VIKING ULTRA

wurde speziell für die Bearbeitung von Nickel- und Chromlegierungen für Hochtemperaturbedingungen entwickelt.

Ein Vollhartmetallfräser der Extraklasse – optimiert für höchste Belastung, maximale Standzeit und absolute Prozessstabilität.



Maschinenbau

Luft- & Raumfahrt

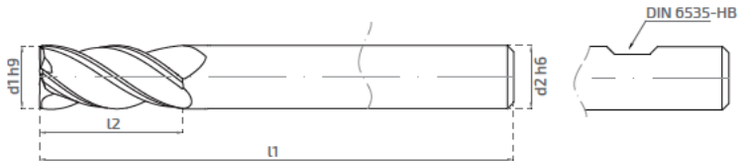
Rüstungsindustrie

Energiebranche

VIKING

ULTRA





VIKING
PRO SERIES

Ab Lager	d1h9	d2h6	l1	l2	Ch/R	Z	Artikelnummer HA	Artikelnummer HB	Preis
*	3	6	51	6	Ch 0.03	3	VM3-3,0	VM3-3,0W	
*	3	6	51	6	R 0.20	4	VM4R02-3,0	VM4R02-3,0W	
*	4	6	58	12	R 0.20	4	VM4R02-4,0	VM4R02-4,0W	
*	4	6	58	12	R 0.50	4	VM4R05-4,0	VM4R05-4,0W	
*	4	6	58	12	R 1.00	4	VM4R10-4,0	VM4R10-4,0W	
*	6	6	58	14	R 0.20	4	VM4R02-6,0	VM4R02-6,0W	
*	6	6	58	14	R 0.50	4	VM4R05-6,0	VM4R05-6,0W	
*	6	6	58	14	R 1.00	4	VM4R10-6,0	VM4R10-6,0W	
	6	6	58	14	R 1.50	4	VM4R15-6,0	VM4R15-6,0W	
*	8	8	64	23	R 0.20	4	VM4R02-8,0	VM4R02-8,0W	
*	8	8	64	23	R 0.50	4	VM4R05-8,0	VM4R05-8,0W	
	8	8	64	23	R 1.50	4	VM4R15-8,0	VM4R15-8,0W	
	8	8	64	23	R 2.00	4	VM4R20-8,0	VM4R20-8,0W	
*	8	8	64	17	Ch 0.30	4	VM4-8,0	VM4-8,0W	
*	10	10	73	24	R 0.20	4	VM4R02-10,0	VM4R02-10,0W	
*	10	10	73	24	R 0.50	4	VM4R05-10,0	VM4R05-10,0W	
*	10	10	73	24	R 1.00	4	VM4R10-10,0	VM4R10-10,0W	
	10	10	73	24	R 2.00	4	VM4R20-10,0	VM4R20-10,0W	
	12	12	65	26	R 0.20	4	VM4R02S-12,0	VM4R02S-12,0W	
*	12	12	82	28	R 0.20	4	VM4R02-12,0	VM4R02-12,0W	
*	12	12	82	28	R 0.50	4	VM4R05-12,0	VM4R05-12,0W	
*	12	12	82	28	R 1.00	4	VM4R10-12,0	VM4R10-12,0W	
	12	12	82	28	R 2.00	4	VM4R20-12,0	VM4R20-12,0W	
	12	12	82	28	R 4.00	4	VM4R40-12,0	VM4R40-12,0W	
*	16	16	93	38	R 0.20	4	VM4R02-16,0	VM4R02-16,0W	
*	16	16	93	38	R 0.50	4	VM4R05-16,0	VM4R05-16,0W	
	20	20	105	44	R 5.00	4	VM4R50-20,0	VM4R50-20,0W	

Z4



Z3









Schnittdaten VIKING ULTRA			
Material	Nutfräsen ap=1.0 - 0.5Ø	Schulterfräsen ap=1.5Ø / ae=0.35 - 0.2 0Ø	Umsäumen ap=1.5Ø / ae=0.20 - 0.10Ø
	Vc (m/min)	Vc (m/min)	Vc (m/min)
AISI 304 - 416 - 420	50-70	70-90	80-100
AISI 316 - 440	45-70	55-80	60-90
17-4 PH 15-5 PH	45-70	55-80	60-90
Chrome-Cobalt Legierungen	30-50	35-55	40-70
Cr - Co Legierungen	60-80	65-85	70-90
Duplex F51	60-80	65-85	70-90
Super Duplex F55	30-50	40-60	50-70
Hastelloy	30-50	40-60	50-70
Inconel 625	30-50	40-60	50-70
Inconel 718	30-50	40-60	50-70
Nimonic	60-80	70-90	80-90
Titan	60-80	70-90	80-90











Vorschub (mm/Zahn)								
ø	ae=1xØ	ae=0.50xØ	ae=0.35xØ	ae=0.30xØ	ae=0.25xØ	ae=0.20xØ	ae=0.15xØ	ae=0.10xØ
3	0.006	0.007	0.007	0.007	0.007	0.008	0.008	0.010
4	0.008	0.010	0.009	0.009	0.010	0.010	0.011	0.014
5	0.011	0.014	0.012	0.013	0.013	0.014	0.015	0.019
6	0.014	0.017	0.015	0.016	0.017	0.018	0.020	0.024
8	0.020	0.024	0.022	0.023	0.024	0.025	0.028	0.034
10	0.027	0.029	0.030	0.031	0.032	0.034	0.038	0.046
12	0.035	0.040	0.040	0.041	0.043	0.045	0.050	0.061
16	0.055	0.065	0.061	0.063	0.066	0.069	0.077	0.094
20	0.075	0.090	0.083	0.086	0.090	0.094	0.105	0.128