | 1,3 |
| 28 | 3,4 | 53,3 | 4,4 | 50,7 | 3,6 | 44,9 | 1,3 |
| 30 | 3,0 | 57,3 | 4,2 | 54,7 | 3,5 | 48,8 | 1,3 |
| 32 | 2,7 | 61,3 | 4,0 | 58,7 | 3,3 | 52,8 | 1,2 |
| 35 | 2,3 | 67,3 | 3,8 | 64,6 | 3,1 | 58,8 | 1,2 |
| 40 | 1,8 | 77,3 | 3,4 | 74,6 | 2,9 | 68,8 | 1,2 |
| 50 | 1,2 | 97,3 | 3,0 | 94,6 | 2,6 | 88,8 | 1,1 |
| 63 | 0,8 | 123,3 | 2,8 | 120,5 | 2,5 | 114,7 | 1,1 |

● WEZ17-Typ

| DC Ø (mm) | Max. Eintauchwinkel RPMX (°) | Zirkularfräsen | | | | Bearbeitung mit Vorbohrung | |
|--------------|---------------------------------|--|-------------------------|--|-------------------------|--|-------------------------|
| | | Max. Bearbeitungs- durchmesser (mm) | Max. Steigung (mm/U) | Min. Bearbeitungs- durchmesser (mm) | Max. Steigung (mm/U) | Min. Bearbeitungs- durchmesser (mm) | Max. Steigung (mm/U) |
| 25 | 10,8 | 47,3 | 13,0 | 41,0 | 8,3 | 33,1 | 1,8 |
| 28 | 8,1 | 53,3 | 11,1 | 46,9 | 7,5 | 39,0 | 1,8 |
| 30 | 7,0 | 57,3 | 10,2 | 50,9 | 7,0 | 43,0 | 1,8 |
| 32 | 6,1 | 61,3 | 9,5 | 54,9 | 6,7 | 47,0 | 1,7 |
| 35 | 5,1 | 67,3 | 8,7 | 60,8 | 6,2 | 53,0 | 1,7 |
| 40 | 4,0 | 77,3 | 7,7 | 70,8 | 5,7 | 63,0 | 1,7 |
| 50 | 2,5 | 97,3 | 6,5 | 90,7 | 5,0 | 83,0 | 1,6 |
| 63 | 1,8 | 123,3 | 5,6 | 116,7 | 4,5 | 109,0 | 1,6 |

* Die Tabelle zeigt Werte mit einem Eckenradius = 0,8 mm.

■ Tauchfräsen - Obergrenzen für die Eingriffsbreite a_e



| Typ | Max. a_e (mm) |
|-------|-----------------|
| WEZ11 | 3 |
| WEZ17 | 5 |

■ Vorsichtsmaßnahmen bei der Montage

- (1) Reinigen Sie den Montagesitz und die Kontaktteile.
- (2) Bringen Sie ausreichend Schmierstoff auf das Schraubengewinde und den Schraubenkopf auf, um ein Festsitzen zu vermeiden.
- (3) Während Sie die Platte fest gegen die Sitzfläche drücken, ziehen Sie die Schrauben mit dem mitgelieferten Schraubenschlüssel an.
- (4) Nach dem Anziehen ist darauf zu achten, dass keine Lücken zwischen den Oberflächen vorhanden sind.



"WaveMill" Serie

WEZ 11000 R(S)



| | | | | |
|------------|--------|------------|-------|-----|
| Spanwinkel | Radial | -7° – -11° | 10 mm | 90° |
| Axial | | 14° – 15° | | |

Abb. 1

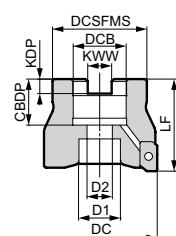


Abb. 2

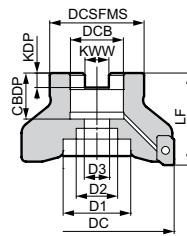
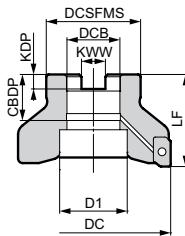


Abb. 3



WEZ-Fräskörper (Aufsteckfräser)

| | | Bezeichnung | Lager | DC | DCSFMS | LF | DCB | KWW | KDP | CBDP | D1 | D2 | D3 | Anzahl Zähne | Gewicht (kg) | Abb. |
|----------|---------------|-------------|-------|----|--------|-------|------|-----|-----|------|----|----|----|--------------|--------------|------|
| Metrisch | WEZ 11040RS04 | ● | 40 | 33 | 40 | 16 | 8,4 | 5,6 | 18 | 14 | 9 | – | 4 | 0,21 | 1 | |
| | 11040RS06 | ● | 40 | 33 | 40 | 16 | 8,4 | 5,6 | 18 | 14 | 9 | – | 6 | 0,20 | 1 | |
| | 11050RS05 | ● | 50 | 41 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 5 | 0,32 | 1 | |
| | 11050RS07 | ● | 50 | 41 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 7 | 0,31 | 1 | |
| | 11063RS06 | ● | 63 | 50 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 6 | 0,58 | 1 | |
| | 11063RS08 | ● | 63 | 50 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 8 | 0,57 | 1 | |
| | 11080RS07 | ● | *80 | 55 | 50 | 27 | 12,4 | 7,0 | 22 | 20 | 14 | – | 7 | 1,08 | 1 | |
| | 11080RS10 | ● | *80 | 55 | 50 | 27 | 12,4 | 7,0 | 22 | 20 | 14 | – | 10 | 1,07 | 1 | |
| | 11100RS09 | ● | 100 | 70 | 50 | 32 | 14,4 | 8,0 | 32 | 46 | – | – | 9 | 1,57 | 3 | |
| | 11100RS12 | ● | 100 | 70 | 50 | 32 | 14,4 | 8,0 | 32 | 46 | – | – | 12 | 1,56 | 3 | |
| Inch | WEZ 11080R07 | ○ | *80 | 55 | 50 | 25,4 | 9,5 | 6,0 | 25 | 20 | 14 | – | 7 | 1,09 | 1 | |
| | 11080R10 | ○ | *80 | 55 | 50 | 25,4 | 9,5 | 6,0 | 25 | 20 | 14 | – | 10 | 1,08 | 1 | |
| | 11100R09 | ○ | *100 | 70 | 63 | 31,75 | 12,7 | 8,0 | 32 | 46 | 27 | 18 | 9 | 2,12 | 2 | |
| | 11100R12 | ○ | *100 | 70 | 63 | 31,75 | 12,7 | 8,0 | 32 | 46 | 27 | 18 | 12 | 2,10 | 2 | |

Die Schneidplatten werden separat verkauft. Überprüfen Sie bei der Auswahl des Fräsern die Größe der Aufnahme (DCB).

* Bitte nutzen Sie die hexagonale Klemmschraube JIS B1176 zur Befestigung der Fräser Ø 80 mm und Ø 100 mm auf der Aufnahme.
(Ø 80 mm: M12x30 to 35 mm, Ø 100 mm: M16x40x45 mm)

Ersatzteile

| Geeignete Fräser | Schraube | Schlüssel |
|------------------|------------|-----------|
| | | |
| WEZ 11040RS04 | | |
| 11040RS06 | | |
| 11050RS05 | | |
| 11050RS07 | | |
| 11063RS06 | BFTX0306IP | 1,5 |
| 11063RS08 | | TRDR08IP |
| 11080R(S)07 | | |
| 11080R(S)10 | | |
| 11100R(S)09 | | |
| 11100R(S)12 | | |

Empfohlene Schnittbedingungen

→ S. 8

Identifikation des Fräskörpers

WEZ 11 050 R S 07

Fräserbezeichnung Plattengröße Fräserdurchmesser Schneidrichtung Metrisch Anzahl Zähne

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT11T324PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT11T330PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT11T332PEER)
Standard: R = 1 mm

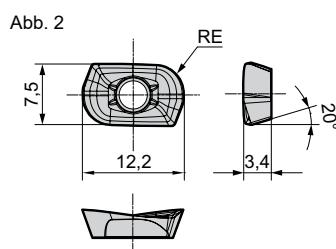
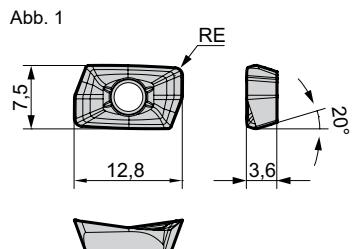
C: Fase
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage → S. 9

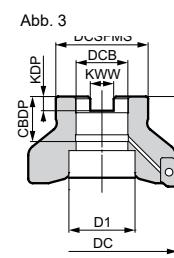
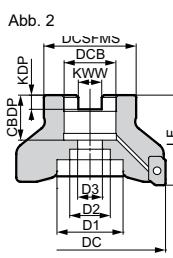
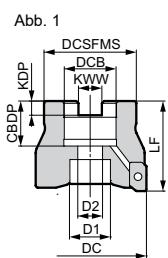
| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | P _M | P | K | K | M _S | N | P | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | | | | | | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | ● | 0,2 | 1 | |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | 0,4 | 1 | |
| 11T305PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | □ | 0,5 | 1 | |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | 0,8 | 1 | |
| 11T310PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | □ | 1,0 | 1 | |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | □ | 1,2 | 1 | |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 1,6 | 1 | |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 2,0 | 1 | |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 2,4 | 1 | |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 3,0 | 2 | |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 3,2 | 2 | |
| AOMT 11T304PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 2 |

L: geringe Schnittkraft
G: allgemeine Anwendung
H: stabile Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichtleisenmetalle

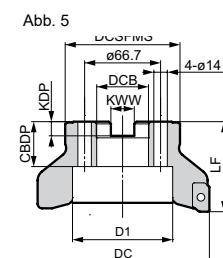
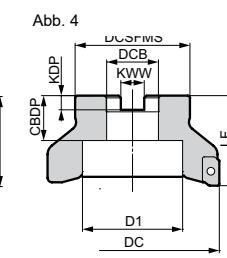


"Wave Mill" Serie

WEZ 17000 R(S)



| | | |
|------------|-----------|-----------|
| Spanwinkel | Radial | -4° – -9° |
| Axial | 10° – 15° | |



15 mm 90°

WEZ-Fräskörper (Aufsteckfräser)

| Bezeichnung | | Lager | DC | DCSFMS | LF | DCB | KWW | KDP | CBDP | D1 | D2 | D3 | Anzahl Zähne | Gewicht (kg) | Abb. |
|-------------|---------------|-------|------|--------|----|-------|------|------|------|----|----|----|--------------|--------------|------|
| Metrisch | WEZ 17040RS03 | ● | 40 | 33 | 40 | 16 | 8,4 | 5,6 | 18 | 14 | 9 | – | 3 | 0,19 | 1 |
| | 17040RS04 | ● | 40 | 33 | 40 | 16 | 8,4 | 5,6 | 18 | 14 | 9 | – | 4 | 0,16 | 1 |
| | 17050RS03 | ● | 50 | 41 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 3 | 0,30 | 1 |
| | 17050RS05 | ● | 50 | 41 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 5 | 0,26 | 1 |
| | 17063RS04 | ● | 63 | 50 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 4 | 0,54 | 1 |
| | 17063RS06 | ● | 63 | 50 | 40 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | – | 6 | 0,51 | 1 |
| | 17080RS04 | ● | *80 | 55 | 50 | 27 | 12,4 | 7,0 | 22 | 20 | 14 | – | 4 | 1,10 | 1 |
| | 17080RS07 | ● | *80 | 55 | 50 | 27 | 12,4 | 7,0 | 22 | 20 | 14 | – | 7 | 1,05 | 1 |
| | 17100RS05 | ● | 100 | 70 | 50 | 32 | 14,4 | 8,0 | 32 | 46 | – | – | 5 | 1,58 | 3 |
| | 17100RS08 | ● | 100 | 70 | 50 | 32 | 14,4 | 8,0 | 32 | 46 | – | – | 8 | 1,57 | 3 |
| | 17125RS06 | ● | 125 | 80 | 63 | 40 | 16,4 | 9,0 | 29 | 52 | 29 | – | 6 | 3,04 | 1 |
| | 17125RS09 | ● | 125 | 80 | 63 | 40 | 16,4 | 9,0 | 29 | 52 | 29 | – | 9 | 3,07 | 1 |
| | 17125RS11 | ● | 125 | 80 | 63 | 40 | 16,4 | 9,0 | 29 | 52 | 29 | – | 11 | 3,02 | 1 |
| | 17160RS08 | ● | 160 | 130 | 63 | 40 | 16,4 | 9,0 | 29 | 90 | – | – | 8 | 5,24 | 5 |
| Inch | WEZ 17080R04 | ○ | *80 | 55 | 50 | 25,4 | 9,5 | 6,0 | 25 | 20 | 14 | – | 4 | 1,10 | 1 |
| | 17080R07 | ○ | *80 | 55 | 50 | 25,4 | 9,5 | 6,0 | 25 | 20 | 14 | – | 7 | 1,06 | 1 |
| | 17100R05 | ○ | *100 | 70 | 63 | 31,75 | 12,7 | 8,0 | 32 | 46 | 27 | 18 | 5 | 2,08 | 2 |
| | 17100R08 | ○ | *100 | 70 | 63 | 31,75 | 12,7 | 8,0 | 32 | 46 | 27 | 18 | 8 | 2,07 | 2 |
| | 17125R06 | ○ | 125 | 80 | 63 | 38,1 | 15,9 | 10,0 | 35,5 | 55 | 30 | – | 6 | 3,09 | 1 |
| | 17125R09 | ○ | 125 | 80 | 63 | 38,1 | 15,9 | 10,0 | 35,5 | 55 | 30 | – | 9 | 3,11 | 1 |
| | 17125R11 | ○ | 125 | 80 | 63 | 38,1 | 15,9 | 10,0 | 35,5 | 55 | 30 | – | 11 | 3,06 | 1 |
| | 17160R08 | ○ | 160 | 100 | 63 | 50,8 | 19,1 | 11,0 | 38 | 72 | – | – | 8 | 5,04 | 4 |
| | 17160R10 | ○ | 160 | 100 | 63 | 50,8 | 19,1 | 11,0 | 38 | 72 | – | – | 10 | 5,09 | 4 |
| | 17160R12 | ○ | 160 | 100 | 63 | 50,8 | 19,1 | 11,0 | 38 | 72 | – | – | 12 | 5,04 | 4 |

Die Schneidplatten werden separat verkauft. Überprüfen Sie bei der Auswahl des Fräzers die Größe der Aufnahme (DCB).

* Bitte nutzen Sie die hexagonale Klemmschraube JIS B1176 zur Befestigung der Fräser Ø 80 mm und Ø 100 mm auf der Aufnahme.
(Ø 80 mm: M12x30 to 35 mm, Ø 100 mm: M16x40x45 mm)

Ersatzteile

| Geeignete Fräser | Schraube | Schlüssel | Handgriff | Bit |
|------------------|------------|-----------|-----------|-----------------|
| | | | | |
| WEZ 17040RS03 | | | | |
| 17040RS04 | | | | |
| 17050RS03 | | | | |
| 17050RS05 | | | | |
| 17063RS04 | | | | |
| 17063RS06 | | | | |
| 17080R(S)04 | | | | |
| 17080R(S)07 | | | | |
| 17100R(S)05 | | | | |
| 17100R(S)08 | | | | |
| 17125R(S)06 | | | | |
| 17125R(S)09 | | | | |
| 17125R(S)11 | | | | |
| 17160R(S)08 | | | | |
| 17160R(S)10 | | | | |
| 17160R(S)12 | | | | |
| | BFTX0409IP | 3,0 | – | HPS1015 TRB15IP |
| | | | | TRDR15IP – – |

Identifikation des Fräskörpers

WEZ 17 100 R S 05

Fräserbezeichnung Plattengröße Fräserdurchmesser Schneidrichtung Metrisch Anzahl Zähne

*Bei der Montage von Schneidplatten mit einem Eckenradius von ≥ 2,4 mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT170524PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT170530PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT170532PEER)
Eckenradius = 4,0 mm: C = 2 mm (AOMT170540PEER)
Eckenradius = 5,0 mm: C = 5 mm (AOMT170550PEER)
Eckenradius = 6,4 mm: C = 5 mm (AOMT170564PEER)
Standard: R = 1 mm

C: Fase
R: Radius

Empfohlene Schnittbedingungen

→ S. 8

"Wave Mill" Serie

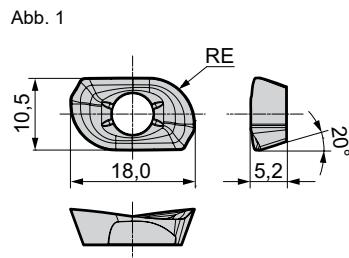
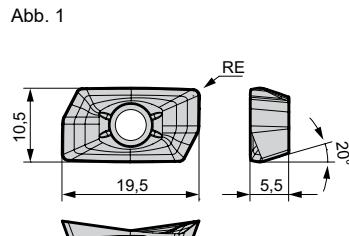
WEZ 17000 R(S)

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|---------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| Hochgeschw./ Leichtbearbeitung | K P M | P | K | K | M S | | | | N | P | | | | |
| Allgemeine Anwendung | K M | P | K | K | M S | M S | M S | N | N | | | | | |
| Schruppen | S M | P | | K | | | | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 170502PEER-L | ● | | — | □ | — | — | □ | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | ● | 0,4 | 1 |
| 170508PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 170512PEER-L | ● | — | — | □ | — | — | □ | ● | ● | — | — | — | 1,2 | 1 |
| 170516PEER-L | ● | — | — | □ | — | — | □ | ● | ● | — | — | — | 1,6 | 1 |
| AOMT 170502PEER-G | ● | ○ | □ | ● | ○ | □ | ● | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-G | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | ● | 0,4 | 1 |
| 170505PEER-G | ● | ○ | □ | □ | ○ | □ | □ | ● | ● | — | — | □ | 0,5 | 1 |
| 170508PEER-G | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 170510PEER-G | ● | — | □ | □ | — | □ | □ | ● | ● | — | — | □ | 1,0 | 1 |
| 170512PEER-G | ● | — | □ | ● | — | □ | ● | ● | ● | — | — | □ | 1,2 | 1 |
| 170516PEER-G | ● | — | □ | ● | — | □ | ● | ● | ● | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | — | □ | ● | — | □ | ● | ● | ● | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | — | □ | — | — | □ | □ | ● | ● | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | — | □ | ● | — | □ | ● | ● | ● | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | — | □ | — | — | □ | ● | ● | ● | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | — | □ | ● | — | □ | ● | ● | ● | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | — | □ | ● | — | □ | ● | ● | ● | — | — | — | 5,0 | 2 |
| 170564PEER-G | ● | — | □ | — | — | □ | ● | ● | ● | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | — | □ | — | — | □ | □ | ● | ● | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | — | □ | ● | — | □ | □ | ● | ● | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 6,4 | 2 |



L: geringe Schnittkraft
 G: allgemeine Anwendung
 H: stabile Schneidkante
 F: Schlitten
 P: Hochpräzisionsbearbeitung
 S: Nichteisenmetalle

"WaveMill" Serie

WEZ 11000 E



Abb. 1

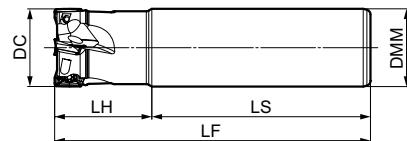
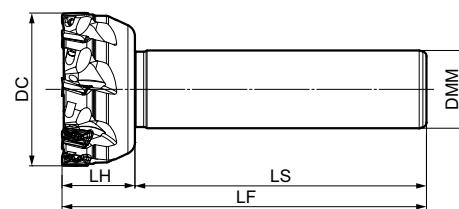


Abb. 2



| | | |
|------------|--------|------------|
| Spanwinkel | Radial | -7° – -18° |
| Axial | | 6° – 15° |

10 mm 90°

WEZ-Fräskörper (Schaftfräser)

| Bezeichnung | Lager | DC | DMM | LH | LS | LF | Anzahl Zähne | Gewicht (kg) | Abb. |
|--------------|-------|----|-----|----|-----|-----|--------------|--------------|------|
| WEZ 11014E01 | ● | 14 | 16 | 25 | 55 | 80 | 1 | 0,10 | 1 |
| 11016E02 | ● | 16 | 16 | 25 | 75 | 100 | 2 | 0,13 | 1 |
| 11016E02-12 | ● | 16 | 12 | 25 | 75 | 100 | 2 | 0,07 | 2 |
| 11018E02 | ● | 18 | 16 | 25 | 75 | 100 | 2 | 0,13 | 2 |
| 11020E02 | ● | 20 | 20 | 30 | 80 | 110 | 2 | 0,23 | 1 |
| 11020E02-16 | ● | 20 | 16 | 30 | 80 | 110 | 2 | 0,15 | 2 |
| 11020E03 | ● | 20 | 20 | 30 | 80 | 110 | 3 | 0,22 | 1 |
| 11020E03-16 | ● | 20 | 16 | 30 | 80 | 110 | 3 | 0,14 | 2 |
| 11022E03 | ● | 22 | 20 | 30 | 80 | 110 | 3 | 0,23 | 1 |
| 11025E02 | ● | 25 | 25 | 35 | 85 | 120 | 2 | 0,40 | 1 |
| 11025E03 | ● | 25 | 25 | 35 | 85 | 120 | 3 | 0,40 | 1 |
| 11025E03-20 | ● | 25 | 20 | 35 | 85 | 120 | 3 | 0,26 | 2 |
| 11025E04 | ● | 25 | 25 | 35 | 85 | 120 | 4 | 0,39 | 2 |
| 11025E04-20 | ● | 25 | 20 | 35 | 85 | 120 | 4 | 0,26 | 2 |
| 11028E04 | ● | 28 | 25 | 35 | 85 | 120 | 4 | 0,41 | 1 |
| 11030E04 | ● | 30 | 25 | 40 | 90 | 130 | 4 | 0,46 | 1 |
| 11032E02 | ● | 32 | 32 | 40 | 90 | 130 | 2 | 0,74 | 1 |
| 11032E03 | ● | 32 | 32 | 40 | 90 | 130 | 3 | 0,73 | 1 |
| 11032E04 | ● | 32 | 32 | 40 | 90 | 130 | 4 | 0,73 | 2 |
| 11032E05 | ● | 32 | 32 | 40 | 90 | 130 | 5 | 0,72 | 2 |
| 11032E05-25 | ● | 32 | 25 | 40 | 90 | 130 | 5 | 0,46 | 2 |
| 11035E05 | ● | 35 | 32 | 40 | 90 | 130 | 5 | 0,75 | 2 |
| 11040E02 | ● | 40 | 32 | 30 | 120 | 150 | 2 | 0,96 | 2 |
| 11040E04 | ● | 40 | 32 | 30 | 120 | 150 | 4 | 0,94 | 2 |
| 11040E06 | ● | 40 | 32 | 30 | 120 | 150 | 6 | 0,93 | 2 |
| 11050E05 | ● | 50 | 32 | 30 | 120 | 150 | 5 | 1,04 | 2 |
| 11050E07 | ● | 50 | 32 | 30 | 120 | 150 | 7 | 1,04 | 2 |
| 11063E08 | ● | 63 | 32 | 30 | 120 | 150 | 8 | 1,24 | 2 |
| 11080E10 | ● | 80 | 32 | 30 | 120 | 150 | 10 | 1,52 | 2 |

Die Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZ 11014E01 | | | |
| 11016E02(-12) | BFTX0305IP | 2,0 | |
| 11018E02 | | | |
| 11020E02(-16) | | | |
| 11020E03(-16) | | | |
| 11022E03 | | | |
| 11025E02 | | | |
| 11025E03(-20) | | | |
| 11025E04(-20) | | | |
| 11028E04 | | | |
| 11030E04 | | | |
| 11032E02 | | | |
| 11032E03 | | | |
| 11032E04 | | | |
| 11032E05(-25) | BFTX0306IP | 1,5 | TRDR08IP |
| 11035E05 | | | |
| 11040E02 | | | |
| 11040E04 | | | |
| 11040E06 | | | |
| 11050E05 | | | |
| 11050E07 | | | |
| 11063E08 | | | |
| 11080E10 | | | |

Identifikation des Fräskörpers

WEZ 11 025 E 03 - 20

Fräserbezeichnung Plattengröße Fräserdurchmesser Schaftausführung Anzahl Zähne Schaftdurchmesser

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT11T324PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT11T330PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT11T332PEER)
Standard: R = 1 mm

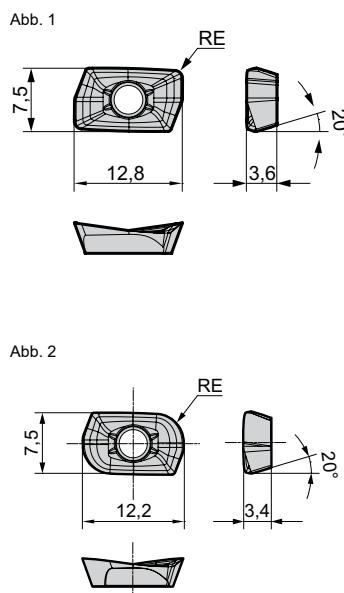
C: Fase
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|------------|-----|--------|------------------|-----|------|---|
| | P _M | P | K | K | M _S | N | P | | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. | |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | ● | 0,2 | 1 | |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | ● | 0,4 | 1 | |
| 11T305PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | □ | 0,5 | 1 | |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | ● | 0,8 | 1 | |
| 11T310PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | □ | 1,0 | 1 | |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | □ | 1,2 | 1 | |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 | |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,0 | 1 | |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,4 | 1 | |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,0 | 2 | |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,2 | 2 | |
| AOMT 11T304PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,2 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: verstärkte Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P16 ist anwendbar für Fräserdurchmesser Ø 14 mm und Ø 16 mm.
*P20 ist anwendbar für Fräserdurchmesser Ø 18 mm, Ø 20 mm.
*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm, Ø 28 mm.

■ Empfohlene Schnittbedingungen

→ S. 8

● = Eurolager
○ = Japanlager

□ = Auf Anfrage

15

■ = Nicht möglich

| | | |
|------------|--------|-------------|
| Spanwinkel | Radial | -14° – -18° |
| | Axial | 6° – 10° |



Abb. 1

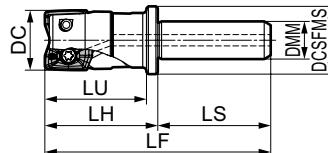
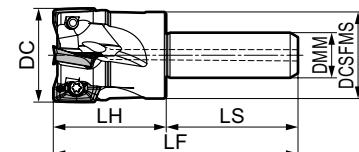


Abb. 2



■ WEZ-Fräskörper (Schaftfräser)

| Bezeichnung | Lager | Abmessungen (mm) | | | | | | | | | |
|------------------|-------|------------------|--------|-----|----|----|----|----|--------------|--------------|------|
| | | DC | DCSFMS | DMM | LH | LU | LS | LF | Anzahl Zähne | Gewicht (kg) | Abb. |
| WEZ 11014ES01-12 | ● | 14 | 18 | 12 | 30 | 27 | 35 | 65 | 1 | 0,05 | 1 |
| 11016ES02-10 | ● | 16 | 18 | 10 | 25 | 22 | 30 | 55 | 2 | 0,04 | 1 |
| 11016ES02-12 | ● | 16 | 18 | 12 | 30 | 27 | 35 | 65 | 2 | 0,05 | 1 |
| 11020ES03-10 | ● | 20 | 18 | 10 | 25 | — | 30 | 55 | 3 | 0,04 | 2 |
| 11020ES03-12 | ● | 20 | 18 | 12 | 30 | — | 35 | 65 | 3 | 0,06 | 2 |
| 11020ES03-16 | ● | 20 | 23 | 16 | 30 | 27 | 40 | 70 | 3 | 0,10 | 1 |
| 11025ES04-12 | ● | 25 | 23 | 12 | 30 | — | 35 | 65 | 4 | 0,09 | 2 |
| 11025ES04-16 | ● | 25 | 23 | 16 | 30 | — | 40 | 70 | 4 | 0,12 | 2 |

Die Schneidplatten werden separat verkauft.

■ Ersatzteile

| Geeignete Fräser | Schraube | Schlüssel |
|------------------|------------|-----------|
| | | |
| WEZ 11014ES01-12 | | |
| 11016ES02-10 | BFTX0305IP | |
| 11016ES02-12 | | |
| 11020ES03-10 | | |
| 11020ES03-12 | | |
| 11020ES03-16 | BFTX0306IP | |
| 11025ES04-12 | | |
| 11025ES04-16 | | |

■ Identifikation des Fräskörpers

| WEZ | 11 | 020 | E | S | 03 | - | 12 |
|-------------------|--------------|-------------------|------------------|---------------|--------------|---|-------------------|
| Fräserbezeichnung | Plattengröße | Fräserdurchmesser | Schaftausführung | Kurzer Schaft | Anzahl Zähne | | Schaftdurchmesser |

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.



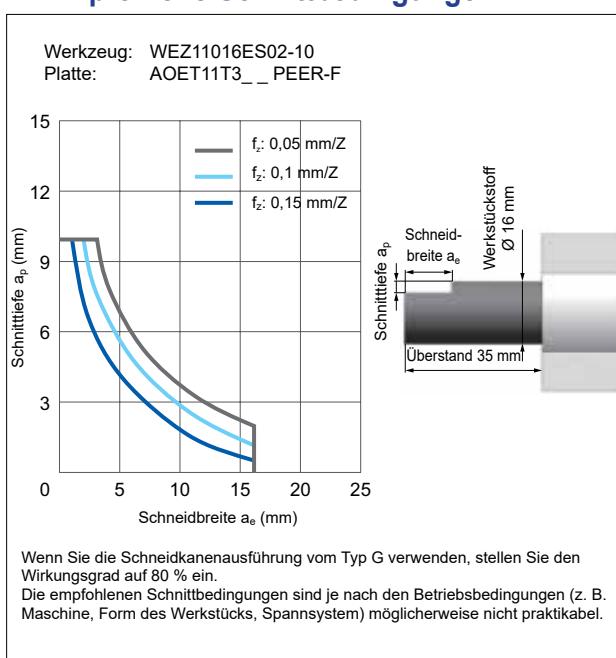
Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm
(AOMT11T324PEER)
Eckenradius = 3,0 mm: C = 1 mm
(AOMT11T330PEER)
Eckenradius = 3,2 mm: C = 1 mm
(AOMT11T332PEER)
Standard: R = 1 mm

C: Fase
R: Radius

■ Empfohlene Schnittbedingungen

→ S. 8

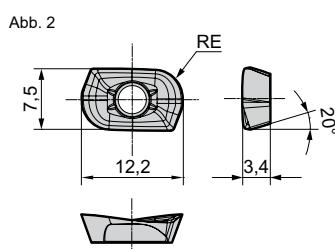
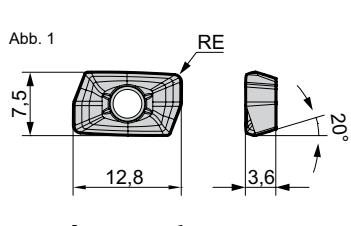


■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | P _M | P | K | K | M _S | N | P | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,2 | 1 |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,4 | 1 |
| 11T305PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 0,5 | 1 |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 11T310PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,0 | 1 |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,0 | 1 |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,4 | 1 |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,0 | 2 |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,2 | 2 |
| AOMT 11T304PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung

H: verstärkte Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P16 ist anwendbar für Fräserdurchmesser Ø 14 mm und Ø 16 mm.

*P20 ist anwendbar für Fräserdurchmesser Ø 18 mm, Ø 20 mm.

*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm, Ø 28 mm.

"WaveMill" Serie

WEZ 11000 EL



Abb. 1

| | | |
|------------|--------|------------|
| Spanwinkel | Radial | -7° – -18° |
| Axial | | 6° – 15° |

10 mm 90°

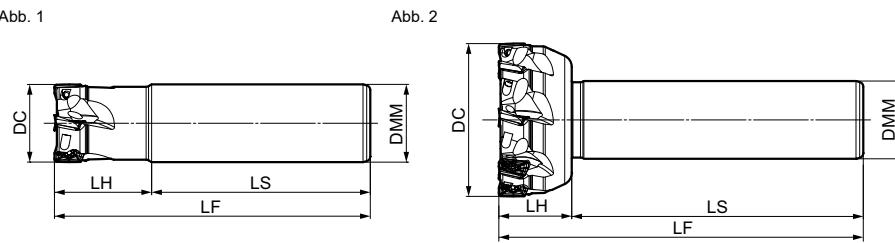


Abb. 2

WEZ-Fräskörper (Schaftfräser, lange Ausführung)

Abmessungen (mm)

| Bezeichnung | Lager | DC | DMM | LH | LS | LF | Anzahl Zähne | Gewicht (kg) | Abb. |
|---------------|-------|----|-----|----|-----|-----|--------------|--------------|------|
| WEZ 11014EL01 | ● | 14 | 16 | 25 | 95 | 120 | 1 | 0,16 | 1 |
| 11016EL02 | ● | 16 | 16 | 25 | 120 | 145 | 2 | 0,19 | 1 |
| 11016EL02-14 | ● | 16 | 14 | 25 | 120 | 145 | 2 | 0,15 | 2 |
| 11018EL02 | ● | 18 | 16 | 25 | 120 | 145 | 2 | 0,20 | 2 |
| 11020EL02 | ● | 20 | 20 | 40 | 110 | 150 | 2 | 0,31 | 1 |
| 11020EL02-18 | ● | 20 | 18 | 25 | 125 | 150 | 2 | 0,26 | 2 |
| 11022EL02 | ● | 22 | 20 | 30 | 120 | 150 | 2 | 0,32 | 2 |
| 11025EL02 | ● | 25 | 25 | 50 | 120 | 170 | 2 | 0,57 | 1 |
| 11025EL02-22 | ● | 25 | 22 | 30 | 140 | 170 | 2 | 0,46 | 2 |
| 11025EL03 | ● | 25 | 25 | 50 | 120 | 170 | 3 | 0,57 | 1 |
| 11028EL02 | ● | 28 | 25 | 30 | 140 | 170 | 2 | 0,60 | 2 |
| 11030EL02 | ● | 30 | 25 | 30 | 140 | 170 | 2 | 0,62 | 2 |
| 11032EL02 | ● | 32 | 32 | 60 | 110 | 170 | 2 | 0,97 | 1 |
| 11032EL02-30 | ● | 32 | 30 | 30 | 140 | 170 | 2 | 0,88 | 2 |
| 11032EL03 | ● | 32 | 32 | 60 | 110 | 170 | 3 | 0,96 | 1 |
| 11035EL02 | ● | 35 | 32 | 30 | 140 | 170 | 2 | 1,02 | 2 |
| 11035EL03 | ● | 35 | 32 | 30 | 140 | 170 | 3 | 1,00 | 2 |
| 11040EL02 | ● | 40 | 32 | 30 | 140 | 170 | 2 | 1,08 | 2 |
| 11050EL03 | ● | 50 | 32 | 30 | 140 | 170 | 3 | 1,19 | 2 |

Die Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZ 11014EL01 | | | |
| 11016EL02(-14) | BFTX0305IP | | |
| 11018EL02 | | | |
| 11020EL02(-18) | | | |
| 11022EL02 | | | |
| 11025EL02(-22) | | | |
| 11025EL03 | | | |
| 11028EL02 | | | |
| 11030EL02 | | | |
| 11032EL02(-30) | BFTX0306IP | 1,5 | TRDR08IP |
| 11032EL03 | | | |
| 11035EL02 | | | |
| 11035EL03 | | | |
| 11040EL02 | | | |
| 11050EL03 | | | |

Identifikation des Fräskörpers

WEZ 11 025 E L 02 - 22

Fräserbezeichnung Plattengröße Fräserdurchmesser Schauführung Langer Schaft Anzahl Zähne Schaftdurchmesser

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.

Modifizieren Sie diese Kante.



Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT11T324PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT11T330PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT11T332PEER)
Standard: R = 1 mm

C: Fase
R: Radius

Empfohlene Schnittbedingungen

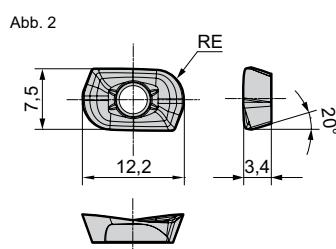
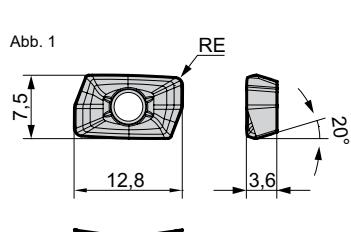
→ S. 8

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | P _M | P | K | K | M _S | N | P | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,2 | 1 |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,4 | 1 |
| 11T305PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 0,5 | 1 |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 11T310PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,0 | 1 |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,0 | 1 |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,4 | 1 |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,0 | 2 |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,2 | 2 |
| AOMT 11T304PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: verstärkte Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P16 ist anwendbar für Fräserdurchmesser Ø 14 mm und Ø 16 mm.

*P20 ist anwendbar für Fräserdurchmesser Ø 18 mm, Ø 20 mm.

*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm, Ø 28 mm.

"WaveMill" Serie

WEZ 17000 E



Abb. 1

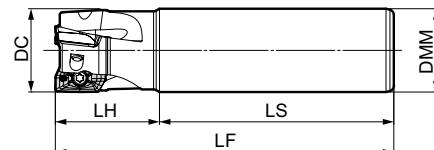
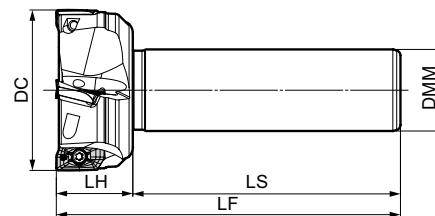


Abb. 2



WEZ-Fräskörper (Schaftfräser)

| Bezeichnung | Lager | Abmessungen (mm) | | | | | | | |
|--------------|-------|------------------|-----|----|-----|-----|--------------|--------------|------|
| | | DC | DMM | LH | LS | LF | Anzahl Zähne | Gewicht (kg) | Abb. |
| WEZ 17025E02 | ● | 25 | 25 | 35 | 85 | 120 | 2 | 0,38 | 1 |
| 17025E02-20 | ● | 25 | 20 | 35 | 85 | 120 | 2 | 0,25 | 2 |
| 17028E02 | ● | 28 | 25 | 35 | 85 | 120 | 2 | 0,40 | 2 |
| 17030E03 | ● | 30 | 25 | 40 | 90 | 130 | 3 | 0,43 | 2 |
| 17032E02 | ● | 32 | 32 | 40 | 90 | 130 | 2 | 0,71 | 1 |
| 17032E03 | ● | 32 | 32 | 40 | 90 | 130 | 3 | 0,69 | 1 |
| 17032E03-25 | ● | 32 | 25 | 40 | 90 | 130 | 3 | 0,44 | 2 |
| 17035E03 | ● | 35 | 32 | 40 | 90 | 130 | 3 | 0,72 | 2 |
| 17040E03 | ● | 40 | 32 | 30 | 105 | 135 | 3 | 0,81 | 2 |
| 17040E04 | ● | 40 | 32 | 30 | 105 | 135 | 4 | 0,79 | 2 |
| 17050E03 | ● | 50 | 32 | 30 | 105 | 135 | 3 | 0,93 | 2 |
| 17050E03-42 | ● | 50 | 42 | 30 | 105 | 135 | 3 | 1,41 | 2 |
| 17050E05 | ● | 50 | 32 | 30 | 105 | 135 | 5 | 0,89 | 2 |
| 17050E05-42 | ● | 50 | 42 | 30 | 105 | 135 | 5 | 1,37 | 2 |
| 17063E04 | ● | 63 | 32 | 30 | 105 | 135 | 4 | 1,10 | 2 |
| 17063E04-42 | ● | 63 | 42 | 30 | 105 | 135 | 4 | 1,58 | 2 |
| 17063E06 | ● | 63 | 32 | 30 | 105 | 135 | 6 | 1,08 | 2 |
| 17063E06-42 | ● | 63 | 42 | 30 | 105 | 135 | 6 | 1,56 | 2 |
| 17080E07 | ● | 80 | 32 | 30 | 105 | 135 | 7 | 1,39 | 2 |

Die Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | Schlüssel |
|-------------------|------------|-----------|
| | | |
| WEZ 17025E02(-20) | | |
| 17028E02 | BFTX0407IP | |
| 17030E03 | | |
| 17032E02 | | |
| 17032E03(-25) | | |
| 17035E03 | | |
| 17040E03 | | |
| 17040E04 | | |
| 17050E03(-42) | | |
| 17050E05(-42) | | |
| 17063E04(-42) | | |
| 17063E06(-42) | | |
| 17080E07 | | |

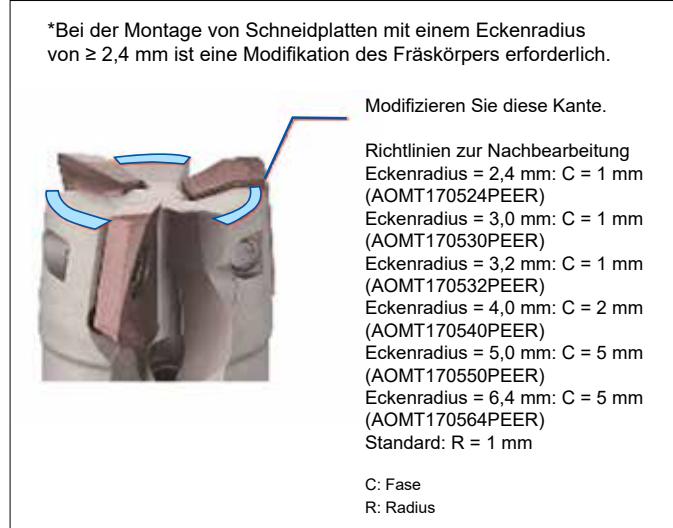
Empfohlene Schnittbedingungen

→ S. 8

Identifikation des Fräskörpers

WEZ 17 025 E 02 - 20

Fräser-bezeichnung Platten-größe Fräser-durchmesser Schaft-ausführung Anzahl Zähne Schaft-durchmesser

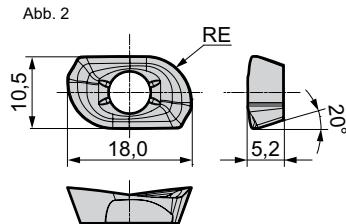
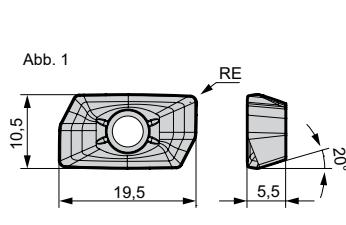


■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|--------|-----|------------|--------|--------|------------------|---|
| | P _M | P | K | K | M _S | N | P | | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. | |
| AOMT 170502PEER-L | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | □ | 0,2 | 1 |
| 170504PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,4 | 1 |
| 170508PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,8 | 1 |
| 170512PEER-L | ● | — | — | □ | — | — | □ | ● | ● | — | — | — | — | 1,2 | 1 |
| 170516PEER-L | ● | — | — | □ | — | — | □ | ● | ● | — | — | — | — | 1,6 | 1 |
| AOMT 170502PEER-G | ● | ● | ○ | □ | ● | — | □ | ● | ● | — | — | — | □ | 0,2 | 1 |
| 170504PEER-G | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | — | ● | 0,4 | 1 |
| 170505PEER-G | ● | ● | ○ | □ | □ | — | □ | □ | ● | — | — | — | □ | 0,5 | 1 |
| 170508PEER-G | ● | ○ | ● | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,8 | 1 |
| 170510PEER-G | ● | — | — | □ | — | — | □ | □ | ● | — | — | — | □ | 1,0 | 1 |
| 170512PEER-G | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | □ | 1,2 | 1 |
| 170516PEER-G | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | — | — | □ | □ | — | □ | □ | ● | — | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | — | — | □ | □ | — | □ | ● | ● | — | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | — | 5,0 | 2 |
| 170564PEER-G | □ | — | — | □ | □ | — | □ | ● | ● | — | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ○ | ● | ● | ○ | — | ● | ● | ● | — | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ○ | ● | ● | ○ | — | ● | ● | ● | — | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | — | — | □ | □ | — | □ | □ | ● | — | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | — | — | □ | ● | — | □ | ● | ● | — | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170502PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 6,4 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: verstärkte Schneidkante
F: Schlitten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

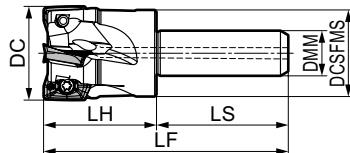
*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm und Ø 28 mm.
*P32 ist anwendbar für Fräserdurchmesser Ø 30 mm, Ø 32 mm und Ø 35 mm.

| | | |
|------------|--------|-------------|
| Spanwinkel | Radial | -10° – -12° |
| | Axial | 6° – 8° |

15 mm 90°



Abb. 1



■ WEZ-Fräskörper (Schaftfräser)

| Bezeichnung | Lager | DC | DCSFMS | DMM | LH | LS | LF | Anzahl Zähne | Gewicht (kg) | Abb. |
|------------------|-------|----|--------|-----|----|----|----|--------------|--------------|------|
| WEZ 17025ES02-16 | ● | 25 | 23 | 16 | 30 | 40 | 70 | 2 | 0,11 | 1 |
| 17032ES03-16 | ● | 32 | 27 | 16 | 30 | 40 | 70 | 3 | 0,14 | 1 |

Die Schneidplatten werden separat verkauft.

■ Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZ 17025ES02-16 | BFTX0407IP | 3,0 | TRDR15IP |
| 17032ES03-16 | BFTX0409IP | | |

■ Identifikation des Fräskörpers

WEZ 17 025 E S 02 - 16

Fräserbezeichnung Plattengröße Fräserdurchmesser Schaftrausführung Kurzer Schaft Anzahl Zähne Schaftdurchmesser

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.

Modifizieren Sie diese Kante.



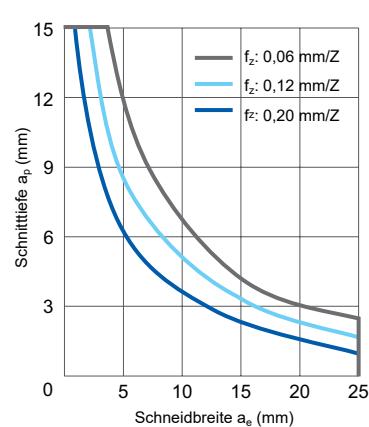
Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT170524PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT170530PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT170532PEER)
Eckenradius = 4,0 mm: C = 2 mm (AOMT170540PEER)
Eckenradius = 5,0 mm: C = 5 mm (AOMT170550PEER)
Eckenradius = 6,4 mm: C = 5 mm (AOMT170564PEER)
Standard: R = 1 mm

C: Fase
R: Radius

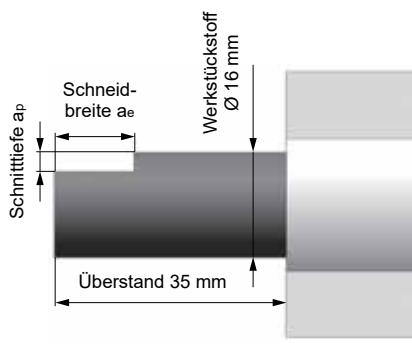
■ Empfohlene Schnittbedingungen

→ S. 8

Werkzeug: WEZ17025ES02-16
Platte: AOET1705__PEER-F



Wenn Sie Spanbrecher vom Typ G verwenden, stellen Sie den Wirkungsgrad auf 80 % ein.
Die empfohlenen Schnittbedingungen sind je nach den Betriebsbedingungen (z. B. Maschine, Form des Werkstücks, Spannsystem) möglicherweise nicht praktikabel.

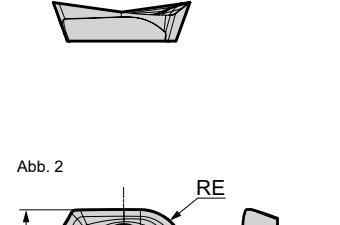
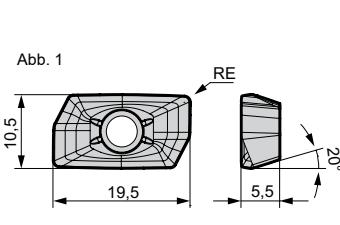


■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | | | |
|--------------------------------|--------------------------|---------|---------|---------|---------|---------|---------|--------|------------|-----|--------|------------------|-----|-----|-----|---|
| Hochgeschw./ Leichtbearbeitung | | | | | | | | | | | | | | | | |
| Allgemeine Anwendung | | | | | | | | | | | | | | | | |
| Schruppen | | | | | | | | | | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | | | | |
| AOMT 170502PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | 0,2 | 1 | | |
| 170504PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,4 | 1 | |
| 170508PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,8 | 1 | |
| 170512PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 1,2 | 1 | |
| 170516PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 1,6 | 1 | |
| AOMT 170502PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 0,2 | 1 | |
| 170504PEER-G | ● | ○ | — | ● | ● | — | ○ | ● | ● | — | — | — | ● | 0,4 | 1 | |
| 170505PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 | |
| 170508PEER-G | ● | ○ | — | ● | ● | — | ○ | ● | ● | — | — | — | ● | 0,8 | 1 | |
| 170510PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-G | — | — | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ○ | ● | ● | ○ | — | — | ● | ● | — | — | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ○ | ● | ● | ○ | — | — | ● | ● | — | — | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170502PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | — | 6,4 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: verstärkte Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm und Ø 28 mm.
*P32 ist anwendbar für Fräserdurchmesser Ø 30 mm, Ø 32 mm und Ø 35 mm.

"WaveMill" Serie

WEZ 17000 EL



Abb. 1

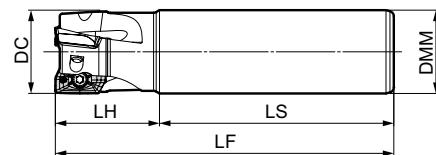
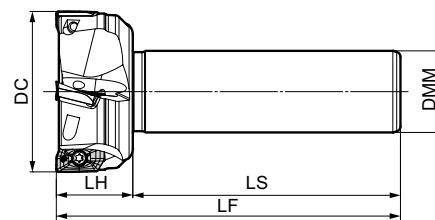


Abb. 2



| | | |
|------------|--------|------------|
| Spanwinkel | Radial | -6° – -12° |
| Axial | | 6° – 15° |

15 mm 90°

WEZ-Fräskörper (Schaftfräser, lange Ausführung)

Abmessungen (mm)

| Bezeichnung | Lager | DC | DMM | LH | LS | LF | Anzahl Zähne | Gewicht (kg) | Abb. |
|---------------|-------|----|-----|----|-----|-----|--------------|--------------|------|
| WEZ 17025EL02 | ● | 25 | 25 | 50 | 120 | 170 | 2 | 0,55 | 1 |
| 17028EL02 | ● | 28 | 25 | 50 | 120 | 170 | 2 | 0,57 | 2 |
| 17030EL02 | ● | 30 | 25 | 50 | 120 | 170 | 2 | 0,59 | 2 |
| 17032EL02 | ● | 32 | 32 | 60 | 110 | 170 | 2 | 0,94 | 1 |
| 17032EL02-30 | ● | 32 | 30 | 50 | 120 | 170 | 2 | 0,85 | 2 |
| 17032EL03 | ● | 32 | 32 | 60 | 110 | 170 | 3 | 0,92 | 1 |
| 17035EL02 | ● | 35 | 32 | 50 | 120 | 170 | 2 | 0,98 | 2 |
| 17040EL02 | ● | 40 | 32 | 50 | 120 | 170 | 2 | 1,09 | 2 |
| 17040EL03 | ● | 40 | 32 | 50 | 120 | 170 | 3 | 1,08 | 2 |
| 17040EL04 | ● | 40 | 32 | 50 | 120 | 170 | 4 | 1,05 | 2 |
| 17050EL03 | ● | 50 | 32 | 50 | 120 | 170 | 3 | 1,29 | 2 |
| 17050EL03-42 | ● | 50 | 42 | 50 | 120 | 170 | 3 | 1,83 | 2 |
| 17050EL05 | ● | 50 | 32 | 50 | 120 | 170 | 5 | 1,25 | 2 |
| 17050EL05-42 | ● | 50 | 42 | 50 | 120 | 170 | 5 | 1,79 | 2 |
| 17063EL04 | ● | 63 | 32 | 50 | 120 | 170 | 4 | 1,61 | 2 |
| 17063EL04-42 | ● | 63 | 42 | 50 | 120 | 170 | 4 | 2,16 | 2 |
| 17063EL06 | ● | 63 | 32 | 50 | 120 | 170 | 6 | 1,58 | 2 |
| 17063EL06-42 | ● | 63 | 42 | 50 | 120 | 170 | 6 | 2,13 | 2 |

Die Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | Schlüssel |
|------------------|------------|-----------|
| | | |
| WEZ 17025EL02 | | |
| 17028EL02 | BFTX0407IP | |
| 17030EL02 | | |
| 17032EL02(-30) | | |
| 17032EL03 | | |
| 17035EL02 | | |
| 17040EL02 | | |
| 17040EL03 | | |
| 17040EL04 | | |
| 17050EL03(-42) | | |
| 17050EL05(-42) | | |
| 17063EL04(-42) | | |
| 17063EL06(-42) | | |

Identifikation des Fräskörpers

WEZ 17 032 E L 02 - 30

Fräser- Platten- Fräser- Schaft- Langer Anzahl Schaft- bezeichnung größe durchmesser ausführung Schaft Schaft Zähne durchmesser

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm
(AOMT170524PEER)

Eckenradius = 3,0 mm: C = 1 mm
(AOMT170530PEER)

Eckenradius = 3,2 mm: C = 1 mm
(AOMT170532PEER)

Eckenradius = 4,0 mm: C = 2 mm
(AOMT170540PEER)

Eckenradius = 5,0 mm: C = 5 mm
(AOMT170550PEER)

Eckenradius = 6,4 mm: C = 5 mm
(AOMT170564PEER)

Standard: R = 1 mm

C: Fase
R: Radius

Empfohlene Schnittbedingungen

→ S. 8

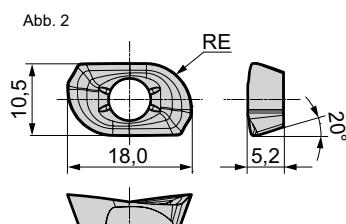
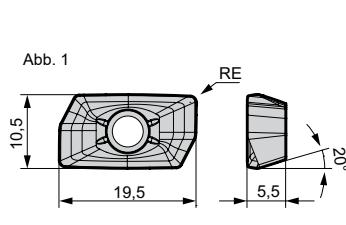
● = Eurolager

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|--------|-----|------------|--------|--------|------------------|---|
| | P _M | P | K | K | M _S | N | P | | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. | |
| AOMT 170502PEER-L | ● | ● | — | — | — | — | — | ● | ● | — | — | — | □ | 0,2 | 1 |
| 170504PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,4 | 1 |
| 170508PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,8 | 1 |
| 170512PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 1,2 | 1 |
| 170516PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 1,6 | 1 |
| AOMT 170502PEER-G | ● | ● | ○ | — | ● | ● | ○ | — | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-G | ● | ● | ○ | ● | ● | ● | ○ | ● | ● | ● | — | — | ● | 0,4 | 1 |
| 170505PEER-G | ● | ● | ○ | — | — | — | — | — | — | — | — | — | □ | 0,5 | 1 |
| 170508PEER-G | ● | ○ | ● | ● | ● | ○ | ● | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 170510PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | □ | 1,0 | 1 |
| 170512PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | □ | 1,2 | 1 |
| 170516PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-G | □ | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | — | — | — | ● | — | — | — | — | — | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170502PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 6,4 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: verstärkte Schneidkante
F: Schlitten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm und Ø 28 mm.
*P32 ist anwendbar für Fräserdurchmesser Ø 30 mm, Ø 32 mm und Ø 35 mm.



■ Merkmale

● Hocheffizientes Schulterfräsen

Die Wendeschneidplatten für den WEZ-Walzenstirnfräser "WaveMill" sind in mehreren Stufen angeordnet und bilden dadurch eine lange Schneidkante, um ein hocheffizientes Schulterfräsen von tiefen Stufen zu ermöglichen.

● Sehr geringe Vibrationsneigung

Scharfe Wendeschneidplatten und eine ungleiche Zahnteilung tragen zur Reduzierung von Rattermarken durch Vibratonen bei.

● Geeignet für alle Arten von Werkstoffen

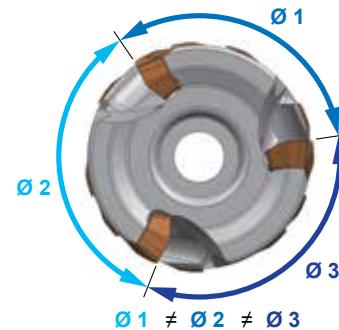
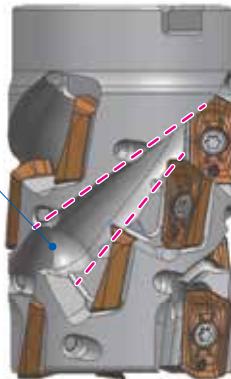
Neben einer Reihe von werkstoffspezifischen Sorten gibt es auch die Allzwecksorte ACU2500, die für Stahl, Edelstahl und Gusseisen geeignet ist.

■ Eigenschaften

● Verbesserte Spannutenform

● Ungleiche Zahnteilung

Optimierte, nach oben verjüngte Spantaschengeometrie für verbesserte Spanabfuhr und Erhöhung der Steifigkeit des Fräskörpers.



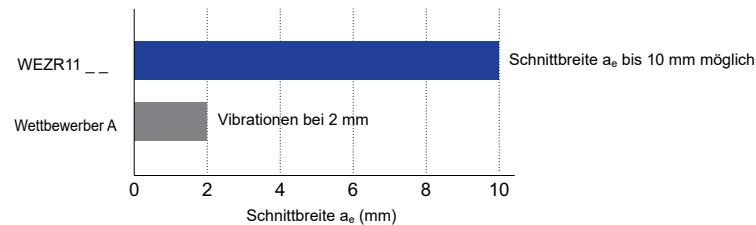
Die ungleiche Zahnteilung reduziert die Vibrationsneigung

■ Schnittleistung

● Deutlich weniger Vibratonen ergeben sich aus der Kombination von scharfen Wendeschneidplatten und ungleichmäßiger Zahnteilung.

Stabile Bearbeitung auch mit BT40-Spindelmaschinen möglich

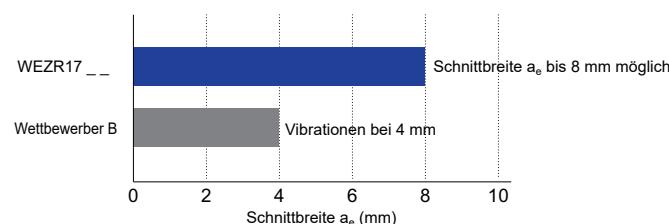
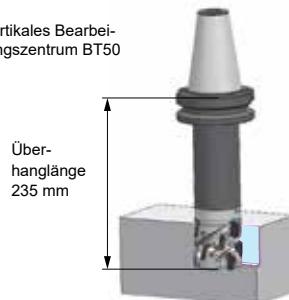
Vertikales Bearbeitungszentrum BT40



Maschine: Vertikales Bearbeitungszentrum BT40, C55, Überlängle 60 mm
Werkstückstoff: WEZR 11032E3632Z03 (Ø 32, 3 Zähne, 4-stufig)
Fräser: AOET11T308PEER-G (ACU2500)
Schneidplatte: Schnittdaten: $v_c = 150 \text{ m/min}$, $f_z = 0,1 \text{ mm/Z}$, $a_p = 30 \text{ mm}$, trocken

Geeignet für die stabile Bearbeitung auch bei langem Überhang

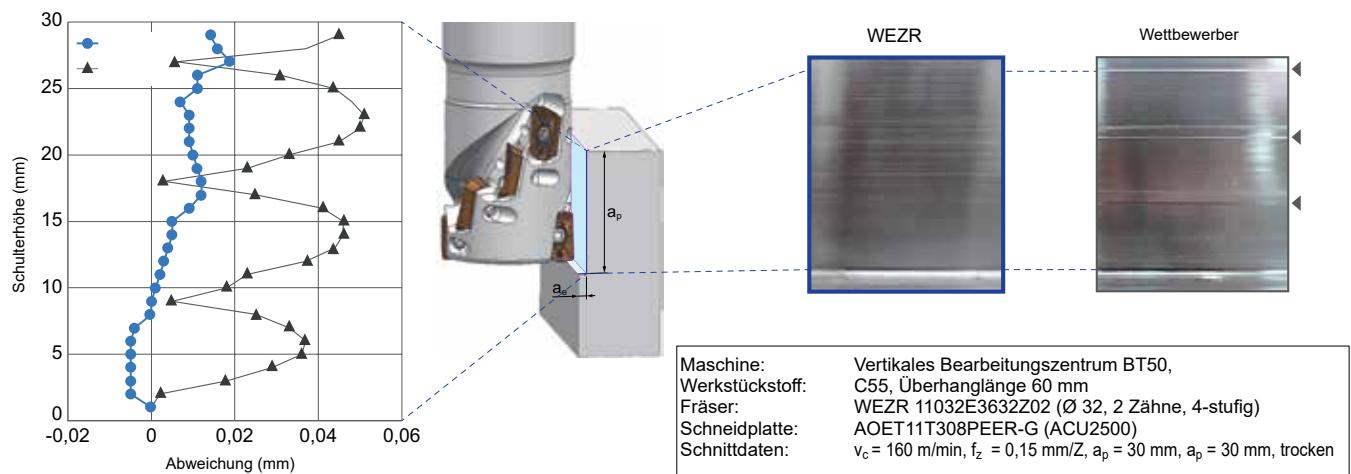
Vertikales Bearbeitungszentrum BT50



Maschine: Vertikales Bearbeitungszentrum BT50, 42CrMo4
Werkstückstoff: WEZR 17063R5727Z04 (Ø 63, 4 Zähne, 4-stufig)
Fräser: AOET170508PEER-G (ACU2500)
Schneidplatte: Schnittdaten: $v_c = 150 \text{ m/min}$, $f_z = 0,15 \text{ mm/Z}$, $a_p = 50 \text{ mm}$, trocken

■ Schnittleistung

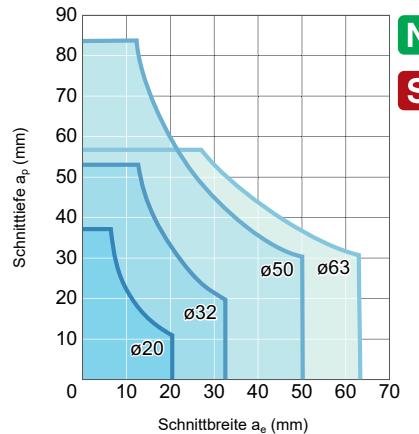
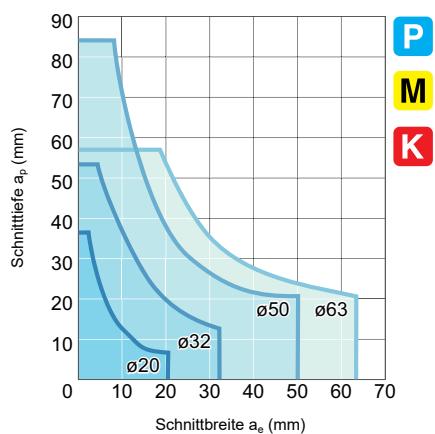
- Die optimierte Schneidenform und die hochpräzise Sintertechnologie führen zu einer hervorragenden Schultergenauigkeit.



■ Anwendungsbereich

- Stahl, rostfreier Stahl, Gusseisen

- Aluminiumlegierungen, Titanlegierungen



Hinweis:

Die oben angegebenen Schnitttiefen sind Richtwerte für den Einsatz auf BT50-Werkzeugmaschinen. Bei Einsatz einer BT40-Werkzeugmaschine sollte eine Schnitttiefe von ca. 50% gewählt werden.

Bei einem Werkzeugüberstand von $L/D = 3$ oder $L/D = 4$ ist eine Schnitttiefe von ca. 50% bzw. 25% zu empfehlen.

In Abhängigkeit von der Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass eine Bearbeitung mit den oben genannten Schnitttiefen nicht möglich ist.

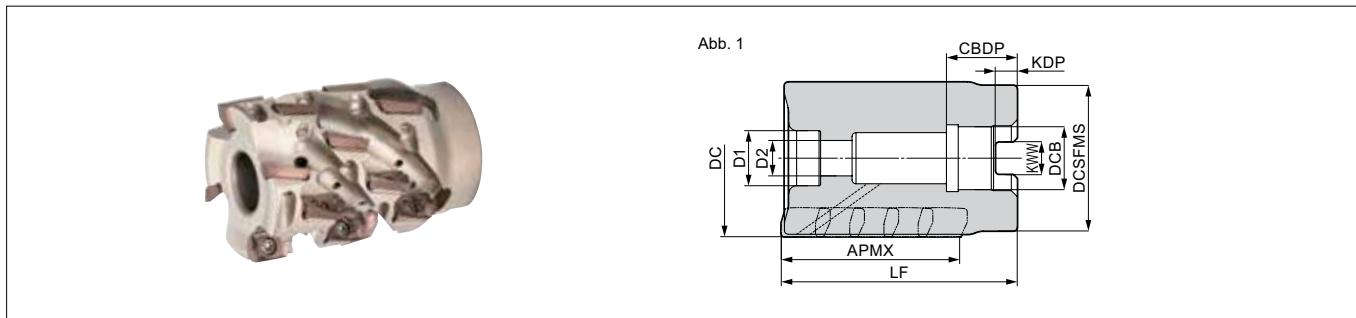
Angaben zur Schnittgeschwindigkeit und zum Vorschub finden Sie auf den nächsten Seiten.

"WaveMill" Serie

WEZR 11000 RS

Walzenstirnfräser

| | | | | |
|------------|--------|------------|----------|-----|
| Spanwinkel | Radial | -11° - -9° | 44-53 mm | 90° |
| Axial | | 14° - 15° | | |



WEZR-Fräskörper (Aufsteckfräser)

| Metrisch | Bezeichnung | Lager | DC | APMX | DCSFMS | LF | DCB | KWW | KDP | CBDP | D1 | D2 | Gesamtzahl Zähne | Stufen | Abmessungen (mm) | | |
|----------|---------------------|-------|----|------|--------|----|-----|------|-----|------|----|----|---------------------|--------|------------------------|-----------------|------|
| | | | | | | | | | | | | | | | Effective Zähnezahl | Gewicht (kg) | Abb. |
| | WEZR 11040RS4416Z04 | ○ | 40 | 44 | 37 | 60 | 16 | 8,4 | 5,6 | 18 | 14 | 9 | 20 | 5 | 4 | 0,27 | 1 |
| | 11050RS5322Z04 | ○ | 50 | 53 | 47 | 70 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | 24 | 6 | 4 | 0,57 | 1 |

Überprüfen Sie bei der Auswahl des Fräzers die Größe der Aufnahme (DCB). Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel | | Schraube | |
|---------------------|------------|-----|-----------|--|----------|--|
| | | | | | | |
| WEZR 11040RS4416Z04 | BFTX0306IP | 1,5 | TRDR08IP | | BX0850 | |
| 11050RS5322Z04 | | | | | BX1060 | |

Identifikation des Fräskörpers

WEZR 11 040 R S 44 16 Z04

| Fräserbezeichnung | Plattengröße | Fräserdurchmesser | Schneidrichtung | Metrisch | Max. Schnitttiefe | Durchm. des Bohrlochs | Effektive Zahnezahl |
|-------------------|--------------|-------------------|-----------------|----------|-------------------|-----------------------|---------------------|
|-------------------|--------------|-------------------|-----------------|----------|-------------------|-----------------------|---------------------|

Empfohlene Schnittbedingungen

| ISO | Werkstückstoff | Härte (HB) | Schneidstoff neigung | Schnittgeschwindigkeit v_c (m/min) | Vorschub f_z (mm/t) | Schneidstoffsorte |
|-----|--------------------------------|---------------------|-------------------------|--------------------------------------|-----------------------|--|
| P | Kohlenstoffstahl | $\leq 280\text{HB}$ | G | 100-150-200 | 0,08-0,12-0,20 | ACU2500 XCU2500 ACP2000 |
| | | $> 280\text{HB}$ | G | 80-100-120 | 0,08-0,12-0,20 | ACP3000 |
| M | Legierter Stahl | $\leq 280\text{HB}$ | G | 100-150-80 | 0,08-0,12-0,20 | ACU2500 ACM200 ACM300 |
| K | Rostfreier Stahl | $\leq 280\text{HB}$ | G | 80-120-160 | 0,08-0,12-0,20 | ACU2500 XCK2000 ACK2000 ACK3000 |
| S | Grauguss/ Kugelgraphitguss | - | G | 100-150-200 | 0,08-0,12-0,20 | ACU2500 XCK2000 ACK2000 ACK3000 |
| S | Hitzebeständige Legierungen | - | G | 40-50-60 | 0,08-0,12-0,20 | ACU2500 ACM200 ACM300 |
| N | Aluminium- legierung | Si $\leq 12,6\%$ | S | 300-500-800 | 0,05-0,10-0,15 | DL2000 |
| | | Si $> 12,6\%$ | S | 100-200-250 | 0,05-0,10-0,15 | H20 |

Min. - Optimum - Max.

Hinweis:

Die oben genannten Schnittbedingungen sind ein Richtwert. Die tatsächlichen Bedingungen müssen entsprechend der Maschinensteifigkeit, der Werkstückspannung, der Schnitttiefe und weiteren Faktoren angepasst werden.

Je nach Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass die Bearbeitung nicht unter den empfohlenen Bedingungen durchgeführt werden kann.

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4\text{ mm}$ ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm
(AOMT11T324PEER)

Eckenradius = 3,0 mm: C = 1 mm
(AOMT11T330PEER)

Eckenradius = 3,2 mm: C = 1 mm
(AOMT11T332PEER)

Standard: R = 1 mm

C: Fase
R: Radius

"Wave Mill" Serie WEZR 11000 RS

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | P _M | P | K | K | M _S | N | P | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,2 | 1 |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,4 | 1 |
| 11T305PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 0,5 | 1 |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | ● | 0,8 | 1 |
| 11T310PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,0 | 1 |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,0 | 1 |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,4 | 1 |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,0 | 2 |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,2 | 2 |
| AOMT 11T304PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 2 |

Abb. 1

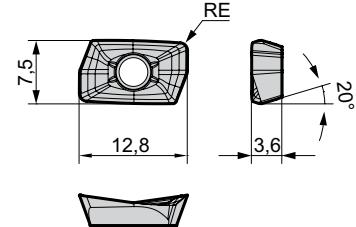
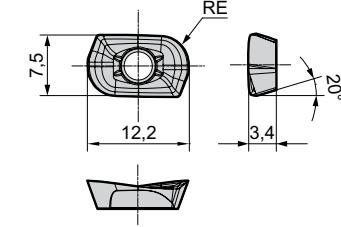


Abb. 2



L: geringe Schnittkraft

G: allgemeine Anwendung

H: stabile Schneidkante

F: Schlichten

P: Hochpräzisionsbearbeitung

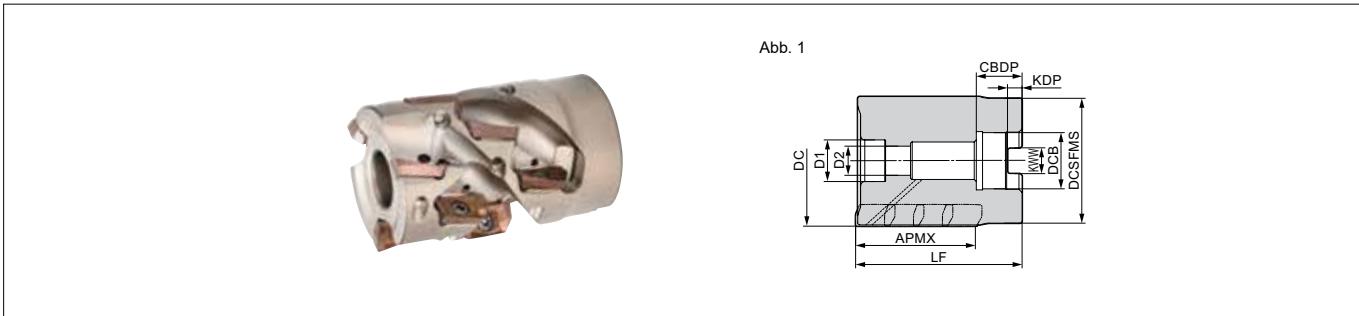
S: Nichtleisenmetalle

"WaveMill" Serie

WEZR 17000 RS

Walzenstirnfräser

| | | | |
|------------|--------|----------|----------|
| Spanwinkel | Radial | -8° - -6 | 29-57 mm |
| Axial | | 7° - 15° | |



WEZR-Fräskörper (Aufsteckfräser)

| Bezeichnung | | Lager | DC | APMX | DCSFMS | LF | DCB | KWW | KDP | CBDP | D1 | D2 | Gesamtzahl Zähne | Stufen | Effective Zahnezahl | Gewicht (kg) | Abb. |
|-------------|---------------------|-------|----|------|--------|----|-----|------|-----|------|----|----|------------------|--------|---------------------|--------------|------|
| Metrisch | WEZR 17050RS2922Z04 | ○ | 40 | 29 | 47 | 50 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | 8 | 2 | 4 | 0,35 | 1 |
| | 17050RS5722Z02 | ○ | 50 | 57 | 47 | 80 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | 8 | 4 | 2 | 0,70 | 1 |
| | 17050RS5722Z03 | ○ | 50 | 57 | 47 | 80 | 22 | 10,4 | 6,3 | 20 | 18 | 11 | 12 | 4 | 3 | 0,59 | 1 |
| | 17063RS2927Z05 | ○ | 63 | 29 | 60 | 55 | 27 | 12,4 | 7 | 22 | 20 | 14 | 10 | 2 | 5 | 0,74 | 1 |
| | 17063RS5727Z03 | ○ | 63 | 57 | 60 | 80 | 27 | 12,4 | 7 | 22 | 20 | 14 | 12 | 4 | 3 | 1,11 | 1 |
| | 17063RS5727Z04 | ○ | 63 | 57 | 60 | 80 | 27 | 12,4 | 7 | 22 | 20 | 14 | 16 | 4 | 4 | 1,05 | 1 |
| | 17080RS5627Z05 | ○ | 80 | 56 | 70 | 80 | 27 | 12,4 | 7 | 22 | 20 | 14 | 20 | 4 | 5 | 1,85 | 1 |
| | 17080RS5632Z05 | ○ | 80 | 56 | 70 | 80 | 32 | 14,4 | 8 | 26 | 25 | 18 | 20 | 4 | 5 | 1,76 | 1 |

Überprüfen Sie bei der Auswahl des Fräzers die Größe der Aufnahme (DCB). Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | Schlüssel | Handgriff | Bit | Schraube |
|---------------------|----------|-----------|-----------|----------|----------|
| | | | | | |
| WEZR 17050RS2922Z04 | | | | | BX1045 |
| 17050RS5722Z02 | | | | | BX1070 |
| 17050RS5722Z03 | | | – | HPS1015 | TRB15IP |
| 17063RS2927Z05 | | | | | BX1240 |
| 17063RS5727Z03 | | | | | BX1265 |
| 17063RS5727Z04 | | | | | BX1265 |
| 17080RS5627Z05 | | | | TRDR15IP | – |
| 17080RS5632Z05 | | | | – | BX1660 |

Identifikation des Fräskörpers

WEZR 17 050 R S 29 22 Z04

| | | | | | | | |
|-------------------|--------------|-------------------|-----------------|----------|-------------------|-----------------------|---------------------|
| Fräserbezeichnung | Plattengröße | Fräserdurchmesser | Schneidrichtung | Metrisch | Max. Schnitttiefe | Durchm. des Bohrlochs | Effektive Zahnezahl |
|-------------------|--------------|-------------------|-----------------|----------|-------------------|-----------------------|---------------------|

Empfohlene Schnittbedingungen

| ISO | Werkstückstoff | Härte (HB) | Schneidplatte (empfohlen) | Schnittgeschwindigkeit v_c (m/min) | Vorschub f_z (mm/t) | Schneidstoffsorte |
|-----|-----------------------------|--------------------------|---------------------------|--------------------------------------|----------------------------------|---------------------------------|
| P | Kohlenstoffstahl | ≤ 280HB | G | 100–150–200 | 0,10–0,20–0,30 | ACU2500 XCU2500 ACP2000 |
| | | > 280HB | G | 80–100–120 | 0,10–0,20–0,30 | ACP3000 |
| M | Legierter Stahl | ≤ 280HB | G | 100–150–80 | 0,10–0,20–0,30 | ACP3000 |
| M | Rostfreier Stahl | ≤ 280HB | G | 80–120–160 | 0,10–0,20–0,30 | ACU2500 ACM200 ACM300 |
| | | > 280HB | G | 80–100–120 | 0,10–0,20–0,30 | ACM3000 |
| K | Grauguss/ Kugelgraphitguss | – | G | 100–150–200 | 0,10–0,20–0,30 | ACU2500 XCK2000 ACK2000 ACK3000 |
| S | Hitzebeständige Legierungen | – | G | 40–50–60 | 0,10–0,20–0,30 | ACU2500 ACM200 ACM300 |
| N | Aluminiumlegierung | Si ≤ 12,6% Si > 12,6% | S | 300–500–800 100–200–250 | 0,05–0,10–0,15 0,05–0,10–0,15 | DL2000 H20 |

Hinweis:

Die oben genannten Schnittbedingungen sind ein Richtwert. Die tatsächlichen Bedingungen müssen entsprechend der Maschinensteifigkeit, der Werkstückspannung, der Schnitttiefe und weiteren Faktoren angepasst werden.

Je nach Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass die Bearbeitung nicht unter den empfohlenen Bedingungen durchgeführt werden kann.

*Bei der Montage von Schneidplatten mit einem Eckenradius von ≥ 2,4 mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT170524PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT170530PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT170532PEER)
Eckenradius = 4,0 mm: C = 2 mm (AOMT170540PEER)
Eckenradius = 5,0 mm: C = 5 mm (AOMT170550PEER)
Eckenradius = 6,4 mm: C = 5 mm (AOMT170564PEER)
Standard: R = 1 mm
C: Fase
R: Radius

"Wave Mill" Serie WEZR 17000 RS

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|---------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | K P M | P | K | K | M S | M S | M S | N P | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 170502PEER-L | ● | ● | — | □ | — | — | □ | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-L | ● | ● | ○ | — | ● | ○ | — | ● | ● | — | — | ● | 0,4 | 1 |
| 170508PEER-L | ● | ● | ○ | — | ● | ○ | — | ● | ● | — | — | ● | 0,8 | 1 |
| 170512PEER-L | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 1,2 | 1 |
| 170516PEER-L | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 1,6 | 1 |
| AOMT 170502PEER-G | ● | ● | ○ | □ | ● | ○ | □ | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-G | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | ● | 0,4 | 1 |
| 170505PEER-G | ● | ● | ○ | □ | □ | ○ | □ | □ | ● | — | — | □ | 0,5 | 1 |
| 170508PEER-G | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 170510PEER-G | ● | ● | — | □ | □ | — | □ | □ | ● | — | — | □ | 1,0 | 1 |
| 170512PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | □ | 1,2 | 1 |
| 170516PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 5,0 | 2 |
| 170564PEER-G | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 6,4 | 2 |

Abb. 1

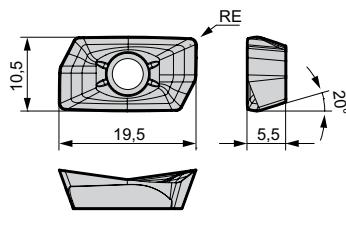
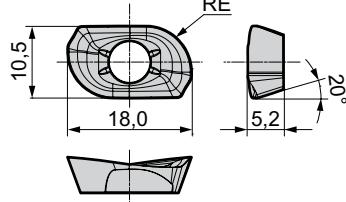


Abb. 2



L: geringe Schnittkraft
G: allgemeine Anwendung
H: stabile Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

| | | | | |
|------------|--------|-------------|----------|-----|
| Spanwinkel | Radial | -15° – -11° | 19–61 mm | 90° |
| Axial | | 8° – 14° | | |



Abb. 1

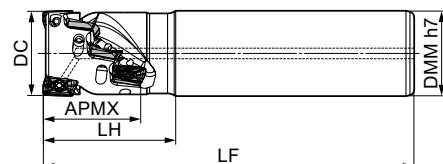
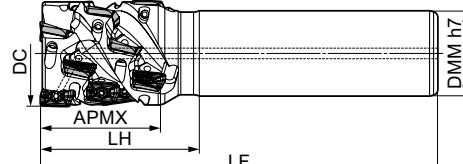


Abb. 2



■ WEZR-Fräskörper (Schaftfräser)

| Bezeichnung | Lager | DC | APMX | DMM | LH | LF | Gesamtzahl Zähne | Stufen | Abmessungen (mm) | | |
|--------------------|-------|----|------|-----|----|-----|------------------|--------|---------------------|--------------|------|
| | | | | | | | | | Effective Zähnezahl | Gewicht (kg) | Abb. |
| WEZR 11020E1920Z02 | ○ | 20 | 19 | 20 | 30 | 110 | 4 | 2 | 2 | 0,22 | 1 |
| 11020E3620Z01 | ○ | 20 | 36 | 20 | 45 | 125 | 4 | 4 | 1 | 0,24 | 1 |
| 11025E2725Z02 | ○ | 25 | 27 | 25 | 40 | 130 | 6 | 3 | 2 | 0,41 | 1 |
| 11025E3625Z02 | ○ | 25 | 36 | 25 | 50 | 140 | 8 | 4 | 2 | 0,42 | 1 |
| 11030E5325Z02 | ○ | 30 | 53 | 25 | 65 | 155 | 12 | 6 | 2 | 0,52 | 2 |
| 11032E3632Z02 | ○ | 32 | 36 | 32 | 50 | 140 | 8 | 4 | 2 | 0,74 | 1 |
| 11032E3632Z03 | ○ | 32 | 36 | 32 | 50 | 140 | 12 | 4 | 3 | 0,71 | 1 |
| 11032E5332Z02 | ○ | 32 | 53 | 32 | 70 | 160 | 12 | 6 | 2 | 0,90 | 1 |
| 11035E5332Z03 | ○ | 35 | 53 | 32 | 65 | 155 | 18 | 6 | 3 | 0,88 | 2 |
| 11040E4432Z03 | ○ | 40 | 44 | 32 | 60 | 150 | 15 | 5 | 3 | 0,87 | 2 |
| 11040E4432Z04 | ○ | 40 | 44 | 32 | 60 | 150 | 20 | 5 | 4 | 0,85 | 2 |
| 11040E6132Z03 | ○ | 40 | 61 | 32 | 75 | 165 | 21 | 7 | 3 | 0,95 | 2 |

Schneidplatten werden separat verkauft.

■ Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZR 11_ _ _ | BFTX0306IP | 1,5 | TRDR08IP |

■ Identifikation des Fräskörpers

WEZR 11 032 E 36 32 Z02

| | | | | | | |
|-------------------|--------------|-------------------|------------------|-------------------|-------------------|---------------------|
| Fräserbezeichnung | Plattengröße | Fräserdurchmesser | Schaftausführung | Max. Schnitttiefe | Schaftdurchmesser | Effektive Zahnezahl |
|-------------------|--------------|-------------------|------------------|-------------------|-------------------|---------------------|

■ Empfohlene Schnittbedingungen

| ISO | Werkstückstoff | Härte (HB) | Schneidstoff festigkeit | Schnittgeschwindigkeit v_c (m/min) | Vorschub f_z (mm/t) | Schneidstoffsorte |
|-----|--------------------------------|------------|----------------------------|--------------------------------------|-----------------------|-------------------|
| P | Kohlenstoffstahl | ≤ 280HB | G | 100–150–200 | 0,08–0,12–0,20 | ACU2500 |
| | | > 280HB | G | 80–100–120 | 0,08–0,12–0,20 | XCU2500 |
| | Legierter Stahl | ≤ 280HB | G | 100–150–80 | 0,08–0,12–0,20 | ACP2000 |
| M | Rostfreier Stahl | ≤ 280HB | G | 80–120–160 | 0,08–0,12–0,20 | ACU2500 |
| K | Grauguss/ Kugelgraphitguss | – | G | 100–150–200 | 0,08–0,12–0,20 | XCK2000 |
| S | Hitzebeständige Legierungen | – | G | 40–50–60 | 0,08–0,12–0,20 | ACK2000 |
| N | Aluminium- legierung | Si ≤ 12,6% | S | 300–500–800 | 0,05–0,10–0,15 | ACK3000 |
| | | Si > 12,6% | S | 100–200–250 | 0,05–0,10–0,15 | DL2000 |
| | | | | | | H20 |

Min. - Optimum - Max.

Hinweis:
Die oben genannten Schnittbedingungen sind ein Richtwert. Die tatsächlichen Bedingungen müssen entsprechend der Maschinensteifigkeit, der Werkstückspannung, der Schnitttiefe und weiteren Faktoren angepasst werden.
Je nach Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass die Bearbeitung nicht unter den empfohlenen Bedingungen durchgeführt werden kann.

*Bei der Montage von Schneidplatten mit einem Eckenradius von ≥ 2,4 mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm
(AOMT11T324PEER)

Eckenradius = 3,0 mm: C = 1 mm
(AOMT11T330PEER)

Eckenradius = 3,2 mm: C = 1 mm
(AOMT11T332PEER)

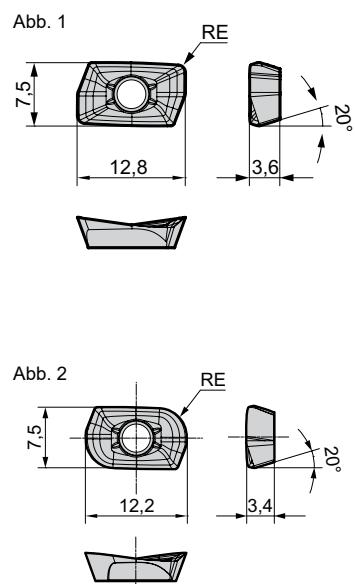
Standard: R = 1 mm

C: Fase
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage → S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | |
|--------------------------------|--------------------------|---------|---------|---------|---------|---------|---------|--------|--------|-----|------------|--------|--------|------------------|---|
| Hochgeschw./ Leichtbearbeitung | | | | | | | | | | | | | | | |
| Allgemeine Anwendung | | | | | | | | | | | | | | | |
| Schruppen | | | | | | | | | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. | |
| AOMT 11T302PEER-G | ● | ○ | □ | ● | ○ | □ | ● | ● | ● | — | — | — | ● | 0,2 | 1 |
| 11T304PEER-G | ● | ○ | ● | ● | ● | ○ | ● | ● | ● | — | — | — | ● | 0,4 | 1 |
| 11T305PEER-G | ● | ○ | □ | □ | ○ | □ | ● | ● | ● | — | — | — | □ | 0,5 | 1 |
| 11T308PEER-G | ● | ○ | ● | ● | ● | ○ | ● | ● | ● | — | — | — | ● | 0,8 | 1 |
| 11T310PEER-G | ● | ○ | □ | □ | ○ | □ | □ | ● | ● | — | — | — | □ | 1,0 | 1 |
| 11T312PEER-G | ● | ○ | □ | ● | ● | □ | ● | ● | ● | — | — | — | □ | 1,2 | 1 |
| 11T316PEER-G | ● | ○ | □ | ● | ● | □ | ● | ● | ● | — | — | — | — | 1,6 | 1 |
| 11T320PEER-G | ● | ○ | □ | ● | ● | □ | ● | ● | ● | — | — | — | — | 2,0 | 1 |
| 11T324PEER-G | ● | ○ | □ | □ | ○ | □ | □ | ● | ● | — | — | — | — | 2,4 | 1 |
| 11T330PEER-G | ● | ○ | □ | ● | ● | □ | ● | ● | ● | — | — | — | — | 3,0 | 2 |
| 11T332PEER-G | ● | ○ | □ | □ | ○ | □ | ● | ● | ● | — | — | — | — | 3,2 | 2 |
| AOMT 11T304PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ○ | ● | ● | ○ | ● | ● | ● | ● | — | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ○ | □ | □ | ○ | □ | □ | ● | ● | — | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ○ | □ | □ | ○ | □ | □ | ● | ● | — | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: stabile Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P20 ist anwendbar für Fräserdurchmesser Ø 18 mm, Ø 20 mm.
*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm, Ø 28 mm.

Ab der zweiten Stufe sind peripherie Schneidplatten mit RE ≤ 0,8 mm einzusetzen.

"WaveMill" Serie

WEZR 17000 E

Walzenstirnfräser

| | | | | |
|------------|--------|-----------|----------|-----|
| Spanwinkel | Radial | -9° – -8° | 29-84 mm | 90° |
| Axial | | 10° – 12° | | |

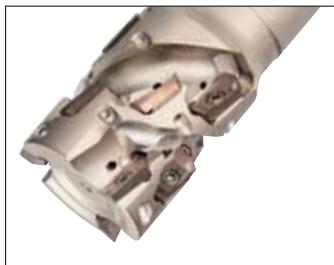
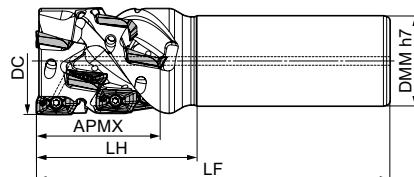


Abb. 1



WEZR-Fräskörper (Schaftfräser)

| Bezeichnung | La- ger | DC | APMX | DMM | LH | LF | Gesamtzahl Zähne | Stufen | Abmessungen (mm) | | |
|--------------------|------------|----|------|-----|-----|-----|---------------------|--------|------------------------|-----------------|------|
| | | | | | | | | | Effective Zähnezahl | Gewicht (kg) | Abb. |
| WEZR 17040E2932Z03 | ○ | 40 | 29 | 32 | 45 | 110 | 6 | 3 | 2 | 0,75 | 1 |
| 17040E4332Z02 | ○ | 40 | 43 | 32 | 60 | 125 | 6 | 2 | 3 | 0,86 | 1 |
| 17050E5742Z03 | ○ | 50 | 57 | 42 | 75 | 130 | 12 | 3 | 4 | 1,58 | 1 |
| 17050E8442Z02 | ○ | 50 | 84 | 42 | 105 | 140 | 12 | 2 | 6 | 1,04 | 1 |

Schneidplatten werden separat verkauft.

Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZR 17_ _ _ | BFTX0409IP | 3,0 | TRDR15IP |

Identifikation des Fräskörpers

WEZR 17 040 E 29 32 Z03

| | | | | | | |
|-----------------------------|-------------------|-----------------------------|----------------------------|---------------------------|-----------------------------|-----------------------------|
| Fräser- bezeich- nung | Platten- größe | Fräser- durch- messer | Schaft- aus- führung | Max. Schnitt- tiefe | Schaft- durch- messer | Effektive Zähne- zahl |
|-----------------------------|-------------------|-----------------------------|----------------------------|---------------------------|-----------------------------|-----------------------------|

Empfohlene Schnittbedingungen

| ISO | Werkstückstoff | Härte (HB) | Schneid- platten- festigkeit | Schnittgeschwin- digkeit v_c (m/min) | Vorschub f_z (mm/t) | Schneid- stoffsorte |
|-----|--------------------------------|---------------|------------------------------------|---|--------------------------|------------------------|
| P | Kohlenstoffstahl | ≤ 280HB | G | 100–150–200 | 0,10–0,20–0,30 | ACU2500 |
| | | > 280HB | G | 80–100–120 | 0,10–0,20–0,30 | XCU2500 |
| | Legierter Stahl | ≤ 280HB | G | 100–150–80 | 0,10–0,20–0,30 | ACP2000 |
| | | | | | | ACP3000 |
| M | Rostfreier Stahl | ≤ 280HB | G | 80–120–160 | 0,10–0,20–0,30 | ACU2500 |
| | | | | | | ACM200 |
| | | | | | | ACM300 |
| K | Grauguss/ Kugelgraphitguss | – | G | 100–150–200 | 0,10–0,20–0,30 | ACU2500 |
| | | | | | | XCK2000 |
| | | | | | | ACK2000 |
| | | | | | | ACK3000 |
| S | Hitzebeständige Legierungen | – | G | 40–50–60 | 0,10–0,20–0,30 | ACU2500 |
| | | | | | | ACM200 |
| | | | | | | ACM300 |
| N | Aluminium- legierung | Si ≤ 12,6% | S | 300–500–800 | 0,05–0,10–0,15 | DL2000 |
| | | Si > 12,6% | S | 100–200–250 | 0,05–0,10–0,15 | H20 |

Min. - Optimum - Max.

Hinweis:

Die oben genannten Schnittbedingungen sind ein Richtwert. Die tatsächlichen Bedingungen müssen entsprechend der Maschinensteifigkeit, der Werkstückspannung, der Schnitttiefe und weiteren Faktoren angepasst werden.

Je nach Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass die Bearbeitung nicht unter den empfohlenen Bedingungen durchgeführt werden kann.

*Bei der Montage von Schneidplatten mit einem Eckenradius von ≥ 2,4 mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm

(AOMT170524PEER)

Eckenradius = 3,0 mm: C = 1 mm

(AOMT170530PEER)

Eckenradius = 3,2 mm: C = 1 mm

(AOMT170532PEER)

Eckenradius = 4,0 mm: C = 2 mm

(AOMT170540PEER)

Eckenradius = 5,0 mm: C = 5 mm

(AOMT170550PEER)

Eckenradius = 6,4 mm: C = 5 mm

(AOMT170564PEER)

Standard: R = 1 mm

C: Fase

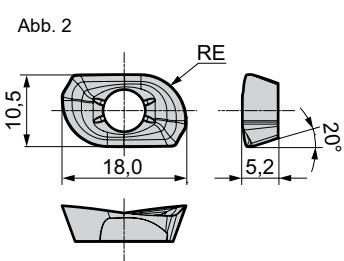
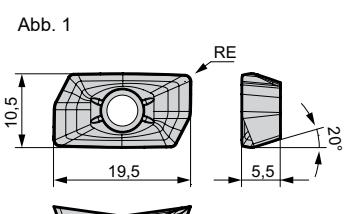
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | |
|--------------------------------|--------------------------|-------------|---------|---------|---------|---------|---------|--------|------------|-----|--------|------------------|---------|
| | K P S | K P S | P | K | K | M S | N | P | | | | | |
| Hochgeschw./ Leichtbearbeitung | | | | | | | | | | | | | |
| Allgemeine Anwendung | | | | | | | | | | | | | |
| Schruppen | | | | | | | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE Abb. |
| AOMT 170502PEER-L | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 0,2 1 |
| 170504PEER-L | ● | ● | ○ | — | — | ● | — | ● | ● | — | — | ● | 0,4 1 |
| 170508PEER-L | ● | ● | ○ | — | — | ○ | — | ● | ● | — | — | ● | 0,8 1 |
| 170512PEER-L | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 1,2 1 |
| 170516PEER-L | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 1,6 1 |
| AOMT 170502PEER-G | ● | ● | ○ | — | — | — | — | ● | ● | — | — | — | 0,2 1 |
| 170504PEER-G | ● | ● | ○ | — | — | ● | — | ● | ● | — | — | ● | 0,4 1 |
| 170505PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 0,5 1 |
| 170508PEER-G | ● | ● | ○ | — | — | ○ | — | ● | ● | — | — | ● | 0,8 1 |
| 170510PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 1,0 1 |
| 170512PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 1,2 1 |
| 170516PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 1,6 1 |
| 170520PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 2,0 1 |
| 170524PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 2,4 1 |
| 170530PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 3,0 1 |
| 170532PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 3,2 1 |
| 170540PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 4,0 1 |
| 170550PEER-G | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 5,0 2 |
| 170564PEER-G | — | — | — | — | — | — | — | ● | ● | — | — | — | 6,4 2 |
| AOMT 170504PEER-H | ● | ● | ○ | — | ● | ● | ○ | ● | ● | — | — | — | 0,4 1 |
| 170508PEER-H | ● | ● | ○ | — | ● | ● | ○ | ● | ● | — | — | — | 0,8 1 |
| 170512PEER-H | ● | ● | — | — | — | — | — | ● | ● | — | — | — | 1,2 1 |
| 170516PEER-H | ● | ● | — | — | ● | — | — | ● | ● | — | — | — | 1,6 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 4,0 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 5,0 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 6,4 2 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 4,0 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 5,0 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 6,4 2 |



L: geringe Schnittkraft
G: allgemeine Anwendung
H: stabile Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

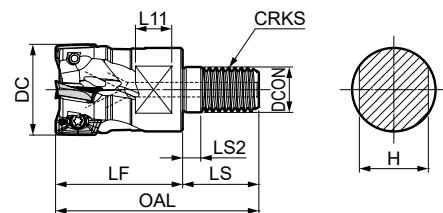
Ab der zweiten Stufe sind peripherie Schneidplatten mit RE ≤ 0,8 mm einzusetzen.



Abb. 1

| | | |
|------------|----------|------------|
| Spanwinkel | Radial | -7° – -18° |
| Axial | 6° – 15° | |

10 mm 90°



■ Fräskörper (einschraubar)

| Bezeichnung | Lager | DC | DCON | CRKS | OAL | LF | LS2 | L11 | H | Abmessungen (mm) | | |
|----------------|-------|----|------|------|-----|----|-----|-----|----|------------------|--------------|------|
| | | | | | | | | | | Anzahl Zähne | Gewicht (kg) | Abb. |
| WEZ 11016M08Z2 | ● | 16 | 8,5 | M8 | 42 | 25 | 5 | 8 | 13 | 2 | 0,03 | 1 |
| 11018M08Z2 | ● | 18 | 8,5 | M8 | 42 | 25 | 5 | 8 | 13 | 2 | 0,03 | 1 |
| 11020M10Z2 | ● | 20 | 10,5 | M10 | 49 | 30 | 5 | 8 | 15 | 2 | 0,06 | 1 |
| 11020M10Z3 | ● | 20 | 10,5 | M10 | 49 | 30 | 5 | 8 | 15 | 3 | 0,05 | 1 |
| 11022M10Z3 | ● | 22 | 10,5 | M10 | 49 | 30 | 5 | 8 | 15 | 3 | 0,06 | 1 |
| 11025M12Z2 | ● | 25 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 2 | 0,11 | 1 |
| 11025M12Z3 | ● | 25 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 3 | 0,10 | 1 |
| 11025M12Z4 | ● | 25 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 4 | 0,10 | 1 |
| 11026M12Z4 | ● | 26 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 4 | 0,10 | 1 |
| 11026M12Z5 | ● | 26 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 5 | 0,09 | 1 |
| 11028M12Z4 | ● | 28 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 4 | 0,11 | 1 |
| 11028M12Z5 | ● | 28 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 5 | 0,10 | 1 |
| 11030M16Z2 | ● | 30 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,20 | 1 |
| 11030M16Z4 | ● | 30 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 4 | 0,19 | 1 |
| 11030M16Z5 | ● | 30 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 5 | 0,17 | 1 |
| 11032M16Z2 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,22 | 1 |
| 11032M16Z3 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 3 | 0,20 | 1 |
| 11032M16Z4 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 4 | 0,20 | 1 |
| 11032M16Z5 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 5 | 0,19 | 1 |
| 11035M16Z2 | ● | 35 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,24 | 1 |
| 11035M16Z5 | ● | 35 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 5 | 0,22 | 1 |
| 11040M16Z2 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,28 | 1 |
| 11040M16Z4 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 4 | 0,26 | 1 |
| 11040M16Z5 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 5 | 0,26 | 1 |
| 11040M16Z6 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 6 | 0,25 | 1 |

Die Schneidplatten werden separat verkauft. Verlängerung siehe S. 44

■ Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|-----------------------|------------|-----|-----------|
| | | | |
| WEZ 11016M08Z2 | BFTX0305IP | 1,5 | TRDR08IP |
| 11018M08Z2 | | | |
| 11020M10Z2–11040M16Z2 | BFTX0306IP | | |

■ Empfohlene Schnittbedingungen

→ S. 8

■ Identifikation des Fräskörpers

WEZ 11 016 M 08 Z2

Fräserbezeichnung Plattengröße Fräskopfdurchmesser Einschraubgewinde Anzahl Zähne

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.

Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT11T324PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT11T330PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT11T332PEER)
Standard: R = 1 mm

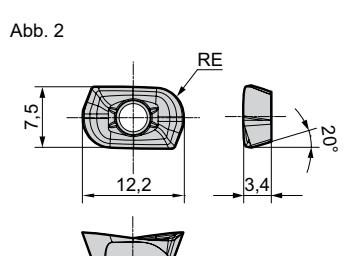
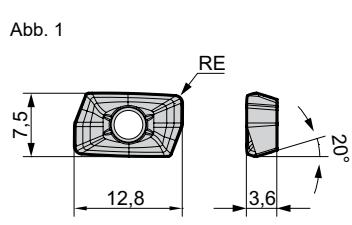
C: Fase
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|----------------|----------------|--------|------------|-----|--------|------------------|-----|------|---|
| | P _M | P | K | K | M _S | M _S | M _S | N | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. | |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | ● | 0,2 | 1 | |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | ● | 0,4 | 1 | |
| 11T305PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | □ | 0,5 | 1 | |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | ● | 0,8 | 1 | |
| 11T310PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | □ | 1,0 | 1 | |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | □ | 1,2 | 1 | |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 | |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,0 | 1 | |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 2,4 | 1 | |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,0 | 2 | |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 3,2 | 2 | |
| AOMT 11T304PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P16 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P20 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T302PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,2 | 2 |



*P16 ist anwendbar für Fräserdurchmesser Ø 14 mm und Ø 16 mm.

*P20 ist anwendbar für Fräserdurchmesser Ø 18 mm, Ø 20 mm.

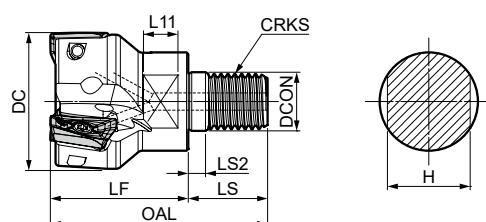
*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm, Ø 28 mm.



| | | |
|------------|--------|------------|
| Spanwinkel | Radial | -6° – -12° |
| Axial | | 6° – 15° |

15 mm 90°

Abb. 1



■ Fräskörper (einschraubar)

| Bezeichnung | Lager | DC | DCON | CRKS | OAL | LF | LS2 | L11 | H | Abmessungen (mm) | | |
|-----------------|-------|----|------|------|-----|----|-----|-----|----|------------------|--------------|------|
| | | | | | | | | | | Anzahl Zähne | Gewicht (kg) | Abb. |
| WEZ 17025M012Z2 | ● | 25 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 2 | 0,08 | 1 |
| 17025M012Z3 | ● | 25 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 3 | 0,07 | 1 |
| 17028M012Z2 | ● | 28 | 12,5 | M12 | 56 | 35 | 5 | 10 | 19 | 2 | 0,10 | 1 |
| 17030M016Z2 | ● | 30 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,17 | 1 |
| 17030M016Z3 | ● | 30 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 3 | 0,15 | 1 |
| 17032M016Z2 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,19 | 1 |
| 17032M016Z3 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 3 | 0,16 | 1 |
| 17032M016Z4 | ● | 32 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 4 | 0,14 | 1 |
| 17035M016Z2 | ● | 35 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,21 | 1 |
| 17035M016Z3 | ● | 35 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 3 | 0,19 | 1 |
| 17040M016Z2 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 2 | 0,15 | 1 |
| 17040M016Z3 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 3 | 0,23 | 1 |
| 17040M016Z4 | ● | 40 | 17 | M16 | 63 | 40 | 5 | 10 | 24 | 4 | 0,21 | 1 |

Die Schneidplatten werden separat verkauft. Verlängerung siehe S. 44

■ Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|---------------------------|------------|-----|-----------|
| | | | |
| WEZ 17025M12Z2–17030M16Z3 | BFTX0407IP | 3,0 | TRDR15IP |
| 17032M16Z2–17040M16Z4 | BFTX0409IP | | |

■ Identifikation des Fräskörpers

WEZ 17 025 M 12 Z2

Fräserbezeichnung Plattengröße Fräskopfdurchmesser Einschraubgewinde Anzahl Zähne

■ Empfohlene Schnittbedingungen

→ S. 8

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT170524PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT170530PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT170532PEER)
Eckenradius = 4,0 mm: C = 2 mm (AOMT170540PEER)
Eckenradius = 5,0 mm: C = 5 mm (AOMT170550PEER)
Eckenradius = 6,4 mm: C = 5 mm (AOMT170564PEER)
Standard: R = 1 mm

C: Fase
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | | |
|--------------------------------|--------------------------|---------|---------|---------|---------|---------|---------|--------|------------|-----|--------|------------------|-----|-----|---|
| Hochgeschw./ Leichtbearbeitung | | | | | | | | | | | | | | | |
| Allgemeine Anwendung | | | | | | | | | | | | | | | |
| Schruppen | | | | | | | | | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | | | |
| AOMT 170502PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | 0,2 | 1 | |
| 170504PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,4 | 1 |
| 170508PEER-L | ● | ○ | — | ● | ○ | — | ● | ● | ● | — | — | — | ● | 0,8 | 1 |
| 170512PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | 1,2 | 1 | |
| 170516PEER-L | ● | — | — | — | — | — | — | ● | ● | — | — | — | 1,6 | 1 | |
| AOMT 170502PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | 0,2 | 1 | |
| 170504PEER-G | ● | ○ | — | ● | ● | — | ○ | ● | ● | — | — | — | ● | 0,4 | 1 |
| 170505PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 | |
| 170508PEER-G | ● | ○ | — | ● | ● | — | ○ | ● | ● | — | — | — | ● | 0,8 | 1 |
| 170510PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 1,2 | 1 |
| 170516PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | — | — | — | — | — | — | ● | ● | — | — | — | — | 5,0 | 2 |
| 170564PEER-G | — | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ○ | ● | ● | ○ | — | — | ● | ● | — | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ○ | ● | ● | ○ | — | — | ● | ● | — | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | — | — | — | ● | — | — | — | — | — | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P25 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170502PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-P32 | ● | — | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | — | 6,4 | 2 |

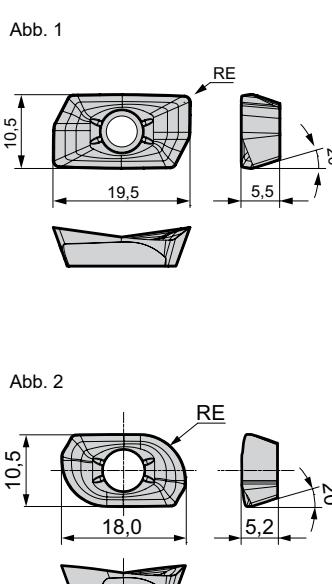
L: geringe Schnittkraft
G: allgemeine Anwendung
H: stabile Schneidkante
F: Schlichten
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

*P25 ist anwendbar für Fräserdurchmesser Ø 25 mm und Ø 28 mm.
*P32 ist anwendbar für Fräserdurchmesser Ø 30 mm, Ø 32 mm und Ø 35 mm.

● = Eurolager
○ = Japanlager

□ = Auf Anfrage

— = Nicht möglich



"WaveMill" Serie

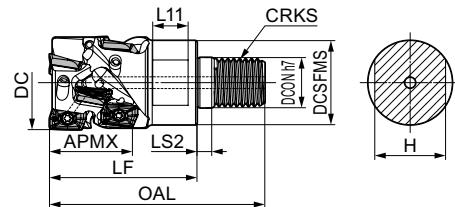
WEZR 11000 M

Walzenstirnfräser - Modular

| | | |
|------------|--------|------|
| Spanwinkel | Radial | -12° |
| | Axial | 11° |

27 mm 90°

Abb. 1



■ Fräskörper (einschraubar)

| Bezeichnung | Lager | DC | APMX | DCSFMS | DCON | CRKS | OAL | LF | LS2 | L11 | H | Gesamtzahl Zähne | Stufen | Effective Zähnezahl | Gewicht (kg) | Abb. |
|-------------------|-------|----|------|--------|------|------|-----|----|-----|-----|----|------------------|--------|---------------------|--------------|------|
| WEZR 11032M1627Z3 | ○ | 32 | 27 | 28,5 | 17 | M16 | 73 | 50 | 5 | 12 | 24 | 9 | 3 | 3 | 0,21 | 1 |

Die Schneidplatten werden separat verkauft. Verlängerung → S44

■ Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZR 11_ _ _ | BFTX0306IP | 1,5 | TRDR08IP |

■ Identifikation des Fräskörpers

WEZR 11 032 M16 27 Z3

Fräser- Platten- Fräskopf- Einschraub- Max. Effective
bezeichnung Größe durchmesser gewinde Schnitt- Zähne-
zahl

■ Empfohlene Schnittbedingungen

| ISO | Werkstückstoff | Härte (HB) | Schnittgeschwindigkeit v_c (m/min) | | Vorschub f_z (mm/t) | Schniedstoffsorte |
|-----|--------------------------------|------------|--------------------------------------|------------------------------|-----------------------|--|
| | | | Schneidstoff herabstufen | Schneidstoff heraufstufen | | |
| P | Kohlenstoffstahl | ≤ 280HB | G | 100–150–200 | 0,08–0,12–0,20 | ACU2500 XCU2500 ACP2000 ACP3000 |
| | Legierter Stahl | > 280HB | G | 80–100–120 | 0,08–0,12–0,20 | |
| M | Rostfreier Stahl | ≤ 280HB | G | 100–150–80 | 0,08–0,12–0,20 | ACU2500 ACM200 ACM300 |
| | Grauguss/ Kugelgraphitguss | ≤ 280HB | G | 80–120–160 | 0,08–0,12–0,20 | ACU2500 XCK2000 ACK2000 ACK3000 |
| S | Hitzebeständige Legierungen | ≤ 280HB | G | 40–50–60 | 0,08–0,12–0,20 | ACU2500 ACM200 ACM300 |
| | Aluminium- legierung | Si ≤ 12,6% | S | 300–500–800 | 0,05–0,10–0,15 | DL2000 H20 |
| N | Si > 12,6% | S | Si > 12,6% | S | 100–200–250 | 0,05–0,10–0,15 |
| | | | | | | |

Min. - Optimum - Max.

Hinweis:

Die oben genannten Schnittbedingungen sind ein Richtwert. Die tatsächlichen Bedingungen müssen entsprechend der Maschinensteifigkeit, der Werkstückspannung, der Schnitttiefe und weiteren Faktoren angepasst werden.

Je nach Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass die Bearbeitung nicht unter den empfohlenen Bedingungen durchgeführt werden kann.

*Bei der Montage von Schneidplatten mit einem Eckenradius von $\geq 2,4$ mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm (AOMT11T324PEER)
Eckenradius = 3,0 mm: C = 1 mm (AOMT11T330PEER)
Eckenradius = 3,2 mm: C = 1 mm (AOMT11T332PEER)
Standard: R = 1 mm

C: Fase
R: Radius

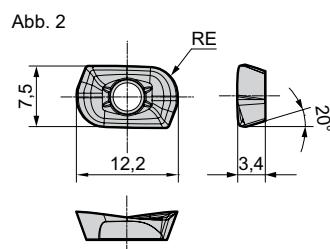
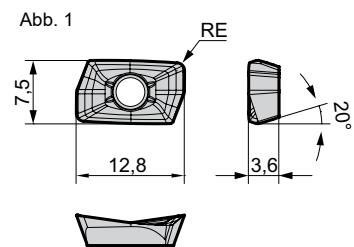
"WaveMill" Serie

WEZR 11000 M

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage → S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|----------------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | P _M | P | K | K | M _S | N | P | | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | | | | | | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | | | | | | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 11T302PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | ● | 0,2 | 1 | |
| 11T304PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | 0,4 | 1 | |
| 11T305PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | □ | 0,5 | 1 | |
| 11T308PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | ● | 0,8 | 1 | |
| 11T310PEER-G | ● | ● | ○ | ● | ● | ● | ● | ● | ● | — | □ | 1,0 | 1 | |
| 11T312PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | □ | 1,2 | 1 | |
| 11T316PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 1,6 | 1 | |
| 11T320PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 2,0 | 1 | |
| 11T324PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 2,4 | 1 | |
| 11T330PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 3,0 | 2 | |
| 11T332PEER-G | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | 3,2 | 2 | |
| AOMT 11T304PEER-H | ● | ○ | ● | ● | ● | ● | ● | ● | ● | — | — | — | 0,4 | 1 |
| 11T308PEER-H | ● | ○ | ● | ● | ● | ● | ● | ● | ● | — | — | — | 0,8 | 1 |
| 11T312PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,2 | 1 |
| 11T316PEER-H | ● | ● | ● | ● | ● | ● | ● | ● | ● | — | — | — | 1,6 | 1 |
| AOET 11T302PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 11T304PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 11T305PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 11T308PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 11T310PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 11T312PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 11T316PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 11T320PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 11T324PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 11T330PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 2 |
| 11T332PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 2 |
| AOET 11T302PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 11T304PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 11T305PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 11T308PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 11T310PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 11T312PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 11T316PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 11T320PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 11T324PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 11T330PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 2 |
| 11T332PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 2 |



L: geringe Schnittkraft
 G: allgemeine Anwendung
 H: stabile Schneidkante
 F: Schlichten
 P: Hochpräzisionsbearbeitung
 S: Nichteisenmetalle

Ab der zweiten Stufe sind peripherie Schneidplatten mit RE ≤ 0,8 mm einzusetzen.

"WaveMill" Serie

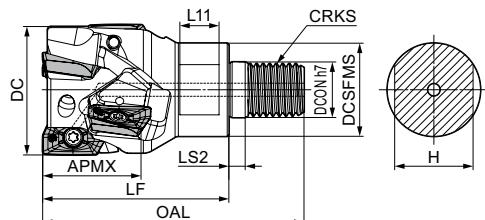
WEZR 17000 M

Walzenstirnfräser - Modular

| | | |
|------------|--------|-----|
| Spanwinkel | Radial | -9° |
| | Axial | 10° |



Abb. 1



■ Fräskörper (einschraubar)

| Bezeichnung | Lager | DC | APMX | DCSFMS | DCON | CRKS | OAL | LF | LS2 | L11 | H | Gesamtzahl Zähne | Stufen | Effective Zähnezahl | Gewicht (kg) | Abb. |
|-------------------|-------|----|------|--------|------|------|-----|----|-----|-----|----|------------------|--------|---------------------|--------------|------|
| WEZR 17040M1629Z3 | ○ | 40 | 29 | 28,5 | 17 | M16 | 80 | 57 | 5 | 12 | 24 | 6 | 2 | 3 | 0,29 | 1 |

Die Schneidplatten werden separat verkauft. Verlängerung → S44

■ Ersatzteile

| Geeignete Fräser | Schraube | | Schlüssel |
|------------------|------------|-----|-----------|
| | | | |
| WEZR 17_ _ _ | BFTX0409IP | 3,0 | TRDR15IP |

■ Identifikation des Fräskörpers

| WEZR | 17 | 040 | M16 | 29 | Z3 |
|-------------------|--------------|---------------------|-------------------|-------------------|---------------------|
| Fräserbezeichnung | Plattengröße | Fräskopfdurchmesser | Einschraubgewinde | Max. Schnitttiefe | Effective Zähnezahl |

■ Empfohlene Schnittbedingungen

| ISO | Werkstückstoff | Härte (HB) | Schneidstoff hersteller | Schnittgeschwindigkeit v_c (m/min) | Vorschub f_z (mm/t) | Schneidstoffsorte |
|-----|--------------------------------|------------|----------------------------|--------------------------------------|-----------------------|-------------------|
| P | Kohlenstoffstahl | ≤ 280HB | G | 100–150–200 | 0,10–0,20–0,30 | ACU2500 |
| | | > 280HB | G | 80–100–120 | 0,10–0,20–0,30 | XCU2500 |
| | Legierter Stahl | ≤ 280HB | G | 100–150–80 | 0,10–0,20–0,30 | ACP2000 |
| | | | | | | ACP3000 |
| M | Rostfreier Stahl | ≤ 280HB | G | 80–120–160 | 0,10–0,20–0,30 | ACU2500 |
| | | | | | | ACM200 |
| | | | | | | ACM300 |
| K | Grauguss/ Kugelgraphitguss | – | G | 100–150–200 | 0,10–0,20–0,30 | ACU2500 |
| | | | | | | XCK2000 |
| | | | | | | ACK2000 |
| | | | | | | ACK3000 |
| S | Hitzebeständige Legierungen | – | G | 40–50–60 | 0,10–0,20–0,30 | ACU2500 |
| | | | | | | ACM200 |
| | | | | | | ACM300 |
| N | Aluminium- legierung | Si ≤ 12,6% | S | 300–500–800 | 0,05–0,10–0,15 | DL2000 |
| | | Si > 12,6% | S | 100–200–250 | 0,05–0,10–0,15 | H20 |

Min. - Optimum - Max.

Hinweis:

Die oben genannten Schnittbedingungen sind ein Richtwert. Die tatsächlichen Bedingungen müssen entsprechend der Maschinensteifigkeit, der Werkstückspannung, der Schnitttiefe und weiteren Faktoren angepasst werden.

Je nach Steifigkeit der Maschine und des Werkstücks kann es vorkommen, dass die Bearbeitung nicht unter den empfohlenen Bedingungen durchgeführt werden kann.

*Bei der Montage von Schneidplatten mit einem Eckenradius von ≥ 2,4 mm ist eine Modifikation des Fräskörpers erforderlich.



Modifizieren Sie diese Kante.

Richtlinien zur Nachbearbeitung
Eckenradius = 2,4 mm: C = 1 mm
(AOMT170524PEER)

Eckenradius = 3,0 mm: C = 1 mm
(AOMT170530PEER)

Eckenradius = 3,2 mm: C = 1 mm
(AOMT170532PEER)

Eckenradius = 4,0 mm: C = 2 mm
(AOMT170540PEER)

Eckenradius = 5,0 mm: C = 5 mm
(AOMT170550PEER)

Eckenradius = 6,4 mm: C = 5 mm
(AOMT170564PEER)

Standard: R = 1 mm

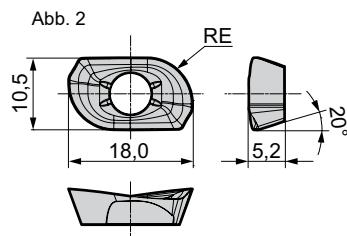
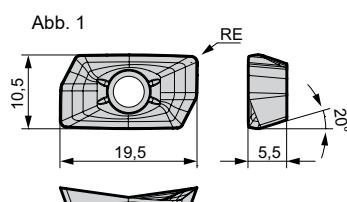
C: Fase
R: Radius

■ Fräsplatten

Vorsichtsmaßnahmen bei der Montage

→ S. 9

| Anwendung | Beschichtetes Hartmetall | | | | | | | | Hartmetall | DLC | Cermet | Abmessungen (mm) | | |
|--------------------------------|--------------------------|---------|---------|---------|---------|---------|---------|--------|------------|-----|--------|------------------|-----|------|
| | P KM | P M | K P | K M | K S | M S | N | P | | | | | | |
| Hochgeschw./ Leichtbearbeitung | ● | ○ | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Allgemeine Anwendung | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Schruppen | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | ● | | |
| Bezeichnung | ACU2500 | XCU2500 | ACP2000 | ACP3000 | XCK2000 | ACK2000 | ACK3000 | ACM200 | ACM300 | H20 | DL2000 | T2500A | RE | Abb. |
| AOMT 170502PEER-L | ● | ● | ○ | — | □ | — | □ | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-L | ● | ● | ○ | — | ● | ○ | — | ● | ● | — | — | ● | 0,4 | 1 |
| 170508PEER-L | ● | ● | ○ | — | ● | ○ | — | ● | ● | — | — | ● | 0,8 | 1 |
| 170512PEER-L | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 1,2 | 1 |
| 170516PEER-L | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 1,6 | 1 |
| AOMT 170502PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | □ | 0,2 | 1 |
| 170504PEER-G | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | ● | 0,4 | 1 |
| 170505PEER-G | ● | ● | — | □ | □ | — | □ | ● | ● | — | — | □ | 0,5 | 1 |
| 170508PEER-G | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | ● | 0,8 | 1 |
| 170510PEER-G | ● | ● | — | □ | □ | — | □ | ● | ● | — | — | □ | 1,0 | 1 |
| 170512PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | □ | 1,2 | 1 |
| 170516PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 1,6 | 1 |
| 170520PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 2,0 | 1 |
| 170524PEER-G | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 2,4 | 1 |
| 170530PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 3,0 | 1 |
| 170532PEER-G | ● | ● | — | □ | — | — | □ | ● | ● | — | — | — | 3,2 | 1 |
| 170540PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 4,0 | 1 |
| 170550PEER-G | ● | ● | — | □ | ● | — | □ | ● | ● | — | — | — | 5,0 | 2 |
| 170564PEER-G | □ | ● | — | □ | — | — | □ | ● | ● | — | — | — | 6,4 | 2 |
| AOMT 170504PEER-H | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | — | 0,4 | 1 |
| 170508PEER-H | ● | ● | ○ | ● | ● | ○ | ● | ● | ● | — | — | — | 0,8 | 1 |
| 170512PEER-H | ● | ● | — | □ | □ | — | □ | □ | ● | — | — | — | 1,2 | 1 |
| 170516PEER-H | ● | ● | — | □ | ● | — | □ | □ | ● | — | — | — | 1,6 | 1 |
| AOET 170502PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,2 | 1 |
| 170504PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,4 | 1 |
| 170505PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,5 | 1 |
| 170508PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 0,8 | 1 |
| 170510PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,0 | 1 |
| 170512PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,2 | 1 |
| 170516PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 1,6 | 1 |
| 170520PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,0 | 1 |
| 170524PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 2,4 | 1 |
| 170530PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,0 | 1 |
| 170532PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 3,2 | 1 |
| 170540PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 4,0 | 1 |
| 170550PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 5,0 | 2 |
| 170564PEER-F | ● | — | — | — | — | — | — | — | — | — | — | — | 6,4 | 2 |
| AOET 170502PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,2 | 1 |
| 170504PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,4 | 1 |
| 170505PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,5 | 1 |
| 170508PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 0,8 | 1 |
| 170510PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,0 | 1 |
| 170512PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,2 | 1 |
| 170516PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 1,6 | 1 |
| 170520PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,0 | 1 |
| 170524PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 2,4 | 1 |
| 170530PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,0 | 1 |
| 170532PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 3,2 | 1 |
| 170540PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 4,0 | 1 |
| 170550PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 5,0 | 2 |
| 170564PEFR-S | — | — | — | — | — | — | — | — | — | ● | ● | — | 6,4 | 2 |



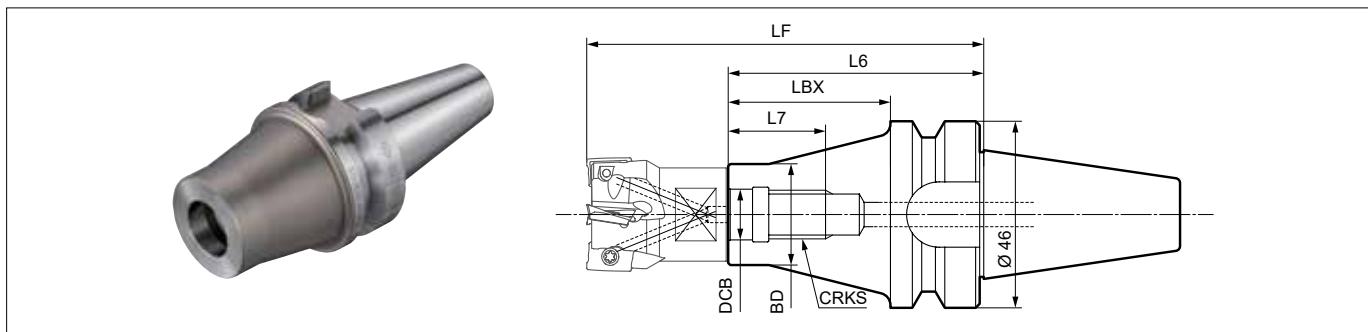
L: geringe Schnittkraft
G: allgemeine Anwendung
H: stabile Schneidkante
F: Schlitzen
P: Hochpräzisionsbearbeitung
S: Nichteisenmetalle

Ab der zweiten Stufe sind peripherie Schneidplatten mit RE ≤ 0,8 mm einzusetzen.

"WaveMill" Serie

Modularwerkzeuge

■ BBT Spannfutter mit Plananlage für Modulare Fräskörper

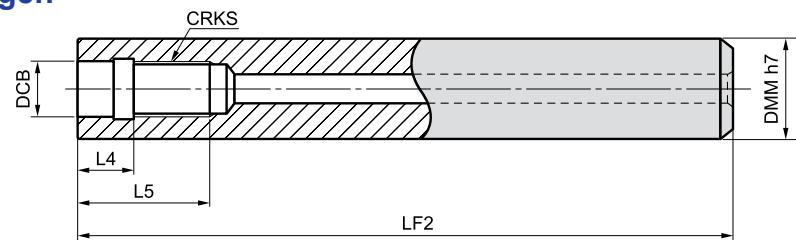
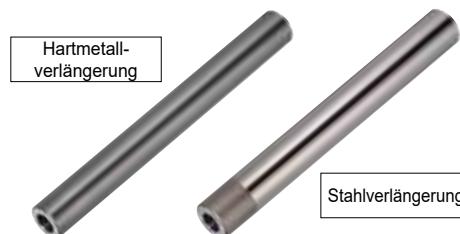


■ BBT Spannfutter

| Bezeichnung | Lager | CRKS | DCB | BD | L6 | LBX | L7 | LF* | Abmessungen (mm) |
|-------------|-------|------|------|------|----|-----|----|-----|------------------------|
| | | | | | | | | | Bohrung für Kühlmittel |
| BBT30-M8-50 | ○ | M8 | 8,5 | 15,9 | 73 | 50 | 18 | 98 | ja |
| M10-45 | ○ | M10 | 10,5 | 19,9 | 68 | 45 | 20 | 98 | ja |
| M12-40 | ○ | M12 | 12,5 | 24,9 | 63 | 40 | 22 | 98 | ja |
| M16-35 | ○ | M16 | 17 | 31,9 | 58 | 35 | 24 | 98 | ja |

* Die Auskraglänge für LF gilt mit montiertem Kopf. Kann ebenfalls bei BT30-Spezialmaschinen verwendet werden.

■ Hartmetall- und Stahlverlängerungen



■ Hartmetallverlängerung

| Bezeichnung | Lager | CRKS | DCB | DMM | LF2 | L4 | L5 | LF* | Abmessungen (mm) |
|-----------------|-------|------|------|-----|-----|----|----|-----|------------------|
| | | | | | | | | | Bezeichnung |
| MA 15 M08 L120C | ● | M8 | 8,5 | 15 | 120 | 10 | 18 | 145 | MA 15 M08 L120S |
| 15 M08 L160C | ● | M8 | 8,5 | 15 | 160 | 10 | 18 | 185 | MA 20 M10 L150S |
| MA 16 M08 L120C | ● | M8 | 8,5 | 16 | 120 | 10 | 18 | 145 | MA 25 M12 L200S |
| 16 M08 L160C | ● | M8 | 8,5 | 16 | 160 | 10 | 18 | 185 | MA 32 M16 L200S |
| MA 18 M10 L150C | ● | M10 | 10,5 | 18 | 150 | 10 | 20 | 180 | ● M8 |
| 18 M10 L200C | ● | M10 | 10,5 | 18 | 200 | 10 | 20 | 230 | ● M10 |
| MA 20 M10 L150C | ○ | M10 | 10,5 | 20 | 150 | 10 | 20 | 180 | ● M12 |
| 20 M10 L200C | ○ | M10 | 10,5 | 20 | 200 | 10 | 20 | 230 | ● M16 |
| MA 23 M12 L200C | ● | M12 | 12,5 | 23 | 200 | 10 | 22 | 235 | ● 12,5 |
| 23 M12 L250C | ● | M12 | 12,5 | 23 | 250 | 10 | 22 | 285 | ● 25 |
| MA 25 M12 L200C | ● | M12 | 12,5 | 25 | 200 | 10 | 22 | 235 | ● 25 |
| 25 M12 L250C | ● | M12 | 12,5 | 25 | 250 | 10 | 22 | 285 | ● 32 |
| MA 28 M16 L200C | ● | M16 | 17,0 | 28 | 200 | 10 | 24 | 240 | ● 17,0 |
| 28 M16 L300C | ● | M16 | 17,0 | 28 | 300 | 10 | 24 | 340 | ● 17,0 |
| MA 32 M16 L200C | ● | M16 | 17,0 | 32 | 200 | 10 | 24 | 240 | ● 17,0 |
| 32 M16 L300C | ● | M16 | 17,0 | 32 | 300 | 10 | 24 | 340 | ● 17,0 |

■ Stahlverlängerung

| Bezeichnung | Lager | CRKS | DCB | DMM | LF2 | L4 | L5 | LF* | Abmessungen (mm) |
|-----------------|-------|------|------|-----|-----|----|----|-----|------------------|
| | | | | | | | | | Bezeichnung |
| MA 16 M08 L120S | ● | M8 | 8,5 | 16 | 120 | 10 | 18 | 145 | MA 15 M08 L120C |
| MA 20 M10 L150S | ● | M10 | 10,5 | 20 | 150 | 10 | 20 | 180 | 15 M08 L160C |
| MA 25 M12 L200S | ● | M12 | 12,5 | 25 | 200 | 10 | 22 | 235 | 16 M08 L160C |
| MA 32 M16 L200S | ● | M16 | 17,0 | 32 | 200 | 10 | 24 | 240 | 18 M10 L150C |

■ Bezeichnungsschlüssel

MA 15 M08 L120 C

Modular Arbor
Verlängerung | Befestigungs-
Schaft- gewinde
durchmesser | Länge | Material
C: Hartmetall
S: Stahl

■ Modulares System



■ Empfohlenes Anzugsmoment

| Schraube | Schlüssel | (Nm) | | |
|----------|-----------|------|----|---|
| | | | W | S |
| M 8 | 8 | 13 | 23 | |
| M10 | 8 | 15 | 46 | |
| M12 | 10 | 19 | 60 | |
| M16 | 10,12 | 24 | 80 | |



Hinweise zum Anziehen des Fräskopfes:

Beachten Sie bei der Montage des Kopfes auf einem Aufnahmedorn das beigelegte Anzugsdrehmoment in der obigen Tabelle.

Prüfen Sie vorher Größe des Befestigungsgewindes für den Fräskopf und die Verlängerung.

■ Anwendungsbeispiele

| C40, Nabe | P | Sumitomo | Wettbewerber |
|--------------------|--------------------|---|---------------------|
| BAZ BT40, vertikal | Fräser | WEZ17025E02 | Quadratische Platte |
| | Sorte | ACU2500 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 25 | 25 |
| | Anzahl Zähne | 2 | 2 |
| | v_c (m/min) | 120 | 120 |
| | v_f (mm/min) | 300 | 300 |
| | f_z (mm/Z) | 0,066 | 0,066 |
| | a_p (mm) | 9 | 9 |
| | a_e (mm) | 5 | 5 |
| Kühlung | | nass | nass |
| Ergebnis | | Kein klapperndes Geräusch mehr (typisch für dünnwandige Werkstücke). Die stabile Bearbeitung ermöglicht eine längere Standzeit. | |

| Formteile aus Stahl C50 | P | Sumitomo | Wettbewerber |
|--|--------------------|--|----------------|
| Universal Fräsmaschine BT40  | Fräser | WEZ11022E03 | 2 Schneidecken |
| | Sorte | T2500A | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 22 | 22 |
| | Anzahl Zähne | 3 | 3 |
| | v_c (m/min) | 83 | 75 |
| | v_f (mm/min) | 320 | 290 |
| | f_z (mm/Z) | 0,09 | 0,09 |
| | a_p (mm) | 2,5 | 2,5 |
| | a_e (mm) | 10 | 10 |
| | Kühlung | – | – |
| | Ergebnis | Hohe Oberflächenqualität und Bearbeitungseffizienz durch Cermetschneidstoff. | |

| SM490A, Maschinenbauteil | | P | Sumitomo | Wettbewerber |
|--------------------------|--------------------|--|----------------|--------------|
| BAZ BT50, vertikal | Fräser | WEZ17032EL03 | 2 Schneidecken | |
| | Sorte | ACU2500 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 32 | 32 | |
| | Anzahl Zähne | 3 | 2 | |
| | v_c (m/min) | 150 | 150 | |
| | v_f (mm/min) | 671 | 447 | |
| | f_z (mm/Z) | 0,15 | 0,15 | |
| | a_p (mm) | 1,25 | 1,25 | |
| | a_e (mm) | 32 | 32 | |
| Kühlung | | nass | nass | |
| Ergebnis | | Effizienzsteigerung um das 1, 5-Fache, ruhige und stabile Bearbeitung. | | |

| C50, Maschinenbauteil | | P | Sumitomo | Wettbewerber |
|---|--------------------|--|----------------|--------------|
| 5-Achs-Steuerung BAZ HSK-A100, vertikal | Fräser | WEZ11020M10Z3 | 2 Schneidecken | |
| | Sorte | ACU2500 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 20 | 20 | |
| | Anzahl Zähne | 3 | 3 | |
| | v_c (m/min) | 72 | 72 | |
| | v_f (mm/min) | 4.000 | 4.000 | |
| | f_z (mm/Z) | 0,2 | 0,2 | |
| | a_p (mm) | 0,7 | 0,7 | |
| | a_e (mm) | 20 | 20 | |
| Kühlung | | trocken | trocken | |
| Ergebnis | | Stabiler, ratterfreier Lauf auch beim Nutenfräsen mit einem Überhang von 120 mm (L/D=6). | | |

| | | | | |
|---------------------------------|--------------------|--|----------|--------------|
| X2CrNiMo17132, Maschinenbauteil | | M | Sumitomo | Wettbewerber |
| BAZ BT40, vertikal | Fräser | WEZ17035E03 | – | – |
| | Sorte | ACU2500 | – | – |
| | Spanbrecher | P | – | – |
| | Fräserdurchm. (mm) | 35 | – | – |
| | Anzahl Zähne | 3 | – | – |
| | v_c (m/min) | 100 | – | – |
| | v_f (mm/min) | 410 | – | – |
| | f_z (mm/Z) | 0,15 | – | – |
| | a_p (mm) | 9 | – | – |
| | a_e (mm) | 0,1 | – | – |
| Kühlung | | nass | – | – |
| Ergebnis | | Hervorragende Oberflächen-güte, geeignet für Schlichtbe-arbeitungen ($a_e = 0,1$ mm). | | |

| | | | |
|-------------------------|--------------------|--|---------------------|
| SCS13, Maschinenbauteil | M | Sumitomo | Wettbewerber |
| BAZ BT50, vertikal | Fräser | WEZ11040E04 | Quadratische Platte |
| | Sorte | ACM300 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 40 | 40 |
| | Anzahl Zähne | 4 | 4 |
| | v_c (m/min) | 80 | 80 |
| | v_f (mm/min) | 254 | 254 |
| | f_z (mm/Z) | 0,1 | 0,1 |
| | a_p (mm) | 1 | 1 |
| | a_e (mm) | 40 | 40 |
| Kühlung | | – | – |
| Ergebnis | | Längere Standzeiten ohne Ausbrüche auch bei der Bearbeitung der schwarzen Zunderschicht. | |

■ Anwendungsbeispiele

| X5CrNiS18 10, Halbleiterbauelement M | | Sumitomo | Wettbewerber |
|---|--------------------|---|---------------------|
| BAZ BT50, horizontal | Fräser | WEZ17050RS05 | Quadratische Platte |
| | Sorte | ACU2500 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 50 | 50 |
| | Anzahl Zähne | 5 | 5 |
| | v_c (m/min) | 80 | 80 |
| | v_f (mm/min) | 320 | 320 |
| | f_z (mm/Z) | 0,13 | 0,13 |
| | a_p (mm) | 0,2 | 0,2 |
| | a_e (mm) | 40 | 40 |
| | Kühlung | nass | nass |
| Ergebnis | | Verbesserte Oberflächengüte und geringere Gratbildung, Verkürzung der Nachbearbeitungszeit um die Hälfte. | |



| Maschinenbauteil aus rostfreiem Duplex SUS M | | Sumitomo | Wettbewerber |
|---|--------------------|--|----------------|
| Multitasking-Maschine | Fräser | WEZ11025ES02-16* | 2 Schneidecken |
| | Sorte | ACU2500 | – |
| | Spanbrecher | F | – |
| | Fräserdurchm. (mm) | 25 | 25 |
| | Anzahl Zähne | 2 | 2 |
| | v_c (m/min) | 90 | 90 |
| | v_f (mm/min) | 300 | 300 |
| | f_z (mm/Z) | 0,13 | 0,13 |
| | a_p (mm) | 1,5 | 1,5 |
| | a_e (mm) | 25 | 25 |
| | Kühlung | nass | nass |
| Ergebnis | | Unterdrückt Gratbildung und verlängert die Standzeit um das 1,6-Fache. | |



| GG-30, Maschinenbauteil K | | Sumitomo | Wettbewerber |
|----------------------------------|--------------------|--|----------------|
| BAZ BT50, vertikal | Fräser | WEZ17063RS06 | 2 Schneidecken |
| | Sorte | ACK3000 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 63 | 63 |
| | Anzahl Zähne | 6 | 4 |
| | v_c (m/min) | 150 | 175 |
| | v_f (mm/min) | 377 | 254 |
| | f_z (mm/Z) | 0,08 | 0,07 |
| | a_p (mm) | 3,5 | 3,5 |
| | a_e (mm) | 50 | 50 |
| | Kühlung | nass | nass |
| Ergebnis | | Stirnseitige Bearbeitung mit 1,5-fach höherer Effektivität und zweifach höherer Standzeit. | |



| GG-25, Maschinenbauteil K | | Sumitomo | Wettbewerber |
|----------------------------------|--------------------|---|----------------|
| BAZ BT50, horizontal | Fräser | WEZ11050RS07 | 2 Schneidecken |
| | Sorte | ACU2500 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 50 | 50 |
| | Anzahl Zähne | 7 | 5 |
| | v_c (m/min) | 180 | 180 |
| | v_f (mm/min) | 805 | 574 |
| | f_z (mm/Z) | 0,1 | 0,1 |
| | a_p (mm) | 0,3 | 0,3 |
| | a_e (mm) | 10 | 10 |
| | Kühlung | nass | nass |
| Ergebnis | | Leise Bearbeitungsgeräusche, erhöhte Produktivität. Gute Oberflächenqualität mit 3 µm Parallelität und 4 µm Ebenheit. | |



| GG-25, Kurbelwelle K | | Sumitomo | Wettbewerber |
|-----------------------------|--------------------|--|--------------|
| | Fräser | WEZ17050E05 | – |
| | Sorte | XCK2000 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 50 | 50 |
| | Anzahl Zähne | 5 | 5 |
| | v_c (m/min) | 188 | 188 |
| | v_f (mm/min) | 898 | 898 |
| | f_z (mm/Z) | 0,15 | 0,15 |
| | a_p (mm) | 1,0 | 1,0 |
| | a_e (mm) | – | – |
| | Kühlung | nass | nass |
| Ergebnis | | Hervorragende Verschleißfestigkeit, 4,7-fach höhere Standzeit. | |



| GG-25, Bahnbauteil K | | Sumitomo | Wettbewerber |
|-----------------------------|--------------------|--|---------------------|
| BAZ, vertikal | Fräser | WEZ11040M16Z6 | Quadratische Platte |
| | Sorte | ACK3000 | – |
| | Spanbrecher | G | – |
| | Fräserdurchm. (mm) | 40 | 40 |
| | Anzahl Zähne | 6 | 3 |
| | v_c (m/min) | 37 | 48 |
| | v_f (mm/min) | 707 | 344 |
| | f_z (mm/Z) | 0,4 | 0,3 |
| | a_p (mm) | 2,5x1 Stufe+1 | 1,5x2 Stufen+0,5 |
| | a_e (mm) | – | – |
| | Kühlung | nass | |
| Ergebnis | | Die verbesserte Schneidenschräfe ermöglicht eine stabile Bearbeitung mit einer 4,5-fach höheren Effizienz. | |



■ Anwendungsbeispiele

| Kunststoffelektronik | | N | Sumitomo | Wettbewerber |
|----------------------------------|--------------------|---|----------------|--------------|
| BAZ BT40, vertikal | Fräser | WEZ11080R07 | 2 Schneidecken | |
| | Sorte | DL2000 | – | |
| | Spanbrecher | S | – | |
| | Fräserdurchm. (mm) | 80 | 80 | |
| | Anzahl Zähne | 7 | 7 | |
| | v_c (m/min) | 376 | 376 | |
| | v_f (mm/min) | 1.050 | 1.050 | |
| | f_z (mm/Z) | 0,1 | 0,1 | |
| | a_p (mm) | 3 | 3 | |
| | a_e (mm) | 50 | 50 | |
| | Kühlung | nass | nass | |
| | Ergebnis | Geringerer Geräuschpegel durch verbesserte Schneidleistung. | | |
| Al-Alloy A2025, Maschinenbauteil | Fräser | WEZ17063RS04 | 2 Schneidecken | |
| | Sorte | H20 | – | |
| | Spanbrecher | S | – | |
| | Fräserdurchm. (mm) | 63 | 63 | |
| | Anzahl Zähne | 4 | 4 | |
| | v_c (m/min) | 1.187 | 1.187 | |
| | v_f (mm/min) | 1.920 | 1.920 | |
| | f_z (mm/Z) | 0,08 | 0,08 | |
| | a_p (mm) | 1 | 1 | |
| | a_e (mm) | 50 | 50 | |
| | Kühlung | – | – | |
| | Ergebnis | Sehr geringe Maßschwankungen und konstante Bearbeitungsgenauigkeit. | | |

| Industriell 3D-gedrucktes Maschinenbauteil aus FRPP-Kunstharz | | N | Sumitomo | Wettbewerber |
|---|--------------------|--|----------------|--------------|
| BAZ BT50, horizontal | Fräser | WEZ11020E02 | 2 Schneidecken | |
| | Sorte | ACM300 | – | |
| | Spanbrecher | L | – | |
| | Fräserdurchm. (mm) | 20 | 20 | |
| | Anzahl Zähne | 2 | 3 | |
| | v_c (m/min) | 200 | 37 | |
| | v_f (mm/min) | 640 | 220 | |
| | f_z (mm/Z) | 0,1 | 0,091 | |
| | a_p (mm) | 5-9 x 3 Stufen | 5-9 x 3 Stufen | |
| | a_e (mm) | 0,95 x 1 Stufe | 0,95 x 1 Stufe | |
| | Kühlung | – | – | |
| | Ergebnis | Minimale Abstufung der Bearbeitungsfläche, höhere Schnittleistung. | | |
| Al-Legierung A5052, Maschinenbauteil | Fräser | WEZ17025M12Z2 | – | |
| | Sorte | DL2000 | – | |
| | Spanbrecher | S | – | |
| | Fräserdurchm. (mm) | 25 | – | |
| | Anzahl Zähne | 2 | – | |
| | v_c (m/min) | 785 | – | |
| | v_f (mm/min) | 4.000 | – | |
| | f_z (mm/Z) | 0,2 | – | |
| | a_p (mm) | 3,9 | – | |
| | a_e (mm) | 25 | – | |
| | Kühlung | nass | – | |
| | Ergebnis | Stabile, ratterfreie Bearbeitung auch bei einem Überhang von 100 mm (L/D=4). | | |

| Titan-Legierungen, Flugzeugbauteil | | S | Sumitomo | Wettbewerber |
|------------------------------------|--------------------|--|----------------|--------------|
| Kombi-Drehmaschine | Fräser | WEZ17035E03 | 2 Schneidecken | |
| | Sorte | ACM300 | – | |
| | Spanbrecher | L | – | |
| | Fräserdurchm. (mm) | 35 | 35 | |
| | Anzahl Zähne | 3 | 3 | |
| | v_c (m/min) | 45 | 45 | |
| | v_f (mm/min) | – | – | |
| | f_z (mm/Z) | 0,16 | 0,16 | |
| | a_p (mm) | 3 | 3 | |
| | a_e (mm) | 17,5 | 17,5 | |
| | Kühlung | nass | nass | |
| | Ergebnis | Standzeitverbesserung | | |
| BAZ BT50, vertikal | Fräser | WEZ11063RS08 | 2 Schneidecken | |
| | Sorte | ACU2500 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 63 | 63 | |
| | Anzahl Zähne | 8 | 8 | |
| | v_c (m/min) | 48 | 48 | |
| | v_f (mm/min) | 310 | 310 | |
| | f_z (mm/Z) | 0,16 | 0,16 | |
| | a_p (mm) | 2 | 2 | |
| | a_e (mm) | 50 | 50 | |
| | Kühlung | nass | nass | |
| | Ergebnis | Keine Ausbrüche, längere Standzeiten und reduzierte Gratbildung. | | |

"WaveMill" Serie

WEZR - Typ

■ Anwendungsbeispiele WEZR

| SUM42L, Maschinenbauteil | | P | Sumitomo | Wettbewerber |
|--------------------------|--------------------|--|----------------|--------------|
| Multi-tasking Maschine | Fräser | WEZR11032E3632Z003 | 2 Schneidecken | |
| | Sorte | ACU2500 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 32 | 25 | |
| | Anzahl Zähne | 3x4 Stufen | 2x3 Stufen | |
| | v_c (m/min) | 120 | 80 | |
| | v_f (mm/min) | 716 | 102 | |
| | f_z (mm/Z) | 0,20 | 0,05 | |
| | a_p (mm) | 32 | 32 | |
| | a_e (mm) | 3,0 | 0,8 | |
| Kühlung | | nass | nass | |
| Ergebnis | | Keine Rattermarken, Erhöhung der Effizienz um mehr als das 12-Fache. | | |



| GG-25, Maschinenbauteil | | K | Sumitomo | Wettbewerber |
|-------------------------|--------------------|---|----------------|--------------|
| BAZ BT50, vertikal | Fräser | WEZR11032M1645Z3* | 2 Schneidecken | |
| | Sorte | ACU2500 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 32 | 25 | |
| | Anzahl Zähne | 3x5 Stufen | 3x5 Stufen | |
| | v_c (m/min) | 80 | 80 | |
| | v_f (mm/min) | 500 | 500 | |
| | f_z (mm/Z) | 0,2 | 0,2 | |
| | a_p (mm) | 45 | 45 | |
| | a_e (mm) | 0,5–6,0 | 0,5–6,0 | |
| Kühlung | | trocken | trocken | |
| Ergebnis | | Ermöglicht eine geräuscharme Bearbeitung auch bei einem Werkzeugüberstand von 200 mm. | | |

* Sonderanfertigung

| Titan-Legierung Ti-6Al-4V, Bauteil für die Luftfahrtindustrie | | S | Sumitomo | Wettbewerber |
|---|--------------------|--|----------------|--------------|
| BAZ HSK63, vertikal | Fräser | WEZR11032M1618Z3* | 2 Schneidecken | |
| | Sorte | ACM300 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 32 | 32 | |
| | Anzahl Zähne | 3x2 Stufen | 3x3 Stufen | |
| | v_c (m/min) | 40 | 40 | |
| | v_f (mm/min) | 119 | 84 | |
| | f_z (mm/Z) | 0,10 | 0,07 | |
| | a_p (mm) | 15 | 15 | |
| | a_e (mm) | 24 | 24 | |
| Kühlung | | nass | nass | |
| Ergebnis | | Geeignet für die Bearbeitung mit reduzierter Schnittkraft, selbst bei 14-facher Vorschubgeschwindigkeit. | | |

* Sonderanfertigung

| Al-Legierung ADC12, Bauteil für die Luftfahrtindustrie | | N | Sumitomo | Wettbewerber |
|--|--------------------|---|----------------------|--------------|
| BAZ BT30, vertikal | Fräser | WEZR11033E4525Z03* | Volkhartmetallfräser | |
| | Sorte | DL2000 | – | |
| | Spanbrecher | G | – | |
| | Fräserdurchm. (mm) | 33 | 32 | |
| | Anzahl Zähne | 3x5 Stufen | 4 | |
| | v_c (m/min) | 487 | 100 | |
| | v_f (mm/min) | 800 | 224 | |
| | f_z (mm/Z) | 0,056 | 0,056 | |
| | a_p (mm) | 25 | 25 | |
| | a_e (mm) | 1 | 1 | |
| Kühlung | | nass | nass | |
| Ergebnis | | Effizienzsteigerung um mindestens das 5-Fache bei reduzierten Werkzeugkosten. | | |



* Sonderanfertigung



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Vertretung: