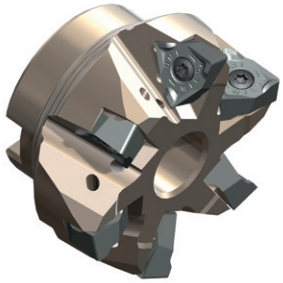
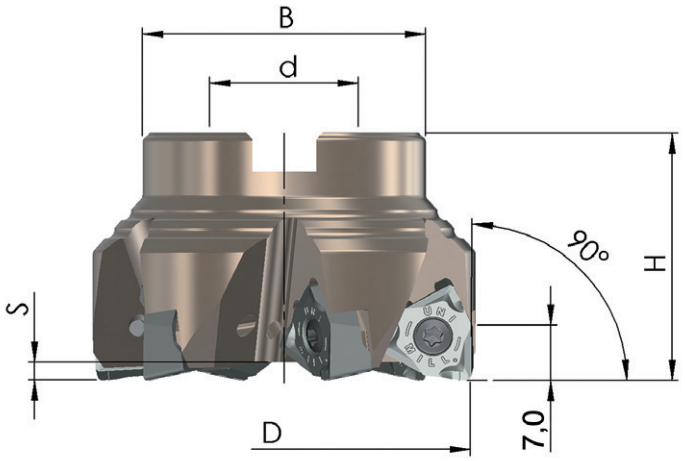
B22 Eckfräser 90° *Step mills, Fraises à 90°, Frese per spallamenti retti*

Aufsteckfräser *Shell type mills, Fraises à alésage, Frese per attacco a manicotto*



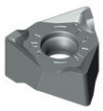
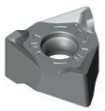


Bestell-Nr. *Order-No., Référence, Codice*	D	H	d	B	S	Z	MS
90PP-050-853-4	50	40	22	46	2,75	4	MS 10x25-912
90PP-063-853-5	63	40	22	46	2,75	5	MS 10x25-912
90PP-080-853-6	80	50	27	58	5,75	6	MS 12x35-912
90PP-100-853-7	100	50	32	78	3,75	7	MS 16x35-6912
90PP-125-853-9	125	63	40	90	3,75	9	MS 20x55-7991
90PP-160-853-11	160	63	40	90	3,75	11	MS 20x55-7991
Enge Teilung *close pitch, à pas réduit, a passo stretto:*							
90PP-050-853-5	50	40	22	46	2,75	5	MS 10x25-912
90PP-063-853-6	63	40	22	46	2,75	6	MS 10x25-912
90PP-080-853-7	80	50	27	58	5,75	7	MS 12x35-912
90PP-100-853-9	100	50	32	78	3,75	9	MS 16x35-6912
90PP-125-853-11	125	63	40	90	3,75	11	MS 20x55-7991
90PP-160-853-13	160	63	40	90	3,75	13	MS 20x55-7991

MS= Mittenschraube *Central screw, Vis centrale, Vite centrale di fissaggio*

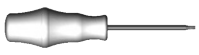
B22 Fräswendeplatten und Schnittdaten

Milling inserts and parameters, Plaquettes de fraisage et paramètres, Inserti e parametri di taglio

			HT45 (code 31)	HT32 (code 33)	HT20 (code 32)				
	**JMB22-753R08-** IK 12,9x7,8 R0,8 U	Order-No.	**B22GW -31-A**	**B22DX -33-A**	**B22AT -32-A**	**Parallelitätsfehler bis zu 0,05mm möglich!** *Parallelism error up to 0,05 mm!* *Attention défaut de parallélisme possible de max 0,05mm!* *Errore di parallelismo fino à max. 0,05 mm!*			
		f_z [mm]	0,15 (0,10-0,25)	0,15 (0,10-0,20)	0,20 (0,15-0,25)				
	**JMB22-853R08-** IK 12,9x7,8 R0,8 M S	Order-No.	**B22RX -31-B**	**B22NW -33-B**	**B22JZ -32-B**				
		f_z [mm]	0,15 (0,10-0,25)	0,15 (0,10-0,20)	0,20 (0,15-0,25)				
			10	10	10				

v_c [m/min]	**Stahl** *Steel* *Acier* *Acciaio*	**Rostfrei** *Stainless* *Acier inoxydable* *Inossidabile*	**Guss** *Cast iron* *Fonte* *Ghisa*	**NE-Metalle** *Non-ferrous metals* *Non ferreux* *Metalli non ferrosi*	**Hochwarmfest** *Highly heat-resistant* *Superalliages* *Resistente al calore*	**Gehärtet** *Tempered* *Aciers traités* *Temprato*
HT45	250 (200 - 350)	240 (140 - 300)	240 (130 - 280)			
HT32	250 (200 - 350)	240 (140 - 300)			60 (40 - 200)	
HT20			260 (180 - 350)			80 (40 - 120)

Ersatzteile *Spare parts, Pièces de rechange, Parti di ricambio*

SS 4,0-2 (M = 3,2-3,3 Nm)	 **T 15+**	**Fett** *Grease, Graisse, Grasso*

Jongen Werkzeugtechnik GmbH | Siemensring 11 | 47877 Willich | Germany
Tel.: +49 (0) 21 54 92 85-0 | Fax: +49 (0) 21 54 9285 9 2000
Email: info@jongen.de | www.jongen.de