Seco

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Katalog & Technischer Guide

Bohrungsbearbeitung 2026.1

Seco entwickelt Werkzeuge, Technologien und Lösungen für anspruchsvollste Fertigungsaufgaben. Seit der Gründung in Fagersta, Schweden, bis zur heutigen globalen Unternehmensausrichtung ist unser Geschäftsmodell stets auf die speziellen Bedürfnisse unserer Kunden ausgerichtet und von Vertrauen geprägt.

Wir kombinieren hochmoderne Präzisionswerkzeuge mit partnerschaftlichen Kundenbeziehungen und technischem Know-How, um die Zerspanungswelt gemeinsam voranzubringen.

Wir sind "Made for Makers" – mit innovativen Ideen und nachhaltigen Ansätzen. Nachhaltigkeit steht im Mittelpunkt unseres Handelns. Wir stellen uns den Herausforderungen einer sich wandelnden Industrie und sind stolz darauf, mitzuwirken, neue Wege zu erschließen, um mit unseren Kunden und Partnern die Zukunft zu gestalten. Wenn nicht, schaffen wir es.

Made for Makers

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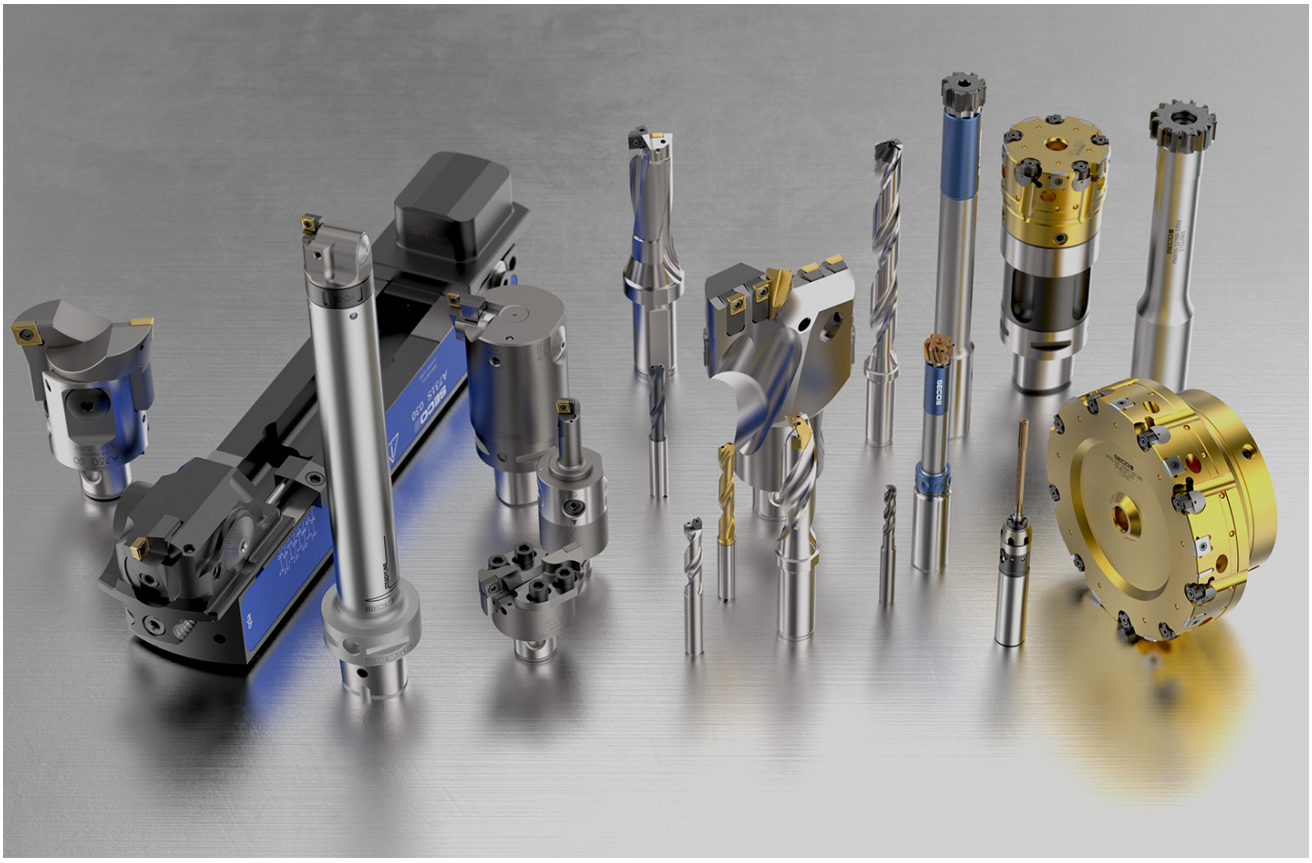
Herausforderungen meistern

Bohrungsbearbeitung ist ein wichtiger Schritt im Prozess. Hochwertige Werkzeuge ermöglichen mehr Produktivität und geringere Werkzeugkosten. Mit einem Partner, der bewährte Prozesse und neue Lösungen anbieten kann, steigern Sie Ihren Erfolg. Ein Partner, der Ihre individuellen Herausforderungen versteht und ein umfassendes Spektrum an Lösungen zum Bohren, Reiben, Ausdrehen und Gewindeschneiden anbietet.

Bei Seco Tools erhalten Sie all diese Lösungen aus einer Hand. Mit langjähriger Erfahrung in der Bohrungsbearbeitung haben wir die nötige Expertise in Forschung und Entwicklung und umfassende praktische Erfahrung, um Ihre Prozesse optimal zu gestalten.

Wir konzentrieren uns darauf, die Produktivität unserer Kunden in der Bohrungsbearbeitung zu steigern. Das bedeutet: Sie erhalten Werkzeuge, technischen Support, Austausch mit Experten und Entwicklung von Lösungen mit nur einem Anbieter.



WAS BRAUCHEN SIE FÜR IHRE BOHRUNGSBEARBEITUNG?

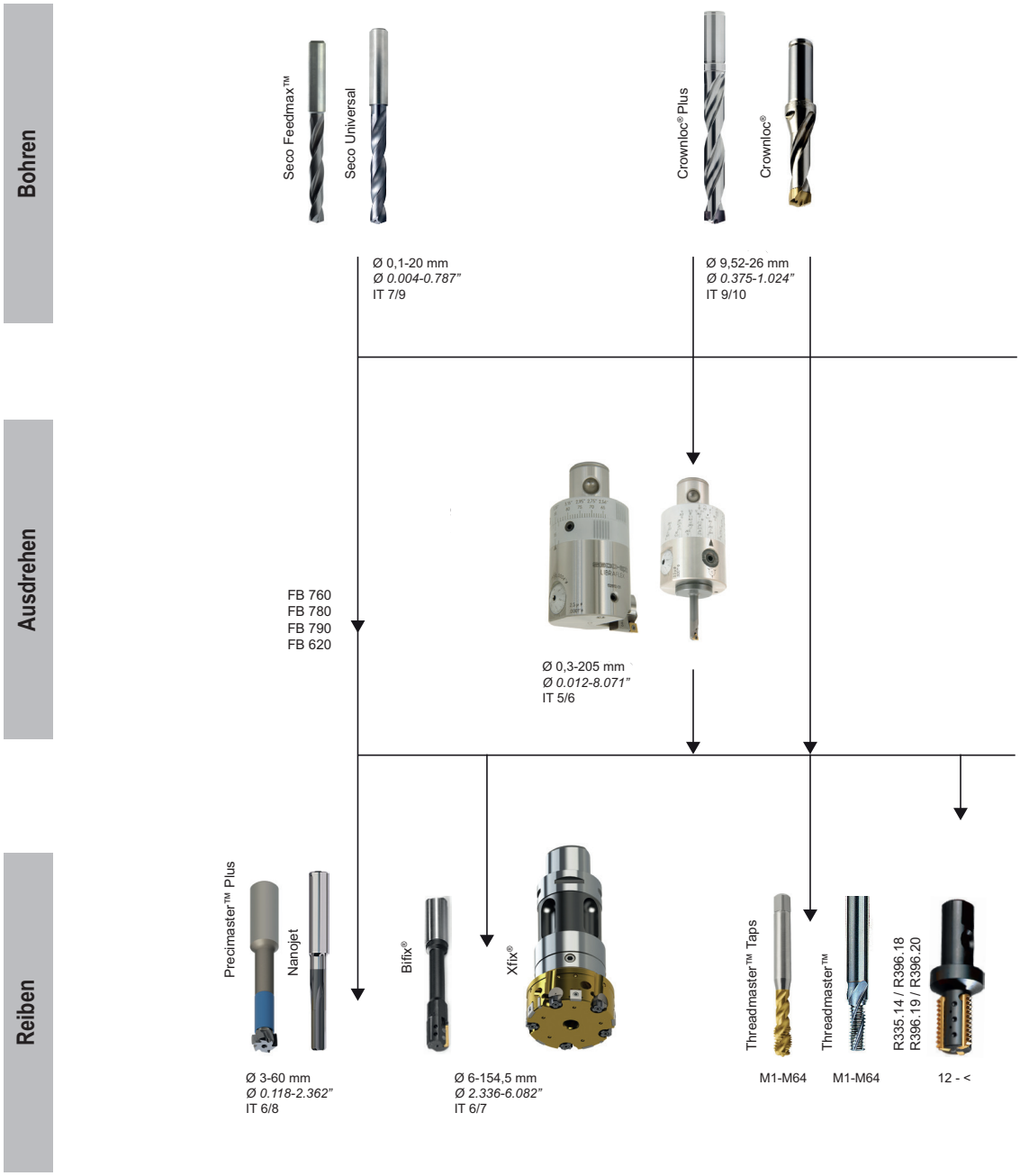
	Bohren			Reiben				Ausdrehen		Gewindeschneiden			
	Seco Universal Seco Feedmax™	Crownloc® Crownloc® Plus	Perfomax®	Precimaster™ Plus	Nanojet	Bifix®	Xfix™	Schruppausdrehen	Feinausdrehen	Threadmaster™	Threadmaster™ Gewinde-bohrer		Gewindefräsen 396.18/.19/.20
Seite(n)	29-166	185-237	238-324	329-366	367-392	393-419	420-459	598-501	502-552	Siehe Katalog Gewinde			
IT	7-9	9-10	12	6-8	6-8	6-7	6-7	9-10	5-6	–	–	–	–
	0,02 mm *(0.0008")*	0,05 mm *(0.002")*	–	Folgt der Vorbohrung	Folgt der Vorbohrung	Folgt der Vorbohrung	Folgt der Vorbohrung	0,005 mm *(0.0002")*	0,005 mm *(0.0002")*	–	–	–	–
	0,02 mm *(0.0008")*	0,05 mm *(0.002")*	–	0,007 mm *(0.0003")*	0,007 mm *(0.0003")*	0,005 mm *(0.0002")*	0,005 mm *(0.0002")*	0,02 mm *(0.0008")*	0,01 mm *(0.0004")*	–	–	–	–
$\sqrt{R_a}$	1,0 µm *(39 µin)*	1,6 µm *(63 µin)*	2,0 µm *(79 µin)*	0,6 µm *(24 µin)*	0,6 µm *(24 µin)*	0,25 µm *(10 µin)*	0,8 µm *(31 µin)*	1,0 µm *(39 µin)*	0,6 µm *(24 µin)*	–	–	–	–
TCTR	–	–	–	–	–	–	–	–	–	–	6H 6HX 6G 2B Normal	5HX 2BX Normal-X 6HX 6GX	–
Gewindeform	–	–	–	–	–	–	–	–	–	M MF UNC UNF NPT NPTF BSP	M MF UNC UNF G NPT NPTF	M MF UNC UNF G	ISO UN W NPT NPTF BSPT

Werkzeugauswahl

Seco Feedmax, Crownloc oder Perfomax werden eingesetzt für Bohrungen im Durchmesserbereich 0,1 bis 160 mm (0.004-6.299"), mit Toleranzen von IT7 bis IT12.
Bei gegossenen Bohrungen wird sehr oft Schruppausdrehen oder Vorschlichten genutzt, mit Brücken- und Jumbo-Brückenwerkzeugen für große Durchmesser.
Hochpräzisionsbohrungen mit Toleranzen von IT5 oder IT6 werden mit Schlichtwerkzeugen zum Reiben und Ausspindeln erzielt.
* Schruppen IT9/10, ** Schlichten IT 5/6

Threadmaster DTM, TM, TM2, 396.18 und 396.19:
Dasselbe Werkzeug kann für rechte und linke Gewinde eingesetzt werden. Fräser für metrisches und UN-Gewinde gibt es nur für Innengewinde. Es können ebenfalls alle Toleranzen mit demselben Werkzeug gefertigt werden.

Threadmaster Gewindebohrer:
Verfügbar in den meistverwendeten Gewinden und Toleranzen sowohl zum Gewindeschneiden als auch zum Gewindebohren.



Gegossene Bohrungen

Perfomax®

SD602

Ø 15-85 mm
Ø 0.591-3.346”
IT 12

Ø 60-160 mm
Ø 2.362-6.299”
IT 12

RB 750
RB 610

Ø 18-205 mm
Ø 0.709-8.071”
IT 9/10

Schruppausdrehen

RB 750
RB 610

Ø 18-205 mm
Ø 0.709-8.071”
IT 9/10

BB 731
Jumbo

Ø 204-3205 mm
Ø 8.031-126.181”
*IT 9/10
**IT 5/6

Feinausdrehen

FB 760
FB 780
FB 790
FB 620

Ø 0,3-205 mm
Ø 0.012-8.071”
IT 5/10

Bohrerprogramm – Die Wahl des richtigen Bohrers

Seco Feedmax™ Vollhartmetallbohrer

PRODUKTIVITÄT
- Hohe Vorschübe und Schnittgeschwindigkeiten
- Bohrungen mit engen Toleranzen
- Für Anwendungen mit hoher Stabilität
- Für alle Werkstoffe

Crownloc® und Crownloc® Plus Bohrer mit austauschbaren Kronen

FLEXIBILITÄT
- Austauschbare Hartmetallkronen
- Geometrien für unterschiedliche Werkstoffe
- Nicht nachschleifbar
- Verschiedene Kronendurchmesser für jeden Bohrerkörper

Perfomax® Bohrer mit Wendeschneidplatten

KOSTENGÜNSTIG
- Sorten und Geometrien für alle Werkstoffe
- Quadratische Wendeschneidplatten für geringe Kosten/Bohrung
- Bohren, Eintauchen, Kreuzbohrungen mit winkeligem Eintritt oder Austritt, Ausdrehen, etc.
- Hohe Prozesssicherheit

ISO-Attribute

ISO-Attribut	Erklärung
ADJLN	Untere Einstellgrenze
ADJLX	Obere Einstellgrenze
ADJRG	Einstellbereich
AN	Hauptfreiwinkel
APMX	Maximale Schnitttiefe
AZ	Maximale axiale Schnitttiefe
B	Schaftbreite
BD	Körper-Durchmesser
BD1	Körper-Durchmesser 1
BD2	Körper-Durchmesser 2
BDX	Maximaler Körper-Durchmesser
BHTA	Konuswinkel
BLQ	Auswuchtgüte
BN	Breite der Führungsfase
CBDP	Bohrungstiefe der Werkzeugaufnahme
CDX	Maximale Schnitttiefe
CEDC	Schneidenanzahl
CHA	Winkel der Querbohrung
CHW	Fasenbreite
CNT	Gewindegröße des Kühlmitteleinlasses
CW	Schnitttiefe/Stechbreite
CZC	Code Anschlussgröße
D1	Durchmesser Befestigungsbohrung
DC	Schnittdurchmesser
DCB	Bohrungsdurchmesser Werkzeugaufnahme
DCBN	Bohrungsdurchmesser Werkzeugaufnahme min.
DCBX	Bohrungsdurchmesser Werkzeugaufnahme max.
DCB1	Bohrungsdurchmesser Werkzeugaufnahme 1
DCC	Code der Design-Konfiguration
DCINN	Werkzeuginnendurchmesser, min.
DCINX	Werkzeuginnendurchmesser, max.
DCN	Werkzeugdurchmesser, min.
DCON	Schaftdurchmesser
DCX	Werkzeugdurchmesser, max.
DF	Bunddurchmesser
DMM	Schaftdurchmesser
FLGW	Flanschbreite
GAN	Spanwinkel
GB	Winkel der Führungsfase
HTB	Körperhöhe
IC	Durchmesser des einbeschriebenen Kreises
INSD	Durchmesser des Schneidkopfs
INSL	Länge der Wendeschneidplatte
KRINS	Einstellwinkel
L	Schneidkantenlänge
LB	Körperlänge
LB1	Körperlänge 1
LCF	Spannutenlänge
LE	Effektive Schneidenlänge
LF	Funktionale Länge
LFS	Sekundäre Funktionale Länge
LH	Kopflänge

ISO-Attribut	Erklärung
LPR	Länge Überstand
LS	Schaftlänge
LSC	Länge der Pratze
LU	Nutzlänge
LUX	Maximale Nutzlänge
M	M-Abmessung
OAL	Gesamtlänge
RE	Eckenradius
S	Wendeschneidplatten-Dicke
TDZ	Größe des Gewindedurchmessers
WB	Körperbreite
WF	Funktionale Breite

SMG – Einführung

Zum Beispiel stehen die Referenzwerkstoffe EN C45E für SMG P4 und EN 42 CrMo 4 für sowohl SMG P5 als auch SMG H5. Weitere Informationen, siehe Tabellen.
Die SMG Werkstoff-Klassifizierung umfasst einen speziellen Werkstoffstandard in einer spezifischen Ausführung als Referenz, womit eine schnelle und einfache Anpassung der Schnittdaten eines jeden Werkstoffes im Vergleich zu dem entsprechenden Seco Referenz-Werkstoff erfolgen kann.
Als Beispiel werden die Referenzwerkstoffe EN C45E für SMG P4 und EN 42 CrMo 4 für die beiden SMG P5 und SMG H5 in der nachstehenden Tabelle 1 dargestellt, wobei die entsprechenden Materialeigenschaften mit aufgeführt sind.

Die Grundlage für SMG (Seco Werkstoff-Gruppen) ist die Klassifizierung der Werkstoffe basierend auf ihrem Typ und nicht basierend auf der Zerspanbarkeit. Daher sind auch Composites enthalten. Trotz des großen Umfangs ist die Identifizierung der einzelnen Werkstoffe zu den Gruppen recht einfach.
Jede SMG verfügt über einen spezifischen Werkstoffstandard in einer speziellen Ausführung als Referenz, so dass die Schnittdaten für jeden vorhandenen Werkstoff im Vergleich zu jedem Seco Referenz-Werkstoff leicht anzupassen sind, siehe Seiten 658-669.

SMG	Beschreibung	Eigenschaften	Referenz
P4	Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungsstähle	520 < R_m < 1200	C 45E R_m = 660 N/mm²
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²

SMG	Beschreibung	Eigenschaften	Referenz
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 50 HRC

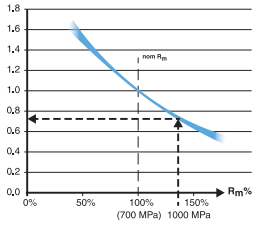
Mit besonderem Fokus auf EN 42 CrMo 4 in geglühter Ausführung kann die Bruchfestigkeit R_m typischerweise zwischen R_m = 630 N/mm² und R_m = 780 N/mm² liegen und bietet damit einen Referenzbereich für SMG P5.

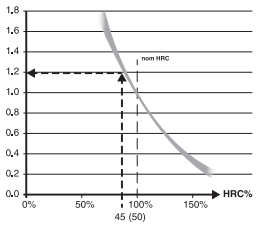
In vergüteter Ausführung kann die Bruchfestigkeit Rm typischerweise zwischen R_m = 900 N/mm² und R_m = 1100 N/mm² liegen, gehört damit aber immer noch zu SMG P5. Bei einer Härte von mehr als R_m = 1200 N/mm² gehört sie jedoch zu SMG H5.

SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI / ASTM	GOST	Ausführung	R_{m_nom}	HRC_{nom}
P4	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Geglüht	700	
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Vergütet	1000	
H5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Vergütet		45
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Vergütet		50

Vergüteter Stahl EN 42CrMo4 kann als Beispiel dafür dienen, wie abhängig die Bearbeitbarkeit der Werkstoffe von deren Ausführung ist.

Die nachstehende Graphik zeigt, wie die Schnittdatenempfehlung für nominelle Werkstoffausführungen an entsprechende R_m (linkes Diagramm für ISO-P) und an entsprechende HRC (für ISO-H) angepasst werden kann.





Um darzustellen, wie in der SMG die nominelle v_c der SMG P5 genauer berechnet werden kann, benötigen wir die ultimative Zugfestigkeit Rm. In diesem Falle verwenden wir EN 42 CrMo 4 vergütet auf R_m = 1000 N/mm2 gemäß der obigen Tabelle (blaue Pfeile fett). Angenommen bei der SMG P5 beträgt die nominelle Schnittgeschwindigkeit für ein bestimmtes Produkt und Bearbeitung v_c = 280 m/min.
So ist die tatsächliche Schnittgeschwindigkeit v_c = 280 m/min x 0,75 = 210 m/min. Daher kann bei der SMG H5 die nominelle Schnittgeschwindigkeit angepasst werden, indem man den gehärteten Werkstoff EN 42 CrMo 4 mit einer Härte von HRC 45 verwendet (kleinere graue Pfeile).

Gehen wir davon aus, dass die nominelle Schnittgeschwindigkeit für SMG H5 v_c = 50 m/min für ein bestimmtes Produkt und eine bestimmte Bearbeitung beträgt, so ist die tatsächliche Schnittgeschwindigkeit v_c = 50 m/min x 1,2 = 60 m/min.
Weitere Werkstoffdetails finden Sie auf Seite(n) 658-669, weitere Schnittdatenempfehlungen auf den entsprechenden Katalogseiten.
Darüber hinaus finden Sie weitere geeignete Werkzeuge zur Schnittdatenberechnung unter My Pages – Suggest auf
www.secotools.com

Hochleistungs- und Universal-Lösungen

Was benötigen Sie in Ihren Anwendungen zum VHM-Bohren?

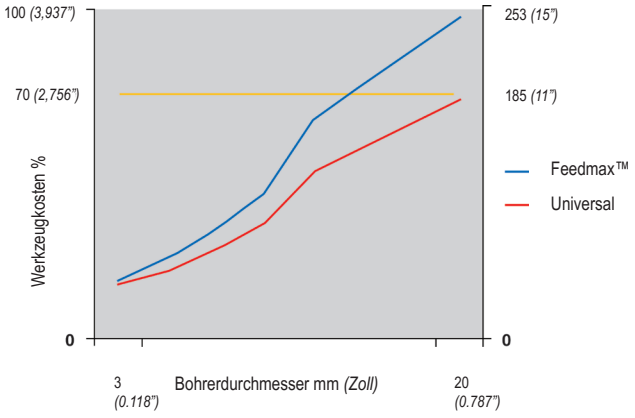
Universal – vielseitiger Vollhartmetallbohrer für allgemeine Bearbeitungen

Universal ist ein Mehrzweckbohrer für den Einsatz in allgemeinen Bearbeitungen, der in einem weiten Anwendungs- und Werkstoffbereich in allen Industriezweigen eingesetzt werden kann.
Die spezielle Ausführung mit einer stabilen, selbstzentrierenden 140-Grad-Bohrerspitze, polierten Spankammern und der hervorragenden Bohrungsqualität bietet hohe Einsatzfähigkeit, Anwendungssicherheit und Vielseitigkeit zu äußerst niedrigen Kosten.
Mit dem Universal reduzieren Sie Ihre Lagerhaltungskosten bei gleichzeitig deutlich höherer Bearbeitungsflexibilität und erreichen damit letztendlich beträchtlich geringere Rüstzeiten.
Universal ist eine Alternative zum Feedmax™ bei Bearbeitungen, bei denen Vielseitigkeit, Flexibilität und geringere Lagerhaltungskosten im Fokus stehen.

Feedmax™ – produktiver Hochleistungs-Vollhartmetallbohrer

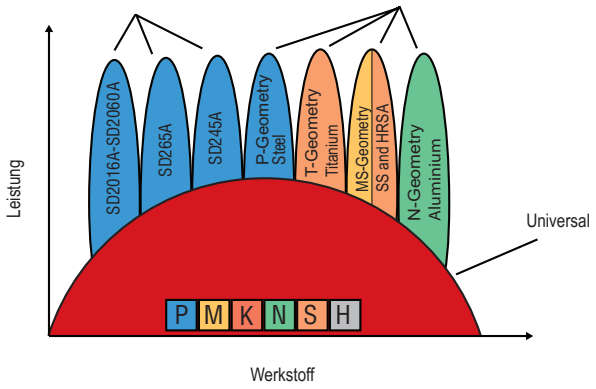
Feedmax™ bietet eine einzigartige Kombination der neuesten Hartmetall-, Beschichtungs- und Geometrie-Technologie.
Feedmax™ wurde entwickelt für hohe Produktivität und geringe Kosten pro Bohrung bei hohen Vorschüben bis zu 0,70 mm/U *(0.028 Zoll/U)* und hohen Schnittgeschwindigkeiten bis zu 220 m/min *(720 sf/min)*. Selbstzentrierend - hohe Bohrungsqualität, keine Zentrierbohrung erforderlich. Dank der modernen Beschichtungstechnologie mit hoher Warmfestigkeit, der stabilen Schneidkanten mit Schutzfasen, hervorragender Spanabfuhr und einer exzellenten Schneidkantenqualität bietet der Feedmax eine lange und zuverlässige Standzeit.
Der Feedmax™ bietet ein umfangreiches Programm an optimierten Geometrien für unterschiedliche Werkstoffe und Anwendungen, für qualitativ hochwertige Bohrungen bei niedrigen Kosten.

MRR, Zeitspan-
volumen (cm^3 / min)

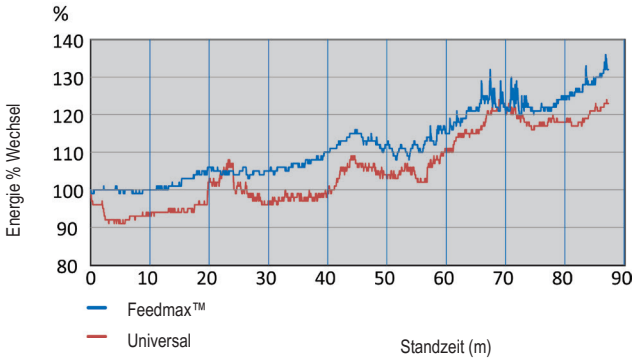


Feedmax™
Anwendungsoptimierte
Geometrien

Feedmax™
Werkstoffoptimierte
Geometrien



Standzeit, niedrigere Schnittdaten

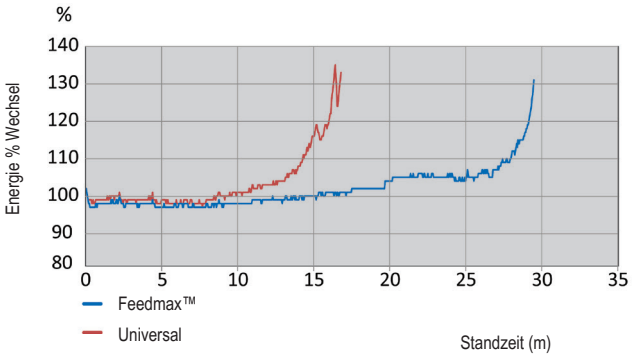


Die erste Bohrung dient als Referenzbohrung, 100% basierend auf der Spindelleistung
Schnittdaten
v_c = 90 m/min
f = 0,15 mm/U

v_c = 295 sf/min
f = 0.006 in/U

Werkstoff = SMG P5-P6, SS2244, DIN41CrMo4, AISI 4140

Standzeit, hohe Schnittdaten

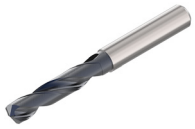
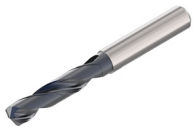
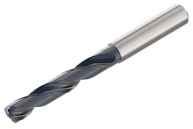


Die erste Bohrung dient als Referenzbohrung, 100% basierend auf der Spindelleistung
Schnittdaten
v_c = 160 m/min
f = 0,24 mm/U

v_c = 525 sf/min
f = 0.009 in/U

Werkstoff = SMG P5-P6, SS2244, DIN41CrMo4, AISI 4140

Programmübersicht

Universal & Feedmax™	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD1103 	Seite(n) 30, 31, 32, 33, 34	∅ 3-20 mm *(0.118-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD1103A 	Seite(n) 35, 36, 37, 38, 39	∅ 3-20 mm *(0.118-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD1105A 	Seite(n) 40, 41, 42, 43, 44, 45	∅ 3-20 mm *(0.118-0.787")*	~ 5 x D	m7	IT 8-9	Ra 1-3 µm *(Ra 39-118 µin)*
SD1108A	Seite(n) 46, 47, 48, 49	∅ 3-20 mm *(0.118-0.787")*	~ 8 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD1112A	Seite(n) 50, 51, 52	∅ 3-20 mm *(0.118-0.787")*	~ 12 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD203A-P	Seite(n) 54, 55, 56, 57, 58, 59	∅ 2-20 mm *(0.078-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-P	Seite(n) 60, 61, 62, 63, 64, 65, 66	∅ 2-20 mm *(0.078-0.787")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD206, SD206A	Seite(n) 67, 68	∅ 0,7-2,0 mm *(0.027-0.078")*	~ 6 x D	h6	IT 9	Ra 1-2 µm *(Ra 39-79 µin)*
SD207A-P	Seite(n) 69, 70, 71	∅ 3-20 mm *(0.118-0.787")*	~ 7 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Programmübersicht

Feedmax™	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD2016A	Seite(n) 72	∅ 3-12 mm *(0.118-0.472")*	~ 16 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2020A	Seite(n) 73	∅ 3-10 mm *(0.118-0.393")*	~ 20 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2025A	Seite(n) 74	∅ 3-10 mm *(0.118-0.393")*	~ 25 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2030A	Seite(n) 75	∅ 3-10 mm *(0.118-0.393")*	~ 30 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2040A	Seite(n) 76	∅ 3-8 mm *(0.118-0.315")*	~ 40 x D	e8	IT 9-10	Ra 1-3 µm *(Ra 39-118 µin)*
SD2050A	Seite(n) 77	∅ 3-6,35 mm *(0.118-0.250")*	~ 50 x D	e8	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2060A	Seite(n) 78	∅ 3-5 mm *(0.118-0.197")*	~ 60 x D	e8	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Programmübersicht

Feedmax™	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD245A	Seite(n) 79-80, 81	∅ 5-14 mm *(0.196-0.551")*	~ 5 x D	m7	IT 8	Ra 1-2 µm *(Ra 39-79 µin)*
SD265A	Seite(n) 83	∅ 6-16 mm *(0.236-0.630")*	~ 5 x D	js6	IT 7	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-MS Superlegierungen	Seite(n) 90, 91, 92, 93	∅ 2-20 mm *(0.079-0.551")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-MS Superlegierungen	Seite(n) 94, 95, 96, 97	∅ 2-20 mm *(0.079-0.551")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-M	Seite(n) 98, 99, 100	∅ 3-14,25 mm *(0.118-0.561")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-M	Seite(n) 101, 102, 103	∅ 2,5-16 mm *(0.098-0.630")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-T, SD205A-T	Seite(n) 104, 105	∅ 4,73-12 mm *(0.188-0.472")*	~ 3 x D, ~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-N	Seite(n) 106, 107	∅ 2,5-14 mm *(0.098-0.551)*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Programmübersicht

Feedmax™	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD205A-C1, -C2	Seite(n) 111-112	∅ 6-9,55 mm *(0.236-0.376")*	~ 5 x D	m7	IT 9	–
SD203-CX1	Seite(n) 113	∅ 3,26-9,53 mm *(0.128-0.375")*	~ 5 x D	m7	IT 9	–
SD22	Seite(n) 115, 116, 117, 118, 119, 120	∅ 0,1-2,0 mm *(0.004-0.079")*	~ 2 x D	0,005/0 mm (+0.0002"/0)	–	–
SD26	Seite(n) 121, 122, 123, 124, 125, 126	∅ 0,1-2,0 mm *(0.004-0.079")*	~ 6 x D	0/-0,004 mm (0/-0.00016")	–	–

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Code-Schlüssel

Universal

SD1105	A	–	0850	–	049	–	10	R	1
1	2		3		4		5	6	7

1.
Bohrertyp – Vollhartmetallbohrer:
SD1103: ~3 x D
SD1105: ~5 x D
SD1108: ~8 x D
SD1112: ~12 x D

2.
Innenkühlung

3.
(Kronen)Bohrerdurchmesser in mm

4.
Bohrtiefe

5.
Schaftdurchmesser mm/Zoll

6.
Rechtsdrehend

7.
Schaftart
1. Zylindrisch

Feedmax™

SD205	A	–	0950	–	049	–	10	R	1	–	P
1	2		3		4		5	6	7		8

1.
Bohrertyp – Vollhartmetallbohrer:
SD203: ~3 x D
SD205: ~5 x D
SD207: ~7 x D
SD2040: ~40 x D
SD2050: ~50 x D
SD2060: ~60 x D

2.
Innenkühlung

3.
(Kronen)Bohrerdurchmesser in mm

4.
Bohrtiefe

5.
Schaftdurchmesser mm/Zoll

6.
Rechtsdrehend

7.
Schaftart
1. Zylindrisch

8.
P-Geometrie für Stahl
MS-Geometrie für Superlegierungen und Rostfrei

Feedmax™

SD205	A	–	9.5	–	45	–	10	R	1	–	M
1	2		3		4		5	6	7		8

1.
Bohrertyp – Vollhartmetallbohrer:
SD206: ~6 x D
SD2016A: ~16 x D
SD2020A: ~20 x D
SD2025A: ~25 x D
SD2030A: ~30 x D
SD245: ~5 x D
SD265: ~5 x D
SD22: ~2 x D
SD26: ~6 x D

2.
Innenkühlung

3.
(Kronen)Bohrerdurchmesser in mm

4.
Bohrtiefe

5.
Schaftdurchmesser mm/Zoll

6.
Rechtsdrehend

7.
Schaftart
1. Zylindrisch
5. Whistle Notch

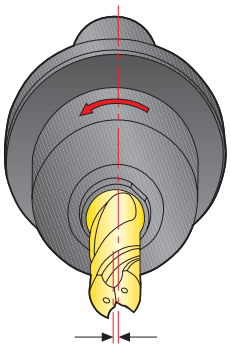
8.
M – Geometrie für Superlegierungen
T – Geometrie für Titanlegierungen
N – Geometrie für Aluminium
C1 – Geometrie für CFK und Austritt in CFK
C2 – Geometrie für CFK und Austritt
in z. B. Ti oder Al
CX1 – PKD-Bohrer für CFK
und GFK

Einstellung

Aufnahme/Rundlaufabweichung
Bei Bohrern mit zylindrischem Schaft können Spannzangenfutter, Hydro-Dehnspannfutter oder Schrumpffutter verwendet werden.
Die maximale Rundlaufabweichung beträgt 0,04 mm (0.0016”) gemessen in der Spindel.
Beste Ergebnisse erzielen Sie mit einer Rundlaufabweichung von 0,02 mm (0,0008”).

Stabilität
Stabilität ist entscheidend fürStandzeit und Bohrungsqualität.
Bitte vorher den Zustand von Maschinenspindel und Aufspannvorrichtung prüfen, um die bestmöglichen
Bearbeitungsbedingungen zu garantieren.
Instabile Bedingungen können zu Werkzeugbruch führen.

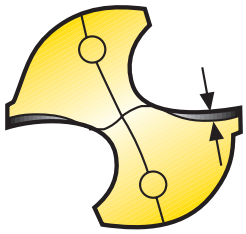
Empfehlungen für Werkzeugaufnahmen



Verwenden Sie die folgenden Aufnahmen für beste Ergebnisse:
Typ 5603 - Schrumpfaufnahmen
Typ 5834/HC/HCR/HCS - Hydrodehnspannfutter
Typ 5672 - Hochpräzisionsspannzangenfutter
Weitere Informationen finden Sie im Seco Katalog Werkzeug-Systeme.

Max. 0,02 mm (0.0008”)

Standzeit
Der maximale Freiflächenverschleiß beträgt 0,1 bis 0,3 mm (0.004-0.012”) gemessen an der breitesten Stelle.



0,1-0,3 mm (0.004-0.012”)

Schrumpfaufnahme
(Für zylindrische Aufnahmen, nur -R1 Schäfte verwenden)

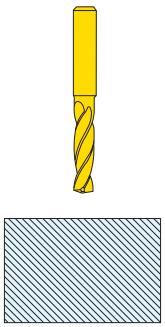
Hydro-Dehnspannfutter
(Für zylindrische Aufnahmen, nur -R1 Schäfte verwenden)

Hochpräzisionsspannzangenfutter
(Für zylindrische Aufnahmen, nur -R1 Schäfte verwenden)

Bearbeitungsverfahren

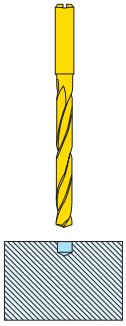
Bohrungseintritt auf einer bearbeiteten Oberfläche

3-15 x D



Kein Vorbohren oder Eintrittsvorschub erforderlich.

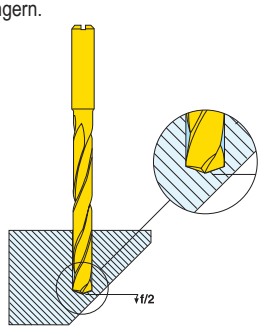
> 16 x D



Zentrierbohren mit einem kurzen Seco Feedmax ist erforderlich.

Winkelige Austrittsflächen

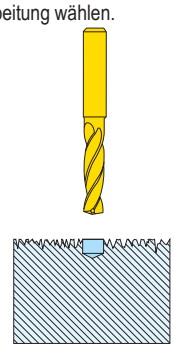
Bevor der Bohrer austritt, den Vorschub um 50 % verringern.



Oder SD245A Bohrer verwenden.

Ungleichmäßiger/winkeliger Eintritt

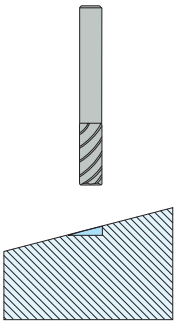
Bei ungleichmäßigen oder winkeligen Eintrittsflächen eine entsprechende Vorbearbeitung wählen.



Gleichmäßige Eintrittsfläche

Zentrierbohren mit einem kurzen Seco Feedmax.

Vorbearbeitungs-alternativen

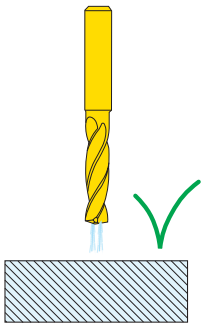


Winkeliger Bohrungseintritt

Fräsen einer ebenen Fläche mit einem Seco Vollhart-metallfräser.

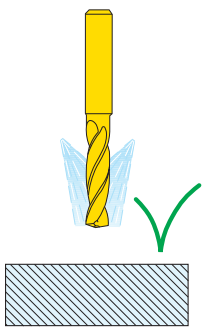
Kühlmittelempfehlungen

1.



Erste Wahl

2.



≤ 5 x D

1. Kühlmitteldruck*
Minimaler Kühlschmierstoffdruck von 10 bar bei ≤ 5 x D
Minimaler Kühlschmierstoffdruck von 30 bar bei > 5 x D
Minimaler Kühlschmierstoffdruck von 40 bar bei > 16 x D

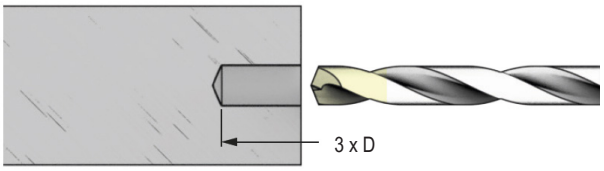
2. Kühlmittelmischung
Wir empfehlen für diese Bearbeitung allgemein eine Kühlschmierstoffkonzentration von 6 bis 8%.
Bei hochlegierten Werkstücken und Rostfrei empfehlen wir eine Kühlschmierstoffkonzentration von 10%.

* Bei niedrigerem Kühlschmierstoffdruck sind die Schnittdaten entsprechend anzugleichen.

Bearbeitungsstrategie – Produktivität

SD2016A (16 x D) bis SD2040A (40 x D)

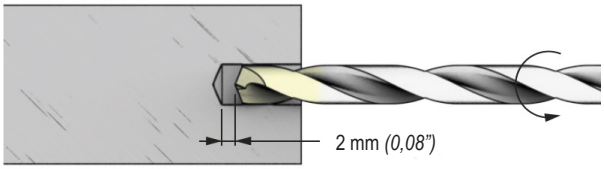
1. Pilotbohrung



≥10 bar
EIN

- SD2030A

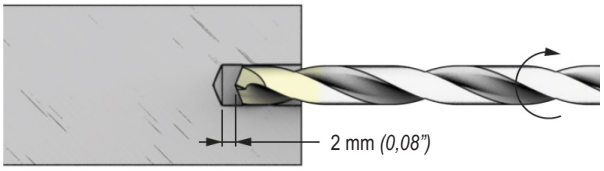
2. Einfahren



AUS

- Bis zu SD2040A
- Mit Drehung gegen den Uhrzeigersinn und Anschlag 2 mm über Bohrlochtiefe
- n_{max} = 100 U/min
- v_f = 1000 mm/min

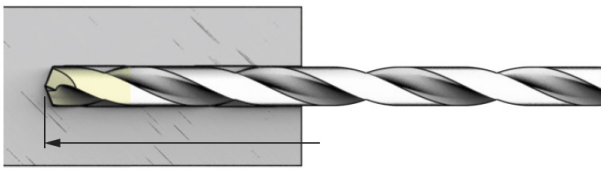
3. Änderung der Spindeldrehrichtung



≥40 bar
EIN

- Bis zu SD2040A
- Drehrichtung im Uhrzeigersinn ändern und Kühlmittelzufuhr starten

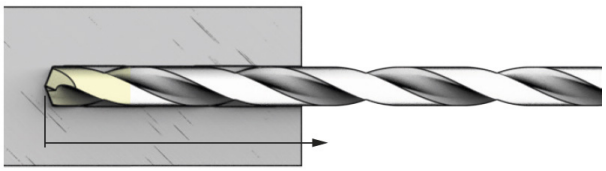
4. Tieflochbohren



≥40 bar
EIN

- Bis zu SD2040A
- v_c = 100%
- v_f = 100%

5. Zurückziehen



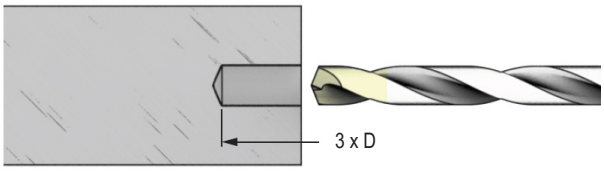
AUS

- Bis zu SD2040A
- n_{max} = 100 U/min
- v_f = 1000 mm/min

Bearbeitungsstrategie – Einsparung von Werkzeugkosten

SD2030A (30 x D) bis SD2060A (60 x D)

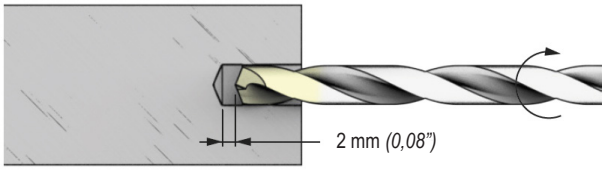
1. Pilotbohrung



≥10 bar
EIN

- SD2030A

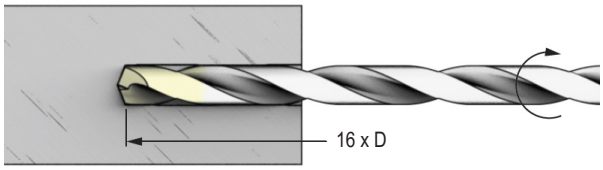
2. Einfahren



AUS

- SD2016A
- Mit Drehung im Uhrzeigersinn und Anschlag 2 mm über Bohrlochtiefe
- n_{max} = 100 U/min
- v_f = 1000 mm/min

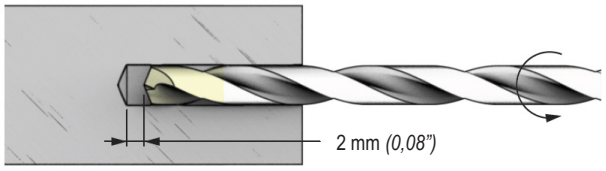
3. Vorbohren



≥10 bar
EIN

- SD2016A
- v_c = 100%
- v_f = 100%

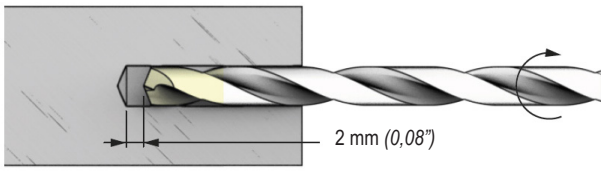
4. Einfahren



AUS

- SD2030A - SD2060A
- Mit Drehung gegen den Uhrzeigersinn und Anschlag 2 mm über Bohrlochtiefe
- n_{max} = 100 U/min
- v_f = 1000 mm/min

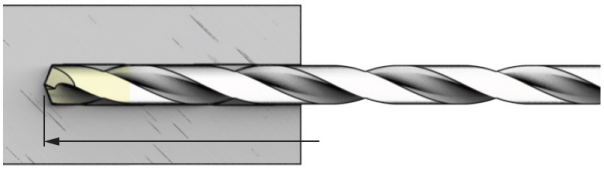
5. Änderung der Spindeldrehrichtung



≥40 bar
EIN

- SD2030A - SD2060A
- Drehrichtung im Uhrzeigersinn ändern und Kühlmittelzufuhr starten

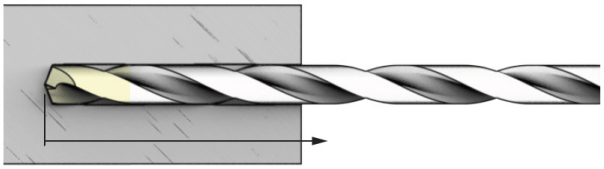
6. Tieflochbohren



≥40 bar
EIN

- SD2030A - SD2060A
- v_c = 100%
- v_f = 100%

7. Zurückziehen

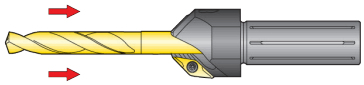


AUS

- SD2030A - SD2060A
- n_{max} = 100 U/min
- v_f = 1000 mm/min

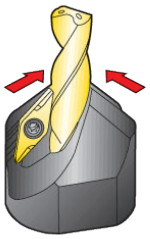
Montagehinweise für Fasringe

1.

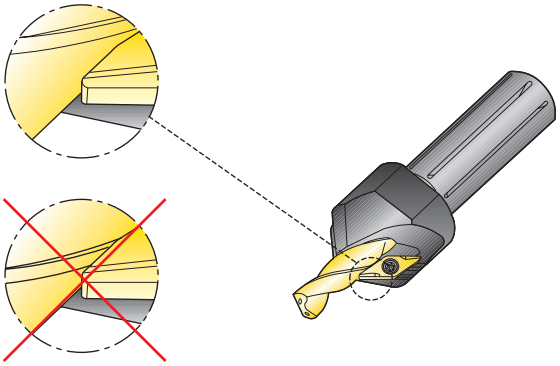


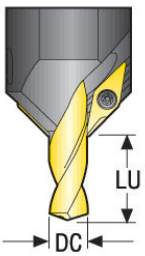
2.

3.

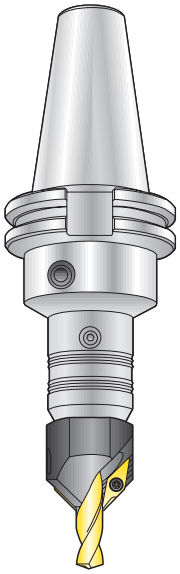


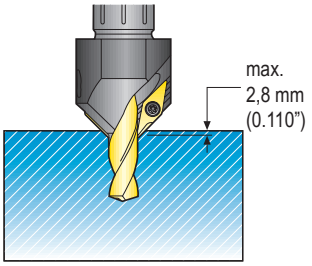
4.





Maximale Fastiefe





Bohrerdurchmesser DC		LU Bohrtiefe (min.-max.) SD1103 / SD203A		SD1105 / SD205A		SD207A	
mm	*Zoll*	mm	*Zoll*	mm	*Zoll*	mm	*Zoll*
4,00-4,75	*.157-.187*	4-17	*.157-.669*	10-27	*.394-1.063*	30-45	*1.181-1.772*
4,76-6,00	*.187-.236*	6-20	*.236-.787*	18-32	*.709-1.260*	30-45	*1.181-1.772*
6,01-8,00	*.241-.315*	15-27	*.590-1.063*	28-42	*1.102-1.653*	42-57	*1.653-2.244*
8,01-10,00	*.315-.394*	17-31	*.669-1.220*	34-48	*1.338-1.890*	47-62	*1.850-2.441*
10,01-12,00	*.394-.472*	21-36	*.826-1.417*	40-56	*1.575-2.205*	57-72	*2.244-2.835*
12,01-14,00	*.473-.551*	22-37	*.866-1.457*	43-59	*1.693-2.323*	68-83	*2.677-3.268*
14,01-16,00	*.552-.630*	23-39	*.906-1.535*	44-60	*1.732-2.362*	76-92	*2.992-3.622*

Nur mit zylindrischem Schaft (R1) verwenden.

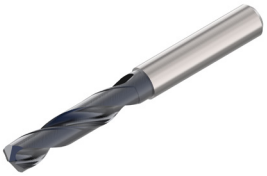
Seco Universal – Bohrer

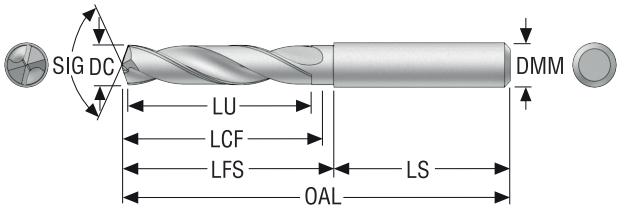
Seco Universal-Vollhartmetallbohrer sind eine kosteneffiziente und vielseitige Lösung für kleine bis mittelgroße Serien. Die Seco Universal-Bohrer eignen sich für die meisten Anwendungen in allen Branchen.

- Vielseitig einsetzbare Spitzengeometrie mit 4-Flächen-Anschliff und hervorragenden Zentriereigenschaften
- Hochverschleißfeste TiAlN-Beschichtung für lange Standzeit
- Kann in Kombination mit dem Gewindebohrer Threadmaster™ und für vorbereitende Bearbeitungen mit dem Nanojet/ Precimaster™ Plus eingesetzt werden

SD1103

Bohrtiefe ca. 3 x D – Metrisch/Zoll





– Zylinderschaft DIN 6537A
– DC-Toleranz m7
– Äußere Kühlmittelzufuhr
– Schnittdaten siehe Seite(n) 137
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-0300-014-06R1 *SD_DRILL_3.0MM_3XD*	02898974	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0310-014-06R1 *SD_DRILL_3.1MM_3XD*	02898975	3,1 *0.122*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0318-014-06R1 *SD_DRILL_1/8_3XD*	02898976	3,175 *0.125*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0320-014-06R1 *SD_DRILL_3.2MM_3XD*	02898977	3,2 *0.126*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0325-014-06R1 *SD_DRILL_3.25MM_3XD*	02898978	3,25 *0.128*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0330-014-06R1 *SD_DRILL_3.3MM_3XD*	02898979	3,3 *0.130*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0340-014-06R1 *SD_DRILL_3.4MM_3XD*	02898980	3,4 *0.134*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0350-014-06R1 *SD_DRILL_3.5MM_3XD*	02898981	3,5 *0.138*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0360-014-06R1 *SD_DRILL_3.6MM_3XD*	02898983	3,6 *0.142*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0365-014-06R1 *SD_DRILL_3.65MM_3XD*	02898984	3,65 *0.144*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0370-014-06R1 *SD_DRILL_3.7MM_3XD*	02898985	3,7 *0.146*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0380-017-06R1 *SD_DRILL_3.8MM_3XD*	02898986	3,8 *0.150*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0390-017-06R1 *SD_DRILL_3.9MM_3XD*	02898987	3,9 *0.154*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0397-017-06R1 *SD_DRILL_5/32_3XD*	02898988	3,969 *0.156*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0400-017-06R1 *SD_DRILL_4.0MM_3XD*	02898989	4,0 *0.157*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0410-017-06R1 *SD_DRILL_4.1MM_3XD*	02898990	4,1 *0.161*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0420-017-06R1 *SD_DRILL_4.2MM_3XD*	02898991	4,2 *0.165*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0430-017-06R1 *SD_DRILL_4.3MM_3XD*	02898992	4,3 *0.169*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0437-017-06R1 *SD_DRILL_11/64_3XD*	02898993	4,366 *0.172*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0440-017-06R1 *SD_DRILL_4.4MM_3XD*	02898994	4,4 *0.173*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0450-017-06R1 *SD_DRILL_4.5MM_3XD*	02898995	4,5 *0.177*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0460-017-06R1 *SD_DRILL_4.6MM_3XD*	02898996	4,6 *0.181*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0465-017-06R1 *SD_DRILL_4.65MM_3XD*	02898997	4,65 *0.183*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0470-017-06R1 *SD_DRILL_4.7MM_3XD*	02898998	4,7 *0.185*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0476-020-06R1 *SD_DRILL_3/16_3XD*	02898999	4,763 *0.188*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-0480-020-06R1 *SD_DRILL_4.8MM_3XD*	02899000	4,8 *0.189*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0490-020-06R1 *SD_DRILL_4.9MM_3XD*	02899001	4,9 *0.193*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0500-020-06R1 *SD_DRILL_5.0MM_3XD*	02899002	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0510-020-06R1 *SD_DRILL_5.1MM_3XD*	02899003	5,1 *0.201*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0516-020-06R1 *SD_DRILL_13/64_3XD*	02899004	5,159 *0.203*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0520-020-06R1 *SD_DRILL_5.2MM_3XD*	02899005	5,2 *0.205*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0530-020-06R1 *SD_DRILL_5.3MM_3XD*	02899006	5,3 *0.209*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0540-020-06R1 *SD_DRILL_5.4MM_3XD*	02899007	5,4 *0.213*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0550-020-06R1 *SD_DRILL_5.5MM_3XD*	02899008	5,5 *0.217*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0555-020-06R1 *SD_DRILL_5.55MM_3XD*	02899009	5,55 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0556-020-06R1 *SD_DRILL_7/32_3XD*	02899010	5,556 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0560-020-06R1 *SD_DRILL_5.6MM_3XD*	02899011	5,6 *0.220*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0570-020-06R1 *SD_DRILL_5.7MM_3XD*	02899012	5,7 *0.224*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0580-020-06R1 *SD_DRILL_5.8MM_3XD*	02899013	5,8 *0.228*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0590-020-06R1 *SD_DRILL_5.9MM_3XD*	02899014	5,9 *0.232*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0595-020-06R1 *SD_DRILL_15/64_3XD*	02899015	5,953 *0.234*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0600-020-06R1 *SD_DRILL_6.0MM_3XD*	02899016	6,0 *0.236*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103-0610-024-08R1 *SD_DRILL_6.1MM_3XD*	02899017	6,1 *0.240*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0620-024-08R1 *SD_DRILL_6.2MM_3XD*	02899018	6,2 *0.244*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0630-024-08R1 *SD_DRILL_6.3MM_3XD*	02899019	6,3 *0.248*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0635-024-08R1 *SD_DRILL_1/4_3XD*	02899020	6,35 *0.250*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0640-024-08R1 *SD_DRILL_6.4MM_3XD*	02899021	6,4 *0.252*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0650-024-08R1 *SD_DRILL_6.5MM_3XD*	02899022	6,5 *0.256*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0660-024-08R1 *SD_DRILL_6.6MM_3XD*	02899024	6,6 *0.260*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0675-024-08R1 *SD_DRILL_17/64_3XD*	02899025	6,747 *0.266*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0680-024-08R1 *SD_DRILL_6.8MM_3XD*	02899026	6,8 *0.268*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0690-024-08R1 *SD_DRILL_6.9MM_3XD*	02899027	6,9 *0.272*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0700-024-08R1 *SD_DRILL_7.0MM_3XD*	02899028	7,0 *0.276*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0710-029-08R1 *SD_DRILL_7.1MM_3XD*	02899029	7,1 *0.280*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0714-029-08R1 *SD_DRILL_9/32_3XD*	02899030	7,144 *0.281*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0720-029-08R1 *SD_DRILL_7.2MM_3XD*	02899031	7,2 *0.283*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0730-029-08R1 *SD_DRILL_7.3MM_3XD*	02899032	7,3 *0.287*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0740-029-08R1 *SD_DRILL_7.4MM_3XD*	02899033	7,4 *0.291*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0750-029-08R1 *SD_DRILL_7.5MM_3XD*	02899034	7,5 *0.295*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0754-029-08R1 *SD_DRILL_19/64_3XD*	02899035	7,541 *0.297*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9

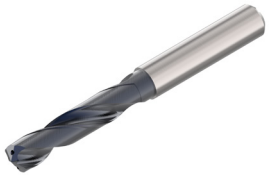
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-0760-029-08R1 *SD_DRILL_7.6MM_3XD*	02899037	7,6 *0.299*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0780-029-08R1 *SD_DRILL_7.8MM_3XD*	02899040	7,8 *0.307*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0790-029-08R1 *SD_DRILL_7.9MM_3XD*	02899041	7,9 *0.311*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0794-029-08R1 *SD_DRILL_5/16_3XD*	02899042	7,938 *0.313*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0800-029-08R1 *SD_DRILL_8.0MM_3XD*	02899043	8,0 *0.315*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103-0810-035-10R1 *SD_DRILL_8.1MM_3XD*	02899044	8,1 *0.319*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0820-035-10R1 *SD_DRILL_8.2MM_3XD*	02899045	8,2 *0.323*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0830-035-10R1 *SD_DRILL_8.3MM_3XD*	02899046	8,3 *0.327*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0833-035-10R1 *SD_DRILL_21/64_3XD*	02899047	8,334 *0.328*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0840-035-10R1 *SD_DRILL_8.4MM_3XD*	02899048	8,4 *0.331*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0850-035-10R1 *SD_DRILL_8.5MM_3XD*	02899049	8,5 *0.335*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0860-035-10R1 *SD_DRILL_8.6MM_3XD*	02899050	8,6 *0.339*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0870-035-10R1 *SD_DRILL_8.7MM_3XD*	02899051	8,7 *0.343*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0873-035-10R1 *SD_DRILL_11/32_3XD*	02899052	8,731 *0.344*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0880-035-10R1 *SD_DRILL_8.8MM_3XD*	02899053	8,8 *0.346*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0890-035-10R1 *SD_DRILL_8.9MM_3XD*	02899054	8,9 *0.350*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0900-035-10R1 *SD_DRILL_9.0MM_3XD*	02899055	9,0 *0.354*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0910-035-10R1 *SD_DRILL_9.1MM_3XD*	02899056	9,1 *0.358*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0913-035-10R1 *SD_DRILL_23/64_3XD*	02899058	9,128 *0.359*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0920-035-10R1 *SD_DRILL_9.2MM_3XD*	02899059	9,2 *0.362*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0930-035-10R1 *SD_DRILL_9.3MM_3XD*	02899060	9,3 *0.366*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0940-035-10R1 *SD_DRILL_9.4MM_3XD*	02899061	9,4 *0.370*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0950-035-10R1 *SD_DRILL_9.5MM_3XD*	02899062	9,5 *0.374*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0953-035-10R1 *SD_DRILL_3/8_3XD*	02899063	9,525 *0.375*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0960-035-10R1 *SD_DRILL_9.6MM_3XD*	02899065	9,6 *0.378*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0970-035-10R1 *SD_DRILL_9.7MM_3XD*	02899066	9,7 *0.382*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0980-035-10R1 *SD_DRILL_9.8MM_3XD*	02899067	9,8 *0.386*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0990-035-10R1 *SD_DRILL_9.9MM_3XD*	02899068	9,9 *0.390*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-0992-035-10R1 *SD_DRILL_25/64_3XD*	02899069	9,922 *0.391*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-1000-035-10R1 *SD_DRILL_10.0MM_3XD*	02899070	10,0 *0.394*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103-1020-040-12R1 *SD_DRILL_10.2MM_3XD*	02899071	10,2 *0.402*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1032-040-12R1 *SD_DRILL_13/32_3XD*	02899072	10,319 *0.406*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1040-040-12R1 *SD_DRILL_10.4MM_3XD*	02899073	10,4 *0.409*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1050-040-12R1 *SD_DRILL_10.5MM_3XD*	02899074	10,5 *0.413*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1060-040-12R1 *SD_DRILL_10.6MM_3XD*	02899075	10,6 *0.417*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9

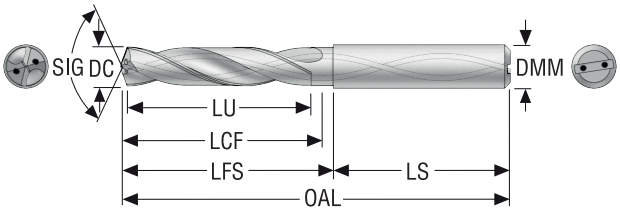
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-1072-040-12R1 *SD_DRILL_27/64_3XD*	02899076	10,716 *0.422*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1080-040-12R1 *SD_DRILL_10.8MM_3XD*	02899077	10,8 *0.425*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1090-040-12R1 *SD_DRILL_10.9MM_3XD*	02899078	10,9 *0.429*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1100-040-12R1 *SD_DRILL_11.0MM_3XD*	02899079	11,0 *0.433*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1110-040-12R1 *SD_DRILL_11.1MM_3XD*	02899080	11,1 *0.437*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1111-040-12R1 *SD_DRILL_7/16_3XD*	02899081	11,113 *0.438*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1120-040-12R1 *SD_DRILL_11.2MM_3XD*	02899082	11,2 *0.441*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1130-040-12R1 *SD_DRILL_11.3MM_3XD*	02899083	11,3 *0.445*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1140-040-12R1 *SD_DRILL_11.4MM_3XD*	02899084	11,4 *0.449*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1150-040-12R1 *SD_DRILL_11.5MM_3XD*	02899085	11,5 *0.453*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1160-040-12R1 *SD_DRILL_11.6MM_3XD*	02899088	11,6 *0.457*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1170-040-12R1 *SD_DRILL_11.7MM_3XD*	02899089	11,7 *0.461*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1180-040-12R1 *SD_DRILL_11.8MM_3XD*	02899090	11,8 *0.465*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1190-040-12R1 *SD_DRILL_11.9MM_3XD*	02899091	11,9 *0.469*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1200-040-12R1 *SD_DRILL_12.0MM_3XD*	02899093	12,0 *0.472*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1210-043-14R1 *SD_DRILL_12.1MM_3XD*	02899094	12,1 *0.476*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1220-043-14R1 *SD_DRILL_12.2MM_3XD*	02899095	12,2 *0.480*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1240-043-14R1 *SD_DRILL_12.4MM_3XD*	02899097	12,4 *0.488*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1250-043-14R1 *SD_DRILL_12.5MM_3XD*	02899098	12,5 *0.492*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1260-043-14R1 *SD_DRILL_12.6MM_3XD*	02899099	12,6 *0.496*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1270-043-14R1 *SD_DRILL_1/2_3XD*	02899100	12,7 *0.500*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1275-043-14R1 *SD_DRILL_12.75MM_3XD*	02899101	12,75 *0.502*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1280-043-14R1 *SD_DRILL_12.8MM_3XD*	02899102	12,8 *0.504*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1300-043-14R1 *SD_DRILL_13.0MM_3XD*	02899104	13,0 *0.512*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1310-043-14R1 *SD_DRILL_33/64_3XD*	02899105	13,1 *0.516*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1320-043-14R1 *SD_DRILL_13.2MM_3XD*	02899106	13,2 *0.520*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1330-043-14R1 *SD_DRILL_13.3MM_3XD*	02899107	13,3 *0.524*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1349-043-14R1 *SD_DRILL_17/32_3XD*	02899109	13,494 *0.531*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1350-043-14R1 *SD_DRILL_13.5MM_3XD*	02899110	13,5 *0.531*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1360-043-14R1 *SD_DRILL_13.6MM_3XD*	02899111	13,6 *0.535*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1380-043-14R1 *SD_DRILL_13.8MM_3XD*	02899113	13,8 *0.543*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1400-043-14R1 *SD_DRILL_14.0MM_3XD*	02899115	14,0 *0.551*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103-1420-045-16R1 *SD_DRILL_14.2MM_3XD*	02899116	14,2 *0.559*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1450-045-16R1 *SD_DRILL_14.5MM_3XD*	02899119	14,5 *0.571*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1470-045-16R1 *SD_DRILL_14.7MM_3XD*	02899120	14,7 *0.579*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-1475-045-16R1 *SD_DRILL_14.75MM_3XD*	02899121	14,75 *0.581*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1500-045-16R1 *SD_DRILL_15.0MM_3XD*	02899123	15,0 *0.591*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1510-045-16R1 *SD_DRILL_15.1MM_3XD*	02899124	15,1 *0.594*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1550-045-16R1 *SD_DRILL_15.5MM_3XD*	02899126	15,5 *0.610*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1580-045-16R1 *SD_DRILL_15.8MM_3XD*	02899128	15,8 *0.622*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1588-045-16R1 *SD_DRILL_5/8_3XD*	02899129	15,875 *0.625*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1600-045-16R1 *SD_DRILL_16.0MM_3XD*	02899130	16,0 *0.630*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103-1650-051-18R1 *SD_DRILL_16.5MM_3XD*	02899131	16,5 *0.650*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103-1700-051-18R1 *SD_DRILL_17.0MM_3XD*	02899132	17,0 *0.669*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103-1750-051-18R1 *SD_DRILL_17.5MM_3XD*	02899133	17,5 *0.689*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103-1800-051-18R1 *SD_DRILL_18.0MM_3XD*	02899134	18,0 *0.709*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103-1850-055-20R1 *SD_DRILL_18.5MM_3XD*	02899135	18,5 *0.728*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9
SD1103-1950-055-20R1 *SD_DRILL_19.5MM_3XD*	02899138	19,5 *0.768*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9
SD1103-2000-055-20R1 *SD_DRILL_20.0MM_3XD*	02899139	20,0 *0.787*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9

SD1103A

Bohrtiefe ca. 3 x D – Metrisch/Zoll





– Zylinderschaft DIN 6537A
– DC-Toleranz m7
– Kühlmittelzufuhr
– Schnittdaten siehe Seite(n) 138
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103A-0300-014-06R1 *SD_DRILL_3.0MM_3XD_A*	02898244	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0310-014-06R1 *SD_DRILL_3.1MM_3XD_A*	02898245	3,1 *0.122*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0318-014-06R1 *SD_DRILL_1/8_3XD_A*	02898246	3,175 *0.125*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0320-014-06R1 *SD_DRILL_3.2MM_3XD_A*	02898247	3,2 *0.126*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0330-014-06R1 *SD_DRILL_3.3MM_3XD_A*	02898249	3,3 *0.130*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0340-014-06R1 *SD_DRILL_3.4MM_3XD_A*	02898250	3,4 *0.134*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0350-014-06R1 *SD_DRILL_3.5MM_3XD_A*	02898251	3,5 *0.138*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0357-014-06R1 *SD_DRILL_9/64_3XD_A*	02898252	3,572 *0.141*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0360-014-06R1 *SD_DRILL_3.6MM_3XD_A*	02898253	3,6 *0.142*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0365-014-06R1 *SD_DRILL_3.65MM_3XD_A*	02898254	3,65 *0.144*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0370-014-06R1 *SD_DRILL_3.7MM_3XD_A*	02898255	3,7 *0.146*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0380-017-06R1 *SD_DRILL_3.8MM_3XD_A*	02898256	3,8 *0.150*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0390-017-06R1 *SD_DRILL_3.9MM_3XD_A*	02898257	3,9 *0.154*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0397-017-06R1 *SD_DRILL_5/32_3XD_A*	02898258	3,969 *0.156*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0400-017-06R1 *SD_DRILL_4.0MM_3XD_A*	02898259	4,0 *0.157*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0410-017-06R1 *SD_DRILL_4.1MM_3XD_A*	02898260	4,1 *0.161*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0420-017-06R1 *SD_DRILL_4.2MM_3XD_A*	02898261	4,2 *0.165*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0430-017-06R1 *SD_DRILL_4.3MM_3XD_A*	02898262	4,3 *0.169*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0437-017-06R1 *SD_DRILL_11/64_3XD_A*	02898263	4,366 *0.172*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0450-017-06R1 *SD_DRILL_4.5MM_3XD_A*	02898264	4,5 *0.177*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0460-017-06R1 *SD_DRILL_4.6MM_3XD_A*	02898265	4,6 *0.181*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0465-017-06R1 *SD_DRILL_4.65MM_3XD_A*	02898266	4,65 *0.183*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0470-017-06R1 *SD_DRILL_4.7MM_3XD_A*	02898267	4,7 *0.185*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0476-020-06R1 *SD_DRILL_3/16_3XD_A*	02898268	4,763 *0.188*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0480-020-06R1 *SD_DRILL_4.8MM_3XD_A*	02898269	4,8 *0.189*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103A-0490-020-06R1 *SD_DRILL_4.9MM_3XD_A*	02898270	4,9 *0.193*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0500-020-06R1 *SD_DRILL_5.0MM_3XD_A*	02898271	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0510-020-06R1 *SD_DRILL_5.1MM_3XD_A*	02898272	5,1 *0.201*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0516-020-06R1 *SD_DRILL_13/64_3XD_A*	02898273	5,159 *0.203*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0520-020-06R1 *SD_DRILL_5.2MM_3XD_A*	02898275	5,2 *0.205*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0530-020-06R1 *SD_DRILL_5.3MM_3XD_A*	02898276	5,3 *0.209*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0540-020-06R1 *SD_DRILL_5.4MM_3XD_A*	02898277	5,4 *0.213*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0550-020-06R1 *SD_DRILL_5.5MM_3XD_A*	02898278	5,5 *0.217*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0555-020-06R1 *SD_DRILL_5.55MM_3XD_A*	02898279	5,55 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0556-020-06R1 *SD_DRILL_7/32_3XD_A*	02898280	5,556 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0560-020-06R1 *SD_DRILL_5.6MM_3XD_A*	02898281	5,6 *0.220*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0570-020-06R1 *SD_DRILL_5.7MM_3XD_A*	02898282	5,7 *0.224*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0580-020-06R1 *SD_DRILL_5.8MM_3XD_A*	02898283	5,8 *0.228*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0590-020-06R1 *SD_DRILL_5.9MM_3XD_A*	02898284	5,9 *0.232*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0595-020-06R1 *SD_DRILL_15/64_3XD_A*	02898285	5,953 *0.234*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0600-020-06R1 *SD_DRILL_6.0MM_3XD_A*	02898286	6,0 *0.236*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1103A-0610-024-08R1 *SD_DRILL_6.1MM_3XD_A*	02898287	6,1 *0.240*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0620-024-08R1 *SD_DRILL_6.2MM_3XD_A*	02898288	6,2 *0.244*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0630-024-08R1 *SD_DRILL_6.3MM_3XD_A*	02898289	6,3 *0.248*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0635-024-08R1 *SD_DRILL_1/4_3XD_A*	02898290	6,35 *0.250*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0640-024-08R1 *SD_DRILL_6.4MM_3XD_A*	02898291	6,4 *0.252*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0650-024-08R1 *SD_DRILL_6.5MM_3XD_A*	02898292	6,5 *0.256*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0660-024-08R1 *SD_DRILL_6.6MM_3XD_A*	02898293	6,6 *0.260*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0670-024-08R1 *SD_DRILL_6.7MM_3XD_A*	02898294	6,7 *0.264*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0675-024-08R1 *SD_DRILL_17/64_3XD_A*	02898295	6,747 *0.266*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0680-024-08R1 *SD_DRILL_6.8MM_3XD_A*	02898296	6,8 *0.268*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0690-024-08R1 *SD_DRILL_6.9MM_3XD_A*	02898297	6,9 *0.272*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0700-024-08R1 *SD_DRILL_7.0MM_3XD_A*	02898298	7,0 *0.276*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0710-029-08R1 *SD_DRILL_7.1MM_3XD_A*	02898299	7,1 *0.280*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0714-029-08R1 *SD_DRILL_9/32_3XD_A*	02898300	7,144 *0.281*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0720-029-08R1 *SD_DRILL_7.2MM_3XD_A*	02898301	7,2 *0.283*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0730-029-08R1 *SD_DRILL_7.3MM_3XD_A*	02898302	7,3 *0.287*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0740-029-08R1 *SD_DRILL_7.4MM_3XD_A*	02898303	7,4 *0.291*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0750-029-08R1 *SD_DRILL_7.5MM_3XD_A*	02898304	7,5 *0.295*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0754-029-08R1 *SD_DRILL_19/64_3XD_A*	02898305	7,541 *0.297*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9

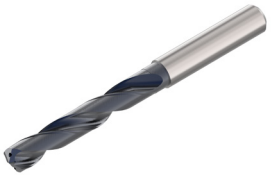
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103A-0760-029-08R1 *SD_DRILL_7.6MM_3XD_A*	02898307	7,6 *0.299*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0770-029-08R1 *SD_DRILL_7.7MM_3XD_A*	02898308	7,7 *0.303*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0780-029-08R1 *SD_DRILL_7.8MM_3XD_A*	02898309	7,8 *0.307*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0790-029-08R1 *SD_DRILL_7.9MM_3XD_A*	02898310	7,9 *0.311*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0794-029-08R1 *SD_DRILL_5/16_3XD_A*	02898311	7,938 *0.313*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0800-029-08R1 *SD_DRILL_8.0MM_3XD_A*	02898312	8,0 *0.315*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT9
SD1103A-0810-035-10R1 *SD_DRILL_8.1MM_3XD_A*	02898313	8,1 *0.319*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0820-035-10R1 *SD_DRILL_8.2MM_3XD_A*	02898314	8,2 *0.323*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0830-035-10R1 *SD_DRILL_8.3MM_3XD_A*	02898315	8,3 *0.327*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0833-035-10R1 *SD_DRILL_21/64_3XD_A*	02898316	8,334 *0.328*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0840-035-10R1 *SD_DRILL_8.4MM_3XD_A*	02898317	8,4 *0.331*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0850-035-10R1 *SD_DRILL_8.5MM_3XD_A*	02898318	8,5 *0.335*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0860-035-10R1 *SD_DRILL_8.6MM_3XD_A*	02898319	8,6 *0.339*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0870-035-10R1 *SD_DRILL_8.7MM_3XD_A*	02898320	8,7 *0.343*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0873-035-10R1 *SD_DRILL_11/32_3XD_A*	02898321	8,731 *0.344*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0880-035-10R1 *SD_DRILL_8.8MM_3XD_A*	02898322	8,8 *0.346*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0900-035-10R1 *SD_DRILL_9.0MM_3XD_A*	02898324	9,0 *0.354*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0910-035-10R1 *SD_DRILL_9.1MM_3XD_A*	02898325	9,1 *0.358*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0930-035-10R1 *SD_DRILL_9.3MM_3XD_A*	02898328	9,3 *0.366*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0940-035-10R1 *SD_DRILL_9.4MM_3XD_A*	02898329	9,4 *0.370*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0950-035-10R1 *SD_DRILL_9.5MM_3XD_A*	02898330	9,5 *0.374*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0953-035-10R1 *SD_DRILL_3/8_3XD_A*	02898331	9,525 *0.375*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0955-035-10R1 *SD_DRILL_9.55MM_3XD_A*	02898332	9,55 *0.376*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0960-035-10R1 *SD_DRILL_9.6MM_3XD_A*	02898333	9,6 *0.378*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0970-035-10R1 *SD_DRILL_9.7MM_3XD_A*	02898334	9,7 *0.382*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0980-035-10R1 *SD_DRILL_9.8MM_3XD_A*	02898335	9,8 *0.386*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-0990-035-10R1 *SD_DRILL_9.9MM_3XD_A*	02898336	9,9 *0.390*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-1000-035-10R1 *SD_DRILL_10.0MM_3XD_A*	02898338	10,0 *0.394*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT9
SD1103A-1020-040-12R1 *SD_DRILL_10.2MM_3XD_A*	02898339	10,2 *0.402*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1032-040-12R1 *SD_DRILL_13/32_3XD_A*	02898340	10,319 *0.406*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1040-040-12R1 *SD_DRILL_10.4MM_3XD_A*	02898341	10,4 *0.409*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1050-040-12R1 *SD_DRILL_10.5MM_3XD_A*	02898342	10,5 *0.413*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1060-040-12R1 *SD_DRILL_10.6MM_3XD_A*	02898343	10,6 *0.417*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1072-040-12R1 *SD_DRILL_27/64_3XD_A*	02898344	10,716 *0.422*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1080-040-12R1 *SD_DRILL_10.8MM_3XD_A*	02898345	10,8 *0.425*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9

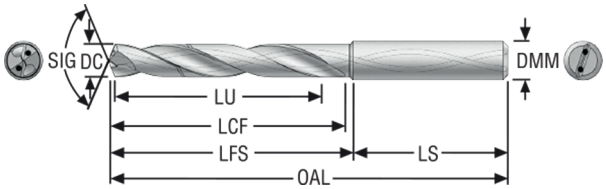
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103A-1090-040-12R1 *SD_DRILL_10.9MM_3XD_A*	02898346	10,9 *0.429*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1100-040-12R1 *SD_DRILL_11.0MM_3XD_A*	02898347	11,0 *0.433*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1110-040-12R1 *SD_DRILL_11.1MM_3XD_A*	02898348	11,1 *0.437*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1111-040-12R1 *SD_DRILL_7/16_3XD_A*	02898349	11,113 *0.438*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1120-040-12R1 *SD_DRILL_11.2MM_3XD_A*	02898350	11,2 *0.441*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1130-040-12R1 *SD_DRILL_11.3MM_3XD_A*	02898351	11,3 *0.445*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1140-040-12R1 *SD_DRILL_11.4MM_3XD_A*	02898352	11,4 *0.449*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1150-040-12R1 *SD_DRILL_11.5MM_3XD_A*	02898353	11,5 *0.453*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1151-040-12R1 *SD_DRILL_29/64_3XD_A*	02898354	11,509 *0.453*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1170-040-12R1 *SD_DRILL_11.7MM_3XD_A*	02898357	11,7 *0.461*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1180-040-12R1 *SD_DRILL_11.8MM_3XD_A*	02898358	11,8 *0.465*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1190-040-12R1 *SD_DRILL_11.9MM_3XD_A*	02898359	11,9 *0.469*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1200-040-12R1 *SD_DRILL_12.0MM_3XD_A*	02898361	12,0 *0.472*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1210-043-14R1 *SD_DRILL_12.1MM_3XD_A*	02898362	12,1 *0.476*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1220-043-14R1 *SD_DRILL_12.2MM_3XD_A*	02898363	12,2 *0.480*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1230-043-14R1 *SD_DRILL_31/64_3XD_A*	02898364	12,303 *0.484*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1250-043-14R1 *SD_DRILL_12.5MM_3XD_A*	02898366	12,5 *0.492*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1260-043-14R1 *SD_DRILL_12.6MM_3XD_A*	02898367	12,6 *0.496*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1270-043-14R1 *SD_DRILL_1/2_3XD_A*	02898368	12,7 *0.500*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1280-043-14R1 *SD_DRILL_12.8MM_3XD_A*	02898370	12,8 *0.504*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1290-043-14R1 *SD_DRILL_12.9MM_3XD_A*	02898371	12,9 *0.508*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1300-043-14R1 *SD_DRILL_13.0MM_3XD_A*	02898372	13,0 *0.512*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1310-043-14R1 *SD_DRILL_33/64_3XD_A*	02898373	13,1 *0.516*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1320-043-14R1 *SD_DRILL_13.2MM_3XD_A*	02898374	13,2 *0.520*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1330-043-14R1 *SD_DRILL_13.3MM_3XD_A*	02898375	13,3 *0.524*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1349-043-14R1 *SD_DRILL_17/32_3XD_A*	02898377	13,494 *0.531*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1350-043-14R1 *SD_DRILL_13.5MM_3XD_A*	02898378	13,5 *0.531*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1360-043-14R1 *SD_DRILL_13.6MM_3XD_A*	02898379	13,6 *0.535*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1370-043-14R1 *SD_DRILL_13.7MM_3XD_A*	02898380	13,7 *0.539*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1380-043-14R1 *SD_DRILL_13.8MM_3XD_A*	02898381	13,8 *0.543*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1390-043-14R1 *SD_DRILL_13.9MM_3XD_A*	02898382	13,9 *0.547*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1400-043-14R1 *SD_DRILL_14.0MM_3XD_A*	02898383	14,0 *0.551*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT9
SD1103A-1420-045-16R1 *SD_DRILL_14.2MM_3XD_A*	02898384	14,2 *0.559*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1429-045-16R1 *SD_DRILL_9/16_3XD_A*	02898385	14,288 *0.563*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1450-045-16R1 *SD_DRILL_14.5MM_3XD_A*	02898386	14,5 *0.571*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103A-1470-045-16R1 *SD_DRILL_14.7MM_3XD_A*	02898387	14,7 *0.579*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1475-045-16R1 *SD_DRILL_14.75MM_3XD_A*	02898388	14,75 *0.581*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1480-045-16R1 *SD_DRILL_14.8MM_3XD_A*	02898389	14,8 *0.583*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1500-045-16R1 *SD_DRILL_15.0MM_3XD_A*	02898390	15,0 *0.591*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1510-045-16R1 *SD_DRILL_15.1MM_3XD_A*	02898391	15,1 *0.594*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1530-045-16R1 *SD_DRILL_15.3MM_3XD_A*	02898392	15,3 *0.602*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1550-045-16R1 *SD_DRILL_15.5MM_3XD_A*	02898393	15,5 *0.610*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1570-045-16R1 *SD_DRILL_15.7MM_3XD_A*	02898394	15,7 *0.618*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1580-045-16R1 *SD_DRILL_15.8MM_3XD_A*	02898395	15,8 *0.622*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1588-045-16R1 *SD_DRILL_5/8_3XD_A*	02898396	15,875 *0.625*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1600-045-16R1 *SD_DRILL_16.0MM_3XD_A*	02898397	16,0 *0.630*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT9
SD1103A-1650-051-18R1 *SD_DRILL_16.5MM_3XD_A*	02898398	16,5 *0.650*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103A-1700-051-18R1 *SD_DRILL_17.0MM_3XD_A*	02898399	17,0 *0.669*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103A-1750-051-18R1 *SD_DRILL_17.5MM_3XD_A*	02898400	17,5 *0.689*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103A-1800-051-18R1 *SD_DRILL_18.0MM_3XD_A*	02898401	18,0 *0.709*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT9
SD1103A-1850-055-20R1 *SD_DRILL_18.5MM_3XD_A*	02898402	18,5 *0.728*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9
SD1103A-1900-055-20R1 *SD_DRILL_19.0MM_3XD_A*	02898403	19,0 *0.748*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9
SD1103A-1905-055-20R1 *SD_DRILL_3/4_3XD_A*	02898404	19,05 *0.750*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9
SD1103A-2000-055-20R1 *SD_DRILL_20.0MM_3XD_A*	02898406	20,0 *0.787*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT9

SD1105A

Bohrtiefe ca. 5 x D – Metrisch/Zoll





– Zylinderschaft DIN 6537A
– Kühlmittelzufuhr
– Schnittdaten siehe Seite(n) 139
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-0300-023-06R1 *SD_DRILL_3.0MM_5XD_A*	02897845	3,0 *0.118*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0310-023-06R1 *SD_DRILL_3.1MM_5XD_A*	02897846	3,1 *0.122*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0318-023-06R1 *SD_DRILL_1/8_5XD_A*	02897847	3,175 *0.125*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0320-023-06R1 *SD_DRILL_3.2MM_5XD_A*	02897848	3,2 *0.126*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0325-023-06R1 *SD_DRILL_3.25MM_5XD_A*	02897849	3,25 *0.128*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0330-023-06R1 *SD_DRILL_3.3MM_5XD_A*	02897850	3,3 *0.130*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0340-023-06R1 *SD_DRILL_3.4MM_5XD_A*	02897851	3,4 *0.134*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0350-023-06R1 *SD_DRILL_3.5MM_5XD_A*	02897852	3,5 *0.138*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0357-023-06R1 *SD_DRILL_9/64_5XD_A*	02897853	3,572 *0.141*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0360-023-06R1 *SD_DRILL_3.6MM_5XD_A*	02897854	3,6 *0.142*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0365-023-06R1 *SD_DRILL_3.65MM_5XD_A*	02897855	3,65 *0.144*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0370-023-06R1 *SD_DRILL_3.7MM_5XD_A*	02897856	3,7 *0.146*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0380-029-06R1 *SD_DRILL_3.8MM_5XD_A*	02897857	3,8 *0.150*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0390-029-06R1 *SD_DRILL_3.9MM_5XD_A*	02897858	3,9 *0.154*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0397-029-06R1 *SD_DRILL_5/32_5XD_A*	02897859	3,969 *0.156*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0400-029-06R1 *SD_DRILL_4.0MM_5XD_A*	02897860	4,0 *0.157*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0410-029-06R1 *SD_DRILL_4.1MM_5XD_A*	02897861	4,1 *0.161*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0420-029-06R1 *SD_DRILL_4.2MM_5XD_A*	02897862	4,2 *0.165*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0430-029-06R1 *SD_DRILL_4.3MM_5XD_A*	02897863	4,3 *0.169*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0437-029-06R1 *SD_DRILL_11/64_5XD_A*	02897864	4,366 *0.172*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0440-029-06R1 *SD_DRILL_4.4MM_5XD_A*	02897865	4,4 *0.173*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0450-029-06R1 *SD_DRILL_4.5MM_5XD_A*	02897866	4,5 *0.177*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0460-029-06R1 *SD_DRILL_4.6MM_5XD_A*	02897867	4,6 *0.181*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0465-029-06R1 *SD_DRILL_4.65MM_5XD_A*	02897868	4,65 *0.183*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0470-029-06R1 *SD_DRILL_4.7MM_5XD_A*	02897869	4,7 *0.185*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-0476-035-06R1 *SD_DRILL_3/16_5XD_A*	02897870	4,763 *0.188*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0480-035-06R1 *SD_DRILL_4.8MM_5XD_A*	02897871	4,8 *0.189*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0490-035-06R1 *SD_DRILL_4.9MM_5XD_A*	02897872	4,9 *0.193*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0500-035-06R1 *SD_DRILL_5.0MM_5XD_A*	02897873	5,0 *0.197*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0510-035-06R1 *SD_DRILL_5.1MM_5XD_A*	02897874	5,1 *0.201*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0516-035-06R1 *SD_DRILL_13/64_5XD_A*	02897875	5,159 *0.203*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0520-035-06R1 *SD_DRILL_5.2MM_5XD_A*	02897876	5,2 *0.205*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0530-035-06R1 *SD_DRILL_5.3MM_5XD_A*	02897877	5,3 *0.209*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0540-035-06R1 *SD_DRILL_5.4MM_5XD_A*	02897878	5,4 *0.213*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0550-035-06R1 *SD_DRILL_5.5MM_5XD_A*	02897879	5,5 *0.217*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0555-035-06R1 *SD_DRILL_5.55MM_5XD_A*	02897880	5,55 *0.219*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0556-035-06R1 *SD_DRILL_7/32_5XD_A*	02897881	5,556 *0.219*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0560-035-06R1 *SD_DRILL_5.6MM_5XD_A*	02897882	5,6 *0.220*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0570-035-06R1 *SD_DRILL_5.7MM_5XD_A*	02897883	5,7 *0.224*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0580-035-06R1 *SD_DRILL_5.8MM_5XD_A*	02897884	5,8 *0.228*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0590-035-06R1 *SD_DRILL_5.9MM_5XD_A*	02897885	5,9 *0.232*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0595-035-06R1 *SD_DRILL_15/64_5XD_A*	02897886	5,953 *0.234*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0600-035-06R1 *SD_DRILL_6.0MM_5XD_A*	02897887	6,0 *0.236*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT9
SD1105A-0610-043-08R1 *SD_DRILL_6.1MM_5XD_A*	02897888	6,1 *0.240*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0620-043-08R1 *SD_DRILL_6.2MM_5XD_A*	02897889	6,2 *0.244*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0630-043-08R1 *SD_DRILL_6.3MM_5XD_A*	02897890	6,3 *0.248*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0635-043-08R1 *SD_DRILL_1/4_5XD_A*	02897891	6,35 *0.250*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0640-043-08R1 *SD_DRILL_6.4MM_5XD_A*	02897892	6,4 *0.252*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0650-043-08R1 *SD_DRILL_6.5MM_5XD_A*	02897893	6,5 *0.256*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0660-043-08R1 *SD_DRILL_6.6MM_5XD_A*	02897894	6,6 *0.260*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0670-043-08R1 *SD_DRILL_6.7MM_5XD_A*	02897895	6,7 *0.264*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0675-043-08R1 *SD_DRILL_17/64_5XD_A*	02897896	6,747 *0.266*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0680-043-08R1 *SD_DRILL_6.8MM_5XD_A*	02897897	6,8 *0.268*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0690-043-08R1 *SD_DRILL_6.9MM_5XD_A*	02897898	6,9 *0.272*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0700-043-08R1 *SD_DRILL_7.0MM_5XD_A*	02897899	7,0 *0.276*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0710-043-08R1 *SD_DRILL_7.1MM_5XD_A*	02897900	7,1 *0.280*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0714-043-08R1 *SD_DRILL_9/32_5XD_A*	02897901	7,144 *0.281*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0720-043-08R1 *SD_DRILL_7.2MM_5XD_A*	02897902	7,2 *0.283*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0730-043-08R1 *SD_DRILL_7.3MM_5XD_A*	02897903	7,3 *0.287*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0740-043-08R1 *SD_DRILL_7.4MM_5XD_A*	02897904	7,4 *0.291*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-0750-043-08R1 *SD_DRILL_7.5MM_5XD_A*	02897905	7,5 *0.295*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0754-043-08R1 *SD_DRILL_19/64_5XD_A*	02897906	7,541 *0.297*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0760-043-08R1 *SD_DRILL_7.6MM_5XD_A*	02897908	7,6 *0.299*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0770-043-08R1 *SD_DRILL_7.7MM_5XD_A*	02897909	7,7 *0.303*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0780-043-08R1 *SD_DRILL_7.8MM_5XD_A*	02897910	7,8 *0.307*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0790-043-08R1 *SD_DRILL_7.9MM_5XD_A*	02897911	7,9 *0.311*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0794-043-08R1 *SD_DRILL_5/16_5XD_A*	02897912	7,938 *0.313*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0800-043-08R1 *SD_DRILL_8.0MM_5XD_A*	02897913	8,0 *0.315*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT9
SD1105A-0810-049-10R1 *SD_DRILL_8.1MM_5XD_A*	02897914	8,1 *0.319*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0820-049-10R1 *SD_DRILL_8.2MM_5XD_A*	02897915	8,2 *0.323*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0830-049-10R1 *SD_DRILL_8.3MM_5XD_A*	02897916	8,3 *0.327*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0833-049-10R1 *SD_DRILL_21/64_5XD_A*	02897917	8,334 *0.328*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0840-049-10R1 *SD_DRILL_8.4MM_5XD_A*	02897918	8,4 *0.331*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0850-049-10R1 *SD_DRILL_8.5MM_5XD_A*	02897919	8,5 *0.335*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0860-049-10R1 *SD_DRILL_8.6MM_5XD_A*	02897920	8,6 *0.339*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0870-049-10R1 *SD_DRILL_8.7MM_5XD_A*	02897921	8,7 *0.343*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0873-049-10R1 *SD_DRILL_11/32_5XD_A*	02897922	8,731 *0.344*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0880-049-10R1 *SD_DRILL_8.8MM_5XD_A*	02897923	8,8 *0.346*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0890-049-10R1 *SD_DRILL_8.9MM_5XD_A*	02897924	8,9 *0.350*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0900-049-10R1 *SD_DRILL_9.0MM_5XD_A*	02897925	9,0 *0.354*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0910-049-10R1 *SD_DRILL_9.1MM_5XD_A*	02897926	9,1 *0.358*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0913-049-10R1 *SD_DRILL_23/64_5XD_A*	02897927	9,128 *0.359*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0920-049-10R1 *SD_DRILL_9.2MM_5XD_A*	02897928	9,2 *0.362*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0930-049-10R1 *SD_DRILL_9.3MM_5XD_A*	02897929	9,3 *0.366*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0940-049-10R1 *SD_DRILL_9.4MM_5XD_A*	02897930	9,4 *0.370*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0950-049-10R1 *SD_DRILL_9.5MM_5XD_A*	02897931	9,5 *0.374*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0953-049-10R1 *SD_DRILL_3/8_5XD_A*	02897932	9,525 *0.375*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0955-049-10R1 *SD_DRILL_9.55MM_5XD_A*	02897933	9,55 *0.376*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0960-049-10R1 *SD_DRILL_9.6MM_5XD_A*	02897934	9,6 *0.378*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0970-049-10R1 *SD_DRILL_9.7MM_5XD_A*	02897935	9,7 *0.382*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0980-049-10R1 *SD_DRILL_9.8MM_5XD_A*	02897936	9,8 *0.386*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0990-049-10R1 *SD_DRILL_9.9MM_5XD_A*	02897937	9,9 *0.390*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-0992-049-10R1 *SD_DRILL_25/64_5XD_A*	02897938	9,922 *0.391*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-1000-049-10R1 *SD_DRILL_10.0MM_5XD_A*	02897939	10,0 *0.394*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT9
SD1105A-1010-056-12R1 *SD_DRILL_10.1MM_5XD_A*	02897940	10,1 *0.398*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9

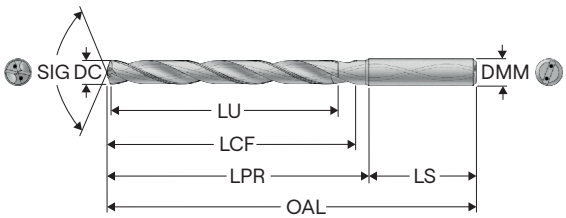
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-1020-056-12R1 *SD_DRILL_10.2MM_5XD_A*	02897941	10,2 *0.402*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1030-056-12R1 *SD_DRILL_10.3MM_5XD_A*	02897942	10,3 *0.406*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1032-056-12R1 *SD_DRILL_13/32_5XD_A*	02897943	10,319 *0.406*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1040-056-12R1 *SD_DRILL_10.4MM_5XD_A*	02897944	10,4 *0.409*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1050-056-12R1 *SD_DRILL_10.5MM_5XD_A*	02897945	10,5 *0.413*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1060-056-12R1 *SD_DRILL_10.6MM_5XD_A*	02897946	10,6 *0.417*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1070-056-12R1 *SD_DRILL_10.7MM_5XD_A*	02897947	10,7 *0.421*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1072-056-12R1 *SD_DRILL_27/64_5XD_A*	02897948	10,716 *0.422*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1080-056-12R1 *SD_DRILL_10.8MM_5XD_A*	02897949	10,8 *0.425*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1090-056-12R1 *SD_DRILL_10.9MM_5XD_A*	02897951	10,9 *0.429*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1100-056-12R1 *SD_DRILL_11.0MM_5XD_A*	02897952	11,0 *0.433*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1110-056-12R1 *SD_DRILL_11.1MM_5XD_A*	02897953	11,1 *0.437*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1111-056-12R1 *SD_DRILL_7/16_5XD_A*	02897954	11,113 *0.438*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1120-056-12R1 *SD_DRILL_11.2MM_5XD_A*	02897955	11,2 *0.441*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1130-056-12R1 *SD_DRILL_11.3MM_5XD_A*	02897956	11,3 *0.445*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1140-056-12R1 *SD_DRILL_11.4MM_5XD_A*	02897957	11,4 *0.449*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1150-056-12R1 *SD_DRILL_11.5MM_5XD_A*	02897958	11,5 *0.453*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1155-056-12R1 *SD_DRILL_11.55MM_5XD_A*	02897960	11,55 *0.455*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1160-056-12R1 *SD_DRILL_11.6MM_5XD_A*	02897961	11,6 *0.457*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1170-056-12R1 *SD_DRILL_11.7MM_5XD_A*	02897962	11,7 *0.461*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1180-056-12R1 *SD_DRILL_11.8MM_5XD_A*	02897963	11,8 *0.465*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1190-056-12R1 *SD_DRILL_11.9MM_5XD_A*	02897964	11,9 *0.469*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1191-056-12R1 *SD_DRILL_15/32_5XD_A*	02897965	11,906 *0.469*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1200-056-12R1 *SD_DRILL_12.0MM_5XD_A*	02897966	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT9
SD1105A-1210-060-14R1 *SD_DRILL_12.1MM_5XD_A*	02897967	12,1 *0.476*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1220-060-14R1 *SD_DRILL_12.2MM_5XD_A*	02897968	12,2 *0.480*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1225-060-14R1 *SD_DRILL_12.25MM_5XD_A*	02897969	12,25 *0.482*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1230-060-14R1 *SD_DRILL_31/64_5XD_A*	02897970	12,303 *0.484*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1240-060-14R1 *SD_DRILL_12.4MM_5XD_A*	02897972	12,4 *0.488*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1250-060-14R1 *SD_DRILL_12.5MM_5XD_A*	02897973	12,5 *0.492*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1260-060-14R1 *SD_DRILL_12.6MM_5XD_A*	02897974	12,6 *0.496*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1270-060-14R1 *SD_DRILL_1/2_5XD_A*	02897950	12,7 *0.500*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1275-060-14R1 *SD_DRILL_12.75MM_5XD_A*	02897976	12,75 *0.502*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1280-060-14R1 *SD_DRILL_12.8MM_5XD_A*	02897977	12,8 *0.504*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1290-060-14R1 *SD_DRILL_12.9MM_5XD_A*	02897978	12,9 *0.508*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-1300-060-14R1 *SD_DRILL_13.0MM_5XD_A*	02897979	13,0 *0.512*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1310-060-14R1 *SD_DRILL_33/64_5XD_A*	02897980	13,1 *0.516*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1320-060-14R1 *SD_DRILL_13.2MM_5XD_A*	02897981	13,2 *0.520*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1349-060-14R1 *SD_DRILL_17/32_5XD_A*	02897984	13,494 *0.531*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1350-060-14R1 *SD_DRILL_13.5MM_5XD_A*	02897985	13,5 *0.531*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1360-060-14R1 *SD_DRILL_13.6MM_5XD_A*	02897986	13,6 *0.535*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1370-060-14R1 *SD_DRILL_13.7MM_5XD_A*	02897987	13,7 *0.539*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1380-060-14R1 *SD_DRILL_13.8MM_5XD_A*	02897988	13,8 *0.543*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1390-060-14R1 *SD_DRILL_35/64_5XD_A*	02897989	13,9 *0.547*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1400-060-14R1 *SD_DRILL_14.0MM_5XD_A*	02897990	14,0 *0.551*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT9
SD1105A-1410-063-16R1 *SD_DRILL_14.1MM_5XD_A*	02897991	14,1 *0.555*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1420-063-16R1 *SD_DRILL_14.2MM_5XD_A*	02897992	14,2 *0.559*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1429-063-16R1 *SD_DRILL_9/16_5XD_A*	02897993	14,288 *0.563*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1430-063-16R1 *SD_DRILL_14.3MM_5XD_A*	02897994	14,3 *0.563*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1450-063-16R1 *SD_DRILL_14.5MM_5XD_A*	02897996	14,5 *0.571*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1470-063-16R1 *SD_DRILL_14.7MM_5XD_A*	02897998	14,7 *0.579*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1480-063-16R1 *SD_DRILL_14.8MM_5XD_A*	02898000	14,8 *0.583*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1490-063-16R1 *SD_DRILL_14.9MM_5XD_A*	02898001	14,9 *0.587*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1500-063-16R1 *SD_DRILL_15.0MM_5XD_A*	02898002	15,0 *0.591*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1510-063-16R1 *SD_DRILL_15.1MM_5XD_A*	02898003	15,1 *0.594*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1520-063-16R1 *SD_DRILL_15.2MM_5XD_A*	02898004	15,2 *0.598*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1530-063-16R1 *SD_DRILL_15.3MM_5XD_A*	02898005	15,3 *0.602*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1550-063-16R1 *SD_DRILL_15.5MM_5XD_A*	02898007	15,5 *0.610*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1560-063-16R1 *SD_DRILL_15.6MM_5XD_A*	02898008	15,6 *0.614*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1570-063-16R1 *SD_DRILL_15.7MM_5XD_A*	02898009	15,7 *0.618*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1580-063-16R1 *SD_DRILL_15.8MM_5XD_A*	02898010	15,8 *0.622*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1588-063-16R1 *SD_DRILL_5/8_5XD_A*	02898011	15,875 *0.625*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1590-063-16R1 *SD_DRILL_15.9MM_5XD_A*	02898012	15,9 *0.626*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1600-063-16R1 *SD_DRILL_16.0MM_5XD_A*	02898013	16,0 *0.630*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT9
SD1105A-1610-071-18R1 *SD_DRILL_16.1MM_5XD_A*	02898014	16,1 *0.634*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1620-071-18R1 *SD_DRILL_16.2MM_5XD_A*	02898015	16,2 *0.638*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1650-071-18R1 *SD_DRILL_16.5MM_5XD_A*	02898018	16,5 *0.650*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1670-071-18R1 *SD_DRILL_16.7MM_5XD_A*	02898020	16,7 *0.657*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1675-071-18R1 *SD_DRILL_16.75MM_5XD_A*	02898021	16,75 *0.659*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1680-071-18R1 *SD_DRILL_16.8MM_5XD_A*	02898022	16,8 *0.661*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-1700-071-18R1 *SD_DRILL_17.0MM_5XD_A*	02898024	17,0 *0.669*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1710-071-18R1 *SD_DRILL_17.1MM_5XD_A*	02898025	17,1 *0.673*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1720-071-18R1 *SD_DRILL_17.2MM_5XD_A*	02898026	17,2 *0.677*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1730-071-18R1 *SD_DRILL_17.3MM_5XD_A*	02898027	17,3 *0.681*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1750-071-18R1 *SD_DRILL_17.5MM_5XD_A*	02898029	17,5 *0.689*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1770-071-18R1 *SD_DRILL_17.7MM_5XD_A*	02898031	17,7 *0.697*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1800-071-18R1 *SD_DRILL_18.0MM_5XD_A*	02898034	18,0 *0.709*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT9
SD1105A-1830-077-20R1 *SD_DRILL_18.3MM_5XD_A*	02898037	18,3 *0.720*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1850-077-20R1 *SD_DRILL_18.5MM_5XD_A*	02898039	18,5 *0.728*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1860-077-20R1 *SD_DRILL_18.6MM_5XD_A*	02898040	18,6 *0.732*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1870-077-20R1 *SD_DRILL_18.7MM_5XD_A*	02898041	18,7 *0.736*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1880-077-20R1 *SD_DRILL_18.8MM_5XD_A*	02898042	18,8 *0.740*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1900-077-20R1 *SD_DRILL_19.0MM_5XD_A*	02898044	19,0 *0.748*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1910-077-20R1 *SD_DRILL_19.1MM_5XD_A*	02898046	19,1 *0.752*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1930-077-20R1 *SD_DRILL_19.3MM_5XD_A*	02898048	19,3 *0.760*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1950-077-20R1 *SD_DRILL_19.5MM_5XD_A*	02898050	19,5 *0.768*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1970-077-20R1 *SD_DRILL_19.7MM_5XD_A*	02898052	19,7 *0.776*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-1980-077-20R1 *SD_DRILL_19.8MM_5XD_A*	02898053	19,8 *0.780*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9
SD1105A-2000-077-20R1 *SD_DRILL_20.0MM_5XD_A*	02898055	20,0 *0.787*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT9

SD1108A

Bohrtiefe ca. 8 x D – Metrisch/Zoll



– Zylinderschaft DIN 6537A
– DC-Toleranz m7
– Kühlmittelzufuhr
– Schnittdaten siehe Seite(n) 140
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1108A-0300-028-06R1 *SD_DRILL_3.0MM_8XD_A*	03295178	3,0 *0.118*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0310-028-06R1 *SD_DRILL_3.1MM_8XD_A*	03295179	3,1 *0.122*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0318-028-06R1 *SD_DRILL_1/8_8XD_A*	03323680	3,175 *0.125*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0320-028-06R1 *SD_DRILL_3.2MM_8XD_A*	03295180	3,2 *0.126*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0330-028-06R1 *SD_DRILL_3.3MM_8XD_A*	03295181	3,3 *0.130*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0340-028-06R1 *SD_DRILL_3.4MM_8XD_A*	03295182	3,4 *0.134*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0350-028-06R1 *SD_DRILL_3.5MM_8XD_A*	03295183	3,5 *0.138*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0357-028-06R1 *SD_DRILL_9/64_8XD_A*	03323681	3,572 *0.141*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0360-028-06R1 *SD_DRILL_3.6MM_8XD_A*	03295184	3,6 *0.142*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0370-028-06R1 *SD_DRILL_3.7MM_8XD_A*	03295185	3,7 *0.146*	28,0 *1.102*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0380-037-06R1 *SD_DRILL_3.8MM_8XD_A*	03295186	3,8 *0.150*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0390-037-06R1 *SD_DRILL_3.9MM_8XD_A*	03295187	3,9 *0.154*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0397-037-06R1 *SD_DRILL_5/32_8XD_A*	03323682	3,969 *0.156*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0400-037-06R1 *SD_DRILL_4.0MM_8XD_A*	03295188	4,0 *0.157*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0410-037-06R1 *SD_DRILL_4.1MM_8XD_A*	03295189	4,1 *0.161*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0420-037-06R1 *SD_DRILL_4.2MM_8XD_A*	03295190	4,2 *0.165*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0430-037-06R1 *SD_DRILL_4.3MM_8XD_A*	03295191	4,3 *0.169*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0437-037-06R1 *SD_DRILL_11/64_8XD_A*	03323683	4,366 *0.172*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0440-037-06R1 *SD_DRILL_4.4MM_8XD_A*	03295192	4,4 *0.173*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0450-037-06R1 *SD_DRILL_4.5MM_8XD_A*	03295193	4,5 *0.177*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0460-037-06R1 *SD_DRILL_4.6MM_8XD_A*	03295194	4,6 *0.181*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0470-037-06R1 *SD_DRILL_4.7MM_8XD_A*	03295195	4,7 *0.185*	37,0 *1.457*	85,0 *3.346*	49,0 *1.929*	36,0 *1.417*	45,0 *1.772*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0476-048-06R1 *SD_DRILL_3/16_8XD_A*	03323684	4,763 *0.188*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0480-048-06R1 *SD_DRILL_4.8MM_8XD_A*	03295197	4,8 *0.189*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0490-048-06R1 *SD_DRILL_4.9MM_8XD_A*	03295198	4,9 *0.193*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9

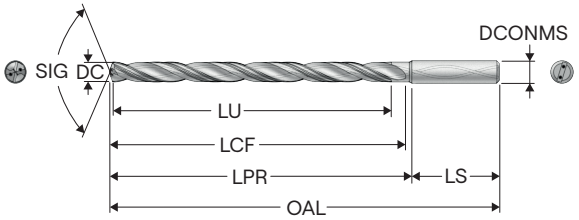
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1108A-0500-048-06R1 *SD_DRILL_5.0MM_8XD_A*	03295199	5,0 *0.197*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0510-048-06R1 *SD_DRILL_5.1MM_8XD_A*	03295200	5,1 *0.201*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0516-048-06R1 *SD_DRILL_13/64_8XD_A*	03323685	5,159 *0.203*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0520-048-06R1 *SD_DRILL_5.2MM_8XD_A*	03295201	5,2 *0.205*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0530-048-06R1 *SD_DRILL_5.3MM_8XD_A*	03295202	5,3 *0.209*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0540-048-06R1 *SD_DRILL_5.4MM_8XD_A*	03295203	5,4 *0.213*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0550-048-06R1 *SD_DRILL_5.5MM_8XD_A*	03295204	5,5 *0.217*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0556-048-06R1 *SD_DRILL_7/32_8XD_A*	03295206	5,556 *0.219*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0560-048-06R1 *SD_DRILL_5.6MM_8XD_A*	03295207	5,6 *0.220*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0570-048-06R1 *SD_DRILL_5.7MM_8XD_A*	03295208	5,7 *0.224*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0580-048-06R1 *SD_DRILL_5.8MM_8XD_A*	03295012	5,8 *0.228*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0590-048-06R1 *SD_DRILL_5.9MM_8XD_A*	03295013	5,9 *0.232*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0595-048-06R1 *SD_DRILL_15/64_8XD_A*	03323686	5,953 *0.234*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0600-048-06R1 *SD_DRILL_6.0MM_8XD_A*	03295014	6,0 *0.236*	48,0 *1.890*	97,0 *3.819*	61,0 *2.402*	36,0 *1.417*	57,0 *2.244*	6,0 *0.236*	140°	TiAlN	IT9
SD1108A-0610-055-08R1 *SD_DRILL_6.1MM_8XD_A*	03295015	6,1 *0.240*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0620-055-08R1 *SD_DRILL_6.2MM_8XD_A*	03295016	6,2 *0.244*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0630-055-08R1 *SD_DRILL_6.3MM_8XD_A*	03295017	6,3 *0.248*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0635-055-08R1 *SD_DRILL_1/4_8XD_A*	03295018	6,35 *0.250*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0640-055-08R1 *SD_DRILL_6.4MM_8XD_A*	03295019	6,4 *0.252*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0650-055-08R1 *SD_DRILL_6.5MM_8XD_A*	03295020	6,5 *0.256*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0660-055-08R1 *SD_DRILL_6.6MM_8XD_A*	03295021	6,6 *0.260*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0670-055-08R1 *SD_DRILL_6.7MM_8XD_A*	03295022	6,7 *0.264*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0675-055-08R1 *SD_DRILL_17/64_8XD_A*	03323687	6,747 *0.266*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0680-055-08R1 *SD_DRILL_6.8MM_8XD_A*	03295023	6,8 *0.268*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0690-055-08R1 *SD_DRILL_6.9MM_8XD_A*	03295024	6,9 *0.272*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0700-055-08R1 *SD_DRILL_7.0MM_8XD_A*	03295025	7,0 *0.276*	55,0 *2.165*	106,0 *4.173*	70,0 *2.756*	36,0 *1.417*	66,0 *2.598*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0710-064-08R1 *SD_DRILL_7.1MM_8XD_A*	03295026	7,1 *0.280*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0714-064-08R1 *SD_DRILL_9/32_8XD_A*	03323688	7,144 *0.281*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0730-064-08R1 *SD_DRILL_7.3MM_8XD_A*	03323689	7,3 *0.287*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0740-064-08R1 *SD_DRILL_7.4MM_8XD_A*	03295027	7,4 *0.291*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0750-064-08R1 *SD_DRILL_7.5MM_8XD_A*	03295028	7,5 *0.295*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0754-064-08R1 *SD_DRILL_19/64_8XD_A*	03323690	7,541 *0.297*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0760-064-08R1 *SD_DRILL_7.6MM_8XD_A*	03323691	7,6 *0.299*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0770-064-08R1 *SD_DRILL_7.7MM_8XD_A*	03295029	7,7 *0.303*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0780-064-08R1 *SD_DRILL_7.8MM_8XD_A*	03295030	7,8 *0.307*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1108A-0790-064-08R1 *SD_DRILL_7.9MM_8XD_A*	03295031	7,9 *0.311*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0794-064-08R1 *SD_DRILL_5/16_8XD_A*	03323692	7,938 *0.313*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0800-064-08R1 *SD_DRILL_8.0MM_8XD_A*	03295032	8,0 *0.315*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*	140°	TiAlN	IT9
SD1108A-0810-080-10R1 *SD_DRILL_8.1MM_8XD_A*	03295033	8,1 *0.319*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0820-080-10R1 *SD_DRILL_8.2MM_8XD_A*	03295034	8,2 *0.323*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0830-080-10R1 *SD_DRILL_8.3MM_8XD_A*	03295035	8,3 *0.327*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0840-080-10R1 *SD_DRILL_8.4MM_8XD_A*	03295036	8,4 *0.331*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0850-080-10R1 *SD_DRILL_8.5MM_8XD_A*	03295037	8,5 *0.335*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0860-080-10R1 *SD_DRILL_8.6MM_8XD_A*	03295038	8,6 *0.339*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0870-080-10R1 *SD_DRILL_8.7MM_8XD_A*	03295039	8,7 *0.343*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0873-080-10R1 *SD_DRILL_11/32_8XD_A*	03323694	8,731 *0.344*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0880-080-10R1 *SD_DRILL_8.8MM_8XD_A*	03295040	8,8 *0.346*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0900-080-10R1 *SD_DRILL_9.0MM_8XD_A*	03295041	9,0 *0.354*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0910-080-10R1 *SD_DRILL_9.1MM_8XD_A*	03295042	9,1 *0.358*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0913-080-10R1 *SD_DRILL_23/64_8XD_A*	03323695	9,128 *0.359*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0930-080-10R1 *SD_DRILL_9.3MM_8XD_A*	03295043	9,3 *0.366*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0940-080-10R1 *SD_DRILL_9.4MM_8XD_A*	03295044	9,4 *0.370*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0950-080-10R1 *SD_DRILL_9.5MM_8XD_A*	03295045	9,5 *0.374*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0953-080-10R1 *SD_DRILL_3/8_8XD_A*	03323696	9,525 *0.375*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0970-080-10R1 *SD_DRILL_9.7MM_8XD_A*	03295046	9,7 *0.382*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0980-080-10R1 *SD_DRILL_9.8MM_8XD_A*	03295047	9,8 *0.386*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0990-080-10R1 *SD_DRILL_9.9MM_8XD_A*	03295048	9,9 *0.390*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-0992-080-10R1 *SD_DRILL_25/64_8XD_A*	03323697	9,922 *0.391*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-1000-080-10R1 *SD_DRILL_10.0MM_8XD_A*	03295049	10,0 *0.394*	80,0 *3.150*	139,0 *5.472*	99,0 *3.898*	40,0 *1.575*	95,0 *3.740*	10,0 *0.394*	140°	TiAlN	IT9
SD1108A-1020-096-12R1 *SD_DRILL_10.2MM_8XD_A*	03295050	10,2 *0.402*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1030-096-12R1 *SD_DRILL_10.3MM_8XD_A*	03295051	10,3 *0.406*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1032-096-12R1 *SD_DRILL_13/32_8XD_A*	03323698	10,319 *0.406*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1040-096-12R1 *SD_DRILL_10.4MM_8XD_A*	03295053	10,4 *0.409*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1050-096-12R1 *SD_DRILL_10.5MM_8XD_A*	03295054	10,5 *0.413*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1070-096-12R1 *SD_DRILL_10.7MM_8XD_A*	03295055	10,7 *0.421*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1072-096-12R1 *SD_DRILL_27/64_8XD_A*	03323699	10,716 *0.422*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1080-096-12R1 *SD_DRILL_10.8MM_8XD_A*	03295056	10,8 *0.425*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1100-096-12R1 *SD_DRILL_11.0MM_8XD_A*	03295057	11,0 *0.433*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1111-096-12R1 *SD_DRILL_7/16_8XD_A*	03323700	11,113 *0.438*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1120-096-12R1 *SD_DRILL_11.2MM_8XD_A*	03295058	11,2 *0.441*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1108A-1130-096-12R1 *SD_DRILL_11.3MM_8XD_A*	03295059	11,3 *0.445*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1150-096-12R1 *SD_DRILL_11.5MM_8XD_A*	03295060	11,5 *0.453*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1170-096-12R1 *SD_DRILL_11.7MM_8XD_A*	03295061	11,7 *0.461*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1180-096-12R1 *SD_DRILL_11.8MM_8XD_A*	03295062	11,8 *0.465*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1190-096-12R1 *SD_DRILL_11.9MM_8XD_A*	03295063	11,9 *0.469*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1191-096-12R1 *SD_DRILL_15/32_8XD_A*	03323701	11,906 *0.469*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1200-096-12R1 *SD_DRILL_12.0MM_8XD_A*	03295064	12,0 *0.472*	96,0 *3.780*	163,0 *6.417*	118,0 *4.646*	45,0 *1.772*	114,0 *4.488*	12,0 *0.472*	140°	TiAlN	IT9
SD1108A-1230-119-14R1 *SD_DRILL_31/64_8XD_A*	03295065	12,3 *0.484*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1250-119-14R1 *SD_DRILL_12.5MM_8XD_A*	03295066	12,5 *0.492*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1270-119-14R1 *SD_DRILL_1/2_8XD_A*	03295067	12,7 *0.500*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1300-119-14R1 *SD_DRILL_13.0MM_8XD_A*	03295068	13,0 *0.512*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1349-119-14R1 *SD_DRILL_17/32_8XD_A*	03323702	13,494 *0.531*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1350-119-14R1 *SD_DRILL_13.5MM_8XD_A*	03295069	13,5 *0.531*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1400-119-14R1 *SD_DRILL_14.0MM_8XD_A*	03295070	14,0 *0.551*	119,0 *4.685*	182,0 *7.165*	137,0 *5.394*	45,0 *1.772*	133,0 *5.236*	14,0 *0.551*	140°	TiAlN	IT9
SD1108A-1429-136-16R1 *SD_DRILL_9/16_8XD_A*	03295071	14,288 *0.563*	136,0 *5.354*	204,0 *8.031*	156,0 *6.142*	48,0 *1.890*	152,0 *5.984*	16,0 *0.630*	140°	TiAlN	IT9
SD1108A-1450-136-16R1 *SD_DRILL_14.5MM_8XD_A*	03295072	14,5 *0.571*	136,0 *5.354*	204,0 *8.031*	156,0 *6.142*	48,0 *1.890*	152,0 *5.984*	16,0 *0.630*	140°	TiAlN	IT9
SD1108A-1500-136-16R1 *SD_DRILL_15.0MM_8XD_A*	03295073	15,0 *0.591*	136,0 *5.354*	204,0 *8.031*	156,0 *6.142*	48,0 *1.890*	152,0 *5.984*	16,0 *0.630*	140°	TiAlN	IT9
SD1108A-1550-136-16R1 *SD_DRILL_15.5MM_8XD_A*	03295074	15,5 *0.610*	136,0 *5.354*	204,0 *8.031*	156,0 *6.142*	48,0 *1.890*	152,0 *5.984*	16,0 *0.630*	140°	TiAlN	IT9
SD1108A-1588-136-16R1 *SD_DRILL_5/8_8XD_A*	03295075	15,875 *0.625*	136,0 *5.354*	204,0 *8.031*	156,0 *6.142*	48,0 *1.890*	152,0 *5.984*	16,0 *0.630*	140°	TiAlN	IT9
SD1108A-1600-136-16R1 *SD_DRILL_16.0MM_8XD_A*	03295076	16,0 *0.630*	136,0 *5.354*	204,0 *8.031*	156,0 *6.142*	48,0 *1.890*	152,0 *5.984*	16,0 *0.630*	140°	TiAlN	IT9
SD1108A-1650-153-18R1 *SD_DRILL_16.5MM_8XD_A*	03295077	16,5 *0.650*	153,0 *6.024*	223,0 *8.780*	175,0 *6.890*	48,0 *1.890*	171,0 *6.732*	18,0 *0.709*	140°	TiAlN	IT9
SD1108A-1700-153-18R1 *SD_DRILL_17.0MM_8XD_A*	03295078	17,0 *0.669*	153,0 *6.024*	223,0 *8.780*	175,0 *6.890*	48,0 *1.890*	171,0 *6.732*	18,0 *0.709*	140°	TiAlN	IT9
SD1108A-1750-153-18R1 *SD_DRILL_17.5MM_8XD_A*	03295079	17,5 *0.689*	153,0 *6.024*	223,0 *8.780*	175,0 *6.890*	48,0 *1.890*	171,0 *6.732*	18,0 *0.709*	140°	TiAlN	IT9
SD1108A-1800-153-18R1 *SD_DRILL_18.0MM_8XD_A*	03295080	18,0 *0.709*	153,0 *6.024*	223,0 *8.780*	175,0 *6.890*	48,0 *1.890*	171,0 *6.732*	18,0 *0.709*	140°	TiAlN	IT9
SD1108A-1850-170-20R1 *SD_DRILL_18.5MM_8XD_A*	03295081	18,5 *0.728*	170,0 *6.693*	244,0 *9.606*	194,0 *7.638*	50,0 *1.969*	190,0 *7.480*	20,0 *0.787*	140°	TiAlN	IT9
SD1108A-1900-170-20R1 *SD_DRILL_19.0MM_8XD_A*	03295082	19,0 *0.748*	170,0 *6.693*	244,0 *9.606*	194,0 *7.638*	50,0 *1.969*	190,0 *7.480*	20,0 *0.787*	140°	TiAlN	IT9
SD1108A-1905-170-20R1 *SD_DRILL_3/4_8XD_A*	03323703	19,05 *0.750*	170,0 *6.693*	244,0 *9.606*	194,0 *7.638*	50,0 *1.969*	190,0 *7.480*	20,0 *0.787*	140°	TiAlN	IT9
SD1108A-1950-170-20R1 *SD_DRILL_19.5MM_8XD_A*	03295083	19,5 *0.768*	170,0 *6.693*	244,0 *9.606*	194,0 *7.638*	50,0 *1.969*	190,0 *7.480*	20,0 *0.787*	140°	TiAlN	IT9
SD1108A-2000-170-20R1 *SD_DRILL_20.0MM_8XD_A*	03295084	20,0 *0.787*	170,0 *6.693*	244,0 *9.606*	194,0 *7.638*	50,0 *1.969*	190,0 *7.480*	20,0 *0.787*	140°	TiAlN	IT9

SD1112A

Bohrtiefe ca. 12 x D – Metrisch/Zoll



– Zylinderschaft DIN 6537A
– DC-Toleranz m7
– Kühlmittelzufuhr
– Schnittdaten siehe Seite(n) 141
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1112A-0300-048-06R1 *SD_DRILL_3.0MM_12XD_A*	03295085	3,0 *0.118*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0310-048-06R1 *SD_DRILL_3.1MM_12XD_A*	03295086	3,1 *0.122*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0318-048-06R1 *SD_DRILL_1/8_12XD_A*	03323704	3,175 *0.125*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0320-048-06R1 *SD_DRILL_3.2MM_12XD_A*	03295087	3,2 *0.126*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0330-048-06R1 *SD_DRILL_3.3MM_12XD_A*	03295088	3,3 *0.130*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0340-048-06R1 *SD_DRILL_3.4MM_12XD_A*	03295089	3,4 *0.134*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0350-048-06R1 *SD_DRILL_3.5MM_12XD_A*	03295090	3,5 *0.138*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0360-048-06R1 *SD_DRILL_3.6MM_12XD_A*	03295091	3,6 *0.142*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0370-048-06R1 *SD_DRILL_3.7MM_12XD_A*	03295092	3,7 *0.146*	48,0 *1.890*	92,0 *3.622*	56,0 *2.205*	36,0 *1.417*	54,0 *2.126*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0380-056-06R1 *SD_DRILL_3.8MM_12XD_A*	03295093	3,8 *0.150*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0390-056-06R1 *SD_DRILL_3.9MM_12XD_A*	03295094	3,9 *0.154*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0397-056-06R1 *SD_DRILL_5/32_12XD_A*	03323706	3,969 *0.156*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0400-056-06R1 *SD_DRILL_4.0MM_12XD_A*	03295095	4,0 *0.157*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0410-056-06R1 *SD_DRILL_4.1MM_12XD_A*	03295096	4,1 *0.161*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0420-056-06R1 *SD_DRILL_4.2MM_12XD_A*	03295097	4,2 *0.165*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0430-056-06R1 *SD_DRILL_4.3MM_12XD_A*	03295098	4,3 *0.169*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0440-056-06R1 *SD_DRILL_4.4MM_12XD_A*	03295099	4,4 *0.173*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0450-056-06R1 *SD_DRILL_4.5MM_12XD_A*	03295100	4,5 *0.177*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0460-056-06R1 *SD_DRILL_4.6MM_12XD_A*	03295101	4,6 *0.181*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0470-056-06R1 *SD_DRILL_4.7MM_12XD_A*	03295102	4,7 *0.185*	56,0 *2.205*	102,0 *4.016*	66,0 *2.598*	36,0 *1.417*	64,0 *2.520*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0476-074-06R1 *SD_DRILL_3/16_12XD_A*	03323708	4,763 *0.188*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0490-074-06R1 *SD_DRILL_4.9MM_12XD_A*	03295104	4,9 *0.193*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0500-074-06R1 *SD_DRILL_5.0MM_12XD_A*	03295105	5,0 *0.197*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0510-074-06R1 *SD_DRILL_5.1MM_12XD_A*	03295106	5,1 *0.201*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0516-074-06R1 *SD_DRILL_13/64_12XD_A*	03323709	5,159 *0.203*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1112A-0520-074-06R1 *SD_DRILL_5.2MM_12XD_A*	03295107	5,2 *0.205*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0530-074-06R1 *SD_DRILL_5.3MM_12XD_A*	03295108	5,3 *0.209*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0550-074-06R1 *SD_DRILL_5.5MM_12XD_A*	03295110	5,5 *0.217*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0560-074-06R1 *SD_DRILL_5.6MM_12XD_A*	03295112	5,6 *0.220*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0580-074-06R1 *SD_DRILL_5.8MM_12XD_A*	03295114	5,8 *0.228*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0600-074-06R1 *SD_DRILL_6.0MM_12XD_A*	03295116	6,0 *0.236*	74,0 *2.913*	121,0 *4.764*	85,0 *3.346*	36,0 *1.417*	83,0 *3.268*	6,0 *0.236*	140°	TiAlN	IT9
SD1112A-0610-098-08R1 *SD_DRILL_6.1MM_12XD_A*	03295117	6,1 *0.240*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0620-098-08R1 *SD_DRILL_6.2MM_12XD_A*	03295118	6,2 *0.244*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0635-098-08R1 *SD_DRILL_1/4_12XD_A*	03295120	6,35 *0.250*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0650-098-08R1 *SD_DRILL_6.5MM_12XD_A*	03295122	6,5 *0.256*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0660-098-08R1 *SD_DRILL_6.6MM_12XD_A*	03295123	6,6 *0.260*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0670-098-08R1 *SD_DRILL_6.7MM_12XD_A*	03295124	6,7 *0.264*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0675-098-08R1 *SD_DRILL_17/64_12XD_A*	03323710	6,747 *0.266*	98,0 *3.858*	148,0 *5.827*	128,0 *5.039*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0680-098-08R1 *SD_DRILL_6.8MM_12XD_A*	03295125	6,8 *0.268*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0690-098-08R1 *SD_DRILL_6.9MM_12XD_A*	03295126	6,9 *0.272*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0700-098-08R1 *SD_DRILL_7.0MM_12XD_A*	03295127	7,0 *0.276*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0714-098-08R1 *SD_DRILL_9/32_12XD_A*	03323711	7,144 *0.281*	98,0 *3.858*	148,0 *5.827*	128,0 *5.039*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0740-098-08R1 *SD_DRILL_7.4MM_12XD_A*	03295129	7,4 *0.291*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0750-098-08R1 *SD_DRILL_7.5MM_12XD_A*	03295130	7,5 *0.295*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0754-098-08R1 *SD_DRILL_19/64_12XD_A*	03323713	7,541 *0.297*	98,0 *3.858*	148,0 *5.827*	128,0 *5.039*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0780-098-08R1 *SD_DRILL_7.8MM_12XD_A*	03295131	7,8 *0.307*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0790-098-08R1 *SD_DRILL_7.9MM_12XD_A*	03295132	7,9 *0.311*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0794-098-08R1 *SD_DRILL_5/16_12XD_A*	03323714	7,938 *0.313*	98,0 *3.858*	148,0 *5.827*	128,0 *5.039*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0800-098-08R1 *SD_DRILL_8.0MM_12XD_A*	03295133	8,0 *0.315*	98,0 *3.858*	148,0 *5.827*	112,0 *4.409*	36,0 *1.417*	110,0 *4.331*	8,0 *0.315*	140°	TiAlN	IT9
SD1112A-0810-123-10R1 *SD_DRILL_8.1MM_12XD_A*	03295135	8,1 *0.319*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0820-123-10R1 *SD_DRILL_8.2MM_12XD_A*	03295136	8,2 *0.323*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0830-123-10R1 *SD_DRILL_8.3MM_12XD_A*	03295137	8,3 *0.327*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0840-123-10R1 *SD_DRILL_8.4MM_12XD_A*	03295138	8,4 *0.331*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0850-123-10R1 *SD_DRILL_8.5MM_12XD_A*	03295139	8,5 *0.335*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0860-123-10R1 *SD_DRILL_8.6MM_12XD_A*	03295140	8,6 *0.339*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0873-123-10R1 *SD_DRILL_11/32_12XD_A*	03323715	8,731 *0.344*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0880-123-10R1 *SD_DRILL_8.8MM_12XD_A*	03295142	8,8 *0.346*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0900-123-10R1 *SD_DRILL_9.0MM_12XD_A*	03295143	9,0 *0.354*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0930-123-10R1 *SD_DRILL_9.3MM_12XD_A*	03295144	9,3 *0.366*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0950-123-10R1 *SD_DRILL_9.5MM_12XD_A*	03295145	9,5 *0.374*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1112A-0953-123-10R1 *SD_DRILL_3/8_12XD_A*	03323717	9,525 *0.375*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0980-123-10R1 *SD_DRILL_9.8MM_12XD_A*	03295147	9,8 *0.386*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-0992-123-10R1 *SD_DRILL_25/64_12XD_A*	03323718	9,922 *0.391*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-1000-123-10R1 *SD_DRILL_10.0MM_12XD_A*	03295148	10,0 *0.394*	123,0 *4.843*	180,0 *7.087*	140,0 *5.512*	40,0 *1.575*	138,0 *5.433*	10,0 *0.394*	140°	TiAlN	IT9
SD1112A-1020-140-12R1 *SD_DRILL_10.2MM_12XD_A*	03295149	10,2 *0.402*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1030-140-12R1 *SD_DRILL_10.3MM_12XD_A*	03295150	10,3 *0.406*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1032-140-12R1 *SD_DRILL_13/32_12XD_A*	03323719	10,319 *0.406*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1050-140-12R1 *SD_DRILL_10.5MM_12XD_A*	03295151	10,5 *0.413*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1080-140-12R1 *SD_DRILL_10.8MM_12XD_A*	03295152	10,8 *0.425*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1100-140-12R1 *SD_DRILL_11.0MM_12XD_A*	03295153	11,0 *0.433*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1111-140-12R1 *SD_DRILL_7/16_12XD_A*	03323722	11,113 *0.438*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1120-140-12R1 *SD_DRILL_11.2MM_12XD_A*	03295154	11,2 *0.441*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1150-140-12R1 *SD_DRILL_11.5MM_12XD_A*	03295155	11,5 *0.453*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1200-140-12R1 *SD_DRILL_12.0MM_12XD_A*	03295158	12,0 *0.472*	140,0 *5.512*	206,0 *8.110*	161,0 *6.339*	45,0 *1.772*	158,0 *6.220*	12,0 *0.472*	140°	TiAlN	IT9
SD1112A-1250-168-14R1 *SD_DRILL_12.5MM_12XD_A*	03295161	12,5 *0.492*	168,0 *6.614*	230,0 *9.055*	185,0 *7.283*	45,0 *1.772*	182,0 *7.165*	14,0 *0.551*	140°	TiAlN	IT9
SD1112A-1270-168-14R1 *SD_DRILL_1/2_12XD_A*	03295162	12,7 *0.500*	168,0 *6.614*	230,0 *9.055*	185,0 *7.283*	45,0 *1.772*	182,0 *7.165*	14,0 *0.551*	140°	TiAlN	IT9
SD1112A-1300-168-14R1 *SD_DRILL_13.0MM_12XD_A*	03295163	13,0 *0.512*	168,0 *6.614*	230,0 *9.055*	185,0 *7.283*	45,0 *1.772*	182,0 *7.165*	14,0 *0.551*	140°	TiAlN	IT9
SD1112A-1350-168-14R1 *SD_DRILL_13.5MM_12XD_A*	03295164	13,5 *0.531*	168,0 *6.614*	230,0 *9.055*	185,0 *7.283*	45,0 *1.772*	182,0 *7.165*	14,0 *0.551*	140°	TiAlN	IT9
SD1112A-1400-168-14R1 *SD_DRILL_14.0MM_12XD_A*	03295165	14,0 *0.551*	168,0 *6.614*	230,0 *9.055*	185,0 *7.283*	45,0 *1.772*	182,0 *7.165*	14,0 *0.551*	140°	TiAlN	IT9
SD1112A-1429-192-16R1 *SD_DRILL_9/16_12XD_A*	03295166	14,288 *0.563*	192,0 *7.559*	260,0 *10.236*	212,0 *8.346*	48,0 *1.890*	208,0 *8.189*	16,0 *0.630*	140°	TiAlN	IT9
SD1112A-1500-192-16R1 *SD_DRILL_15.0MM_12XD_A*	03295168	15,0 *0.591*	192,0 *7.559*	260,0 *10.236*	212,0 *8.346*	48,0 *1.890*	208,0 *8.189*	16,0 *0.630*	140°	TiAlN	IT9
SD1112A-1600-192-16R1 *SD_DRILL_16.0MM_12XD_A*	03295171	16,0 *0.630*	192,0 *7.559*	260,0 *10.236*	212,0 *8.346*	48,0 *1.890*	208,0 *8.189*	16,0 *0.630*	140°	TiAlN	IT9
SD1112A-1650-216-18R1 *SD_DRILL_16.5MM_12XD_A*	03295172	16,5 *0.650*	216,0 *8.504*	285,0 *11.220*	237,0 *9.331*	48,0 *1.890*	234,0 *9.213*	18,0 *0.709*	140°	TiAlN	IT9
SD1112A-1700-216-18R1 *SD_DRILL_17.0MM_12XD_A*	03295173	17,0 *0.669*	216,0 *8.504*	285,0 *11.220*	237,0 *9.331*	48,0 *1.890*	234,0 *9.213*	18,0 *0.709*	140°	TiAlN	IT9
SD1112A-1750-216-18R1 *SD_DRILL_17.5MM_12XD_A*	03295174	17,5 *0.689*	216,0 *8.504*	285,0 *11.220*	237,0 *9.331*	48,0 *1.890*	234,0 *9.213*	18,0 *0.709*	140°	TiAlN	IT9
SD1112A-1800-216-18R1 *SD_DRILL_18.0MM_12XD_A*	03295175	18,0 *0.709*	216,0 *8.504*	285,0 *11.220*	237,0 *9.331*	48,0 *1.890*	234,0 *9.213*	18,0 *0.709*	140°	TiAlN	IT9
SD1112A-1900-238-20R1 *SD_DRILL_19.0MM_12XD_A*	03295176	19,0 *0.748*	238,0 *9.370*	310,0 *12.205*	260,0 *10.236*	50,0 *1.969*	258,0 *10.157*	20,0 *0.787*	140°	TiAlN	IT9

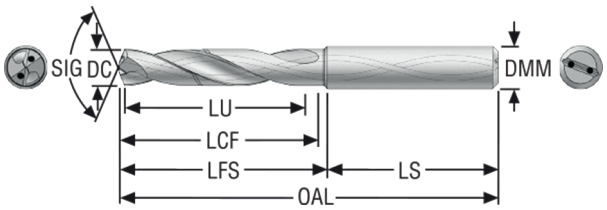
Feedmax -P

Die Feedmax -P-Bohrer bieten eine hohe Produktivität und geringe Kosten pro Bohrung durch eine einzigartige Kombination von Hartmetall, Beschichtung und Geometrie.

- Die selbstzentrierende Geometrie sorgt für hochqualitative Bohrungen ohne Einsatz eines Zentrierbohrers.
- Eine spezielle TiAlN-Beschichtung sorgt für eine hohe Warmhärte, die in Kombination mit einer starken Schneide eine lange und berechenbare Standzeit ermöglicht.

SD203A-P

Bohrtiefe ca. 3 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 142–143
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0200-007-04R1-P	03045918	2,0 *0.079*	7,0 *0.276*	41,0 *1.614*	14,0 *0.551*	27,0 *1.063*	11,0 *0.433*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0210-007-04R1-P	03045919	2,1 *0.083*	7,0 *0.276*	41,0 *1.614*	14,0 *0.551*	27,0 *1.063*	11,0 *0.433*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0220-007-04R1-P	03045920	2,2 *0.087*	7,0 *0.276*	41,0 *1.614*	14,0 *0.551*	27,0 *1.063*	11,0 *0.433*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0230-008-04R1-P	03045921	2,3 *0.091*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0235-008-04R1-P	03138154	2,35 *0.093*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0238-008-04R1-P	03120476	2,381 *0.094*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0240-008-04R1-P	03045922	2,4 *0.094*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0250-008-04R1-P	03045923	2,5 *0.098*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0260-008-04R1-P	03045924	2,6 *0.102*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0270-009-04R1-P	03045925	2,7 *0.106*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0278-009-04R1-P	03120495	2,778 *0.109*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0280-009-04R1-P	03045926	2,8 *0.110*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0290-009-04R1-P	03045927	2,9 *0.114*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN	IT8-9
SD203A-0300-014-06R1-P	03045928	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0310-014-06R1-P	03045929	3,1 *0.122*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0318-014-06R1-P	03046061	3,175 *0.125*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0320-014-06R1-P	03045930	3,2 *0.126*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0325-014-06R1-P	03045931	3,25 *0.128*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0330-014-06R1-P	03045932	3,3 *0.130*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0340-014-06R1-P	03045933	3,4 *0.134*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0350-014-06R1-P	03045934	3,5 *0.138*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0357-014-06R1-P	03046062	3,572 *0.141*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0360-014-06R1-P	03045935	3,6 *0.142*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0365-014-06R1-P	03045936	3,65 *0.144*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0370-014-06R1-P	03045937	3,7 *0.146*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0380-017-06R1-P	03045938	3,8 *0.150*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0390-017-06R1-P	03045939	3,9 *0.154*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0397-017-06R1-P	03046063	3,97 *0.156*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0400-017-06R1-P	03045940	4,0 *0.157*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0410-017-06R1-P	03045941	4,1 *0.161*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0420-017-06R1-P	03045942	4,2 *0.165*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0430-017-06R1-P	03045943	4,3 *0.169*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0437-017-06R1-P	03046064	4,366 *0.172*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0450-017-06R1-P	03045944	4,5 *0.177*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0460-017-06R1-P	03045945	4,6 *0.181*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0465-017-06R1-P	03045946	4,65 *0.183*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0470-017-06R1-P	03045947	4,7 *0.185*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0476-020-06R1-P	03046065	4,763 *0.188*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0480-020-06R1-P	03045948	4,8 *0.189*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0490-020-06R1-P	03045949	4,9 *0.193*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0500-020-06R1-P	03045950	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0510-020-06R1-P	03045951	5,1 *0.201*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0516-020-06R1-P	03046066	5,159 *0.203*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0520-020-06R1-P	03045952	5,2 *0.205*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0530-020-06R1-P	03045953	5,3 *0.209*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0540-020-06R1-P	03045954	5,4 *0.213*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0550-020-06R1-P	03045955	5,5 *0.217*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0555-020-06R1-P	03045956	5,55 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0556-020-06R1-P	03046067	5,556 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0560-020-06R1-P	03045957	5,6 *0.220*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0570-020-06R1-P	03045958	5,7 *0.224*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0580-020-06R1-P	03045959	5,8 *0.228*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0590-020-06R1-P	03045960	5,9 *0.232*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0595-020-06R1-P	03046068	5,953 *0.234*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0600-020-06R1-P	03045961	6,0 *0.236*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN	IT8-9
SD203A-0610-024-08R1-P	03045962	6,1 *0.240*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0620-024-08R1-P	03045963	6,2 *0.244*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0630-024-08R1-P	03045964	6,3 *0.248*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0635-024-08R1-P	03046069	6,35 *0.250*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0640-024-08R1-P	03045965	6,4 *0.252*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0650-024-08R1-P	03045966	6,5 *0.256*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0660-024-08R1-P	03045967	6,6 *0.260*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0670-024-08R1-P	03045968	6,7 *0.264*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0675-024-08R1-P	03046070	6,747 *0.266*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0680-024-08R1-P	03045969	6,8 *0.268*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0690-024-08R1-P	03045970	6,9 *0.272*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0700-024-08R1-P	03045971	7,0 *0.276*	24,0 *0.945*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0710-029-08R1-P	03045972	7,1 *0.280*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0714-029-08R1-P	03046071	7,144 *0.281*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0720-029-08R1-P	03045973	7,2 *0.283*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0730-029-08R1-P	03045974	7,3 *0.287*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0740-029-08R1-P	03045975	7,4 *0.291*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0750-029-08R1-P	03045976	7,5 *0.295*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0754-029-08R1-P	03046072	7,541 *0.297*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0755-029-08R1-P	03045977	7,55 *0.297*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0760-029-08R1-P	03045978	7,6 *0.299*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0770-029-08R1-P	03045979	7,7 *0.303*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0780-029-08R1-P	03045980	7,8 *0.307*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0790-029-08R1-P	03045981	7,9 *0.311*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0794-029-08R1-P	03046073	7,938 *0.313*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0800-029-08R1-P	03045982	8,0 *0.315*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN	IT8-9
SD203A-0810-035-10R1-P	03045983	8,1 *0.319*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0820-035-10R1-P	03045984	8,2 *0.323*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0830-035-10R1-P	03045985	8,3 *0.327*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0833-035-10R1-P	03046074	8,334 *0.328*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0840-035-10R1-P	03045986	8,4 *0.331*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0850-035-10R1-P	03045987	8,5 *0.335*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0860-035-10R1-P	03045988	8,6 *0.339*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0870-035-10R1-P	03045989	8,7 *0.343*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0873-035-10R1-P	03046075	8,731 *0.344*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0880-035-10R1-P	03045990	8,8 *0.346*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0890-035-10R1-P	03045991	8,9 *0.350*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0900-035-10R1-P	03045992	9,0 *0.354*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0910-035-10R1-P	03045993	9,1 *0.358*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0913-035-10R1-P	03046076	9,128 *0.359*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9

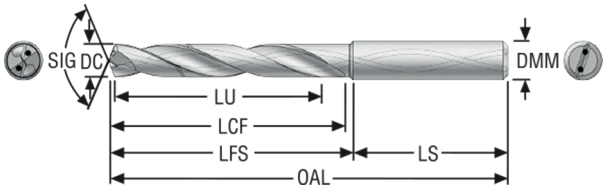
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0920-035-10R1-P	03045994	9,2 *0.362*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0930-035-10R1-P	03045995	9,3 *0.366*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0940-035-10R1-P	03045996	9,4 *0.370*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0950-035-10R1-P	03045997	9,5 *0.374*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0953-035-10R1-P	03046077	9,525 *0.375*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0955-035-10R1-P	03045998	9,55 *0.376*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0960-035-10R1-P	03045999	9,6 *0.378*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0970-035-10R1-P	03046000	9,7 *0.382*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0980-035-10R1-P	03046001	9,8 *0.386*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0990-035-10R1-P	03046002	9,9 *0.390*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-0992-035-10R1-P	03046078	9,922 *0.391*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-1000-035-10R1-P	03046003	10,0 *0.394*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN	IT8-9
SD203A-1020-040-12R1-P	03046004	10,2 *0.402*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1032-040-12R1-P	03046079	10,319 *0.406*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1040-040-12R1-P	03046005	10,4 *0.409*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1050-040-12R1-P	03046006	10,5 *0.413*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1060-040-12R1-P	03046007	10,6 *0.417*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1072-040-12R1-P	03046080	10,716 *0.422*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1080-040-12R1-P	03046008	10,8 *0.425*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1090-040-12R1-P	03046009	10,9 *0.429*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1100-040-12R1-P	03046010	11,0 *0.433*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1110-040-12R1-P	03046011	11,1 *0.437*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1111-040-12R1-P	03046081	11,113 *0.438*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1120-040-12R1-P	03046012	11,2 *0.441*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1130-040-12R1-P	03046013	11,3 *0.445*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1140-040-12R1-P	03046014	11,4 *0.449*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1150-040-12R1-P	03046015	11,5 *0.453*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1151-040-12R1-P	03046082	11,509 *0.453*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1155-040-12R1-P	03046016	11,55 *0.455*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1160-040-12R1-P	03046017	11,6 *0.457*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1170-040-12R1-P	03046018	11,7 *0.461*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1180-040-12R1-P	03046019	11,8 *0.465*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1190-040-12R1-P	03046020	11,9 *0.469*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1191-040-12R1-P	03046083	11,906 *0.469*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9
SD203A-1200-040-12R1-P	03046021	12,0 *0.472*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-1210-043-14R1-P	03046022	12,1 *0.476*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1220-043-14R1-P	03046023	12,2 *0.480*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1230-043-14R1-P	03046084	12,303 *0.484*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1240-043-14R1-P	03046024	12,4 *0.488*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1250-043-14R1-P	03046025	12,5 *0.492*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1260-043-14R1-P	03046026	12,6 *0.496*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1270-043-14R1-P	03046085	12,7 *0.500*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1275-043-14R1-P	03046027	12,75 *0.502*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1280-043-14R1-P	03046028	12,8 *0.504*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1290-043-14R1-P	03046029	12,9 *0.508*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1300-043-14R1-P	03046030	13,0 *0.512*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1310-043-14R1-P	03046031	13,1 *0.516*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1320-043-14R1-P	03046032	13,2 *0.520*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1330-043-14R1-P	03046033	13,3 *0.524*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1349-043-14R1-P	03046086	13,494 *0.531*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1350-043-14R1-P	03046035	13,5 *0.531*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1360-043-14R1-P	03046036	13,6 *0.535*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1370-043-14R1-P	03046037	13,7 *0.539*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1380-043-14R1-P	03046038	13,8 *0.543*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1390-043-14R1-P	03046039	13,9 *0.547*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1400-043-14R1-P	03046040	14,0 *0.551*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9
SD203A-1420-045-16R1-P	03046041	14,2 *0.559*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1425-045-16R1-P	03138155	14,25 *0.561*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1429-045-16R1-P	03046087	14,288 *0.563*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1450-045-16R1-P	03046042	14,5 *0.571*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1470-045-16R1-P	03046043	14,7 *0.579*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1500-045-16R1-P	03046046	15,0 *0.591*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1510-045-16R1-P	03046047	15,1 *0.594*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1530-045-16R1-P	03046048	15,3 *0.602*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1550-045-16R1-P	03046049	15,5 *0.610*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1570-045-16R1-P	03046050	15,7 *0.618*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1580-045-16R1-P	03046051	15,8 *0.622*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1588-045-16R1-P	03046088	15,875 *0.625*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1600-045-16R1-P	03046052	16,0 *0.630*	45,0 *1.772*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN	IT8-9
SD203A-1650-051-18R1-P	03046053	16,5 *0.650*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-1700-051-18R1-P	03046054	17,0 *0.669*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9
SD203A-1750-051-18R1-P	03046055	17,5 *0.689*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9
SD203A-1800-051-18R1-P	03046056	18,0 *0.709*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9
SD203A-1850-055-20R1-P	03046057	18,5 *0.728*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1900-055-20R1-P	03046058	19,0 *0.748*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1905-055-20R1-P	03046089	19,05 *0.750*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1950-055-20R1-P	03046059	19,5 *0.768*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1980-055-20R1-P	03138156	19,8 *0.780*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-2000-055-20R1-P	03046060	20,0 *0.787*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9

SD205A-P

Bohrtiefe ca. 5 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 144-145
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0200-012-04R1-P	03046131	2,0 *0.079*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0210-012-04R1-P	03046132	2,1 *0.083*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0220-012-04R1-P	03046133	2,2 *0.087*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0230-012-04R1-P	03046134	2,3 *0.091*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0238-013-04R1-P	03120477	2,381 *0.094*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0240-013-04R1-P	03046135	2,4 *0.094*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0250-013-04R1-P	03046136	2,5 *0.098*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0260-013-04R1-P	03046137	2,6 *0.102*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0270-015-04R1-P	03046138	2,7 *0.106*	15,0 *0.591*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	20,5 *0.807*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0278-015-04R1-P	03120496	2,778 *0.109*	15,0 *0.591*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	20,5 *0.807*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0280-015-04R1-P	03046139	2,8 *0.110*	15,0 *0.591*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	20,5 *0.807*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0290-015-04R1-P	03046141	2,9 *0.114*	15,0 *0.591*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	20,5 *0.807*	4,0 *0.157*	140°	TiAlN	IT8-9
SD205A-0300-023-06R1-P	03046142	3,0 *0.118*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0310-023-06R1-P	03046143	3,1 *0.122*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0318-023-06R1-P	03046327	3,175 *0.125*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0320-023-06R1-P	03046144	3,2 *0.126*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0325-023-06R1-P	03046145	3,25 *0.128*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0330-023-06R1-P	03046146	3,3 *0.130*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0340-023-06R1-P	03046147	3,4 *0.134*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0350-023-06R1-P	03046148	3,5 *0.138*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0357-023-06R1-P	03046328	3,572 *0.141*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0360-023-06R1-P	03046149	3,6 *0.142*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0365-023-06R1-P	03046150	3,65 *0.144*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0370-023-06R1-P	03046151	3,7 *0.146*	23,0 *0.906*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0380-029-06R1-P	03046152	3,8 *0.150*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0390-029-06R1-P	03046153	3,9 *0.154*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0397-029-06R1-P	03046329	3,97 *0.156*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0400-029-06R1-P	03046154	4,0 *0.157*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0410-029-06R1-P	03046155	4,1 *0.161*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0420-029-06R1-P	03046157	4,2 *0.165*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0430-029-06R1-P	03046158	4,3 *0.169*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0437-029-06R1-P	03046330	4,366 *0.172*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0440-029-06R1-P	03046159	4,4 *0.173*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0450-029-06R1-P	03046160	4,5 *0.177*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0460-029-06R1-P	03046161	4,6 *0.181*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0465-029-06R1-P	03046162	4,65 *0.183*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0470-029-06R1-P	03046163	4,7 *0.185*	29,0 *1.142*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0476-035-06R1-P	03046331	4,763 *0.188*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0480-035-06R1-P	03046164	4,8 *0.189*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0490-035-06R1-P	03046165	4,9 *0.193*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0500-035-06R1-P	03046166	5,0 *0.197*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0510-035-06R1-P	03046167	5,1 *0.201*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0516-035-06R1-P	03046332	5,159 *0.203*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0520-035-06R1-P	03046168	5,2 *0.205*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0530-035-06R1-P	03046169	5,3 *0.209*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0540-035-06R1-P	03046170	5,4 *0.213*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0550-035-06R1-P	03046171	5,5 *0.217*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0555-035-06R1-P	03046172	5,55 *0.219*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0556-035-06R1-P	03046333	5,556 *0.219*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0560-035-06R1-P	03046173	5,6 *0.220*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0570-035-06R1-P	03046174	5,7 *0.224*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0580-035-06R1-P	03046175	5,8 *0.228*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0590-035-06R1-P	03046176	5,9 *0.232*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0595-035-06R1-P	03046334	5,953 *0.234*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0600-035-06R1-P	03046177	6,0 *0.236*	35,0 *1.378*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN	IT8-9
SD205A-0610-043-08R1-P	03046179	6,1 *0.240*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0620-043-08R1-P	03046180	6,2 *0.244*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0630-043-08R1-P	03046181	6,3 *0.248*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0635-043-08R1-P	03046335	6,35 *0.250*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0640-043-08R1-P	03046182	6,4 *0.252*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0650-043-08R1-P	03046183	6,5 *0.256*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0660-043-08R1-P	03046184	6,6 *0.260*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0670-043-08R1-P	03046185	6,7 *0.264*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0675-043-08R1-P	03046336	6,747 *0.266*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0680-043-08R1-P	03046186	6,8 *0.268*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0690-043-08R1-P	03046187	6,9 *0.272*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0700-043-08R1-P	03046188	7,0 *0.276*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0710-043-08R1-P	03046190	7,1 *0.280*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0714-043-08R1-P	03046337	7,144 *0.281*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0720-043-08R1-P	03046191	7,2 *0.283*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0730-043-08R1-P	03046192	7,3 *0.287*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0740-043-08R1-P	03046193	7,4 *0.291*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0750-043-08R1-P	03046194	7,5 *0.295*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0754-043-08R1-P	03046338	7,541 *0.297*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0755-043-08R1-P	03046195	7,55 *0.297*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0760-043-08R1-P	03046196	7,6 *0.299*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0770-043-08R1-P	03046197	7,7 *0.303*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0780-043-08R1-P	03046198	7,8 *0.307*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0790-043-08R1-P	03046199	7,9 *0.311*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0794-043-08R1-P	03046339	7,938 *0.313*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0800-043-08R1-P	03046200	8,0 *0.315*	43,0 *1.693*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN	IT8-9
SD205A-0810-049-10R1-P	03046201	8,1 *0.319*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0820-049-10R1-P	03046202	8,2 *0.323*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0830-049-10R1-P	03046203	8,3 *0.327*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0833-049-10R1-P	03046340	8,334 *0.328*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0840-049-10R1-P	03046204	8,4 *0.331*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0850-049-10R1-P	03046205	8,5 *0.335*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0860-049-10R1-P	03046206	8,6 *0.339*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0870-049-10R1-P	03046207	8,7 *0.343*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0873-049-10R1-P	03046341	8,731 *0.344*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0880-049-10R1-P	03046208	8,8 *0.346*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0890-049-10R1-P	03046209	8,9 *0.350*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0900-049-10R1-P	03046210	9,0 *0.354*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0910-049-10R1-P	03046211	9,1 *0.358*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0913-049-10R1-P	03046342	9,128 *0.359*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0920-049-10R1-P	03046212	9,2 *0.362*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0930-049-10R1-P	03046213	9,3 *0.366*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0940-049-10R1-P	03046214	9,4 *0.370*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0950-049-10R1-P	03046215	9,5 *0.374*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0953-049-10R1-P	03046343	9,525 *0.375*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0955-049-10R1-P	03046216	9,55 *0.376*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0960-049-10R1-P	03046217	9,6 *0.378*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0970-049-10R1-P	03046218	9,7 *0.382*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0980-049-10R1-P	03046219	9,8 *0.386*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0990-049-10R1-P	03046220	9,9 *0.390*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-0992-049-10R1-P	03046344	9,922 *0.391*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-1000-049-10R1-P	03046221	10,0 *0.394*	49,0 *1.929*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN	IT8-9
SD205A-1010-056-12R1-P	03046222	10,1 *0.398*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1020-056-12R1-P	03046223	10,2 *0.402*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1030-056-12R1-P	03046224	10,3 *0.406*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1032-056-12R1-P	03046345	10,319 *0.406*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1040-056-12R1-P	03046225	10,4 *0.409*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1050-056-12R1-P	03046226	10,5 *0.413*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1060-056-12R1-P	03046227	10,6 *0.417*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1070-056-12R1-P	03046228	10,7 *0.421*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1072-056-12R1-P	03046346	10,716 *0.422*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1080-056-12R1-P	03046229	10,8 *0.425*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1090-056-12R1-P	03046230	10,9 *0.429*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1100-056-12R1-P	03046231	11,0 *0.433*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1110-056-12R1-P	03046232	11,1 *0.437*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1111-056-12R1-P	03046347	11,113 *0.438*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1120-056-12R1-P	03046233	11,2 *0.441*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1130-056-12R1-P	03046234	11,3 *0.445*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1140-056-12R1-P	03046235	11,4 *0.449*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1150-056-12R1-P	03046236	11,5 *0.453*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1151-056-12R1-P	03046348	11,509 *0.453*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1155-056-12R1-P	03046237	11,55 *0.455*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1160-056-12R1-P	03046238	11,6 *0.457*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1170-056-12R1-P	03046239	11,7 *0.461*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1180-056-12R1-P	03046240	11,8 *0.465*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9

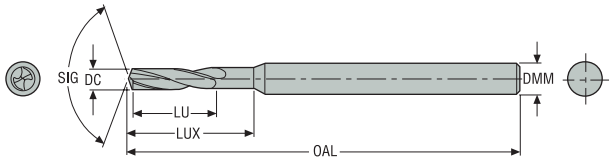
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-1190-056-12R1-P	03046241	11,9 *0.469*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1191-056-12R1-P	03046349	11,906 *0.469*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1200-056-12R1-P	03046242	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN	IT8-9
SD205A-1210-060-14R1-P	03046243	12,1 *0.476*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1220-060-14R1-P	03046244	12,2 *0.480*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1225-060-14R1-P	03046245	12,25 *0.482*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1230-060-14R1-P	03138157	12,3 *0.484*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1240-060-14R1-P	03046246	12,4 *0.488*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1250-060-14R1-P	03046247	12,5 *0.492*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1260-060-14R1-P	03046248	12,6 *0.496*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1270-060-14R1-P	03120497	12,7 *0.500*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1275-060-14R1-P	03046249	12,75 *0.502*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1280-060-14R1-P	03046250	12,8 *0.504*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1290-060-14R1-P	03046251	12,9 *0.508*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1300-060-14R1-P	03046252	13,0 *0.512*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1310-060-14R1-P	03046253	13,1 *0.516*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1320-060-14R1-P	03046254	13,2 *0.520*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1330-060-14R1-P	03046255	13,3 *0.524*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1340-060-14R1-P	03046256	13,4 *0.528*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1349-060-14R1-P	03046350	13,494 *0.531*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1350-060-14R1-P	03046257	13,5 *0.531*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1360-060-14R1-P	03046258	13,6 *0.535*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1370-060-14R1-P	03046259	13,7 *0.539*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1380-060-14R1-P	03046260	13,8 *0.543*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1389-060-14R1-P	03120498	13,891 *0.547*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1390-060-14R1-P	03046261	13,9 *0.547*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1400-060-14R1-P	03046262	14,0 *0.551*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN	IT8-9
SD205A-1410-063-16R1-P	03046263	14,1 *0.555*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1420-063-16R1-P	03046264	14,2 *0.559*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1425-063-16R1-P	03138159	14,25 *0.561*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1429-063-16R1-P	03046351	14,288 *0.563*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1430-063-16R1-P	03046265	14,3 *0.563*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1440-063-16R1-P	03046266	14,4 *0.567*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1450-063-16R1-P	03046267	14,5 *0.571*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1460-063-16R1-P	03046268	14,6 *0.575*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-1470-063-16R1-P	03046269	14,7 *0.579*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1480-063-16R1-P	03046271	14,8 *0.583*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1490-063-16R1-P	03046272	14,9 *0.587*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1500-063-16R1-P	03046273	15,0 *0.591*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1510-063-16R1-P	03046274	15,1 *0.594*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1520-063-16R1-P	03046275	15,2 *0.598*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1525-063-16R1-P	03138160	15,25 *0.600*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1530-063-16R1-P	03046276	15,3 *0.602*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1550-063-16R1-P	03046278	15,5 *0.610*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1560-063-16R1-P	03046280	15,6 *0.614*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1570-063-16R1-P	03046281	15,7 *0.618*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1580-063-16R1-P	03046282	15,8 *0.622*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1588-063-16R1-P	03046352	15,875 *0.625*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1590-063-16R1-P	03046283	15,9 *0.626*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1600-063-16R1-P	03046284	16,0 *0.630*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9
SD205A-1610-071-18R1-P	03046285	16,1 *0.634*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1620-071-18R1-P	03046286	16,2 *0.638*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1625-071-18R1-P	03138161	16,25 *0.640*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1640-071-18R1-P	03046288	16,4 *0.646*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1650-071-18R1-P	03046289	16,5 *0.650*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1667-071-18R1-P	03120499	16,669 *0.656*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1670-071-18R1-P	03046291	16,7 *0.657*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1675-071-18R1-P	03046292	16,75 *0.659*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1680-071-18R1-P	03046293	16,8 *0.661*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1690-071-18R1-P	03046294	16,9 *0.665*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1700-071-18R1-P	03046296	17,0 *0.669*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1710-071-18R1-P	03046297	17,1 *0.673*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1720-071-18R1-P	03046298	17,2 *0.677*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1730-071-18R1-P	03046299	17,3 *0.681*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1746-071-18R1-P	03120500	17,463 *0.688*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1750-071-18R1-P	03046301	17,5 *0.689*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1760-071-18R1-P	03046302	17,6 *0.693*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1780-071-18R1-P	03046304	17,8 *0.701*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1790-071-18R1-P	03046305	17,9 *0.705*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9
SD205A-1800-071-18R1-P	03046306	18,0 *0.709*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-1820-077-20R1-P	03046308	18,2 *0.717*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1850-077-20R1-P	03046311	18,5 *0.728*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1880-077-20R1-P	03046314	18,8 *0.740*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1890-077-20R1-P	03046315	18,9 *0.744*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1900-077-20R1-P	03046316	19,0 *0.748*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1905-077-20R1-P	03046353	19,05 *0.750*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1910-077-20R1-P	03046317	19,1 *0.752*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1930-077-20R1-P	03046319	19,3 *0.760*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1950-077-20R1-P	03046321	19,5 *0.768*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1980-077-20R1-P	03046324	19,8 *0.780*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1990-077-20R1-P	03046325	19,9 *0.783*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-2000-077-20R1-P	03046326	20,0 *0.787*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9

SD206

Bohrtiefe ca. 6 x D – Metrisch/Zoll

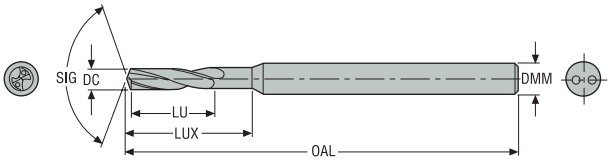


–Zylinderschaft
–Äußere Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 146

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD206-0.70-4.2-3R1	02731644	0,7 *0.028*	4,2 *0.165*	38,0 *1.496*	6,0 *0.236*	3,0 *0.118*	140°	TiAlN	IT9
SD206-0.80-4.8-3R1	02731645	0,8 *0.031*	4,8 *0.189*	38,0 *1.496*	6,7 *0.264*	3,0 *0.118*	140°	TiAlN	IT9
SD206-0.90-5.4-3R1	02731646	0,9 *0.035*	5,4 *0.213*	38,0 *1.496*	7,8 *0.307*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.00-6.0-3R1	02731647	1,0 *0.039*	6,0 *0.236*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.10-6.6-3R1	02731648	1,1 *0.043*	6,6 *0.260*	38,0 *1.496*	8,6 *0.339*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.20-7.2-3R1	02731649	1,2 *0.047*	7,2 *0.283*	38,0 *1.496*	9,2 *0.362*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.30-7.8-3R1	02731650	1,3 *0.051*	7,8 *0.307*	38,0 *1.496*	9,8 *0.386*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.40-8.4-3R1	02731651	1,4 *0.055*	8,4 *0.331*	38,0 *1.496*	10,4 *0.409*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.50-9.0-3R1	02731652	1,5 *0.059*	9,0 *0.354*	38,0 *1.496*	11,0 *0.433*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.60-9.6-3R1	02731653	1,6 *0.063*	9,6 *0.378*	38,0 *1.496*	11,6 *0.457*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.70-10.2-3R1	02731654	1,7 *0.067*	10,2 *0.402*	38,0 *1.496*	12,2 *0.480*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.80-10.8-3R1	02731655	1,8 *0.071*	10,8 *0.425*	38,0 *1.496*	12,8 *0.504*	3,0 *0.118*	140°	TiAlN	IT9
SD206-1.90-11.4-3R1	02731656	1,9 *0.075*	11,4 *0.449*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	140°	TiAlN	IT9
SD206-2.00-12.0-3R1	02731657	2,0 *0.079*	12,0 *0.472*	50,0 *1.969*	14,0 *0.551*	3,0 *0.118*	140°	TiAlN	IT9

SD206A

Bohrtiefe ca. 6 x D – Metrisch/Zoll

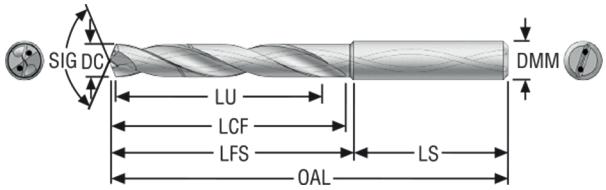


–Zylinderschaft
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 147

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD206A-1.00-6.0-3R1	02731658	1,0 *0.039*	6,0 *0.236*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.10-6.6-3R1	02731659	1,1 *0.043*	6,6 *0.260*	38,0 *1.496*	8,6 *0.339*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.20-7.2-3R1	02731660	1,2 *0.047*	7,2 *0.283*	38,0 *1.496*	9,2 *0.362*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.30-7.8-3R1	02731661	1,3 *0.051*	7,8 *0.307*	38,0 *1.496*	9,8 *0.386*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.40-8.4-3R1	02731662	1,4 *0.055*	8,4 *0.331*	38,0 *1.496*	10,4 *0.409*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.50-9.0-3R1	02731663	1,5 *0.059*	9,0 *0.354*	38,0 *1.496*	11,0 *0.433*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.60-9.6-3R1	02731664	1,6 *0.063*	9,6 *0.378*	38,0 *1.496*	11,6 *0.457*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.70-10.2-3R1	02731665	1,7 *0.067*	10,2 *0.402*	38,0 *1.496*	12,2 *0.480*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.80-10.8-3R1	02731666	1,8 *0.071*	10,8 *0.425*	38,0 *1.496*	12,8 *0.504*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-1.90-11.4-3R1	02731667	1,9 *0.075*	11,4 *0.449*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	140°	TiAlN	IT9
SD206A-2.00-12.0-3R1	02731668	2,0 *0.079*	12,0 *0.472*	50,0 *1.969*	14,0 *0.551*	3,0 *0.118*	140°	TiAlN	IT9

SD207A-P

Bohrtiefe ca. 7 x D – Metrisch/Zoll



—Zylinderschaft DIN 6537A
—Kühlmittelzufuhr
—Schnittdaten siehe Seite(n) 148
—Zwischendurchmesser siehe MyDesign-Software

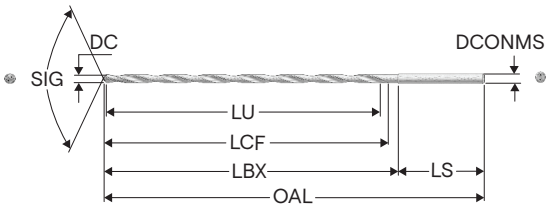
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD207A-0300-030-06R1-P	03046358	3,0 *0.118*	30,0 *1.181*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0330-030-06R1-P	03046359	3,3 *0.130*	30,0 *1.181*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0350-030-06R1-P	03046360	3,5 *0.138*	30,0 *1.181*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	36,0 *1.417*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0400-037-06R1-P	03046361	4,0 *0.157*	37,0 *1.457*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	43,0 *1.693*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0450-037-06R1-P	03046412	4,5 *0.177*	37,0 *1.457*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	43,0 *1.693*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0480-045-06R1-P	03046413	4,8 *0.189*	45,0 *1.772*	94,0 *3.701*	58,0 *2.283*	36,0 *1.417*	56,0 *2.205*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0500-045-06R1-P	03046414	5,0 *0.197*	45,0 *1.772*	94,0 *3.701*	58,0 *2.283*	36,0 *1.417*	56,0 *2.205*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0520-045-06R1-P	03046362	5,2 *0.205*	45,0 *1.772*	94,0 *3.701*	58,0 *2.283*	36,0 *1.417*	56,0 *2.205*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0550-045-06R1-P	03046363	5,5 *0.217*	45,0 *1.772*	94,0 *3.701*	58,0 *2.283*	36,0 *1.417*	56,0 *2.205*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0580-045-06R1-P	03046407	5,8 *0.228*	45,0 *1.772*	94,0 *3.701*	58,0 *2.283*	36,0 *1.417*	56,0 *2.205*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0600-045-06R1-P	03046364	6,0 *0.236*	45,0 *1.772*	94,0 *3.701*	58,0 *2.283*	36,0 *1.417*	56,0 *2.205*	6,0 *0.236*	140°	TiAlN	IT9
SD207A-0635-057-08R1-P	03046365	6,35 *0.250*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	67,0 *2.638*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0650-057-08R1-P	03046366	6,5 *0.256*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	67,0 *2.638*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0680-057-08R1-P	03046367	6,8 *0.268*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	67,0 *2.638*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0690-057-08R1-P	03046368	6,9 *0.272*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	67,0 *2.638*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0700-057-08R1-P	03046369	7,0 *0.276*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	67,0 *2.638*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0750-057-08R1-P	03046370	7,5 *0.295*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	72,0 *2.835*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0780-057-08R1-P	03046371	7,8 *0.307*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	72,0 *2.835*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0800-057-08R1-P	03046372	8,0 *0.315*	57,0 *2.244*	110,0 *4.331*	74,0 *2.913*	36,0 *1.417*	72,0 *2.835*	8,0 *0.315*	140°	TiAlN	IT9
SD207A-0850-062-10R1-P	03046373	8,5 *0.335*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0860-062-10R1-P	03046374	8,6 *0.339*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0870-062-10R1-P	03046411	8,7 *0.343*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0880-062-10R1-P	03046408	8,8 *0.346*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0900-062-10R1-P	03046375	9,0 *0.354*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0950-062-10R1-P	03046376	9,5 *0.374*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD207A-0953-062-10R1-P	03046377	9,525 *0.375*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0975-062-10R1-P	03046402	9,75 *0.384*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-0980-062-10R1-P	03046403	9,8 *0.386*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-1000-062-10R1-P	03046378	10,0 *0.394*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9
SD207A-1020-072-12R1-P	03046379	10,2 *0.402*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1040-072-12R1-P	03046401	10,4 *0.409*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1050-072-12R1-P	03046380	10,5 *0.413*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1080-072-12R1-P	03046404	10,8 *0.425*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1100-072-12R1-P	03046381	11,0 *0.433*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1150-072-12R1-P	03046382	11,5 *0.453*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1180-072-12R1-P	03046405	11,8 *0.465*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1200-072-12R1-P	03046383	12,0 *0.472*	72,0 *2.835*	141,0 *5.551*	96,0 *3.780*	45,0 *1.772*	94,0 *3.701*	12,0 *0.472*	140°	TiAlN	IT9
SD207A-1225-083-14R1-P	03046415	12,25 *0.482*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1250-083-14R1-P	03046384	12,5 *0.492*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1270-083-14R1-P	03046385	12,7 *0.500*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1280-083-14R1-P	03046416	12,8 *0.504*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1300-083-14R1-P	03046386	13,0 *0.512*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1350-083-14R1-P	03046387	13,5 *0.531*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1380-083-14R1-P	03046409	13,8 *0.543*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1400-083-14R1-P	03046388	14,0 *0.551*	83,0 *3.268*	155,0 *6.102*	110,0 *4.331*	45,0 *1.772*	108,0 *4.252*	14,0 *0.551*	140°	TiAlN	IT9
SD207A-1425-092-16R1-P	03046417	14,25 *0.561*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1450-092-16R1-P	03046389	14,5 *0.571*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1480-092-16R1-P	03046418	14,8 *0.583*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1500-092-16R1-P	03046390	15,0 *0.591*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1550-092-16R1-P	03046391	15,5 *0.610*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1580-092-16R1-P	03046410	15,8 *0.622*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1600-092-16R1-P	03046392	16,0 *0.630*	92,0 *3.622*	171,0 *6.732*	123,0 *4.843*	48,0 *1.890*	121,0 *4.764*	16,0 *0.630*	140°	TiAlN	IT9
SD207A-1650-103-18R1-P	03046393	16,5 *0.650*	103,0 *4.055*	185,0 *7.283*	137,0 *5.394*	48,0 *1.890*	135,0 *5.315*	18,0 *0.709*	140°	TiAlN	IT9
SD207A-1680-103-18R1-P	03046419	16,8 *0.661*	103,0 *4.055*	185,0 *7.283*	137,0 *5.394*	48,0 *1.890*	135,0 *5.315*	18,0 *0.709*	140°	TiAlN	IT9
SD207A-1700-103-18R1-P	03046394	17,0 *0.669*	103,0 *4.055*	185,0 *7.283*	137,0 *5.394*	48,0 *1.890*	135,0 *5.315*	18,0 *0.709*	140°	TiAlN	IT9
SD207A-1750-103-18R1-P	03046395	17,5 *0.689*	103,0 *4.055*	185,0 *7.283*	137,0 *5.394*	48,0 *1.890*	135,0 *5.315*	18,0 *0.709*	140°	TiAlN	IT9
SD207A-1780-103-18R1-P	03046420	17,8 *0.701*	103,0 *4.055*	185,0 *7.283*	137,0 *5.394*	48,0 *1.890*	135,0 *5.315*	18,0 *0.709*	140°	TiAlN	IT9
SD207A-1800-103-18R1-P	03046396	18,0 *0.709*	103,0 *4.055*	185,0 *7.283*	137,0 *5.394*	48,0 *1.890*	135,0 *5.315*	18,0 *0.709*	140°	TiAlN	IT9
SD207A-1850-112-20R1-P	03046397	18,5 *0.728*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-1880-112-20R1-P	03046421	18,8 *0.740*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD207A-1900-112-20R1-P	03046398	19,0 *0.748*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-1905-112-20R1-P	03046399	19,05 *0.750*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-1980-112-20R1-P	03046406	19,8 *0.780*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-2000-112-20R1-P	03046400	20,0 *0.787*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9

SD2016A

Bohrtiefe ca. 16 x D – Metrisch/Zoll

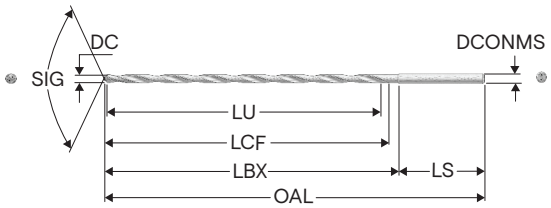


–Zylinderschaft DIN 6537A
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 149
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DCONMS	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2016A-0300-050-04R1	10307340	3,0 *0.118*	50 *1.969*	56,0 *2.205*	61,0 *2.402*	88,0 *3.465*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2016A-0350-060-04R1	10307341	3,5 *0.138*	60 *2.362*	67,0 *2.638*	72,0 *2.835*	99,0 *3.898*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2016A-0400-060-04R1	10307342	4,0 *0.157*	60 *2.362*	67,0 *2.638*	72,0 *2.835*	99,0 *3.898*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2016A-0450-070-06R1	10307343	4,5 *0.177*	70 *2.756*	79,0 *3.110*	81,0 *3.189*	117,0 *4.606*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2016A-0500-090-06R1	10307344	5,0 *0.197*	90 *3.543*	103,0 *4.055*	106,0 *4.173*	142,0 *5.591*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2016A-0550-090-06R1	10307345	5,5 *0.217*	90 *3.543*	103,0 *4.055*	106,0 *4.173*	142,0 *5.591*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2016A-0600-090-06R1	10307346	6,0 *0.236*	90 *3.543*	103,0 *4.055*	106,0 *4.173*	142,0 *5.591*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2016A-0635-120-08R1	10307348	6,35 *0.250*	120 *4.724*	137,0 *5.394*	141,0 *5.551*	177,0 *6.969*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2016A-0650-120-08R1	10307347	6,5 *0.256*	120 *4.724*	137,0 *5.394*	141,0 *5.551*	177,0 *6.969*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2016A-0700-120-08R1	10307349	7,0 *0.276*	120 *4.724*	137,0 *5.394*	141,0 *5.551*	177,0 *6.969*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2016A-0750-120-08R1	10307350	7,5 *0.295*	120 *4.724*	137,0 *5.394*	141,0 *5.551*	177,0 *6.969*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2016A-0794-120-08R1	10307351	7,94 *0.313*	120 *4.724*	137,0 *5.394*	141,0 *5.551*	177,0 *6.969*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2016A-0800-120-08R1	10307352	8,0 *0.315*	120 *4.724*	137,0 *5.394*	141,0 *5.551*	177,0 *6.969*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2016A-0850-150-10R1	10307353	8,5 *0.335*	150 *5.906*	172,0 *6.772*	176,0 *6.929*	216,0 *8.504*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2016A-0900-150-10R1	10307354	9,0 *0.354*	150 *5.906*	172,0 *6.772*	176,0 *6.929*	216,0 *8.504*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2016A-0950-150-10R1	10307355	9,5 *0.374*	150 *5.906*	172,0 *6.772*	176,0 *6.929*	216,0 *8.504*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2016A-0952-150-10R1	10307356	9,52 *0.375*	150 *5.906*	172,0 *6.772*	176,0 *6.929*	216,0 *8.504*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2016A-1000-150-10R1	10307357	10,0 *0.394*	150 *5.906*	172,0 *6.772*	176,0 *6.929*	216,0 *8.504*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2016A-1050-180-12R1	10307358	10,5 *0.413*	180 *7.087*	207,0 *8.150*	211,0 *8.307*	256,0 *10.079*	45,0 *1.772*	12,0 *0.472*	136°	TiAlN + TiN	IT9
SD2016A-1100-180-12R1	10307359	11,0 *0.433*	180 *7.087*	207,0 *8.150*	211,0 *8.307*	256,0 *10.079*	45,0 *1.772*	12,0 *0.472*	136°	TiAlN + TiN	IT9
SD2016A-1150-180-12R1	10307360	11,5 *0.453*	180 *7.087*	207,0 *8.150*	211,0 *8.307*	256,0 *10.079*	45,0 *1.772*	12,0 *0.472*	136°	TiAlN + TiN	IT9
SD2016A-1200-180-12R1	10307361	12,0 *0.472*	180 *7.087*	207,0 *8.150*	211,0 *8.307*	256,0 *10.079*	45,0 *1.772*	12,0 *0.472*	136°	TiAlN + TiN	IT9

SD2020A

Bohrtiefe ca. 20 x D – Metrisch/Zoll

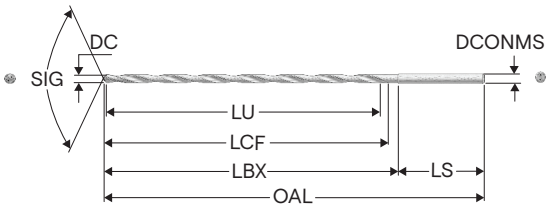


—Zylinderschaft DIN 6537A
—Kühlmittelzufuhr
—Schnittdaten siehe Seite(n) 149
—Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DCONMS	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2020A-0300-063-04R1	10307362	3,0 *0.118*	63 *2.480*	69,0 *2.717*	74,0 *2.913*	101,0 *3.976*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2020A-0350-070-04R1	10307363	3,5 *0.138*	70 *2.756*	82,0 *3.228*	87,0 *3.425*	114,0 *4.488*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2020A-0400-070-04R1	10307364	4,0 *0.157*	70 *2.756*	82,0 *3.228*	87,0 *3.425*	114,0 *4.488*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2020A-0450-090-06R1	10307365	4,5 *0.177*	90 *3.543*	98,0 *3.858*	102,0 *4.016*	138,0 *5.433*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2020A-0500-110-06R1	10307366	5,0 *0.197*	110 *4.331*	120,0 *4.724*	124,0 *4.882*	160,0 *6.299*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2020A-0550-110-06R1	10307367	5,5 *0.217*	110 *4.331*	120,0 *4.724*	124,0 *4.882*	160,0 *6.299*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2020A-0600-110-06R1	10307368	6,0 *0.236*	110 *4.331*	120,0 *4.724*	124,0 *4.882*	160,0 *6.299*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2020A-0635-145-08R1	10307370	6,35 *0.250*	145 *5.709*	159,0 *6.260*	163,0 *6.417*	199,0 *7.835*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2020A-0650-145-08R1	10307369	6,5 *0.256*	145 *5.709*	159,0 *6.260*	163,0 *6.417*	199,0 *7.835*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2020A-0700-145-08R1	10307371	7,0 *0.276*	145 *5.709*	159,0 *6.260*	163,0 *6.417*	199,0 *7.835*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2020A-0750-145-08R1	10307372	7,5 *0.295*	145 *5.709*	159,0 *6.260*	163,0 *6.417*	199,0 *7.835*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2020A-0794-145-08R1	10307373	7,94 *0.313*	145 *5.709*	159,0 *6.260*	163,0 *6.417*	199,0 *7.835*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2020A-0800-145-08R1	10307374	8,0 *0.315*	145 *5.709*	159,0 *6.260*	163,0 *6.417*	199,0 *7.835*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2020A-0850-185-10R1	10307375	8,5 *0.335*	185 *7.283*	202,0 *7.953*	206,0 *8.110*	246,0 *9.685*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2020A-0900-185-10R1	10307376	9,0 *0.354*	185 *7.283*	202,0 *7.953*	206,0 *8.110*	246,0 *9.685*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2020A-0950-185-10R1	10307377	9,5 *0.374*	185 *7.283*	202,0 *7.953*	206,0 *8.110*	246,0 *9.685*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2020A-0952-185-10R1	10307378	9,52 *0.375*	185 *7.283*	202,0 *7.953*	206,0 *8.110*	246,0 *9.685*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2020A-1000-185-10R1	10307379	10,0 *0.394*	185 *7.283*	202,0 *7.953*	206,0 *8.110*	246,0 *9.685*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9

SD2025A

Bohrtiefe ca. 25 x D– Metrisch/Zoll



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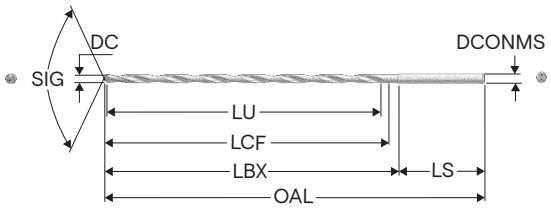
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DCONMS	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2025A-0300-079-04R1	10307380	3,0 *0.118*	79 *3.110*	85,0 *3.346*	90,0 *3.543*	117,0 *4.606*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2025A-0400-094-04R1	10307381	4,0 *0.157*	94 *3.701*	101,0 *3.976*	106,0 *4.173*	133,0 *5.236*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2025A-0450-112-06R1	10307382	4,5 *0.177*	112 *4.409*	121,0 *4.764*	124,0 *4.882*	160,0 *6.299*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2025A-0500-140-06R1	10307383	5,0 *0.197*	140 *5.512*	151,0 *5.945*	154,0 *6.063*	190,0 *7.480*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2025A-0550-140-06R1	10307384	5,5 *0.217*	140 *5.512*	151,0 *5.945*	154,0 *6.063*	190,0 *7.480*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2025A-0600-140-06R1	10307385	6,0 *0.236*	140 *5.512*	151,0 *5.945*	154,0 *6.063*	190,0 *7.480*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2025A-0635-188-08R1	10307387	6,35 *0.250*	188 *7.402*	202,0 *7.953*	205,0 *8.071*	241,0 *9.488*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2025A-0650-188-08R1	10307386	6,5 *0.256*	188 *7.402*	202,0 *7.953*	205,0 *8.071*	241,0 *9.488*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2025A-0700-188-08R1	10307388	7,0 *0.276*	188 *7.402*	202,0 *7.953*	205,0 *8.071*	241,0 *9.488*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2025A-0750-188-08R1	10307389	7,5 *0.295*	188 *7.402*	202,0 *7.953*	205,0 *8.071*	241,0 *9.488*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2025A-0794-188-08R1	10307390	7,94 *0.313*	188 *7.402*	202,0 *7.953*	205,0 *8.071*	241,0 *9.488*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2025A-0800-188-08R1	10307391	8,0 *0.315*	188 *7.402*	202,0 *7.953*	205,0 *8.071*	241,0 *9.488*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2025A-0850-234-10R1	10307392	8,5 *0.335*	234 *9.213*	252,0 *9.921*	255,0 *10.039*	295,0 *11.614*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2025A-0900-234-10R1	10307393	9,0 *0.354*	234 *9.213*	252,0 *9.921*	255,0 *10.039*	295,0 *11.614*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2025A-0950-234-10R1	10307395	9,5 *0.374*	234 *9.213*	252,0 *9.921*	255,0 *10.039*	295,0 *11.614*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2025A-0952-234-10R1	10307396	9,52 *0.375*	234 *9.213*	252,0 *9.921*	255,0 *10.039*	295,0 *11.614*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2025A-1000-234-10R1	10307397	10,0 *0.394*	234 *9.213*	252,0 *9.921*	255,0 *10.039*	295,0 *11.614*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9

SD2030A

Bohrtiefe ca. 30 x D – Metrisch/Zoll



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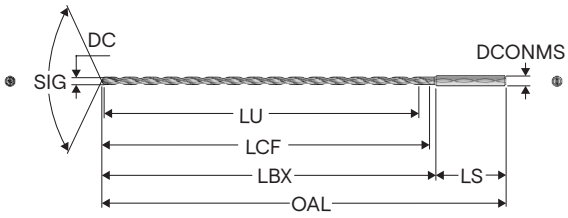
—Schnittdaten siehe Seite(n) 149
—Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DCONMS	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2030A-0300-095-04R1	10307398	3,0 *0.118*	95 *3.740*	101,0 *3.976*	106,0 *4.173*	133,0 *5.236*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2030A-0400-112-04R1	10307399	4,0 *0.157*	112 *4.409*	119,0 *4.685*	124,0 *4.882*	151,0 *5.945*	27,0 *1.063*	4,0 *0.157*	136°	TiAlN + TiN	IT9
SD2030A-0450-135-06R1	10307400	4,5 *0.177*	135 *5.315*	145,0 *5.709*	149,0 *5.866*	185,0 *7.283*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2030A-0500-170-06R1	10307401	5,0 *0.197*	170 *6.693*	180,0 *7.087*	184,0 *7.244*	220,0 *8.661*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2030A-0550-170-06R1	10307402	5,5 *0.217*	170 *6.693*	180,0 *7.087*	184,0 *7.244*	220,0 *8.661*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2030A-0600-170-06R1	10307403	6,0 *0.236*	170 *6.693*	180,0 *7.087*	184,0 *7.244*	220,0 *8.661*	36,0 *1.417*	6,0 *0.236*	136°	TiAlN + TiN	IT9
SD2030A-0635-225-08R1	10307405	6,35 *0.250*	225 *8.858*	239,0 *9.409*	243,0 *9.567*	279,0 *10.984*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2030A-0650-225-08R1	10307404	6,5 *0.256*	225 *8.858*	239,0 *9.409*	243,0 *9.567*	279,0 *10.984*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2030A-0700-225-08R1	10307406	7,0 *0.276*	225 *8.858*	239,0 *9.409*	243,0 *9.567*	279,0 *10.984*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2030A-0750-225-08R1	10307407	7,5 *0.295*	225 *8.858*	239,0 *9.409*	243,0 *9.567*	279,0 *10.984*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2030A-0794-225-08R1	10307408	7,94 *0.313*	225 *8.858*	239,0 *9.409*	243,0 *9.567*	279,0 *10.984*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2030A-0800-225-08R1	10307409	8,0 *0.315*	225 *8.858*	239,0 *9.409*	243,0 *9.567*	279,0 *10.984*	36,0 *1.417*	8,0 *0.315*	136°	TiAlN + TiN	IT9
SD2030A-0850-285-10R1	10307410	8,5 *0.335*	285 *11.220*	302,0 *11.890*	306,0 *12.047*	346,0 *13.622*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2030A-0900-285-10R1	10307411	9,0 *0.354*	285 *11.220*	302,0 *11.890*	306,0 *12.047*	346,0 *13.622*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2030A-0950-285-10R1	10307412	9,5 *0.374*	285 *11.220*	302,0 *11.890*	306,0 *12.047*	346,0 *13.622*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2030A-0952-285-10R1	10307413	9,52 *0.375*	285 *11.220*	302,0 *11.890*	306,0 *12.047*	346,0 *13.622*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9
SD2030A-1000-285-10R1	10307414	10,0 *0.394*	285 *11.220*	302,0 *11.890*	306,0 *12.047*	346,0 *13.622*	40,0 *1.575*	10,0 *0.394*	136°	TiAlN + TiN	IT9

SD2040A

Bohrtiefe ca. 40 x D – Metrisch/Zoll



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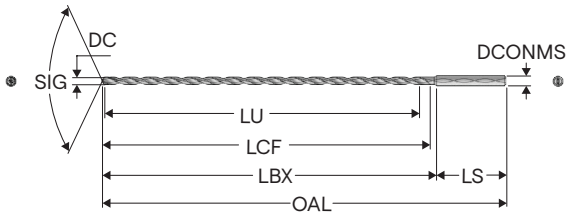
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 150
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2040A-0300-120-04R1	10143441	3,0 *0.118*	120 *4.724*	128,0 –	130,0 *5.118*	157,0 *6.181*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9-10
SD2040A-0400-160-04R1	10143442	4,0 *0.157*	160 *6.299*	169,0 –	142,0 *5.591*	198,0 *7.795*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9-10
SD2040A-0450-180-06R1	10143443	4,5 *0.177*	180 *7.087*	190,0 –	202,0 *7.953*	238,0 *9.370*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9-10
SD2040A-0500-200-06R1	10143444	5,0 *0.197*	200 *7.874*	210,5 –	213,0 *8.386*	249,0 *9.803*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9-10
SD2040A-0600-240-06R1	10143445	6,0 *0.236*	240 *9.449*	252,0 –	254,0 *10.000*	290,0 *11.417*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9-10
SD2040A-0635-254-08R1	10143446	6,35 *0.250*	254 *10.000*	266,5 –	275,0 *10.827*	311,0 *12.244*	36,0 *1.417*	8,0 *0.315*	133°	TiAlN + TiN	IT9-10
SD2040A-0650-260-08R1	10143447	6,5 *0.256*	260 *10.236*	273,0 –	275,0 *10.827*	311,0 *12.244*	36,0 *1.417*	8,0 *0.315*	133°	TiAlN + TiN	IT9-10
SD2040A-0700-280-08R1	10143448	7,0 *0.276*	280 *11.024*	293,5 –	296,0 *11.654*	332,0 *13.071*	36,0 *1.417*	8,0 *0.315*	133°	TiAlN + TiN	IT9-10
SD2040A-0750-300-08R1	10143449	7,5 *0.295*	300 *11.811*	314,0 –	316,0 *12.441*	352,0 *13.858*	36,0 *1.417*	8,0 *0.315*	133°	TiAlN + TiN	IT9-10
SD2040A-0800-320-08R1	10143450	8,0 *0.315*	320 *12.598*	335,0 –	337,0 *13.268*	373,0 *14.685*	36,0 *1.417*	8,0 *0.315*	133°	TiAlN + TiN	IT9-10

SD2050A

Bohrtiefe ca. 50 x D – Metrisch/Zoll



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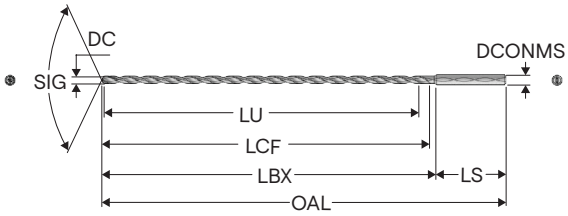
—Schnittdaten siehe Seite(n) 150
—Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2050A-0300-150-04R1	10188284	3,0 *0.118*	150 *5.906*	157,5 –	161,0 *6.339*	188,0 *7.402*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9
SD2050A-0400-200-04R1	10188285	4,0 *0.157*	200 *7.874*	209,0 –	213,0 *8.386*	240,0 *9.449*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9
SD2050A-0450-225-06R1	10188286	4,5 *0.177*	225 *8.858*	234,75 –	252,0 *9.921*	288,0 *11.339*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9
SD2050A-0500-250-06R1	10188287	5,0 *0.197*	250 *9.843*	260,5 –	264,0 *10.394*	300,0 *11.811*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9
SD2050A-0600-300-06R1	10188288	6,0 *0.236*	300 *11.811*	312,0 –	316,0 *12.441*	352,0 *13.858*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9
SD2050A-0635-318-08R1	10188289	6,35 *0.250*	318 *12.520*	330,5 –	337,0 *13.268*	373,0 *14.685*	36,0 *1.417*	8,0 *0.315*	133°	TiAlN + TiN	IT9

SD2060A

Bohrtiefe ca. 60 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 150
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LCF	LB	OAL	LS	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD2060A-0300-180-04R1	10188290	3,0 *0.118*	180 *7.087*	187,5 –	191,0 *7.520*	218,0 *8.583*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9
SD2060A-0400-240-04R1	10188291	4,0 *0.157*	240 *9.449*	249,0 –	253,0 *9.961*	280,0 *11.024*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9
SD2060A-0450-270-06R1	10188292	4,5 *0.177*	270 *10.630*	280,0 –	283,0 *11.142*	319,0 *12.559*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9
SD2060A-0500-300-06R1	10188293	5,0 *0.197*	300 *11.811*	310,5 –	314,0 *12.362*	350,0 *13.780*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9

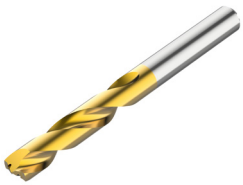
Feedmax™ SD245A

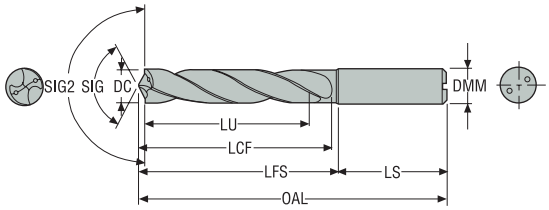
Seco Feedmax SD245A Vollhartmetallbohrer sorgen für mehr Stabilität und verbesserte Zerspanungsleistung bei Bohrungsbearbeitungen mit ungleichmäßigen Austritten und unterbrochenen Schnitten. Die folgenden Merkmale führen zu hoher Bohrungsqualität:

- 4 Führungsfasen
- Optimierte Selbstzentrierung
- Hochverschleißfeste TiAlN+TiN-Beschichtung
- Verbesserte Schneidkantenausführung

SD245A

Bohrtiefe ca. 5 x D – Metrisch/Zoll





–Zylinderschaft DIN 6537A
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 151
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD245A-5.0-32-6R1	02691683	5,0 *0.197*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°/180°	TiAlN + TiN	IT8
SD245A-6.0-32-6R1	02691684	6,0 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°/180°	TiAlN + TiN	IT8
SD245A-02500-138-0315R1	02691686	6,35 *0.250*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-6.5-35-8R1	02691687	6,5 *0.256*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-02656-157-0315R1	02691688	6,747 *0.2656*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-6.8-40-8R1	02691689	6,8 *0.268*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-7.0-40-8R1	02691690	7,0 *0.276*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-02813-157-0315R1	02691691	7,144 *0.2813*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-7.5-40-8R1	02691692	7,5 *0.295*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-03125-165-0315R1	02691693	7,938 *0.3125*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-8.0-42-8R1	02691694	8,0 *0.315*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°/180°	TiAlN + TiN	IT8
SD245A-8.5-42-10R1	02691695	8,5 *0.335*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°/180°	TiAlN + TiN	IT8
SD245A-9.0-45-10R1	02546059	9,0 *0.354*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°/180°	TiAlN + TiN	IT8
SD245A-9.5-45-10R1	02691696	9,5 *0.374*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°/180°	TiAlN + TiN	IT8
SD245A-03750-189-0394R1	02691697	9,525 *0.3750*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°/180°	TiAlN + TiN	IT8
SD245A-10.0-48-10R1	02536888	10,0 *0.394*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°/180°	TiAlN + TiN	IT8
SD245A-10.2-48-12R1	02691699	10,2 *0.402*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°/180°	TiAlN + TiN	IT8
SD245A-04063-189-0472R1	02691700	10,319 *0.4063*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°/180°	TiAlN + TiN	IT8
SD245A-10.5-48-12R1	02691701	10,5 *0.413*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°/180°	TiAlN + TiN	IT8
SD245A-04375-221-0472R1	02691702	11,113 *0.4375*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°/180°	TiAlN + TiN	IT8
SD245A-11.5-56-12R1	02691704	11,5 *0.453*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°/180°	TiAlN + TiN	IT8
SD245A-12.0-56-12R1	02691705	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°/180°	TiAlN + TiN	IT8
SD245A-12.5-56-14R1	02691706	12,5 *0.492*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8
SD245A-0500-221-0551R1	02691707	12,7 *0.500*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8
SD245A-13.0-56-14R1	02691708	13,0 *0.512*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD245A-13.5-59-14R1	02691710	13,5 *0.5314*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8
SD245A-14.0-59-14R1	02691711	14,0 *0.551*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8

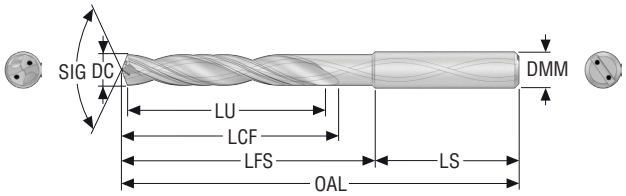
Feedmax™ SD265A

Die Hochpräzisionsbohrer SD265A IT 7 stehen für höchste Genauigkeit. Darüber hinaus kann ein Bohrer SD265A mehrere Werkzeuge ersetzen und komplexe Bohrungsbearbeitungen vereinfachen. Dank der folgenden Merkmale kann die Bohrung in einem Durchgang gefertigt werden:

- Optimierte Bohrungsgeometrie und selbstzentrierende Spitze
- 6 Führungsfasen
- Enge Herstellungstoleranzen (±3µ)
- TiAlN + TiN-Beschichtung für geringe Reibung und hohe Verschleißfestigkeit

SD265A

Bohrtiefe ca. 5 x D – Metrisch/Zoll



—Zylinderschaft DIN 6537A
—Kühlmittelzufuhr
—Schnittdaten siehe Seite(n) 152
—Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD265A-6.006-32-6R1	02691714	6,006 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT7
SD265A-02497-138-0315R1	02722876	6,35 *0.250*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT7
SD265A-03122-165-0315R1	02722877	7,938 *0.313*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT7
SD265A-8.008-42-8R1	02691715	8,008 *0.315*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT7
SD265A-03747-189-0394R1	02722878	9,525 *0.375*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT7
SD265A-10.008-48-10R1	02691716	10,008 *0.394*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT7
SD265A-12.009-56-12R1	02691717	12,009 *0.473*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT7
SD265A-04997-221-0551R1	02722879	12,7 *0.500*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT7
SD265A-14.009-59-14R1	02691718	14,009 *0.552*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT7
SD265A-16.009-62-16R1	02691719	16,009 *0.630*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT7

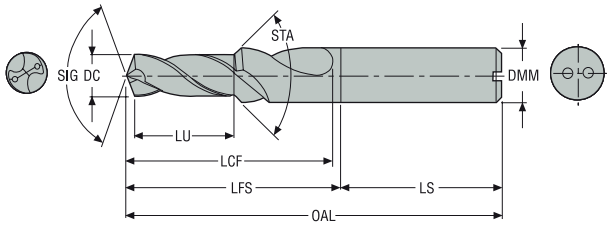
Feedmax™ – Fasbohrer

Mit Seco Feedmax™ werden Bohrungs- und Fasbearbeitungen in einem Schritt ausgeführt. Das erhöht die Effizienz deutlich. Die Produkte für vorbereitende Bearbeitungen sind im Standardprogramm enthalten und ab Lager verfügbar. Sie beinhalten metrische Standardgewinde von M4 bis M16.

- Spezielle Ausführung reduziert die Kosten pro Bohrung und erhöht die Produktivität
- Spezielle reibungsarme Beschichtung bietet hohe Warmhärte und exzellente Spanabfuhr
- Die selbstzentrierende Geometrie ermöglicht eine hohe Bohrungsqualität mittels eines 45° Faswinkels (90° eingeschlossener Winkel)

Fasbohrer – Gewinde M4–M16

Metrisch/Zoll

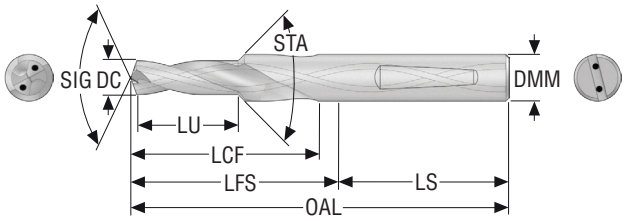


- Zylinderschaft DIN 6537A
- Kühlmittelzufuhr
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8-9
- Eingeschlossener Faswinkel = 90°
- Schnittdaten siehe Seite(n) 142, 143

Bezeichnung	Produkt-nummer	Gewindetyp	Gewinde Größe	DC	LU	OAL	LFS	LS	LCF	DMM
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-C45-3.3-11.4-6R1	02500320	Normale Steigung Metrisches Gewinde	M4	3,3 *0.130*	11,4 *0.449*	66,0 *2.598*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*
SD203A-C45-3.4-11.4-6R1	02500323	Normale Steigung Metrisches Gewinde	M4	3,4 *0.134*	11,4 *0.449*	66,0 *2.598*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*
SD203A-C45-4.2-13.6-6R1	02500324	Normale Steigung Metrisches Gewinde	M5	4,2 *0.165*	13,6 *0.535*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*
SD203A-C45-4.3-13.6-6R1	02500325	Normale Steigung Metrisches Gewinde	M5	4,3 *0.169*	13,6 *0.535*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*
SD203A-C45-5.0-16.5-8R1	02500326	Normale Steigung Metrisches Gewinde	M6	5,0 *0.197*	16,5 *0.650*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	28,0 *1.102*	8,0 *0.315*
SD203A-C45-5.1-16.5-8R1	02500327	Normale Steigung Metrisches Gewinde	M6	5,1 *0.201*	16,5 *0.650*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	28,0 *1.102*	8,0 *0.315*
SD203A-C45-6.8-21-10R1	02500328	Normale Steigung Metrisches Gewinde	M8	6,8 *0.268*	21,0 *0.827*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	34,0 *1.339*	10,0 *0.394*
SD203A-C45-6.9-21-10R1	02500330	Normale Steigung Metrisches Gewinde	M8	6,9 *0.272*	21,0 *0.827*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	34,0 *1.339*	10,0 *0.394*
SD203A-C45-7.0-21-10R1	02500331	Feingewinde Metrisches Gewinde	M8x1.0	7,0 *0.276*	21,0 *0.827*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	34,0 *1.339*	10,0 *0.394*
SD203A-C45-8.5-25.5-12R1	02500333	Normale Steigung Metrisches Gewinde	M10	8,5 *0.335*	25,5 *1.004*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	47,0 *1.850*	12,0 *0.472*
SD203A-C45-8.7-25.5-12R1	02500334	Normale Steigung Metrisches Gewinde	M10	8,7 *0.343*	25,5 *1.004*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	47,0 *1.850*	12,0 *0.472*
SD203A-C45-9.0-25.5-12R1	02500340	Feingewinde Metrisches Gewinde	M10x1.0	9,0 *0.354*	25,5 *1.004*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	47,0 *1.850*	12,0 *0.472*
SD203A-C45-10.2-30.0-14R1	02500342	Normale Steigung Metrisches Gewinde	M12	10,2 *0.402*	30,0 *1.181*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	55,0 *2.165*	14,0 *0.551*
SD203A-C45-10.4-30.0-14R1	02500343	Normale Steigung Metrisches Gewinde	M12	10,4 *0.409*	30,0 *1.181*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	55,0 *2.165*	14,0 *0.551*
SD203A-C45-10.5-30.0-14R1	02500344	Feingewinde Metrisches Gewinde	M12x1.5	10,5 *0.413*	34,5 *1.358*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	55,0 *2.165*	14,0 *0.551*
SD203A-C45-12.0-34.5-16R1	02500346	Normale Steigung Metrisches Gewinde	M14	12,0 *0.472*	34,5 *1.358*	115,0 *4.528*	70,0 *2.756*	45,0 *1.772*	60,0 *2.362*	16,0 *0.630*
SD203A-C45-12.25-34.5-16R1	02500348	Normale Steigung Metrisches Gewinde	M14	12,25 *0.482*	34,5 *1.358*	115,0 *4.528*	70,0 *2.756*	45,0 *1.772*	60,0 *2.362*	16,0 *0.630*
SD203A-C45-12.5-34.5-16R1	02500349	Feingewinde Metrisches Gewinde	M14x1.5	12,5 *0.492*	34,5 *1.358*	115,0 *4.528*	70,0 *2.756*	45,0 *1.772*	60,0 *2.362*	16,0 *0.630*
SD203A-C45-14.0-38.5-18R1	02500350	Normale Steigung Metrisches Gewinde	M16	14,0 *0.551*	38,5 *1.516*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	65,0 *2.559*	18,0 *0.709*
SD203A-C45-14.25-38.5-18R1	02500354	Normale Steigung Metrisches Gewinde	M16	14,25 *0.561*	38,5 *1.516*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	65,0 *2.559*	18,0 *0.709*

Fasbohrer – Gewinde M4–M16

Metrisch/Zoll

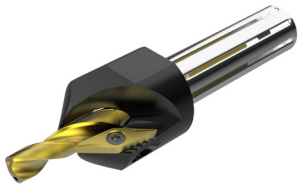


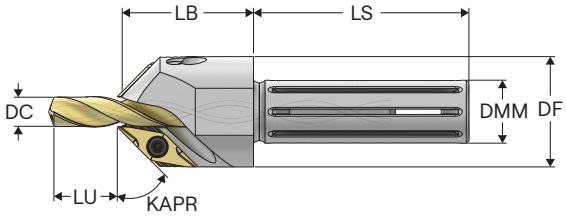
- Whistle Notch-Schaft DIN6537B
- Kühlmittelzufuhr
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8-9
- Eingeschlossener Faswinkel = 90°
- Schnittdaten siehe Seite(n) 142, 143

Bezeichnung	Produkt-nummer	Gewindetyp	Gewinde Größe	DC	LU	OAL	LFS	LS	LCF	DMM
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-C45-3.3-11.4-6R5	02500382	Normale Steigung Metrisches Gewinde	M4	3,3 *0.130*	11,4 *0.449*	66,0 *2.598*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*
SD203A-C45-3.4-11.4-6R5	02500383	Normale Steigung Metrisches Gewinde	M4	3,4 *0.134*	11,4 *0.449*	66,0 *2.598*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*
SD203A-C45-4.2-13.6-6R5	02500391	Normale Steigung Metrisches Gewinde	M5	4,2 *0.165*	13,6 *0.535*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*
SD203A-C45-4.3-13.6-6R5	02500392	Normale Steigung Metrisches Gewinde	M5	4,3 *0.169*	13,6 *0.535*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*
SD203A-C45-5.0-16.5-8R5	02500393	Normale Steigung Metrisches Gewinde	M6	5,0 *0.197*	16,5 *0.650*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	28,0 *1.102*	8,0 *0.315*
SD203A-C45-5.1-16.5-8R5	02500394	Normale Steigung Metrisches Gewinde	M6	5,1 *0.201*	16,5 *0.650*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	28,0 *1.102*	8,0 *0.315*
SD203A-C45-6.8-21.0-10R5	02500395	Normale Steigung Metrisches Gewinde	M8	6,8 *0.268*	21,0 *0.827*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	34,0 *1.339*	10,0 *0.394*
SD203A-C45-6.9-21.0-10R5	02500396	Normale Steigung Metrisches Gewinde	M8	6,9 *0.272*	21,0 *0.827*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	34,0 *1.339*	10,0 *0.394*
SD203A-C45-7.0-21.0-10R5	02500398	Feingewinde Metrisches Gewinde	M8x1.0	7,0 *0.276*	21,0 *0.827*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	34,0 *1.339*	10,0 *0.394*
SD203A-C45-8.5-25.5-12R5	02500401	Normale Steigung Metrisches Gewinde	M10	8,5 *0.335*	25,5 *1.004*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	47,0 *1.850*	12,0 *0.472*
SD203A-C45-8.7-25.5-12R5	02500403	Normale Steigung Metrisches Gewinde	M10	8,7 *0.343*	25,5 *1.004*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	47,0 *1.850*	12,0 *0.472*
SD203A-C45-9.0-25.5-12R5	02500410	Feingewinde Metrisches Gewinde	M10x1.0	9,0 *0.354*	25,5 *1.004*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	47,0 *1.850*	12,0 *0.472*
SD203A-C45-10.2-30.0-14R5	02500412	Normale Steigung Metrisches Gewinde	M12	10,2 *0.402*	30,0 *1.181*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	55,0 *2.165*	14,0 *0.551*
SD203A-C45-10.4-30.0-14R5	02500414	Normale Steigung Metrisches Gewinde	M12	10,4 *0.409*	30,0 *1.181*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	55,0 *2.165*	14,0 *0.551*
SD203A-C45-10.5-30.0-14R5	02500416	Feingewinde Metrisches Gewinde	M12x1.5	10,5 *0.413*	34,5 *1.358*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	55,0 *2.165*	14,0 *0.551*
SD203A-C45-12.0-34.5-16R5	02500417	Normale Steigung Metrisches Gewinde	M14	12,0 *0.472*	34,5 *1.358*	115,0 *4.528*	70,0 *2.756*	45,0 *1.772*	60,0 *2.362*	16,0 *0.630*
SD203A-C45-12.25-34.5-16R5	02500418	Normale Steigung Metrisches Gewinde	M14	12,25 *0.482*	34,5 *1.358*	115,0 *4.528*	70,0 *2.756*	45,0 *1.772*	60,0 *2.362*	16,0 *0.630*
SD203A-C45-12.5-34.5-16R5	02500420	Feingewinde Metrisches Gewinde	M14x1.5	12,5 *0.492*	34,5 *1.358*	115,0 *4.528*	70,0 *2.756*	45,0 *1.772*	60,0 *2.362*	16,0 *0.630*
SD203A-C45-14.0-38.5-18R5	02500423	Normale Steigung Metrisches Gewinde	M16	14,0 *0.551*	38,5 *1.516*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	65,0 *2.559*	18,0 *0.709*
SD203A-C45-14.25-38.5-18R5	02500424	Normale Steigung Metrisches Gewinde	M16	14,25 *0.561*	38,5 *1.516*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	65,0 *2.559*	18,0 *0.709*
SD203A-C45-14.5-38.5-18R5	02500425	Feingewinde Metrisches Gewinde	M16x1.5	14,5 *0.571*	38,5 *1.516*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	65,0 *2.559*	18,0 *0.709*

Fasringe für Universal- und Feedmax-Bohrer

Metrisch



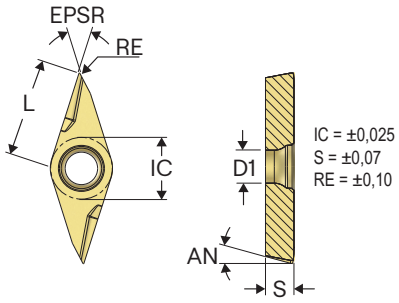


Bezeichnung	Produkt-nummer	DC	Bohrtiefe LU 3 x D (min-max)	5 x D (min-max)	7 x D (min-max)	Max. Fastiefe (mm)	LB	DF	LS	DMM	KAPR°
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
SD200-C45-6R1	02510275	4,01-6,1	4,0-17,0	10,0-27,0	30,0-45,0	2,8	25,0	21,0	41,0	12,0	45
SD200-C45-8R1	02510278	6,01-8,0	15,0-27,0	24,0-35,0	42,0-57,0	2,8	25,0	25,0	44,5	16,0	45
SD200-C45-10R1	02510280	8,01-10,0	17,0-31,0	34,0-48,0	47,0-62,0	2,8	25,0	25,0	44,5	16,0	45
SD200-C45-12R1	02510281	10,01-12,0	21,0-36,0	40,0-56,0	57,0-72,0	2,8	25,0	28,0	46,5	20,0	45
SD200-C45-14R1	02510283	12,01-14,0	22,0-37,0	43,0-59,0	68,0-83,0	2,8	25,0	30,0	46,5	20,0	45
SD200-C45-16R1	02510285	14,01-16,0	23,0-39,0	44,0-60,0	76,0-92,0	2,8	34,0	32,0	53,0	25,0	45

Ersatzteile, im Lieferumfang enthalten

Bohrer-durchmesser (mm)	Wendeplatten-Schlüssel	Schraube für WSP	Spannschlüssel	Spannschraube	Kassette
	Wendeplatte	Wendeplatte	Modul	Modul	Modul
4,00 - 16,00	T07P-2	C02205-T07P	H1.5-2D	SH3040	SD200-3X7.3

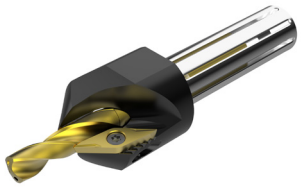
Wendeschneidplatte

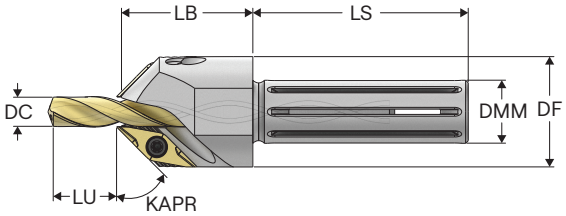


Größe	L mm	EPSR	RE mm	IC mm	D1 mm	AN	S mm
C45	9,000	45°	0,200	5,556	2,900	7°	2,500
Sorte: T400D							
Bezeichnung: SD200-C45							
Produktnummer: 02510325							

Fasringe für Universal- und Feedmax-Bohrer

Zoll



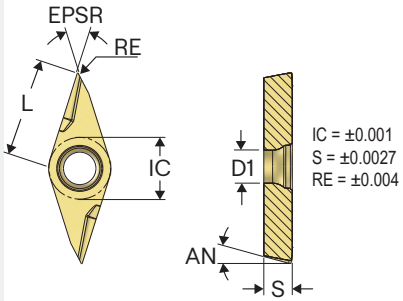


Bezeichnung	Produkt-nummer	DC	Bohrtiefe LU 3 x D (min-max)	Bohrtiefe LU 5 x D (min-max)	Bohrtiefe LU 7 x D (min-max)	Max. Fastiefe (mm)	DF	LB	LS	DMM	KAPR°
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	
SD200-C45-6-500R1	02510287	0.158-0.240	0.157-0.669	0.394-1.063	1.181-1.772	0.110	0.827	0.984	1.614	0.500	45
SD200-C45-8-625R1	02510289	0.237-0.315	0.591-1.063	0.945-1.378	1.654-2.244	0.110	0.984	0.984	1.752	0.625	45
SD200-C45-10-625R1	02510291	0.315-0.394	0.669-1.220	1.339-1.890	1.850-2.441	0.110	0.984	0.984	1.752	0.625	45
SD200-C45-12-750R1	02510292	0.394-0.472	0.827-1.417	1.575-2.205	2.244-2.835	0.110	1.102	0.984	1.831	0.750	45
SD200-C45-14-750R1	02510293	0.473-0.551	0.866-1.457	1.693-2.323	2.677-3.268	0.110	1.181	0.984	1.831	0.750	45
SD200-C45-16-1000R1	02510295	0.552-0.630	0.906-1.535	1.732-2.362	2.992-3.622	0.110	1.260	1.339	2.087	1.000	45

Ersatzteile, im Lieferumfang enthalten

Bohrerdurchmesser (Zoll)	Wendeplatten-Schlüssel	Schraube für WSP	Spannschlüssel	Kassette
	Wendeplatte	Wendeplatte	Modul	Modul
0.158 - 0.630	T07P-2	C02205-T07P	H1.5-2D	SD200-3X7.3

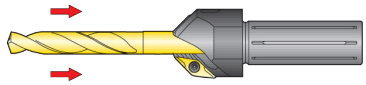
Wendeschneidplatte



Toleranzen: Zoll	Größe	L Zoll	EPSR	RE Zoll	IC Zoll	D1 Zoll	AN	S Zoll
	C45	0.3543	45°	0.0078	0.2187	0.1141	7°	0.0984
	Sorte: T400D							
	Bezeichnung: SD200-C45							
	Produktnummer: 02510325							

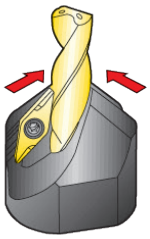
Montagehinweise für Fasringe

1.

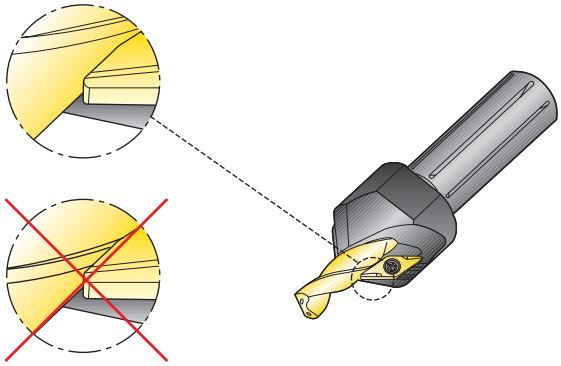


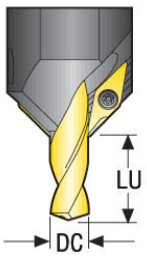
2.

3.

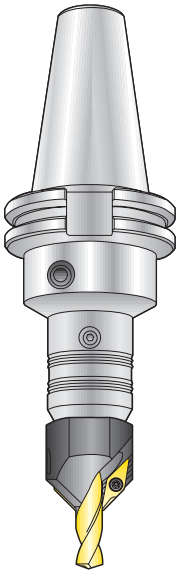


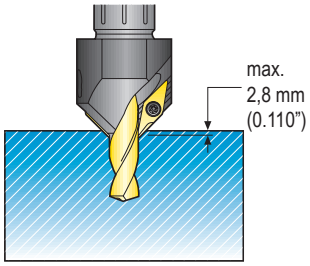
4.





Maximale Fastiefe



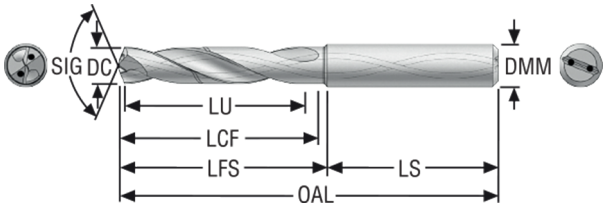


Bohrerdurchmesser DC		LU Bohrtiefe (min.-max.) SD1103 / SD203A		SD1105 / SD205A		SD207A	
mm	*Zoll*	mm	*Zoll*	mm	*Zoll*	mm	*Zoll*
4,00-4,75	*.157-.187*	4-17	*.157-.669*	10-27	*.394-1.063*	30-45	*1.181-1.772*
4,76-6,00	*.187-.236*	6-20	*.236-.787*	18-32	*.709-1.260*	30-45	*1.181-1.772*
6,01-8,00	*.241-.315*	15-27	*.590-1.063*	28-42	*1.102-1.653*	42-57	*1.653-2.244*
8,01-10,00	*.315-.394*	17-31	*.669-1.220*	34-48	*1.338-1.890*	47-62	*1.850-2.441*
10,01-12,00	*.394-.472*	21-36	*.826-1.417*	40-56	*1.575-2.205*	57-72	*2.244-2.835*
12,01-14,00	*.473-.551*	22-37	*.866-1.457*	43-59	*1.693-2.323*	68-83	*2.677-3.268*
14,01-16,00	*.552-.630*	23-39	*.906-1.535*	44-60	*1.732-2.362*	76-92	*2.992-3.622*

Nur mit zylindrischem Schaft (R1) verwenden.

SD203A, -MS

Bohrtiefe ca. 3 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 153-154
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0200-007-04R1-MS	10004064	2,0 *0.079*	7,0 *0.276*	41,0 *1.614*	14,0 *0.551*	27,0 *1.063*	11,0 *0.433*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0210-007-04R1-MS	10004065	2,1 *0.083*	7,0 *0.276*	41,0 *1.614*	14,0 *0.551*	27,0 *1.063*	11,0 *0.433*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0220-007-04R1-MS	10004066	2,2 *0.087*	7,0 *0.276*	41,0 *1.614*	14,0 *0.551*	27,0 *1.063*	11,0 *0.433*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0230-008-04R1-MS	10004067	2,3 *0.091*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0240-008-04R1-MS	10004068	2,4 *0.094*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0250-008-04R1-MS	10004072	2,5 *0.098*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0260-008-04R1-MS	10004073	2,6 *0.102*	8,0 *0.315*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	12,5 *0.492*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0270-009-04R1-MS	10004074	2,7 *0.106*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0278-009-04R1-MS	10004075	2,78 *0.109*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0290-009-04R1-MS	10004076	2,9 *0.114*	9,0 *0.354*	44,0 *1.732*	17,0 *0.669*	27,0 *1.063*	14,5 *0.571*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD203A-0300-014-06R1-MS	10004077	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0310-014-06R1-MS	10004078	3,1 *0.122*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0320-014-06R1-MS	10004079	3,2 *0.126*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0330-014-06R1-MS	10004080	3,3 *0.130*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0340-014-06R1-MS	10004081	3,4 *0.134*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0350-015-06R1-MS	10004083	3,5 *0.138*	15,0 *0.591*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0357-015-06R1-MS	10004084	3,57 *0.141*	15,0 *0.591*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0370-015-06R1-MS	10004085	3,7 *0.146*	15,0 *0.591*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0380-017-06R1-MS	10004086	3,8 *0.150*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0390-017-06R1-MS	10004087	3,9 *0.154*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0397-017-06R1-MS	10004088	3,97 *0.156*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0400-017-06R1-MS	10004089	4,0 *0.157*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0410-017-06R1-MS	10004090	4,1 *0.161*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0420-017-06R1-MS	10004091	4,2 *0.165*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0430-018-06R1-MS	10004092	4,3 *0.169*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9

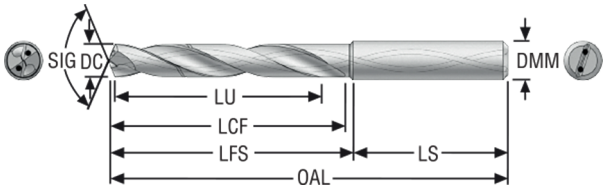
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0450-018-06R1-MS	10004093	4,5 *0.177*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0460-018-06R1-MS	10004094	4,6 *0.181*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0465-018-06R1-MS	10004095	4,65 *0.183*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0470-018-06R1-MS	10004096	4,7 *0.185*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0476-020-06R1-MS	10004097	4,76 *0.187*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0480-020-06R1-MS	10004098	4,8 *0.189*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0490-020-06R1-MS	10004099	4,9 *0.193*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0500-020-06R1-MS	10004101	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0510-020-06R1-MS	10004102	5,1 *0.201*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0516-020-06R1-MS	10004103	5,16 *0.203*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0520-020-06R1-MS	10004104	5,2 *0.205*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0530-020-06R1-MS	10004105	5,3 *0.209*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0540-020-06R1-MS	10004106	5,4 *0.213*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0550-020-06R1-MS	10004107	5,5 *0.217*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0556-020-06R1-MS	10004108	5,56 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0560-021-06R1-MS	10004109	5,6 *0.220*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0570-021-06R1-MS	10004110	5,7 *0.224*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0580-021-06R1-MS	10004111	5,8 *0.228*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0590-021-06R1-MS	10004112	5,9 *0.232*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0595-021-06R1-MS	10004113	5,95 *0.234*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0600-021-06R1-MS	10004114	6,0 *0.236*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD203A-0610-021-08R1-MS	10004115	6,1 *0.240*	21,0 *0.827*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0620-021-08R1-MS	10004116	6,2 *0.244*	21,0 *0.827*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0630-021-08R1-MS	10004117	6,3 *0.248*	21,0 *0.827*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0635-023-08R1-MS	10004121	6,35 *0.250*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0650-023-08R1-MS	10004122	6,5 *0.256*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0660-023-08R1-MS	10004123	6,6 *0.260*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0675-025-08R1-MS	10004124	6,75 *0.266*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0680-025-08R1-MS	10004125	6,8 *0.268*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0690-025-08R1-MS	10004127	6,9 *0.272*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0700-025-08R1-MS	10004128	7,0 *0.276*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0710-025-08R1-MS	10004129	7,1 *0.280*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0714-025-08R1-MS	10004130	7,14 *0.281*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0720-025-08R1-MS	10004132	7,2 *0.283*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0730-025-08R1-MS	10004133	7,3 *0.287*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-0740-025-08R1-MS	10004134	7,4 *0.291*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0750-025-08R1-MS	10004135	7,5 *0.295*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0760-027-08R1-MS	10004136	7,6 *0.299*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0780-027-08R1-MS	10004137	7,8 *0.307*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0794-027-08R1-MS	10004138	7,94 *0.313*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0800-027-08R1-MS	10004139	8,0 *0.315*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD203A-0810-027-10R1-MS	10004140	8,1 *0.319*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0820-027-10R1-MS	10004141	8,2 *0.323*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0830-027-10R1-MS	10004143	8,3 *0.327*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0840-027-10R1-MS	10004144	8,4 *0.331*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0850-027-10R1-MS	10004146	8,5 *0.335*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0860-029-10R1-MS	10004147	8,6 *0.339*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0870-029-10R1-MS	10004148	8,7 *0.343*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0873-029-10R1-MS	10004149	8,73 *0.344*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0880-029-10R1-MS	10004150	8,8 *0.346*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0900-029-10R1-MS	10004151	9,0 *0.354*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0910-029-10R1-MS	10004153	9,1 *0.358*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0913-029-10R1-MS	10004154	9,13 *0.359*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0920-029-10R1-MS	10004156	9,2 *0.362*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0930-029-10R1-MS	10004157	9,3 *0.366*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0950-029-10R1-MS	10004158	9,5 *0.374*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0953-031-10R1-MS	10004160	9,53 *0.375*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0970-031-10R1-MS	10004161	9,7 *0.382*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0980-031-10R1-MS	10004162	9,8 *0.386*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0990-031-10R1-MS	10004163	9,9 *0.390*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-0992-031-10R1-MS	10004164	9,92 *0.391*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-1000-031-10R1-MS	10004165	10,0 *0.394*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD203A-1010-031-12R1-MS	10004166	10,1 *0.398*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1020-031-12R1-MS	10004167	10,2 *0.402*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1032-031-12R1-MS	10004168	10,32 *0.406*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1040-031-12R1-MS	10004169	10,4 *0.409*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1050-031-12R1-MS	10004170	10,5 *0.413*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1072-033-12R1-MS	10004171	10,72 *0.422*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1080-033-12R1-MS	10004172	10,8 *0.425*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1100-033-12R1-MS	10004173	11,0 *0.433*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-1111-033-12R1-MS	10004174	11,11 *0.437*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1120-033-12R1-MS	10004175	11,2 *0.441*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1150-033-12R1-MS	10004176	11,5 *0.453*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1180-033-12R1-MS	10004177	11,8 *0.465*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1191-036-12R1-MS	10004309	11,91 *0.469*	36,0 *1.417*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1200-036-12R1-MS	10004314	12,0 *0.472*	36,0 *1.417*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD203A-1210-036-14R1-MS	10004315	12,1 *0.476*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1250-036-14R1-MS	10004316	12,5 *0.492*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1270-036-14R1-MS	10004317	12,7 *0.500*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1300-036-14R1-MS	10004319	13,0 *0.512*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1310-036-14R1-MS	10004320	13,1 *0.516*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1350-037-14R1-MS	10004321	13,5 *0.531*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1400-037-14R1-MS	10004325	14,0 *0.551*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD203A-1420-037-16R1-MS	10004332	14,2 *0.559*	37,0 *1.457*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1425-038-16R1-MS	10004333	14,25 *0.561*	38,0 *1.496*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1470-038-16R1-MS	10004334	14,7 *0.579*	38,0 *1.496*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1500-040-16R1-MS	10004335	15,0 *0.591*	40,0 *1.575*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1525-040-16R1-MS	10004336	15,25 *0.600*	40,0 *1.575*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1550-040-16R1-MS	10004338	15,5 *0.610*	40,0 *1.575*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1588-040-16R1-MS	10004339	15,88 *0.625*	40,0 *1.575*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1600-040-16R1-MS	10004340	16,0 *0.630*	40,0 *1.575*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD203A-1650-045-18R1-MS	10004341	16,5 *0.650*	45,0 *1.772*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD203A-1700-045-18R1-MS	10004342	17,0 *0.669*	45,0 *1.772*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD203A-1750-045-18R1-MS	10004343	17,5 *0.689*	45,0 *1.772*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD203A-1800-045-18R1-MS	10004344	18,0 *0.709*	45,0 *1.772*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD203A-1850-050-20R1-MS	10004345	18,5 *0.728*	50,0 *1.969*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD203A-1900-050-20R1-MS	10004346	19,0 *0.748*	50,0 *1.969*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD203A-1905-050-20R1-MS	10004347	19,05 *0.750*	50,0 *1.969*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD203A-1950-050-20R1-MS	10004348	19,5 *0.768*	50,0 *1.969*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD203A-2000-050-20R1-MS	10004349	20,0 *0.787*	50,0 *1.969*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9

SD205A, -MS

Bohrtiefe ca. 5 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 155-156
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0200-012-04R1-MS	10004179	2,0 *0.079*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0210-012-04R1-MS	10004180	2,1 *0.083*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0220-012-04R1-MS	10004181	2,2 *0.087*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0230-012-04R1-MS	10004182	2,3 *0.091*	12,0 *0.472*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	15,0 *0.591*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0240-013-04R1-MS	10004183	2,4 *0.094*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0250-013-04R1-MS	10004184	2,5 *0.098*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0260-013-04R1-MS	10004185	2,6 *0.102*	13,0 *0.512*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0270-013-04R1-MS	10004186	2,7 *0.106*	15,0 *0.591*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	20,5 *0.807*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0280-013-04R1-MS	10004187	2,8 *0.110*	15,0 *0.591*	50,0 *1.969*	23,0 *0.906*	27,0 *1.063*	20,5 *0.807*	4,0 *0.157*	140°	TiAlN + NbN	IT8-9
SD205A-0300-021-06R1-MS	10004188	3,0 *0.118*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0310-021-06R1-MS	10004189	3,1 *0.122*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0318-021-06R1-MS	10004191	3,18 *0.125*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0330-021-06R1-MS	10004192	3,3 *0.130*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0340-021-06R1-MS	10004193	3,4 *0.134*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0350-021-06R1-MS	10004194	3,5 *0.138*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0360-027-06R1-MS	10004195	3,6 *0.142*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0380-027-06R1-MS	10004196	3,8 *0.150*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0390-027-06R1-MS	10004197	3,9 *0.154*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0400-027-06R1-MS	10004198	4,0 *0.157*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0410-027-06R1-MS	10004199	4,1 *0.161*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0420-027-06R1-MS	10004200	4,2 *0.165*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0430-027-06R1-MS	10004201	4,3 *0.169*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0450-027-06R1-MS	10004202	4,5 *0.177*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0460-027-06R1-MS	10004203	4,6 *0.181*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0465-027-06R1-MS	10004205	4,65 *0.183*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9

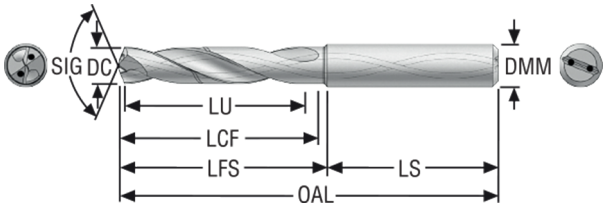
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0470-027-06R1-MS	10004206	4,7 *0.185*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0476-027-06R1-MS	10004208	4,76 *0.187*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0490-032-06R1-MS	10004209	4,9 *0.193*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0500-032-06R1-MS	10004211	5,0 *0.197*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0510-032-06R1-MS	10004212	5,1 *0.201*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0516-032-06R1-MS	10004213	5,16 *0.203*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0520-032-06R1-MS	10004214	5,2 *0.205*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0550-032-06R1-MS	10004215	5,5 *0.217*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0556-032-06R1-MS	10004216	5,56 *0.219*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0560-032-06R1-MS	10004218	5,6 *0.220*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0580-032-06R1-MS	10004219	5,8 *0.228*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0590-032-06R1-MS	10004220	5,9 *0.232*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0595-032-06R1-MS	10004221	5,95 *0.234*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0600-032-06R1-MS	10004222	6,0 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + NbN	IT8-9
SD205A-0620-035-08R1-MS	10004224	6,2 *0.244*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0630-035-08R1-MS	10004225	6,3 *0.248*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0635-035-08R1-MS	10004226	6,35 *0.250*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0640-035-08R1-MS	10004227	6,4 *0.252*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0650-035-08R1-MS	10004228	6,5 *0.256*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0660-035-08R1-MS	10004229	6,6 *0.260*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0670-035-08R1-MS	10004231	6,7 *0.264*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0680-040-08R1-MS	10004234	6,8 *0.268*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0690-040-08R1-MS	10004235	6,9 *0.272*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0700-040-08R1-MS	10004236	7,0 *0.276*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0710-040-08R1-MS	10004237	7,1 *0.280*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0714-040-08R1-MS	10004238	7,14 *0.281*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0720-040-08R1-MS	10004239	7,2 *0.283*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0750-040-08R1-MS	10004240	7,5 *0.295*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0780-042-08R1-MS	10004241	7,8 *0.307*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0794-042-08R1-MS	10004243	7,94 *0.313*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0800-042-08R1-MS	10004245	8,0 *0.315*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + NbN	IT8-9
SD205A-0810-042-10R1-MS	10004246	8,1 *0.319*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0820-042-10R1-MS	10004247	8,2 *0.323*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0840-042-10R1-MS	10004250	8,4 *0.331*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0850-042-10R1-MS	10004251	8,5 *0.335*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-0870-045-10R1-MS	10004252	8,7 *0.343*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0880-045-10R1-MS	10004255	8,8 *0.346*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0900-045-10R1-MS	10004256	9,0 *0.354*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0910-045-10R1-MS	10004257	9,1 *0.358*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0950-045-10R1-MS	10004258	9,5 *0.374*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0953-048-10R1-MS	10004259	9,53 *0.375*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0980-048-10R1-MS	10004266	9,8 *0.386*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-0992-048-10R1-MS	10004269	9,92 *0.391*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-1000-048-10R1-MS	10004270	10,0 *0.394*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + NbN	IT8-9
SD205A-1020-048-12R1-MS	10004272	10,2 *0.402*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1030-048-12R1-MS	10004273	10,3 *0.406*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1050-048-12R1-MS	10004274	10,5 *0.413*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1070-056-12R1-MS	10004275	10,7 *0.421*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1080-056-12R1-MS	10004276	10,8 *0.425*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1100-056-12R1-MS	10004277	11,0 *0.433*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1111-056-12R1-MS	10004278	11,11 *0.437*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1130-056-12R1-MS	10004279	11,3 *0.445*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1150-056-12R1-MS	10004280	11,5 *0.453*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1180-056-12R1-MS	10004281	11,8 *0.465*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1200-056-12R1-MS	10004282	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + NbN	IT8-9
SD205A-1220-056-14R1-MS	10004283	12,2 *0.480*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1250-056-14R1-MS	10004284	12,5 *0.492*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1270-056-14R1-MS	10004285	12,7 *0.500*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1300-056-14R1-MS	10004286	13,0 *0.512*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1310-056-14R1-MS	10004287	13,1 *0.516*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1350-059-14R1-MS	10004288	13,5 *0.531*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1400-059-14R1-MS	10004290	14,0 *0.551*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + NbN	IT8-9
SD205A-1420-060-16R1-MS	10004291	14,2 *0.559*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1425-060-16R1-MS	10004292	14,25 *0.561*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1450-060-16R1-MS	10004293	14,5 *0.571*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1500-060-16R1-MS	10004295	15,0 *0.591*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1550-062-16R1-MS	10004296	15,5 *0.610*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1580-062-16R1-MS	10004297	15,8 *0.622*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1600-062-16R1-MS	10004298	16,0 *0.630*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + NbN	IT8-9
SD205A-1650-071-18R1-MS	10004299	16,5 *0.650*	64,0 *2.520*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-1700-071-18R1-MS	10004300	17,0 *0.669*	64,0 *2.520*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD205A-1750-071-18R1-MS	10004301	17,5 *0.689*	66,0 *2.598*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD205A-1800-071-18R1-MS	10004302	18,0 *0.709*	66,0 *2.598*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD205A-1850-077-20R1-MS	10004303	18,5 *0.728*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD205A-1900-077-20R1-MS	10004304	19,0 *0.748*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD205A-2000-077-20R1-MS	10004307	20,0 *0.787*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9

SD203A, -M

Bohrtiefe ca. 3 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 157-158
–Zwischendurchmesser siehe MyDesign-Software

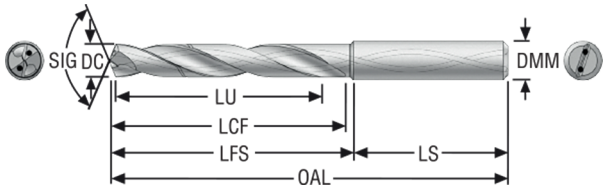
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-3.0-14-6R1-M	02569995	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-3.1-14-6R1-M	02570998	3,1 *0.122*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-3.3-14-6R1-M	02555958	3,3 *0.130*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-3.4-14-6R1-M	02570984	3,4 *0.134*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-3.5-15-6R1-M	02533784	3,5 *0.138*	15,0 *0.591*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-3.9-17-6R1-M	02570988	3,9 *0.154*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-4.0-17-6R1-M	02539902	4,0 *0.157*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-4.2-17-6R1-M	02555959	4,2 *0.165*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-4.3-18-6R1-M	02533700	4,3 *0.169*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-4.5-18-6R1-M	02570993	4,5 *0.177*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-01875-079-0236R1-M	02450103	4,763 *0.188*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-4.8-20-6R1-M	02570982	4,8 *0.189*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-4.9-20-6R1-M	02592709	4,9 *0.193*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-5.0-20-6R1-M	02450075	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-5.5-21-6R1-M	02544249	5,5 *0.217*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-02188-083-0236R1-M	02450104	5,558 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-5.6-21-6R1-M	02544028	5,6 *0.220*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-5.9-21-6R1-M	02515290	5,9 *0.232*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-6.0-21-6R1-M	02450076	6,0 *0.236*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD203A-02500-091-0315R1-M	02450105	6,35 *0.250*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-6.5-23-8R1-M	02450077	6,5 *0.256*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-6.6-23-8R1-M	02450078	6,6 *0.260*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-02656-098-0315R1-M	02450106	6,746 *0.266*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-6.8-25-8R1-M	02450079	6,8 *0.268*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-6.9-25-8R1-M	02450080	6,9 *0.272*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-7.0-25-8R1-M	02450081	7,0 *0.276*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-02813-098-0315R1-M	02450107	7,145 *0.281*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-7.2-25-8R1-M	02537185	7,2 *0.283*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-7.3-25-8R1-M	02530109	7,3 *0.287*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-7.5-25-8R1-M	02450082	7,5 *0.295*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-7.6-27-8R1-M	02545197	7,6 *0.299*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-7.8-27-8R1-M	02450083	7,8 *0.307*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-03125-106-0315R1-M	02450108	7,938 *0.313*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-8.0-27-8R1-M	02450084	8,0 *0.315*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD203A-8.5-27-10R1-M	02450085	8,5 *0.335*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-03438-114-0394R1-M	02450109	8,733 *0.344*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-8.8-29-10R1-M	02450086	8,8 *0.346*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-9.0-29-10R1-M	02450087	9,0 *0.354*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-03594-114-0394R1-M	02450110	9,129 *0.359*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-9.2-29-10R1-M	02546516	9,2 *0.362*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-9.3-29-10R1-M	02582375	9,3 *0.366*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-9.5-29-10R1-M	02450088	9,5 *0.374*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-03750-122-0394R1-M	02450111	9,525 *0.375*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-9.8-31-10R1-M	02450089	9,8 *0.386*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-9.9-31-10R1-M	02515293	9,9 *0.390*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-10.0-31-10R1-M	02450090	10,0 *0.394*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD203A-10.2-31-12R1-M	02450091	10,2 *0.402*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-04063-122-0472R1-M	02450112	10,32 *0.406*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-10.4-31-12R1-M	02535267	10,4 *0.409*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-10.5-31-12R1-M	02450092	10,5 *0.413*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-04219-130-0472R1-M	02450113	10,716 *0.422*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-10.8-33-12R1-M	02450093	10,8 *0.425*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-11.0-33-12R1-M	02450094	11,0 *0.433*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-04375-130-0472R1-M	02450114	11,113 *0.438*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-11.5-33-12R1-M	02450095	11,5 *0.453*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-11.8-33-12R1-M	02450096	11,8 *0.465*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-04688-142-0472R1-M	02592711	11,908 *0.469*	36,0 *1.417*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-12.0-36-12R1-M	02450097	12,0 *0.472*	36,0 *1.417*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD203A-12.25-36-14R1-M	02592712	12,25 *0.482*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-12.3-36-14R1-M	02450098	12,3 *0.484*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-12.5-36-14R1-M	02450099	12,5 *0.492*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-05000-142-0551R1-M	02450115	12,7 *0.500*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-12.9-36-14R1-M	02538263	12,9 *0.508*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-13.0-36-14R1-M	02450100	13,0 *0.512*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-13.5-37-14R1-M	02450101	13,5 *0.531*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-14.0-37-14R1-M	02450102	14,0 *0.551*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-14.25-38-16R1-M	02592715	14,25 *0.561*	38,0 *1.496*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9

SD205A, -M

Bohrtiefe ca. 5 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 159- 160
–Zwischendurchmesser siehe MyDesign-Software

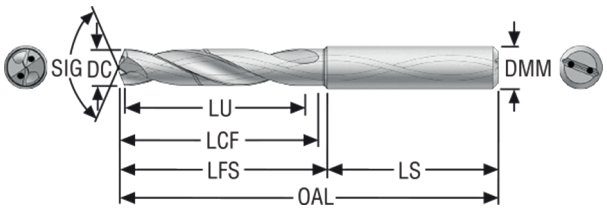
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-2.5-13-4R1-M	02666989	2,5 *0.098*	13,0 *0.512*	46,0 *1.811*	19,0 *0.748*	27,0 *1.063*	17,5 *0.689*	4,0 *0.157*	140°	TiAlN + TiN	IT8-9
SD205A-3.0-21-6R1-M	02556426	3,0 *0.118*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-3.1-21-6R1-M	02642448	3,1 *0.122*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-3.18-21-6R1-M	02541863	3,18 *0.125*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-3.3-21-6R1-M	02555960	3,3 *0.130*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-3.4-21-6R1-M	02554264	3,4 *0.134*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-3.5-21-6R1-M	02533780	3,5 *0.138*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	26,0 *1.024*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-4.0-27-6R1-M	02508340	4,0 *0.157*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-4.2-27-6R1-M	02502549	4,2 *0.165*	27,0 *1.063*	74,0 *2.913*	40,0 *1.575*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-4.3-27-6R1-M	02592718	4,3 *0.169*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-4.5-27-6R1-M	02563659	4,5 *0.177*	27,0 *1.063*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-4.7-27-6R1-M	02604031	4,7 *0.185*	27,0 *1.063*	74,0 *2.913*	40,0 *1.575*	36,0 *1.417*	34,0 *1.339*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-01875-126-0236R1-M	02450062	4,763 *0.188*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-4.9-32-6R1-M	02592720	4,9 *0.193*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-5.0-32-6R1-M	02450034	5,0 *0.197*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-5.1-32-6R1-M	02600034	5,1 *0.201*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-5.2-32-6R1-M	02504408	5,2 *0.205*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-5.5-32-6R1-M	02537341	5,5 *0.217*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-02188-126-0236R1-M	02450063	5,558 *0.219*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-5.6-32-6R1-M	02612445	5,6 *0.220*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-5.9-32-6R1-M	02539334	5,9 *0.232*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-6.0-32-6R1-M	02450035	6,0 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	140°	TiAlN + TiN	IT8-9
SD205A-6.2-35-8R1-M	02547543	6,2 *0.244*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-02500-138-0315R1-M	02450064	6,35 *0.250*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-6.4-35-8R1-M	02666488	6,4 *0.252*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-6.5-35-8R1-M	02450036	6,5 *0.256*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-6.6-35-8R1-M	02450037	6,6 *0.260*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-6.8-40-8R1-M	02450038	6,8 *0.268*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-6.9-40-8R1-M	02450039	6,9 *0.272*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-02813-157-0315R1-M	02450066	7,145 *0.281*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-7.2-40-8R1-M	02519059	7,2 *0.283*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-7.5-40-8R1-M	02450041	7,5 *0.295*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-7.8-42-8R1-M	02450042	7,8 *0.307*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-03125-165-0315R1-M	02450067	7,938 *0.313*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-8.0-42-8R1-M	02450043	8,0 *0.315*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9
SD205A-8.1-42-10R1-M	02672327	8,1 *0.319*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-8.4-42-10R1-M	02570977	8,4 *0.331*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-8.5-42-10R1-M	02450044	8,5 *0.335*	42,0 *1.654*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-8.8-45-10R1-M	02450045	8,8 *0.346*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-9.0-45-10R1-M	02450046	9,0 *0.354*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-9.2-45-10R1-M	02516406	9,2 *0.362*	45,0 *1.772*	103,0 *4.055*	42,0 *1.654*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-9.5-45-10R1-M	02450047	9,5 *0.374*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-03750-189-0394R1-M	02450070	9,525 *0.375*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-9.8-48-10R1-M	02450048	9,8 *0.386*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-10.0-48-10R1-M	02450049	10,0 *0.394*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN + TiN	IT8-9
SD205A-10.2-48-12R1-M	02450050	10,2 *0.402*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-10.5-48-12R1-M	02450051	10,5 *0.413*	48,0 *1.890*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-10.8-56-12R1-M	02450052	10,8 *0.425*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-10.9-56-12R1-M	02592725	10,9 *0.429*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-11.0-56-12R1-M	02450053	11,0 *0.433*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-04375-221-0472R1-M	02450073	11,113 *0.438*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-11.5-56-12R1-M	02450054	11,5 *0.453*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-11.8-56-12R1-M	02450055	11,8 *0.465*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-12.0-56-12R1-M	02450056	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	TiAlN + TiN	IT8-9
SD205A-12.5-56-14R1-M	02450058	12,5 *0.492*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD205A-05000-221-0551R1-M	02450074	12,7 *0.500*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD205A-13.0-56-14R1-M	02450059	13,0 *0.512*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD205A-13.5-59-14R1-M	02450060	13,5 *0.531*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD205A-14.0-59-14R1-M	02450061	14,0 *0.551*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD205A-14.25-60-16R1-M	02592732	14,25 *0.561*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-14.5-60-16R1-M	03117534	14,5 *0.571*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9
SD205A-15.0-60-16R1-M	02570652	15,0 *0.591*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9
SD205A-15.5-62-16R1-M	02543076	15,5 *0.610*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9
SD205A-16.0-62-16R1-M	02555961	16,0 *0.630*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9

SD203A, -T

Bohrtiefe ca. 3 x D – Metrisch/Zoll

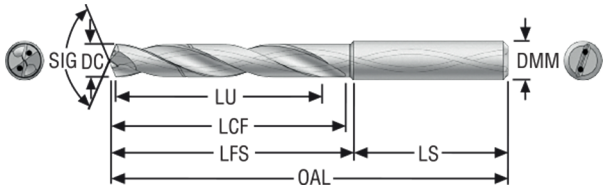


–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten - www.secotools.com
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-01875-079-0236R1-T	02569147	4,763 *0.188*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	Unbeschichtet	IT8-9
SD203A-5.0-20-6R1-T	02523021	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	Unbeschichtet	IT8-9
SD203A-02188-083-0236R1-T	02569156	5,558 *0.219*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	Unbeschichtet	IT8-9
SD203A-6.0-21-6R1-T	02542682	6,0 *0.236*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	Unbeschichtet	IT8-9
SD203A-02500-091-0315R1-T	02569149	6,35 *0.250*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-6.5-23-8R1-T	02545316	6,5 *0.256*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-6.9-25-8R1-T	02537280	6,9 *0.272*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-7.0-25-8R1-T	02525985	7,0 *0.276*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-02813-098-0315R1-T	02569151	7,145 *0.281*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-7.5-25-8R1-T	02527667	7,5 *0.295*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-03125-106-0315R1-T	02569152	7,938 *0.313*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-8.0-27-8R1-T	02513679	8,0 *0.315*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD203A-8.5-27-10R1-T	02548250	8,5 *0.335*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	Unbeschichtet	IT8-9
SD203A-9.0-29-10R1-T	02524440	9,0 *0.354*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	Unbeschichtet	IT8-9
SD203A-9.5-29-10R1-T	02545386	9,5 *0.374*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	Unbeschichtet	IT8-9
SD203A-10.0-31-10R1-T	02525984	10,0 *0.394*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	Unbeschichtet	IT8-9
SD203A-10.5-31-12R1-T	02545387	10,5 *0.413*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	Unbeschichtet	IT8-9
SD203A-11.0-33-12R1-T	02569155	11,0 *0.433*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	Unbeschichtet	IT8-9
SD203A-12.0-36-12R1-T	02562784	12,0 *0.472*	36,0 *1.417*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	Unbeschichtet	IT8-9

SD205A, -T

Bohrtiefe ca. 5 x D – Metrisch/Zoll

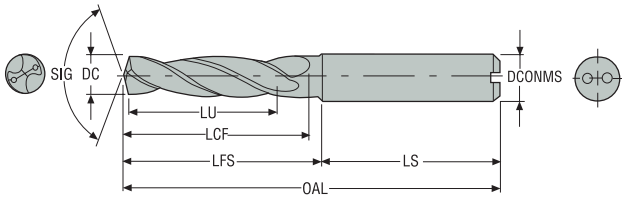


—Zylinderschaft DIN 6537A
—DC-Toleranz m7
—Kühlmittelzufuhr
—Schnittdaten - www.secotools.com
—Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD205A-8.0-42-8R1-T	02569164	8,0 *0.315*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	Unbeschichtet	IT8-9
SD205A-12.0-56-12R1-T	02527621	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	Unbeschichtet	IT8-9

SD203A, -N

Bohrtiefe ca. 3 x D – Metrisch/Zoll



–Zylinderschaft DIN 6537A
–DC-Toleranz m7
–Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 142- 143
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-2.5-8-4R1-N	02691548	2,5 *0.098*	8,0 *0.315*	44,0 *1.732*	16,0 *0.630*	28,0 *1.102*	13,0 *0.512*	4,0 *0.157*	140°	DLC	IT8-9
SD203A-3.0-14-6R1-N	02691549	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-3.3-14-6R1-N	02691551	3,3 *0.130*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-3.5-15-6R1-N	02691552	3,5 *0.138*	15,0 *0.591*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-4.0-17-6R1-N	02691553	4,0 *0.157*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-4.1-17-6R1-N	02691554	4,1 *0.161*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-4.5-18-6R1-N	02691555	4,5 *0.177*	18,0 *0.709*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	24,0 *0.945*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-5.0-20-6R1-N	02691556	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-5.2-20-6R1-N	02691557	5,2 *0.205*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-5.5-20-6R1-N	02691558	5,5 *0.217*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-6.0-21-6R1-N	02691559	6,0 *0.236*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*	140°	DLC	IT8-9
SD203A-02500-091-0315R1-N	02691560	6,35 *0.250*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-6.5-23-8R1-N	02691562	6,5 *0.256*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-02656-098-0315R1-N	02691564	6,746 *0.266*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-6.8-25-8R1-N	02691565	6,8 *0.268*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-7.0-25-8R1-N	02643590	7,0 *0.276*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-7.1-25-8R1-N	02691567	7,1 *0.280*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-02813-098-0315R1-N	02691568	7,145 *0.281*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-7.5-25-8R1-N	02691569	7,5 *0.295*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-8.0-27-8R1-N	02691571	8,0 *0.315*	27,0 *1.063*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	DLC	IT8-9
SD203A-8.5-27-10R1-N	02643592	8,5 *0.335*	27,0 *1.063*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	DLC	IT8-9
SD203A-9.0-29-10R1-N	02691574	9,0 *0.354*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	DLC	IT8-9
SD203A-9.5-29-10R1-N	02691575	9,5 *0.374*	29,0 *1.142*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	DLC	IT8-9
SD203A-03750-122-0394R1-N	02691576	9,525 *0.375*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	DLC	IT8-9
SD203A-10.0-31-10R1-N	02691577	10,0 *0.394*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	140°	DLC	IT8-9

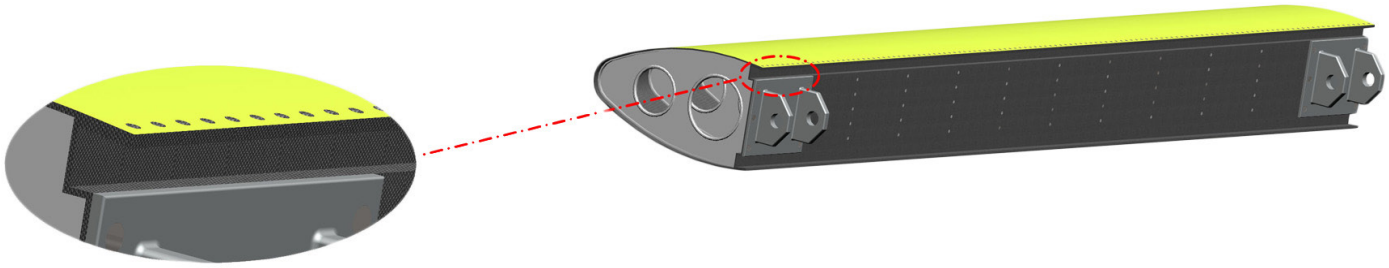
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschich-tung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD203A-10.2-31-12R1-N	02691578	10,2 *0.402*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-04063-122-0472R1-N	02691579	10,32 *0.406*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-10.5-31-12R1-N	02691580	10,5 *0.413*	31,0 *1.220*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-11.0-33-12R1-N	02691582	11,0 *0.433*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-04375-130-0472R1-N	02691585	11,113 *0.438*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-11.5-33-12R1-N	02691588	11,5 *0.453*	33,0 *1.299*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-12.0-36-12R1-N	02691589	12,0 *0.472*	36,0 *1.417*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	DLC	IT8-9
SD203A-12.5-36-14R1-N	02691591	12,5 *0.492*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	DLC	IT8-9
SD203A-05000-142-0551R1-N	02691592	12,7 *0.500*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	DLC	IT8-9
SD203A-13.0-36-14R1-N	02691594	13,0 *0.512*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	DLC	IT8-9
SD203A-05312-146-0551R1-N	02691596	13,492 *0.531*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	DLC	IT8-9
SD203A-13.5-37-14R1-N	02691597	13,5 *0.531*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	DLC	IT8-9
SD203A-14.0-37-14R1-N	02691598	14,0 *0.551*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	DLC	IT8-9

Bohrungsbearbeitung von Verbundwerkstoffen

Seco Tools bietet zwei Lösungen für die Bohrungsbearbeitung von Verbundwerkstoffen: diamantbeschichtete Bohrer und PKD-Bohrer. Die Geometrien der Werkzeuge sind speziell für Verbundwerkstoffe oder geschichtete Werkstoffe ausgelegt.

- Die Spitzengeometrie der C1 und CX1 ist optimiert für Anwendungen in CFK.
- Die flache Geometrie der Bohrerspitze des C2 eignet sich zur Bearbeitung von Verbundwerkstoffen mit Aluminiumschichten.
- Die PKD-Bohrer CX1 ermöglichen mehr Produktivität und längere Standzeit bei der Bearbeitung von Verbundwerkstoffen im Vergleich zu konventionellen Bohrern
- C1 und C2 sind diamantbeschichtete Vollhartmetallbohrer mit Dura-Diamantbeschichtung für mehr Zähigkeit und Verschleißfestigkeit

Composite-Bearbeitung



Delamination vermeiden

Wenn beim Bohrungseintritt bzw. -austritt die Gefahr von Delamination oder Absplitterungen besteht, ist der Fokus klar: Spezielle Werkzeuge, optimiert für Composite-Bearbeitungen, für Werkzeugaustritte sowohl in Composite als auch in Sandwich-Werkstoffen (bestehend aus Al oder Ti).

- Keine Delamination (Eintritt) durch schiebende Schnitte
- Keine Delamination (Austritt) durch ziehende Schnitte

Die DURA-Diamant-Beschichtung gewährleistet während der gesamten Standzeit gute Maßtoleranzen.

Anwendungsbeispiel

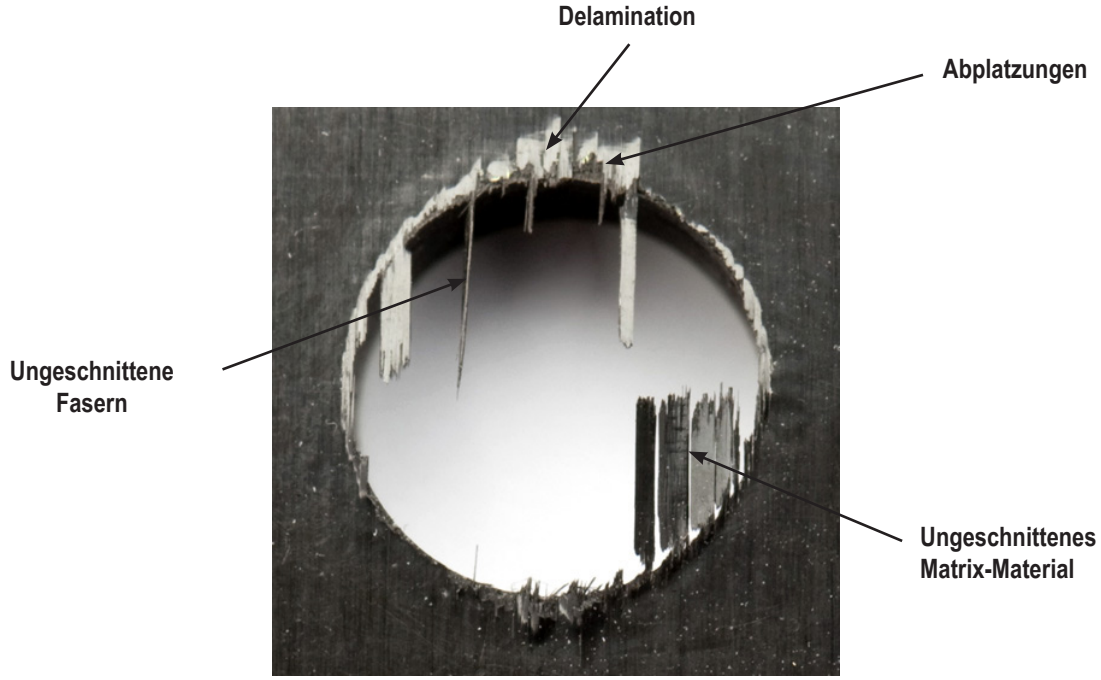
Voller CFK-/GFK-Werkstoff
(Austritt in Composite-Werkstoff)

Geometrie C1
Geometrie CX1

Sandwich-Werkstoff
(Austritt in Al/Ti)

Geometrie C2

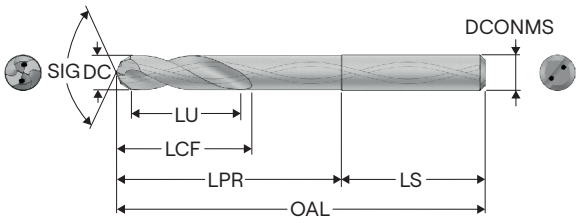
Winkelige Austrittsflächen



Herausforderung:	Delamination (ziehender / schiebender Schnitt)	Abplatzungen	Ungeschnittene Fasern	Ungeschnittenes Matrix-Material
Lösung:	**Ziehender Schnitt** ▪ Negative Geometrie einsetzen ▪ Vorschub/U reduzieren **Schiebender Schnitt** ▪ Vorschub/U reduzieren	▪ Positive Geometrie einsetzen ▪ Vorschub/U reduzieren	▪ Schärfere Geometrie einsetzen ▪ Vorschub/U reduzieren	▪ Schärfere Geometrie einsetzen ▪ Vorschub/U reduzieren ▪ Schnittgeschwindigkeit reduzieren
Herausforderung:	**Geschmolzene Matrix**	**Geringe Standzeit**		
Lösung:	▪ Schnittgeschwindigkeit senken	▪ Schnittgeschwindigkeit senken		

SD205A-C1

Bohrtiefe ca. 5 x D – Metrisch/Zoll

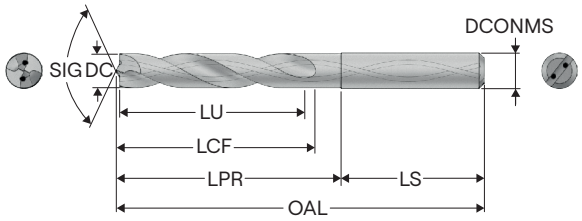


—Zylinderschaft DIN 6537A
—Kühlmittelzufuhr
—Schnittdaten siehe Seite(n) 161

Bezeichnung	Produkt-nummer	Gewünschte Bohrungs-toleranz		DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung
		mm	*Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD205A-6.0-31-6R1-C1	02740089	5,975/6,025	*0.2352/0.2372*	6,0 *0.236*	31,0 *1.220*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	60°/130°	Dura-Diamant
SD205A-9.55-46-10R1-C1	02740092	9,525/9,576	*0.3750/0.3770*	9,55 *0.376*	46,0 *1.811*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	60°/130°	Dura-Diamant

SD205A-C2

Bohrtiefe ca. 5 x D – Metrisch/Zoll

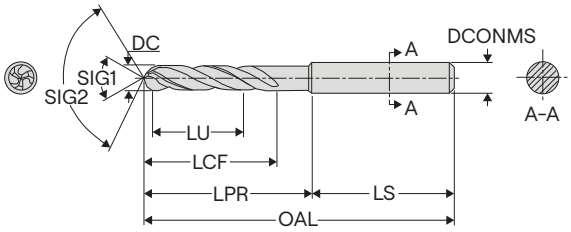


—Zylinderschaft DIN 6537A
—Kühlmittelzufuhr
—Schnittdaten siehe Seite(n) 161

Bezeichnung	Produkt-nummer	Gewünschte Bohrungs-toleranz		DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:	Beschichtung
		mm	*Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD205A-6.0-32-6R1-C2	02740099	5,975/6,025	*0.2352/0.2372*	6,0 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	60°/130°	Dura-Diamant
SD205A-9.55-48-10R1-C2	02740103	9,525/9,576	*0.3750/0.3770*	9,55 *0.376*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	60°/130°	Dura-Diamant

SD203-CX1

Bohrtiefe ca. 3 x D – Metrisch/Zoll



—Zylinderschaft DIN 6537A
—PKD-Schneidkanten
—Schnittdaten siehe Seite(n) 161

Bezeichnung	Produkt-nummer	Gewünschte Bohrungs-toleranz		DC	LU	OAL	LFS	LS	LCF	DMM	Spitzenwinkel:
		mm	*Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	
SD203-3.26-14-6R1-CX1	02827923	3,235/3,285	*0.1273/0.1293*	3,26 *0.128*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	21,0 *0.827*	6,0 *0.236*	60°/130°
SD203-4.17-17-6R1-CX1	02827924	4,142/4,192	*0.1630/0.1650*	4,17 *0.164*	17,0 *0.669*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	25,0 *0.984*	6,0 *0.236*	60°/130°
SD203-6.36-23-8R1-CX1	02827927	6,33/6,38	*0.2492/0.2511*	6,36 *0.250*	23,0 *0.906*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	60°/130°
SD203-9.53-31-10R1-CX1	02827929	9,504/9,554	*0.3741/0.3761*	9,53 *0.375*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*	60°/130°

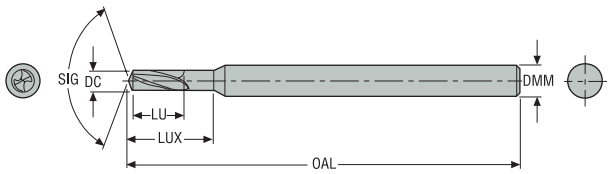
Mikrobohren

Zum Mikrobohren bietet Seco Tools ein Spektrum an speziellen Werkzeugen an, inklusive der kleinen Vollhartmetallbohrer-Reihe SD22 und SD26.

- Deutliche Leistungserhöhung im Vergleich zu konventionellen HSS-Bohrern
- Geeignet für Anwendungen in den Branchen Automobil und Medizintechnik oder auch für Kleinteilbearbeitung im allgemeinen Maschinenbau.

SD22

Bohrtiefe ca. 2 x D (Zentrierbohrer) – Metrisch/Zoll



– Zylinderschaft
– Äußere Kühlmittelzufuhr
– Schnittdaten siehe Seite(n) 162–166

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD22-0.10-0.20-3R1	02731574	0,1 *0.004*	0,2 *0.008*	38,0 *1.496*	0,55 *0.022*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.11-0.22-3R1	02730362	0,11 *0.004*	0,22 *0.009*	38,0 *1.496*	0,55 *0.022*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.12-0.24-3R1	02730460	0,12 *0.005*	0,24 *0.009*	38,0 *1.496*	0,55 *0.022*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.13-0.26-3R1	02730461	0,13 *0.005*	0,26 *0.010*	38,0 *1.496*	0,6 *0.024*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.14-0.28-3R1	02730462	0,14 *0.006*	0,28 *0.011*	38,0 *1.496*	0,6 *0.024*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.15-0.30-3R1	02731575	0,15 *0.006*	0,3 *0.012*	38,0 *1.496*	0,6 *0.024*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.16-0.32-3R1	02730464	0,16 *0.006*	0,32 *0.013*	38,0 *1.496*	0,6 *0.024*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.17-0.34-3R1	02730465	0,17 *0.007*	0,34 *0.013*	38,0 *1.496*	0,7 *0.028*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.18-0.36-3R1	02730466	0,18 *0.007*	0,36 *0.014*	38,0 *1.496*	0,7 *0.028*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.19-0.38-3R1	02730467	0,19 *0.007*	0,38 *0.015*	38,0 *1.496*	0,7 *0.028*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.20-0.40-3R1	02731576	0,2 *0.008*	0,4 *0.016*	38,0 *1.496*	0,75 *0.030*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.21-0.42-3R1	02730468	0,21 *0.008*	0,42 *0.017*	38,0 *1.496*	0,75 *0.030*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.22-0.44-3R1	02730469	0,22 *0.009*	0,44 *0.017*	38,0 *1.496*	0,8 *0.031*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.23-0.46-3R1	02730470	0,23 *0.009*	0,46 *0.018*	38,0 *1.496*	0,8 *0.031*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.24-0.48-3R1	02730471	0,24 *0.009*	0,48 *0.019*	38,0 *1.496*	0,8 *0.031*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.25-0.50-3R1	02731577	0,25 *0.010*	0,5 *0.020*	38,0 *1.496*	0,9 *0.035*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.26-0.52-3R1	02730472	0,26 *0.010*	0,52 *0.020*	38,0 *1.496*	0,9 *0.035*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.27-0.54-3R1	02730473	0,27 *0.011*	0,54 *0.021*	38,0 *1.496*	0,9 *0.035*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.28-0.56-3R1	02730474	0,28 *0.011*	0,56 *0.022*	38,0 *1.496*	1,0 *0.039*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.29-0.58-3R1	02730475	0,29 *0.011*	0,58 *0.023*	38,0 *1.496*	1,0 *0.039*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.30-0.60-3R1	02731579	0,3 *0.012*	0,6 *0.024*	38,0 *1.496*	1,2 *0.047*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.31-0.62-3R1	02730476	0,31 *0.012*	0,62 *0.024*	38,0 *1.496*	1,2 *0.047*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.32-0.64-3R1	02730477	0,32 *0.013*	0,64 *0.025*	38,0 *1.496*	1,2 *0.047*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.33-0.66-3R1	02730478	0,33 *0.013*	0,66 *0.026*	38,0 *1.496*	1,2 *0.047*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.34-0.68-3R1	02730479	0,34 *0.013*	0,68 *0.027*	38,0 *1.496*	1,35 *0.053*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.35-0.70-3R1	02731580	0,35 *0.014*	0,7 *0.028*	38,0 *1.496*	1,35 *0.053*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD22-0.36-0.72-3R1	02730480	0,36 *0.014*	0,72 *0.028*	38,0 *1.496*	1,35 *0.053*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.37-0.74-3R1	02730481	0,37 *0.015*	0,74 *0.029*	38,0 *1.496*	1,35 *0.053*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.38-0.76-3R1	02730482	0,38 *0.015*	0,76 *0.030*	38,0 *1.496*	1,5 *0.059*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.39-0.78-3R1	02730483	0,39 *0.015*	0,78 *0.031*	38,0 *1.496*	1,5 *0.059*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.40-0.80-3R1	02731581	0,4 *0.016*	0,8 *0.031*	38,0 *1.496*	1,6 *0.063*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.41-0.82-3R1	02730484	0,41 *0.016*	0,82 *0.032*	38,0 *1.496*	1,6 *0.063*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.42-0.84-3R1	02730485	0,42 *0.017*	0,84 *0.033*	38,0 *1.496*	1,6 *0.063*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.43-0.86-3R1	02730486	0,43 *0.017*	0,86 *0.034*	38,0 *1.496*	1,6 *0.063*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.44-0.88-3R1	02730487	0,44 *0.017*	0,88 *0.035*	38,0 *1.496*	1,6 *0.063*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.45-0.90-3R1	02731582	0,45 *0.018*	0,9 *0.035*	38,0 *1.496*	1,6 *0.063*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.46-0.92-3R1	02730488	0,46 *0.018*	0,92 *0.036*	38,0 *1.496*	1,7 *0.067*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.47-0.94-3R1	02730489	0,47 *0.019*	0,94 *0.037*	38,0 *1.496*	1,7 *0.067*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.48-0.96-3R1	02730490	0,48 *0.019*	0,96 *0.038*	38,0 *1.496*	1,7 *0.067*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.49-0.98-3R1	02730491	0,49 *0.019*	0,98 *0.039*	38,0 *1.496*	1,7 *0.067*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.50-1.00-3R1	02731584	0,5 *0.020*	1,0 *0.039*	38,0 *1.496*	1,7 *0.067*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.51-1.02-3R1	02730492	0,51 *0.020*	1,02 *0.040*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.52-1.04-3R1	02730493	0,52 *0.020*	1,04 *0.041*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.53-1.06-3R1	02730494	0,53 *0.021*	1,06 *0.042*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.54-1.08-3R1	02730495	0,54 *0.021*	1,08 *0.043*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.55-1.10-3R1	02731585	0,55 *0.022*	1,1 *0.043*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.56-1.12-3R1	02730496	0,56 *0.022*	1,12 *0.044*	38,0 *1.496*	1,9 *0.075*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.57-1.14-3R1	02730497	0,57 *0.022*	1,14 *0.045*	38,0 *1.496*	1,9 *0.075*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.58-1.16-3R1	02730498	0,58 *0.023*	1,16 *0.046*	38,0 *1.496*	1,9 *0.075*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.59-1.18-3R1	02730499	0,59 *0.023*	1,18 *0.046*	38,0 *1.496*	1,9 *0.075*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.60-1.20-3R1	02731586	0,6 *0.024*	1,2 *0.047*	38,0 *1.496*	1,9 *0.075*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.61-1.22-3R1	02730500	0,61 *0.024*	1,22 *0.048*	38,0 *1.496*	2,0 *0.079*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.62-1.24-3R1	02730501	0,62 *0.024*	1,24 *0.049*	38,0 *1.496*	2,0 *0.079*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.63-1.26-3R1	02730502	0,63 *0.025*	1,26 *0.050*	38,0 *1.496*	2,0 *0.079*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.64-1.28-3R1	02730503	0,64 *0.025*	1,28 *0.050*	38,0 *1.496*	2,0 *0.079*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.65-1.30-3R1	02731587	0,65 *0.026*	1,3 *0.051*	38,0 *1.496*	2,0 *0.079*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.66-1.32-3R1	02730504	0,66 *0.026*	1,32 *0.052*	38,0 *1.496*	2,1 *0.083*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.67-1.34-3R1	02730505	0,67 *0.026*	1,34 *0.053*	38,0 *1.496*	2,1 *0.083*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.68-1.36-3R1	02730506	0,68 *0.027*	1,36 *0.054*	38,0 *1.496*	2,1 *0.083*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.69-1.38-3R1	02730507	0,69 *0.027*	1,38 *0.054*	38,0 *1.496*	2,1 *0.083*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.70-1.40-3R1	02731589	0,7 *0.028*	1,4 *0.055*	38,0 *1.496*	2,1 *0.083*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD22-0.71-1.42-3R1	02730508	0,71 *0.028*	1,42 *0.056*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.72-1.44-3R1	02730509	0,72 *0.028*	1,44 *0.057*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.73-1.46-3R1	02730510	0,73 *0.029*	1,46 *0.057*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.74-1.48-3R1	02730511	0,74 *0.029*	1,48 *0.058*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.75-1.50-3R1	02731590	0,75 *0.030*	1,5 *0.059*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.76-1.52-3R1	02730512	0,76 *0.030*	1,52 *0.060*	38,0 *1.496*	2,3 *0.091*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.77-1.54-3R1	02730513	0,77 *0.030*	1,54 *0.061*	38,0 *1.496*	2,3 *0.091*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.78-1.56-3R1	02730514	0,78 *0.031*	1,56 *0.061*	38,0 *1.496*	2,3 *0.091*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.79-1.58-3R1	02730515	0,79 *0.031*	1,58 *0.062*	38,0 *1.496*	2,3 *0.091*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.80-1.60-3R1	02731592	0,8 *0.031*	1,6 *0.063*	38,0 *1.496*	2,3 *0.091*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.81-1.62-3R1	02730516	0,81 *0.032*	1,62 *0.064*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.82-1.64-3R1	02730517	0,82 *0.032*	1,64 *0.065*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.83-1.66-3R1	02730518	0,83 *0.033*	1,66 *0.065*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.84-1.68-3R1	02730519	0,84 *0.033*	1,68 *0.066*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.85-1.70-3R1	02731593	0,85 *0.033*	1,7 *0.067*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.86-1.72-3R1	02730520	0,86 *0.034*	1,72 *0.068*	38,0 *1.496*	2,5 *0.098*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.87-1.74-3R1	02730521	0,87 *0.034*	1,74 *0.069*	38,0 *1.496*	2,5 *0.098*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.88-1.76-3R1	02730522	0,88 *0.035*	1,76 *0.069*	38,0 *1.496*	2,5 *0.098*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.89-1.78-3R1	02730523	0,89 *0.035*	1,78 *0.070*	38,0 *1.496*	2,5 *0.098*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.90-1.80-3R1	02731594	0,9 *0.035*	1,8 *0.071*	38,0 *1.496*	2,5 *0.098*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.91-1.82-3R1	02730524	0,91 *0.036*	1,82 *0.072*	38,0 *1.496*	2,6 *0.102*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.92-1.84-3R1	02730525	0,92 *0.036*	1,84 *0.072*	38,0 *1.496*	2,6 *0.102*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.93-1.86-3R1	02730526	0,93 *0.037*	1,86 *0.073*	38,0 *1.496*	2,6 *0.102*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.94-1.88-3R1	02730527	0,94 *0.037*	1,88 *0.074*	38,0 *1.496*	2,6 *0.102*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.95-1.90-3R1	02731595	0,95 *0.037*	1,9 *0.075*	38,0 *1.496*	2,6 *0.102*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.96-1.92-3R1	02730528	0,96 *0.038*	1,92 *0.076*	38,0 *1.496*	2,7 *0.106*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.97-1.94-3R1	02730529	0,97 *0.038*	1,94 *0.076*	38,0 *1.496*	2,7 *0.106*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.98-1.96-3R1	02730530	0,98 *0.039*	1,96 *0.077*	38,0 *1.496*	2,7 *0.106*	3,0 *0.118*	130°	Unbeschichtet
SD22-0.99-1.98-3R1	02730531	0,99 *0.039*	1,98 *0.078*	38,0 *1.496*	2,7 *0.106*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.00-2.00-3R1	02731596	1,0 *0.039*	2,0 *0.079*	38,0 *1.496*	2,7 *0.106*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.01-2.02-3R1	02730532	1,01 *0.040*	2,02 *0.080*	38,0 *1.496*	3,5 *0.138*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.02-2.04-3R1	02730533	1,02 *0.040*	2,04 *0.080*	38,0 *1.496*	3,5 *0.138*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.03-2.06-3R1	02730534	1,03 *0.041*	2,06 *0.081*	38,0 *1.496*	3,5 *0.138*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.04-2.08-3R1	02730535	1,04 *0.041*	2,08 *0.082*	38,0 *1.496*	3,5 *0.138*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.05-2.10-3R1	02730536	1,05 *0.041*	2,1 *0.083*	38,0 *1.496*	3,5 *0.138*	3,0 *0.118*	130°	Unbeschichtet

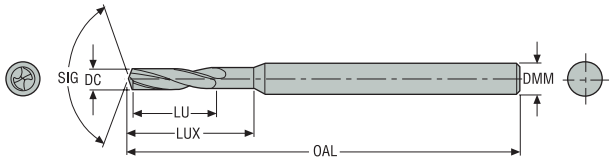
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD22-1.06-2.12-3R1	02730537	1,06 *0.042*	2,12 *0.083*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.07-2.14-3R1	02730538	1,07 *0.042*	2,14 *0.084*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.08-2.16-3R1	02730539	1,08 *0.043*	2,16 *0.085*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.09-2.18-3R1	02730540	1,09 *0.043*	2,18 *0.086*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.10-2.20-3R1	02731598	1,1 *0.043*	2,2 *0.087*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.11-2.22-3R1	02730541	1,11 *0.044*	2,22 *0.087*	38,0 *1.496*	3,7 *0.146*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.12-2.24-3R1	02730542	1,12 *0.044*	2,24 *0.088*	38,0 *1.496*	3,7 *0.146*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.13-2.26-3R1	02730543	1,13 *0.044*	2,26 *0.089*	38,0 *1.496*	3,7 *0.146*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.14-2.28-3R1	02730544	1,14 *0.045*	2,28 *0.090*	38,0 *1.496*	3,7 *0.146*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.15-2.30-3R1	02730545	1,15 *0.045*	2,3 *0.091*	38,0 *1.496*	3,7 *0.146*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.16-2.32-3R1	02730546	1,16 *0.046*	2,32 *0.091*	38,0 *1.496*	3,8 *0.150*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.17-2.34-3R1	02730547	1,17 *0.046*	2,34 *0.092*	38,0 *1.496*	3,8 *0.150*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.18-2.36-3R1	02730548	1,18 *0.046*	2,36 *0.093*	38,0 *1.496*	3,8 *0.150*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.19-2.38-3R1	02730549	1,19 *0.047*	2,38 *0.094*	38,0 *1.496*	3,8 *0.150*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.20-2.40-3R1	02731599	1,2 *0.047*	2,4 *0.094*	38,0 *1.496*	3,8 *0.150*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.21-2.42-3R1	02730550	1,21 *0.048*	2,42 *0.095*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.22-2.44-3R1	02730551	1,22 *0.048*	2,44 *0.096*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.23-2.46-3R1	02730552	1,23 *0.048*	2,46 *0.097*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.24-2.48-3R1	02730553	1,24 *0.049*	2,48 *0.098*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.25-2.50-3R1	02730554	1,25 *0.049*	2,5 *0.098*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.26-2.52-3R1	02730555	1,26 *0.050*	2,52 *0.099*	38,0 *1.496*	4,3 *0.169*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.27-2.54-3R1	02730556	1,27 *0.050*	2,54 *0.100*	38,0 *1.496*	4,3 *0.169*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.28-2.56-3R1	02730557	1,28 *0.050*	2,56 *0.101*	38,0 *1.496*	4,3 *0.169*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.29-2.58-3R1	02730558	1,29 *0.051*	2,58 *0.102*	38,0 *1.496*	4,3 *0.169*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.30-2.60-3R1	02731600	1,3 *0.051*	2,6 *0.102*	38,0 *1.496*	4,3 *0.169*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.31-2.62-3R1	02730559	1,31 *0.052*	2,62 *0.103*	38,0 *1.496*	4,4 *0.173*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.32-2.64-3R1	02730560	1,32 *0.052*	2,64 *0.104*	38,0 *1.496*	4,4 *0.173*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.33-2.66-3R1	02730561	1,33 *0.052*	2,66 *0.105*	38,0 *1.496*	4,4 *0.173*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.34-2.68-3R1	02730562	1,34 *0.053*	2,68 *0.106*	38,0 *1.496*	4,4 *0.173*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.35-2.70-3R1	02730563	1,35 *0.053*	2,7 *0.106*	38,0 *1.496*	4,4 *0.173*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.36-2.72-3R1	02730564	1,36 *0.054*	2,72 *0.107*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.37-2.74-3R1	02730565	1,37 *0.054*	2,74 *0.108*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.38-2.76-3R1	02730566	1,38 *0.054*	2,76 *0.109*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.39-2.78-3R1	02730567	1,39 *0.055*	2,78 *0.109*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.40-2.80-3R1	02731602	1,4 *0.055*	2,8 *0.110*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD22-1.41-2.82-3R1	02730568	1,41 *0.056*	2,82 *0.111*	38,0 *1.496*	4,6 *0.181*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.42-2.84-3R1	02730569	1,42 *0.056*	2,84 *0.112*	38,0 *1.496*	4,6 *0.181*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.43-2.86-3R1	02730570	1,43 *0.056*	2,86 *0.113*	38,0 *1.496*	4,6 *0.181*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.44-2.88-3R1	02730571	1,44 *0.057*	2,88 *0.113*	38,0 *1.496*	4,6 *0.181*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.45-2.90-3R1	02730572	1,45 *0.057*	2,9 *0.114*	38,0 *1.496*	4,6 *0.181*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.46-2.92-3R1	02730573	1,46 *0.057*	2,92 *0.115*	38,0 *1.496*	4,7 *0.185*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.47-2.94-3R1	02730574	1,47 *0.058*	2,94 *0.116*	38,0 *1.496*	4,7 *0.185*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.48-2.96-3R1	02730575	1,48 *0.058*	2,96 *0.117*	38,0 *1.496*	4,7 *0.185*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.49-2.98-3R1	02730576	1,49 *0.059*	2,98 *0.117*	38,0 *1.496*	4,7 *0.185*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.50-3.00-3R1	02731603	1,5 *0.059*	3,0 *0.118*	38,0 *1.496*	4,7 *0.185*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.51-3.02-3R1	02730577	1,51 *0.059*	3,02 *0.119*	38,0 *1.496*	5,1 *0.201*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.52-3.04-3R1	02730578	1,52 *0.060*	3,04 *0.120*	38,0 *1.496*	5,1 *0.201*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.53-3.06-3R1	02730579	1,53 *0.060*	3,06 *0.120*	38,0 *1.496*	5,1 *0.201*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.54-3.08-3R1	02730580	1,54 *0.061*	3,08 *0.121*	38,0 *1.496*	5,1 *0.201*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.55-3.10-3R1	02730581	1,55 *0.061*	3,1 *0.122*	38,0 *1.496*	5,1 *0.201*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.56-3.12-3R1	02730582	1,56 *0.061*	3,12 *0.123*	38,0 *1.496*	5,2 *0.205*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.57-3.14-3R1	02730583	1,57 *0.062*	3,14 *0.124*	38,0 *1.496*	5,2 *0.205*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.58-3.16-3R1	02730584	1,58 *0.062*	3,16 *0.124*	38,0 *1.496*	5,2 *0.205*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.59-3.18-3R1	02730585	1,59 *0.063*	3,18 *0.125*	38,0 *1.496*	5,2 *0.205*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.60-3.20-3R1	02731605	1,6 *0.063*	3,2 *0.126*	38,0 *1.496*	5,2 *0.205*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.61-3.22-3R1	02730586	1,61 *0.063*	3,22 *0.127*	38,0 *1.496*	5,3 *0.209*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.62-3.24-3R1	02730587	1,62 *0.064*	3,24 *0.128*	38,0 *1.496*	5,3 *0.209*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.63-3.26-3R1	02730588	1,63 *0.064*	3,26 *0.128*	38,0 *1.496*	5,3 *0.209*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.64-3.28-3R1	02730589	1,64 *0.065*	3,28 *0.129*	38,0 *1.496*	5,3 *0.209*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.65-3.30-3R1	02730590	1,65 *0.065*	3,3 *0.130*	38,0 *1.496*	5,3 *0.209*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.66-3.32-3R1	02730592	1,66 *0.065*	3,32 *0.131*	38,0 *1.496*	5,4 *0.213*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.67-3.34-3R1	02730593	1,67 *0.066*	3,34 *0.131*	38,0 *1.496*	5,4 *0.213*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.68-3.36-3R1	02730594	1,68 *0.066*	3,36 *0.132*	38,0 *1.496*	5,4 *0.213*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.69-3.38-3R1	02730595	1,69 *0.067*	3,38 *0.133*	38,0 *1.496*	5,4 *0.213*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.70-3.40-3R1	02731606	1,7 *0.067*	3,4 *0.134*	38,0 *1.496*	5,4 *0.213*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.71-3.42-3R1	02730596	1,71 *0.067*	3,42 *0.135*	38,0 *1.496*	5,5 *0.217*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.72-3.44-3R1	02730597	1,72 *0.068*	3,44 *0.135*	38,0 *1.496*	5,5 *0.217*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.73-3.46-3R1	02730598	1,73 *0.068*	3,46 *0.136*	38,0 *1.496*	5,5 *0.217*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.74-3.48-3R1	02730599	1,74 *0.069*	3,48 *0.137*	38,0 *1.496*	5,5 *0.217*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.75-3.50-3R1	02730601	1,75 *0.069*	3,5 *0.138*	38,0 *1.496*	5,5 *0.217*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD22-1.76-3.52-3R1	02730602	1,76 *0.069*	3,52 *0.139*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.77-3.54-3R1	02730603	1,77 *0.070*	3,54 *0.139*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.78-3.56-3R1	02730604	1,78 *0.070*	3,56 *0.140*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.79-3.58-3R1	02730605	1,79 *0.070*	3,58 *0.141*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.80-3.60-3R1	02731607	1,8 *0.071*	3,6 *0.142*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.81-3.62-3R1	02730606	1,81 *0.071*	3,62 *0.143*	38,0 *1.496*	5,7 *0.224*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.82-3.64-3R1	02730607	1,82 *0.072*	3,64 *0.143*	38,0 *1.496*	5,7 *0.224*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.83-3.66-3R1	02730608	1,83 *0.072*	3,66 *0.144*	38,0 *1.496*	5,7 *0.224*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.84-3.68-3R1	02730609	1,84 *0.072*	3,68 *0.145*	38,0 *1.496*	5,7 *0.224*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.85-3.70-3R1	02730610	1,85 *0.073*	3,7 *0.146*	38,0 *1.496*	5,7 *0.224*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.86-3.72-3R1	02730611	1,86 *0.073*	3,72 *0.146*	38,0 *1.496*	5,8 *0.228*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.87-3.74-3R1	02730612	1,87 *0.074*	3,74 *0.147*	38,0 *1.496*	5,8 *0.228*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.88-3.76-3R1	02730613	1,88 *0.074*	3,76 *0.148*	38,0 *1.496*	5,8 *0.228*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.89-3.78-3R1	02730614	1,89 *0.074*	3,78 *0.149*	38,0 *1.496*	5,8 *0.228*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.90-3.80-3R1	02731609	1,9 *0.075*	3,8 *0.150*	38,0 *1.496*	5,8 *0.228*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.91-3.82-3R1	02730615	1,91 *0.075*	3,82 *0.150*	38,0 *1.496*	5,9 *0.232*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.92-3.84-3R1	02730616	1,92 *0.076*	3,84 *0.151*	38,0 *1.496*	5,9 *0.232*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.93-3.86-3R1	02730617	1,93 *0.076*	3,86 *0.152*	38,0 *1.496*	5,9 *0.232*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.94-3.88-3R1	02730618	1,94 *0.076*	3,88 *0.153*	38,0 *1.496*	5,9 *0.232*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.95-3.90-3R1	02730619	1,95 *0.077*	3,9 *0.154*	38,0 *1.496*	5,9 *0.232*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.96-3.92-3R1	02730620	1,96 *0.077*	3,92 *0.154*	38,0 *1.496*	6,0 *0.236*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.97-3.94-3R1	02730621	1,97 *0.078*	3,94 *0.155*	38,0 *1.496*	6,0 *0.236*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.98-3.96-3R1	02730622	1,98 *0.078*	3,96 *0.156*	38,0 *1.496*	6,0 *0.236*	3,0 *0.118*	130°	Unbeschichtet
SD22-1.99-3.98-3R1	02730623	1,99 *0.078*	3,98 *0.157*	38,0 *1.496*	6,0 *0.236*	3,0 *0.118*	130°	Unbeschichtet
SD22-2.00-4.00-3R1	02731610	2,0 *0.079*	4,0 *0.157*	38,0 *1.496*	6,0 *0.236*	3,0 *0.118*	130°	Unbeschichtet

SD26

Bohrtiefe ca. 6 x D – Metrisch/Zoll



–Zylinderschaft
–Äußere Kühlmittelzufuhr
–Schnittdaten siehe Seite(n) 162–166

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD26-0.10-0.40-3R1	02731612	0,1 *0.004*	0,4 *0.016*	38,0 *1.496*	0,7 *0.028*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.11-0.40-3R1	02730624	0,11 *0.004*	0,4 *0.016*	38,0 *1.496*	0,7 *0.028*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.12-0.40-3R1	02730625	0,12 *0.005*	0,4 *0.016*	38,0 *1.496*	0,7 *0.028*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.13-0.65-3R1	02730626	0,13 *0.005*	0,65 *0.026*	38,0 *1.496*	1,0 *0.039*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.14-0.65-3R1	02730627	0,14 *0.006*	0,65 *0.026*	38,0 *1.496*	1,0 *0.039*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.15-0.65-3R1	02731613	0,15 *0.006*	0,9 *0.035*	38,0 *1.496*	1,4 *0.055*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.16-0.90-3R1	02730628	0,16 *0.006*	0,9 *0.035*	38,0 *1.496*	1,4 *0.055*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.17-0.90-3R1	02730629	0,17 *0.007*	0,9 *0.035*	38,0 *1.496*	1,4 *0.055*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.18-0.90-3R1	02730630	0,18 *0.007*	0,9 *0.035*	38,0 *1.496*	1,4 *0.055*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.19-0.90-3R1	02730631	0,19 *0.007*	0,9 *0.035*	38,0 *1.496*	1,4 *0.055*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.20-1.25-3R1	02731615	0,2 *0.008*	1,25 *0.049*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.21-1.25-3R1	02730632	0,21 *0.008*	1,25 *0.049*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.22-1.25-3R1	02730633	0,22 *0.009*	1,25 *0.049*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.23-1.25-3R1	02730634	0,23 *0.009*	1,25 *0.049*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.24-1.25-3R1	02730635	0,24 *0.009*	1,25 *0.049*	38,0 *1.496*	1,8 *0.071*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.25-1.55-3R1	02731617	0,25 *0.010*	1,55 *0.061*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.26-1.55-3R1	02730636	0,26 *0.010*	1,55 *0.061*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.27-1.55-3R1	02730637	0,27 *0.011*	1,55 *0.061*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.28-1.55-3R1	02730638	0,28 *0.011*	1,55 *0.061*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.29-1.55-3R1	02730639	0,29 *0.011*	1,55 *0.061*	38,0 *1.496*	2,2 *0.087*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.30-1.80-3R1	02731618	0,3 *0.012*	1,8 *0.071*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.31-1.80-3R1	02730640	0,31 *0.012*	1,8 *0.071*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.32-1.80-3R1	02730641	0,32 *0.013*	1,8 *0.071*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.33-1.80-3R1	02730642	0,33 *0.013*	1,8 *0.071*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.34-1.80-3R1	02730643	0,34 *0.013*	1,8 *0.071*	38,0 *1.496*	2,4 *0.094*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.35-2.20-3R1	02731619	0,35 *0.014*	2,2 *0.087*	38,0 *1.496*	2,8 *0.110*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD26-0.36-2.20-3R1	02730644	0,36 *0.014*	2,2 *0.087*	38,0 *1.496*	2,8 *0.110*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.37-2.20-3R1	02730645	0,37 *0.015*	2,2 *0.087*	38,0 *1.496*	2,8 *0.110*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.38-2.20-3R1	02730646	0,38 *0.015*	2,2 *0.087*	38,0 *1.496*	2,8 *0.110*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.39-2.70-3R1	02730647	0,39 *0.015*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.40-2.70-3R1	02731620	0,4 *0.016*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.41-2.70-3R1	02730648	0,41 *0.016*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.42-2.70-3R1	02730649	0,42 *0.017*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.43-2.70-3R1	02730650	0,43 *0.017*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.44-2.70-3R1	02730651	0,44 *0.017*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.45-2.70-3R1	02731621	0,45 *0.018*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.46-2.70-3R1	02730652	0,46 *0.018*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.47-2.70-3R1	02730653	0,47 *0.019*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.48-2.70-3R1	02730654	0,48 *0.019*	2,7 *0.106*	38,0 *1.496*	3,6 *0.142*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.49-3.20-3R1	02730655	0,49 *0.019*	3,2 *0.126*	38,0 *1.496*	4,0 *0.157*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.50-3.20-3R1	02731622	0,5 *0.020*	3,2 *0.126*	38,0 *1.496*	4,0 *0.157*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.51-3.20-3R1	02730656	0,51 *0.020*	3,2 *0.126*	38,0 *1.496*	4,0 *0.157*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.52-3.20-3R1	02730657	0,52 *0.020*	3,2 *0.126*	38,0 *1.496*	4,0 *0.157*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.53-3.20-3R1	02730658	0,53 *0.021*	3,2 *0.126*	38,0 *1.496*	4,0 *0.157*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.54-3.60-3R1	02730659	0,54 *0.021*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.55-3.60-3R1	02731623	0,55 *0.022*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.56-3.60-3R1	02730660	0,56 *0.022*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.57-3.60-3R1	02730661	0,57 *0.022*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.58-3.60-3R1	02730662	0,58 *0.023*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.59-3.60-3R1	02730663	0,59 *0.023*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.60-3.60-3R1	02731624	0,6 *0.024*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.61-3.90-3R1	02730664	0,61 *0.024*	3,6 *0.142*	38,0 *1.496*	4,5 *0.177*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.62-3.90-3R1	02730665	0,62 *0.024*	3,9 *0.154*	38,0 *1.496*	5,0 *0.197*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.63-3.90-3R1	02730666	0,63 *0.025*	3,9 *0.154*	38,0 *1.496*	5,0 *0.197*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.64-3.90-3R1	02730667	0,64 *0.025*	3,9 *0.154*	38,0 *1.496*	5,0 *0.197*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.65-3.90-3R1	02731625	0,65 *0.026*	3,9 *0.154*	38,0 *1.496*	5,0 *0.197*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.66-3.90-3R1	02730668	0,66 *0.026*	3,9 *0.154*	38,0 *1.496*	5,0 *0.197*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.67-3.90-3R1	02730669	0,67 *0.026*	3,9 *0.154*	38,0 *1.496*	5,0 *0.197*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.68-4.50-3R1	02730670	0,68 *0.027*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.69-4.50-3R1	02730671	0,69 *0.027*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.70-4.50-3R1	02731626	0,7 *0.028*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD26-0.71-4.50-3R1	02730672	0,71 *0.028*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.72-4.50-3R1	02730673	0,72 *0.028*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.73-4.50-3R1	02730674	0,73 *0.029*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.74-4.50-3R1	02730675	0,74 *0.029*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.75-4.50-3R1	02731627	0,75 *0.030*	4,5 *0.177*	38,0 *1.496*	5,6 *0.220*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.76-5.00-3R1	02730676	0,76 *0.030*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.77-5.00-3R1	02730677	0,77 *0.030*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.78-5.00-3R1	02730678	0,78 *0.031*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.79-5.00-3R1	02730679	0,79 *0.031*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.80-5.00-3R1	02731628	0,8 *0.031*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.81-5.00-3R1	02730680	0,81 *0.032*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.82-5.00-3R1	02730681	0,82 *0.032*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.83-5.00-3R1	02730682	0,83 *0.033*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.84-5.00-3R1	02730683	0,84 *0.033*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.85-5.00-3R1	02731629	0,85 *0.033*	5,0 *0.197*	38,0 *1.496*	6,3 *0.248*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.86-5.70-3R1	02730684	0,86 *0.034*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.87-5.70-3R1	02730685	0,87 *0.034*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.88-5.70-3R1	02730686	0,88 *0.035*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.89-5.70-3R1	02730687	0,89 *0.035*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.90-5.70-3R1	02731630	0,9 *0.035*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.91-5.70-3R1	02730688	0,91 *0.036*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.92-5.70-3R1	02730689	0,92 *0.036*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.93-5.70-3R1	02730690	0,93 *0.037*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.94-5.70-3R1	02730691	0,94 *0.037*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.95-5.70-3R1	02731631	0,95 *0.037*	5,7 *0.224*	38,0 *1.496*	7,1 *0.280*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.96-6.50-3R1	02730692	0,96 *0.038*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.97-6.50-3R1	02730693	0,97 *0.038*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.98-6.50-3R1	02730694	0,98 *0.039*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-0.99-6.50-3R1	02730695	0,99 *0.039*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.00-6.50-3R1	02731632	1,0 *0.039*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.01-6.50-3R1	02730696	1,01 *0.040*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.02-6.50-3R1	02730697	1,02 *0.040*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.03-6.50-3R1	02730698	1,03 *0.041*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.04-6.50-3R1	02730699	1,04 *0.041*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.05-6.50-3R1	02730700	1,05 *0.041*	6,5 *0.256*	38,0 *1.496*	8,0 *0.315*	3,0 *0.118*	130°	Unbeschichtet

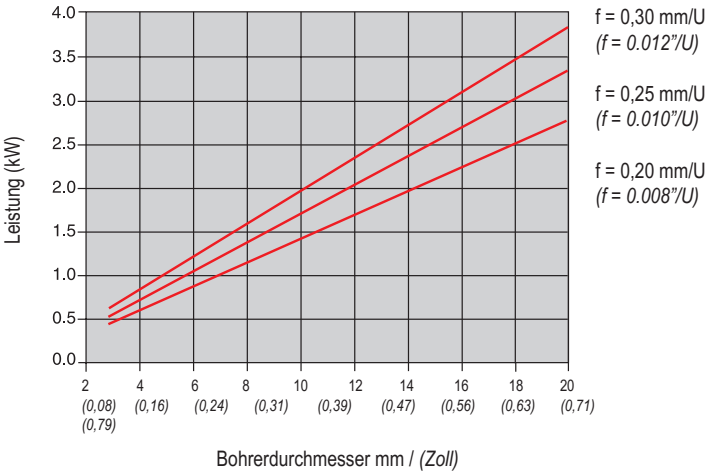
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD26-1.06-7.30-3R1	02730701	1,06 *0.042*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.07-7.30-3R1	02730702	1,07 *0.042*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.08-7.30-3R1	02730703	1,08 *0.043*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.09-7.30-3R1	02730704	1,09 *0.043*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.10-7.30-3R1	02731633	1,1 *0.043*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.11-7.30-3R1	02730705	1,11 *0.044*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.12-7.30-3R1	02730706	1,12 *0.044*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.13-7.30-3R1	02730707	1,13 *0.044*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.14-7.30-3R1	02730708	1,14 *0.045*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.15-7.30-3R1	02730709	1,15 *0.045*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.16-8.20-3R1	02730710	1,16 *0.046*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.17-8.20-3R1	02730711	1,17 *0.046*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.18-8.20-3R1	02730712	1,18 *0.046*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.19-8.20-3R1	02730713	1,19 *0.047*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.20-8.20-3R1	02731634	1,2 *0.047*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.21-8.20-3R1	02730714	1,21 *0.048*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.22-8.20-3R1	02730715	1,22 *0.048*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.23-8.20-3R1	02730716	1,23 *0.048*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.24-8.20-3R1	02730717	1,24 *0.049*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.25-8.20-3R1	02730718	1,25 *0.049*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.26-8.20-3R1	02730719	1,26 *0.050*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.27-8.20-3R1	02730720	1,27 *0.050*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.28-8.20-3R1	02730721	1,28 *0.050*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.29-8.20-3R1	02730722	1,29 *0.051*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.30-8.20-3R1	02731635	1,3 *0.051*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.31-9.20-3R1	02730723	1,31 *0.052*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.32-9.20-3R1	02730724	1,32 *0.052*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.33-9.20-3R1	02730725	1,33 *0.052*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.34-9.20-3R1	02730726	1,34 *0.053*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.35-9.20-3R1	02730727	1,35 *0.053*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.36-9.20-3R1	02730728	1,36 *0.054*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.37-9.20-3R1	02730729	1,37 *0.054*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.38-9.20-3R1	02730730	1,38 *0.054*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.39-9.20-3R1	02730731	1,39 *0.055*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.40-9.20-3R1	02731637	1,4 *0.055*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD26-1.41-9.20-3R1	02730732	1,41 *0.056*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.42-9.20-3R1	02730733	1,42 *0.056*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.43-9.20-3R1	02730734	1,43 *0.056*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.44-9.20-3R1	02730735	1,44 *0.057*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.45-9.20-3R1	02730736	1,45 *0.057*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.46-9.20-3R1	02730737	1,46 *0.057*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.47-9.20-3R1	02730738	1,47 *0.058*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.48-9.20-3R1	02730739	1,48 *0.058*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.49-9.20-3R1	02730740	1,49 *0.059*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.50-9.20-3R1	02731638	1,5 *0.059*	9,2 *0.362*	38,0 *1.496*	11,2 *0.441*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.51-11.20-3R1	02730741	1,51 *0.059*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.52-11.20-3R1	02730742	1,52 *0.060*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.53-11.20-3R1	02730743	1,53 *0.060*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.54-11.20-3R1	02730744	1,54 *0.061*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.55-11.20-3R1	02730745	1,55 *0.061*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.56-11.20-3R1	02730746	1,56 *0.061*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.57-11.20-3R1	02730747	1,57 *0.062*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.58-11.20-3R1	02730748	1,58 *0.062*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.59-11.20-3R1	02730749	1,59 *0.063*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.60-11.20-3R1	02731639	1,6 *0.063*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.61-11.20-3R1	02730750	1,61 *0.063*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.62-11.20-3R1	02730751	1,62 *0.064*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.63-11.20-3R1	02730752	1,63 *0.064*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.64-11.20-3R1	02730753	1,64 *0.065*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.65-11.20-3R1	02730754	1,65 *0.065*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.66-11.20-3R1	02730755	1,66 *0.065*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.67-11.20-3R1	02730756	1,67 *0.066*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.68-11.20-3R1	02730757	1,68 *0.066*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.69-11.20-3R1	02730758	1,69 *0.067*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.70-11.20-3R1	02731640	1,7 *0.067*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.71-11.20-3R1	02730759	1,71 *0.067*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.72-11.20-3R1	02730760	1,72 *0.068*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.73-11.20-3R1	02730761	1,73 *0.068*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.74-11.20-3R1	02730762	1,74 *0.069*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.75-11.20-3R1	02730763	1,75 *0.069*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet

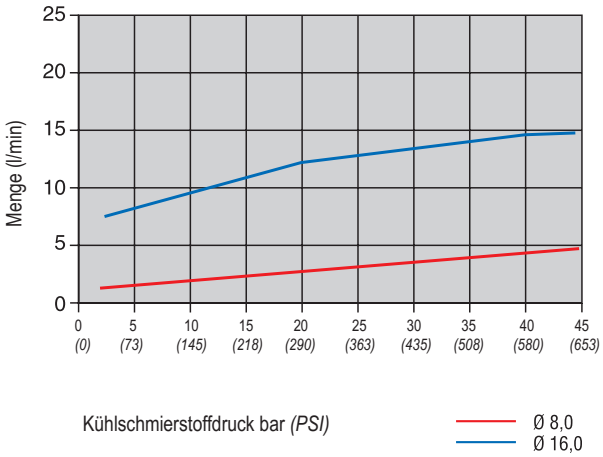
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM	Spitzenwinkel:	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		
SD26-1.76-11.20-3R1	02730764	1,76 *0.069*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.77-11.20-3R1	02730765	1,77 *0.070*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.78-11.20-3R1	02730766	1,78 *0.070*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.79-11.20-3R1	02730767	1,79 *0.070*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.80-11.20-3R1	02731641	1,8 *0.071*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.81-11.20-3R1	02730768	1,81 *0.071*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.82-11.20-3R1	02730769	1,82 *0.072*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.83-11.20-3R1	02730770	1,83 *0.072*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.84-11.20-3R1	02730771	1,84 *0.072*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.85-11.20-3R1	02730772	1,85 *0.073*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.86-11.20-3R1	02730773	1,86 *0.073*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.87-11.20-3R1	02730774	1,87 *0.074*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.88-11.20-3R1	02730775	1,88 *0.074*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.89-11.20-3R1	02730776	1,89 *0.074*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.90-11.20-3R1	02731642	1,9 *0.075*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.91-11.20-3R1	02730777	1,91 *0.075*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.92-11.20-3R1	02730778	1,92 *0.076*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.93-11.20-3R1	02730779	1,93 *0.076*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.94-11.20-3R1	02730780	1,94 *0.076*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.95-11.20-3R1	02730781	1,95 *0.077*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.96-11.20-3R1	02730782	1,96 *0.077*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.97-11.20-3R1	02730783	1,97 *0.078*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.98-11.20-3R1	02730784	1,98 *0.078*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-1.99-11.20-3R1	02730785	1,99 *0.078*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet
SD26-2.00-11.20-3R1	02731643	2,0 *0.079*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Unbeschichtet

Bearbeitungsparameter

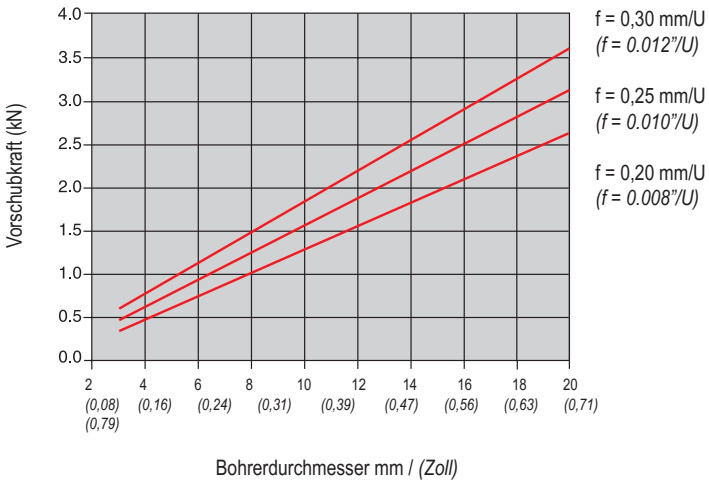
Leistungsbedarf



Kühlmittelmenge und Druck



Vorschubkraft



Einsatz:
Vorschub anpassen, um eine gute Spanformung zu erhalten.
Die Erhöhung des Vorschubs ergibt kürzere Späne.

Die Grafiken zeigen Basiswerte, die, abhängig von Werkstoff und Schnittdaten, den individuellen Bearbeitungsbedingungen angepasst werden müssen.

Bearbeitungsparameter

SD1103, SD1103A, SD1105A, SD203A, SD205A, SD206, SD206A, SD207A, SD2016A, SD2020A, SD2025A, SD2030A
IT8–9/R_a 1–3*

Bohrerdurchmesser DC (mm)	IT9 Toleranz (µm)	IT10 Toleranz (µm)	Bohrdurchmesser DC *(Zoll)*	Toleranz IT9 *(Zoll)*	Toleranz IT10 *(Zoll)*
< 3	**14**	**25**	*-0.118*	*0.0006*	*0.0010*
3-6	**18**	**30**	*> 0.118-0.236*	*0.0007*	*0.0012*
6-10	**22**	**36**	*> 0.236-0.394*	*0.0009*	*0.0014*
10-18	**27**	**43**	*> 0.394-0.709*	*0.0011*	*0.0017*
> 18	**33**	**52**	*> 0.709*	*0.0013*	*0.0020*

* Bei Stahl mit niedrigem Kohlenstoffanteil und Rostfrei können die Werte für die Oberflächengüte geringer ausfallen.

Einsatzhinweise

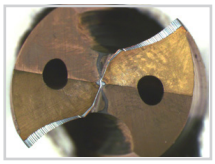
- Stabilität der Aufspannung
- Zustand der Maschinenspindel
- Zustand der Aufnahme

- Aufspannung:
  - Max. Rundlauffehler 0,04 TIR
  - Max. Rundlauffehler bei SD216A innerhalb von 0,04 TIR

- Spanabfuhr:
  - Schnittdaten

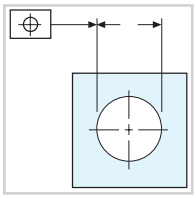
- Kühlung:
  - Druck
  - Durchfluss
  - Konzentration

Schneller Freiflächenverschleiß



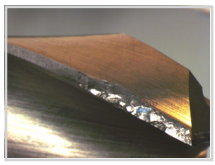
- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen

Durchmesser außer Toleranz



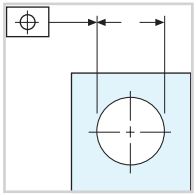
- Vorschub/U erhöhen
- Reibbearbeitung einsetzen, siehe Seite(n) 328
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 479-480

Fasenverschleiß



- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen

Mittenversatz der Bohrung

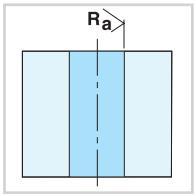


- Vorschub/U im Eintritt reduzieren.
- Vorschub/U reduzieren.
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 479-480
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30-50% reduzieren.
- Mit einem Zentrierbohrer mit 140° vorzentrieren

Ausbrüche/Querschneide

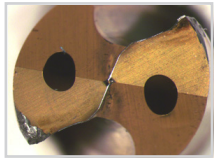
- Vorschub/U beim Eintritt senken
- Kühlmitteldruck erhöhen
- Optimierung des Vorschubes um eine gute Spanbildung zu erzeugen, siehe Seite(n) 479-480

Geringe Oberflächengüte



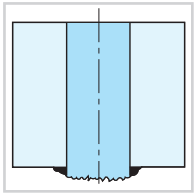
- Vorschub/U reduzieren.
- Schnittgeschwindigkeit erhöhen.
- Reibbearbeitung einsetzen, siehe Seite(n) 328

Ausbrüche/Ecke, Schneidkante



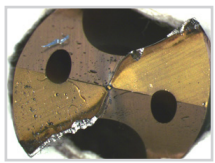
- Vorschub bei Ein- und Austritt reduzieren
- Schnittgeschwindigkeit reduzieren
- Kühlschmierstoffkonzentration erhöhen
- Bohrer nachschleifen

Gratbildung bei Bohreraustritt



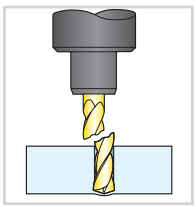
- Vorschub/U beim Ein- und Austritt reduzieren
- Breite der Primärfase (BN) reduzieren

Aufbauschneide



- In der Nähe des Peripheriebereichs die Schnittgeschwindigkeit erhöhen
- In der Nähe des Zentrumbereichs den Vorschub/U erhöhen
- Den Bohrer falls nötig nachschleifen

Werkzeugbruch am Bohrungsgrund



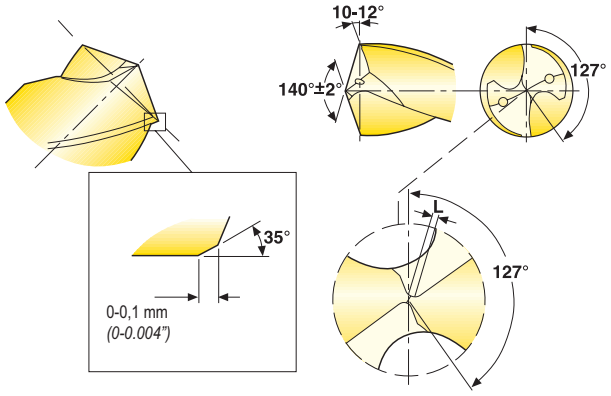
- Vorschub/U beim Ein- und Austritt reduzieren
- Schnittdaten anpassen, um die Spanformung zu optimieren

Nachschliff der Vollhartmetallbohrer für SD1103, SD1103A, SD1105A und SD1108A

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe:
Spitzenanschliff: Diamant-Schleifscheibenform 12A2 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 4: Fase schleifen oder bürsten.

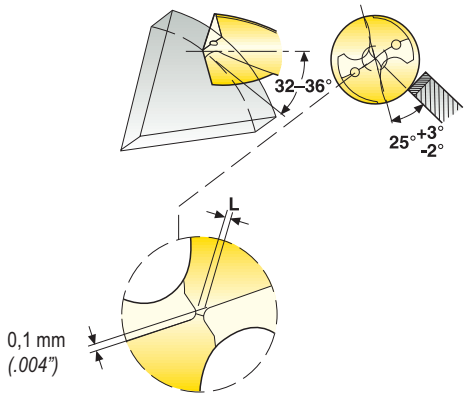
Wichtig:
- Die Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Hinterschliff



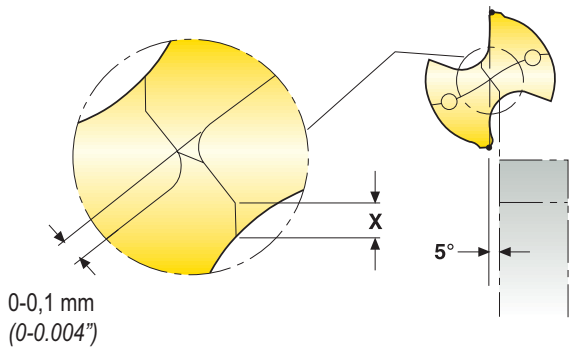
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



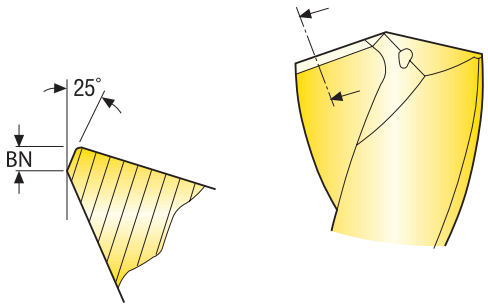
Bohrdurchmesser DC mm	L mm	Bohrdurchmesser DC *Zoll*	L *Zoll*
2-10	0,1-0,3	*0.079-0.394*	*0.004-0.012*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Schleifen der Fläche X



X = 0,08 x (0.003) x Bohrerdurchmesser DC

4. Schneidkantenpräparation



Werkstoff	BN Bohrdurchmesser ≤ 10 mm	> 10 mm	≤ 0.394 *Zoll*	> 0.394 *Zoll*
Stahl	0,05	0,10	*0.002*	*0.004*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,10	*0.002*	*0.004*

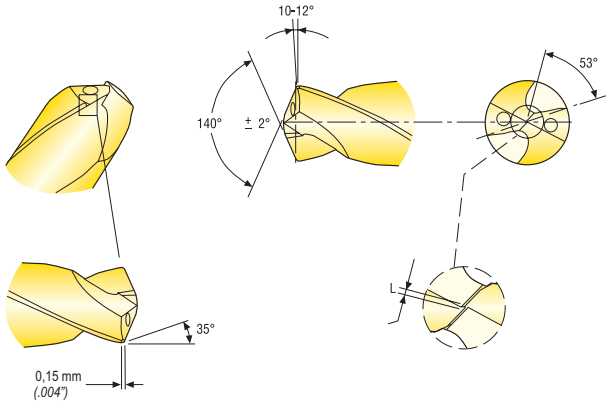
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Hinweise zum Nachschleifen für SD203A, SD205A und SD207A – P-Geometrie

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe:
Abb. 1: Diamant-Schleifscheibenform 12A2 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 4: Fase schleifen oder bürsten.

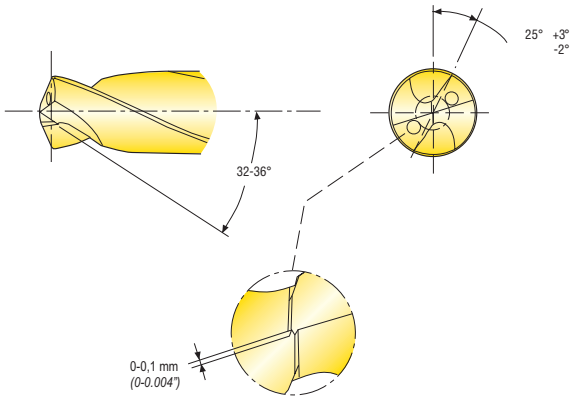
Wichtig:
- Die Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Hinterschliff



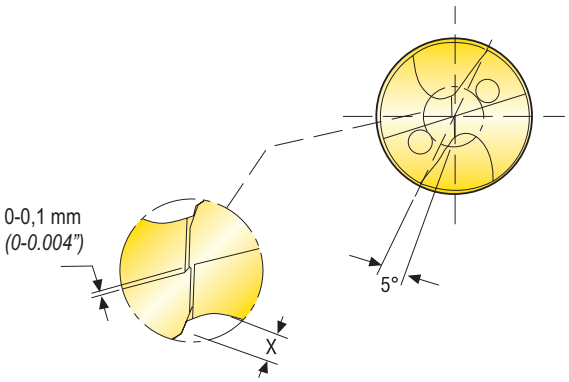
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



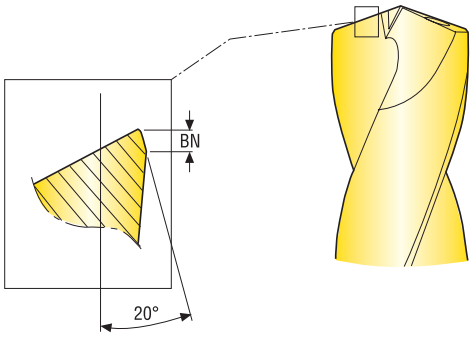
Bohrdurchmesser DC mm	L mm	Bohrdurchmesser DC *Zoll*	L *Zoll*
2-10	0,1-0,3	*0.079-0.394*	*0.004-0.012*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Schleifen der Fläche X



X = 0,08 x (0.003) x Bohrerdurchmesser DC

4. Schneidkantenpräparation



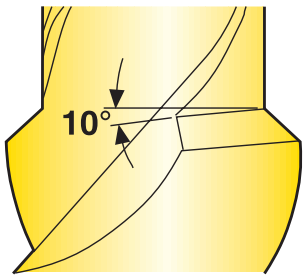
Werkstoff	BN Bohrdurchmesser ≤ 10 mm	> 10 mm	≤ 0.394 *Zoll*	> 0.394 *Zoll*
Stahl	0,05	0,10	*0.002*	*0.004*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,10	*0.002*	*0.004*

Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

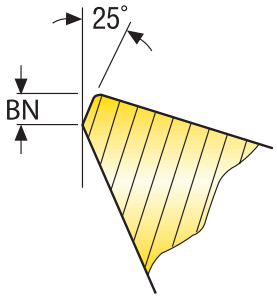
Nachschliff für Fasbohrer

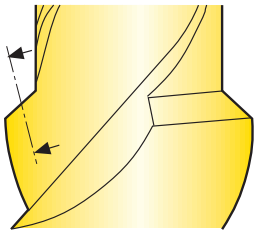
Es gelten die gleichen Anweisungen wie für SD203, SD203A, SD205A und SD207A, ausgenommen für die Fase.

1. Fasen-Ausführung



2. Schneidkantenpräparation, Fase





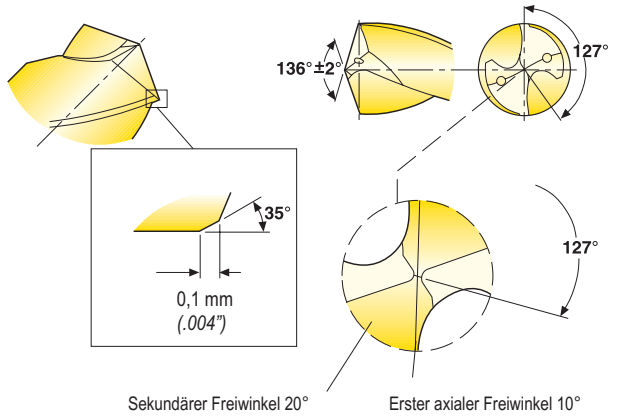
Werkstoff	BN Bohrdurchmesser			
	≤ 10 mm	> 10 mm	≤ 0.394 *Zoll*	> 0.394 *Zoll*
Stahl	0,05	0,05	*0.002*	*0.002*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,05	*0.002*	*0.002*

Nachschleifanweisungen für Geometrie SD212A, SD216A, SD220A, SD225A und SD230A

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe
Spitzenanschliff Diamant-Schleifscheibenform 11V9 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 4: Fase schleifen oder bürsten.

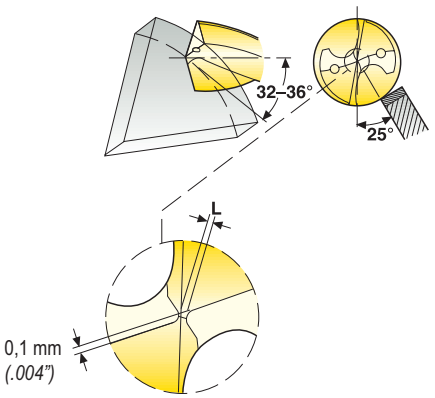
Wichtig:
- Die Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Hinterschliff



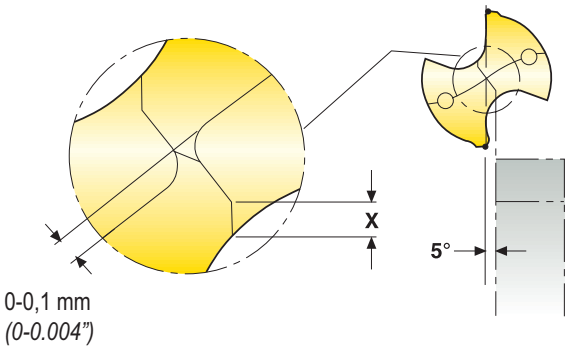
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



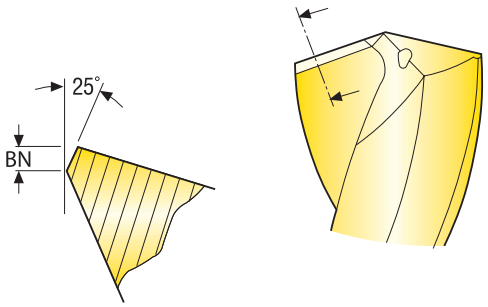
Bohrdurchmesser DC mm	L mm	Bohrdurchmesser DC *Zoll*	L *Zoll*
2-10	0,2	*0.079-0.394*	*0.008*
10-20	0,4	*0.394-0.787*	*0.016*

3. Schleifen der Fläche X



X = 0,08 x (0.003) x Bohrerdurchmesser DC

4. Schneidkantenpräparation

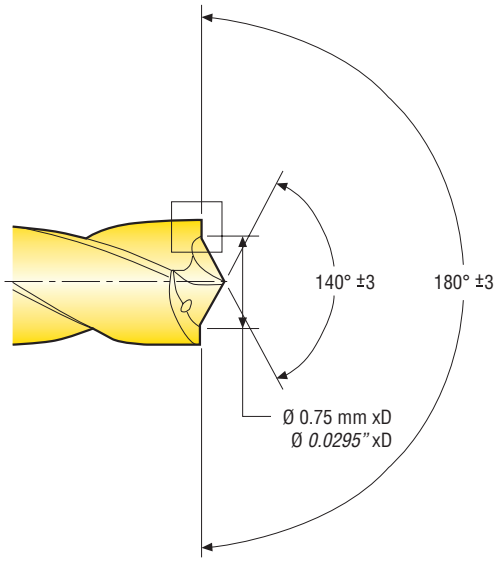


Werkstoff	BN Bohrdurchmesser ≤ 10 mm	> 10 mm	≤ 0.394 *Zoll*	> 0.394 *Zoll*
Stahl	0,05	0,10	*0.002*	*0.004*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,10	*0.002*	*0.004*

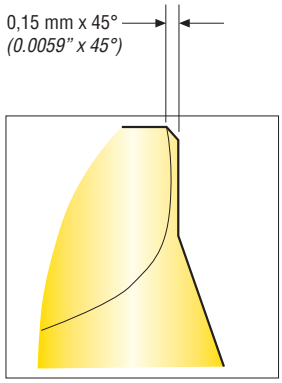
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Nachschleifanweisungen für SD243, SD243A, SD245A und SD247A

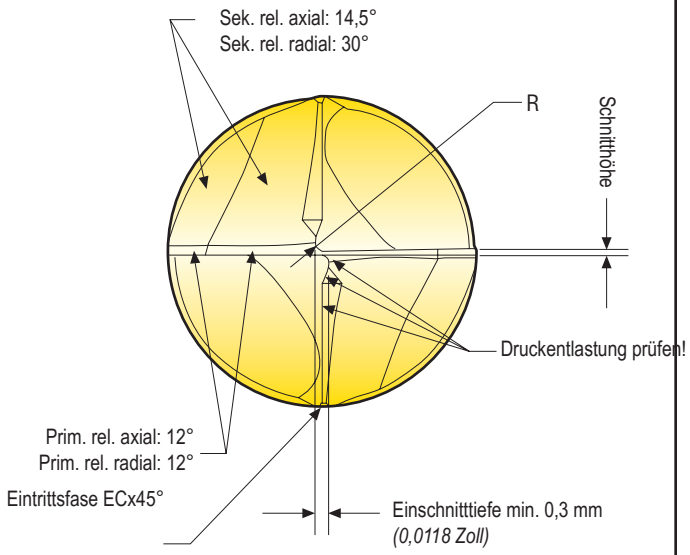
1. Spitzenwinkel



2. Eckenfase

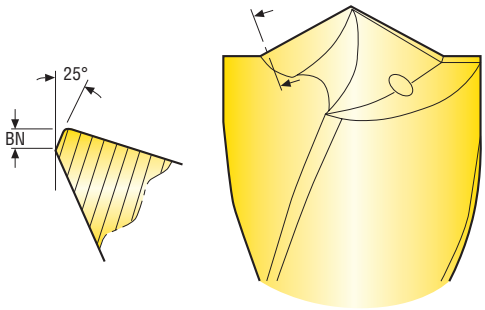


3.



Abmessungen in mm (Zoll)	Schnitthöhe mm (Zoll)	R mm (Zoll)	EC mm (Zoll)
– 10 (0.3937)	0,2 (0.0079)	0,2 (0.0079)	0,3 (0.0118)
10,01 (0.3941) –	0,3 (0.0118)	0,4 (0.0157)	0,5 (0.0197)

4. Schneidkantenpräparation



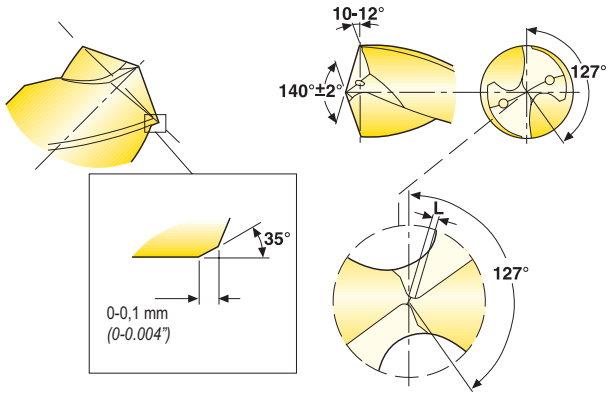
Werkstoff	BN Bohrdurchmesser			
	≤ 10 mm	> 10 mm	≤ 0.394 Zoll	> 0.394 Zoll
Stahl	0,05	0,10	0.002	0.004
Rostfrei	0,05	0,05	0.002	0.002
Guss	0,05	0,10	0.002	0.004

Nachschleifanweisungen für SD265A

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe
Abb. 1: Diamant-Schleifscheibenform 12A2 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 4: Fase schleifen oder bürsten.

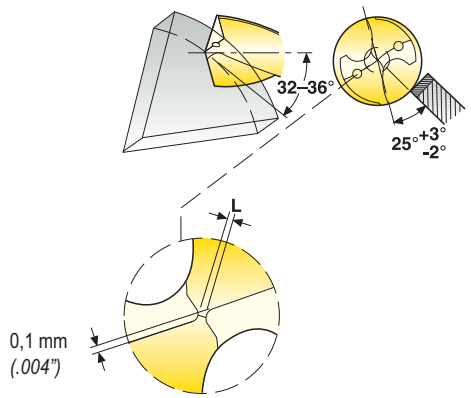
Wichtig:
- Die Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Hinterschliff



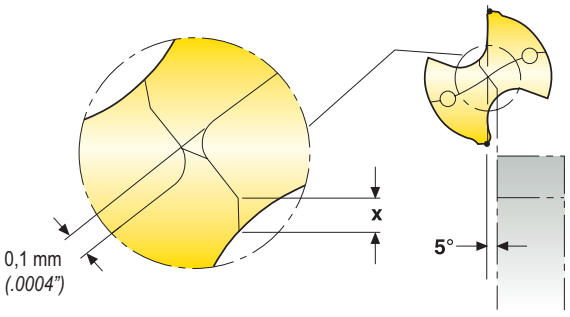
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



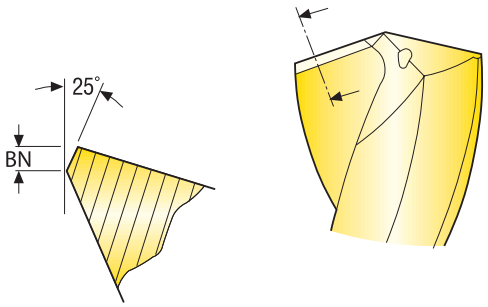
Bohrdurchmesser DC mm	L mm	Bohrdurchmesser DC *Zoll*	L *Zoll*
2-10	0,2	*0.079-0.394*	*0.008*
10-20	0,4	*0.394-0.787*	*0.016*

3. Schleifen der Fläche X



X = 0,08 x (0.003) x Bohrerdurchmesser DC

4. Schneidkantenpräparation



Werkstoff	BN Bohrdurchmesser ≤ 10 mm	> 10 mm	≤ 0.394 *Zoll*	> 0.394 *Zoll*
Stahl	0,05	0,10	*0.002*	*0.004*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,10	*0.002*	*0.004*

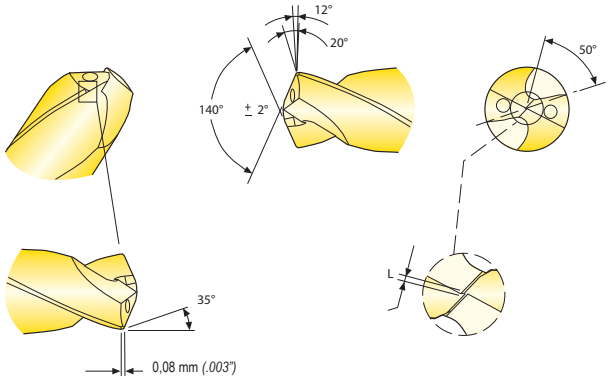
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Nachschliff für -MS-Geometrie

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe
Abb. 1: Diamant-Schleifscheibenform 12A2 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 4: Fase schleifen oder bürsten.

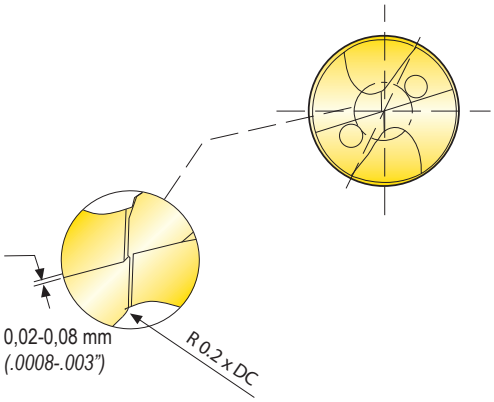
Wichtig:
- Die Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Hinterschliff

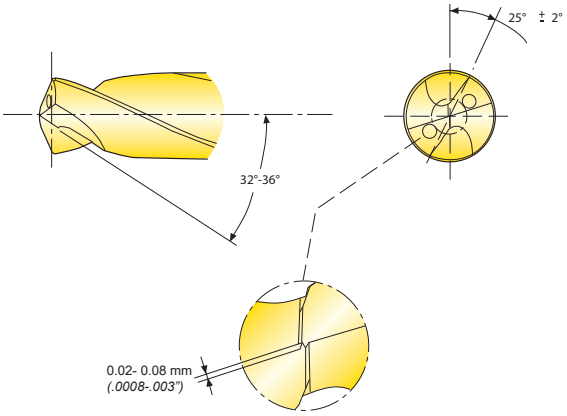


Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

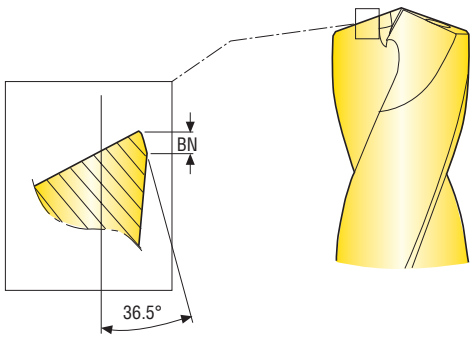
2. Schleifen des Radius R



3. Ausspitzung der Querschneide



4. Schneidkantenpräparation



Bohrdurchmesser DC mm	BN mm	Bohrdurchmesser DC *Zoll*	BN *Zoll*
2-3	0,2	*0.079-0.118*	*0.00787*
3-6	0,025	*0.118-0.236*	*0.00098*
6-10	0,04	*0.236-0.394*	*0.00157*
10-20	0,055	*0.394-0.787*	*0.00216*
20-	0,07	*0.787-*	*0.00275*

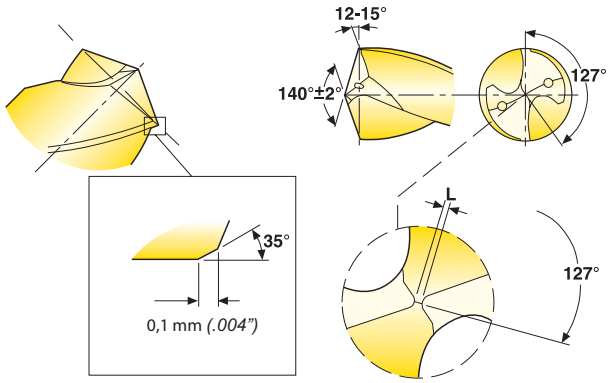
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Nachschliff der Vollhartmetallbohrer mit M- und T-Geometrie

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe
Abb. 1: Diamant-Schleifscheibenform 12A2 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 4: Fase schleifen oder bürsten.

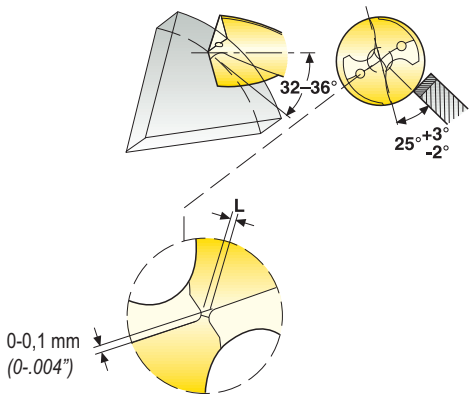
Wichtig:
- Die Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Hinterschliff



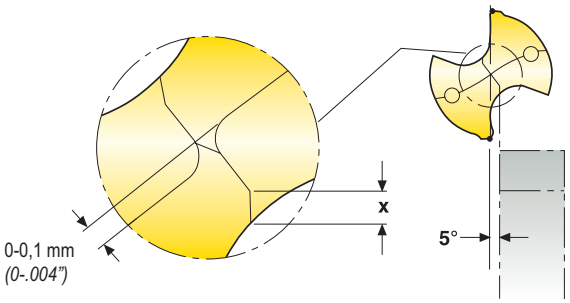
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,01 mm *(0,0004 Zoll)*

2. Ausspitzung der Querschneide

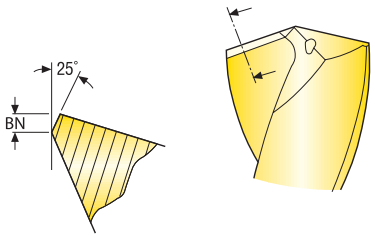


Bohrdurchmesser DC mm	L mm	Bohrdurchmesser DC *Zoll*	L *Zoll*
3-6	0,1-0,2	*0.118-0.236*	*0.004-0.008*
6-10	0,13-0,27	*0.236-0.394*	*0.005-0.011*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Schleifen der Fläche X



4. Schneidkantenpräparation



BN = 0,02 mm *(0.008")*

Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

SD1103 – ∅ 3-20 mm / *0.118-0.787 Zoll*

SMG	f										v_c
	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	105 *345*
P2	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,36 *0.014*	105 *345*
P3	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	90 *295*
P4	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	80 *260*
P5	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	75 *245*
P6	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	85 *280*
P7	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	80 *260*
P8	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	75 *245*
P11	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	75 *245*
P12	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	46 *150*
M1	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	55 *180*
M2	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	45 *150*
K1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,36 *0.014*	70 *230*
K2	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	60 *195*
K3	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	50 *165*
K4	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	49 *160*
K5	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	29 *95*
H3	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	24 *80*
H5	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	45 *150*
H7	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	24 *80*
H8	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	45 *150*
H11	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	60 *195*
H12	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	27 *90*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD1103A – ∅ 3-20 mm / *0.118-0.787 Zoll*

SMG	f										v_c
	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	150 *490*
P2	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,36 *0.014*	145 *475*
P3	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	125 *410*
P4	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	110 *360*
P5	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	105 *345*
P6	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	120 *395*
P7	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	110 *360*
P8	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	105 *345*
P11	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	75 *245*
P12	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	50 *165*
M1	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	80 *260*
M2	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	65 *215*
M3	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	48 *155*
M4	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	36 *120*
M5	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	30 *100*
K1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,36 *0.014*	95 *310*
K2	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	80 *260*
K3	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	70 *230*
K4	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	65 *215*
K5	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	39 *130*
N1	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	260 *850*
N2	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	170 *560*
N3	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	110 *360*
N11	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	210 *690*
H3	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	34 *110*
H5	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	65 *215*
H7	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	34 *110*
H8	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	65 *215*
H11	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	80 *260*
H12	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	38 *125*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD1105A – ∅ **3-20 mm** / *0.118-0.787 Zoll*

SMG	f										v_c
	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	135 *445*
P2	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,36 *0.014*	135 *445*
P3	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	115 *375*
P4	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	100 *330*
P5	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	95 *310*
P6	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	110 *360*
P7	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	100 *330*
P8	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	95 *310*
P11	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	65 *215*
P12	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	48 *155*
M1	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	70 *230*
M2	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	60 *195*
M3	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	44 *145*
M4	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	33 *110*
M5	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	27 *90*
K1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,36 *0.014*	85 *280*
K2	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	75 *245*
K3	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	65 *215*
K4	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	60 *195*
K5	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	36 *120*
N1	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	240 *790*
N2	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	155 *510*
N3	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	100 *330*
N11	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	190 *620*
H3	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	31 *100*
H5	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	60 *195*
H7	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	31 *100*
H8	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	60 *195*
H11	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	75 *245*
H12	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	35 *115*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD1108A – ∅ 3-20 mm / *0.118-0.787 Zoll*

SMG	f										v_c
	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	120 *395*
P2	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,36 *0.014*	115 *375*
P3	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	100 *330*
P4	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	85 *280*
P5	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	85 *280*
P6	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	95 *310*
P7	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	90 *295*
P8	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	85 *280*
P11	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	60 *195*
P12	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	42 *140*
M1	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	60 *195*
M2	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	50 *165*
M3	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	38 *125*
M4	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	29 *95*
M5	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	24 *80*
K1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,36 *0.014*	75 *245*
K2	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	65 *215*
K3	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	55 *180*
K4	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	50 *165*
K5	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	31 *100*
N1	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	205 *670*
N2	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	135 *445*
N3	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	90 *295*
N11	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	165 *540*
H3	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	27 *90*
H5	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	50 *165*
H7	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	27 *90*
H8	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	50 *165*
H11	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	65 *215*
H12	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	30 *100*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Beim Bohren in Rostfrei mit 8 x D und 12 x D kann ein Vorbohren erforderlich sein.

SD1112A – ∅ 3-20 mm / *0.118-0.787 Zoll*

SMG	f										v_c
	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	100 *330*
P2	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,36 *0.014*	100 *330*
P3	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	85 *280*
P4	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	75 *245*
P5	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	70 *230*
P6	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	80 *260*
P7	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	75 *245*
P8	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	0,34 *0.013*	70 *230*
P11	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	50 *165*
P12	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	36 *120*
M1	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	55 *180*
M2	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	43 *140*
M3	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	33 *110*
M4	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	25 *80*
M5	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	21 *70*
K1	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,34 *0.013*	0,34 *0.013*	0,36 *0.014*	65 *215*
K2	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	55 *180*
K3	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	47 *155*
K4	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	0,32 *0.013*	0,34 *0.013*	45 *150*
K5	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	27 *90*
N1	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	180 *590*
N2	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	115 *375*
N3	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	75 *245*
N11	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,32 *0.013*	0,34 *0.013*	0,36 *0.014*	0,38 *0.015*	0,40 *0.016*	145 *475*
H3	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	23 *75*
H5	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	43 *140*
H7	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	23 *75*
H8	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	43 *140*
H11	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	55 *180*
H12	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,17 *0.0065*	26 *85*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Beim Bohren in Rostfrei mit 8 x D und 12 x D kann ein Vorbohren erforderlich sein.

SD203A – ∅ 2-8 mm / *0.079-0.315 Zoll*

SMG		f						v_c
		Ø 2,00 *Ø 0.079*	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 5,00 *Ø 0.197*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	
P1	P	0,14	0,17	0,20	0,24	0,26	0,32	185
	P	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.013*	*610*
P2	P	0,14	0,17	0,20	0,24	0,26	0,32	180
	P	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.013*	*590*
P3	P	0,14	0,16	0,19	0,22	0,25	0,32	155
	P	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*510*
P4	P	0,10	0,13	0,15	0,17	0,19	0,24	210
	P	*0.0040*	*0.0050*	*0.0060*	*0.0065*	*0.0075*	*0.0095*	*690*
P5	P	0,10	0,12	0,14	0,17	0,19	0,22	205
	P	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*670*
P6	P	0,10	0,12	0,14	0,16	0,19	0,22	230
	P	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*750*
P7	P	0,10	0,12	0,14	0,16	0,19	0,22	215
	P	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*710*
P8	P	0,11	0,13	0,15	0,17	0,19	0,24	200
	P	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0075*	*0.0095*	*660*
P11	P	0,060	0,075	0,085	0,10	0,11	0,14	105
	P	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*345*
P12	P	0,060	0,075	0,085	0,10	0,11	0,14	75
	P	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*245*
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	110
	MS	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0075*	*360*
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	90
	MS	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*295*
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	45
	MS	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0080*	*150*
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	50
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*165*
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	42
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*140*
K1	P	0,15	0,18	0,22	0,25	0,28	0,36	175
	P	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.014*	*570*
K2	P	0,14	0,17	0,20	0,22	0,26	0,32	150
	P	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.013*	*490*
K3	P	0,14	0,17	0,20	0,22	0,26	0,32	125
	P	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.013*	*410*
K4	P	0,14	0,17	0,20	0,22	0,26	0,32	120
	P	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.013*	*395*
K5	P	0,12	0,15	0,18	0,20	0,24	0,28	70
	P	*0.0048*	*0.0060*	*0.0070*	*0.0080*	*0.0095*	*0.011*	*230*
N1	N	0,13	0,16	0,19	0,22	0,26	0,32	350
	N	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*1150*
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	225
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*740*
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	150
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*490*
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	285
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*940*
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	39
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*130*
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S11	MS	0,070	0,085	0,095	0,11	0,12	0,14	70
	MS	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*230*
S12	MS	0,070	0,085	0,095	0,11	0,12	0,14	55
	MS	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*180*
S13	MS	0,065	0,075	0,085	0,095	0,10	0,12	43
	MS	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0040*	*0.0048*	*140*
H3	P	0,055	0,070	0,080	0,090	0,10	0,12	28
	P	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*90*
H5	P	0,085	0,10	0,12	0,13	0,15	0,18	55
	P	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0060*	*0.0070*	*180*
H7	P	0,055	0,070	0,080	0,090	0,10	0,12	28
	P	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*90*
H8	P	0,065	0,080	0,090	0,10	0,12	0,14	55
	P	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*180*
H11	P	0,085	0,10	0,12	0,13	0,15	0,18	65
	P	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0060*	*0.0070*	*215*
H12	P	0,065	0,080	0,090	0,10	0,12	0,14	80
	P	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*260*
H21	P	0,065	0,080	0,090	0,10	0,12	0,14	55
	P	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*180*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD203A – ∅ 10-20 mm / *0.394-0.787 Zoll*

SMG		f						v_c
		Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	P	0,38	0,44	0,48	0,50	0,55	0,55	185
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*610*
P2	P	0,38	0,44	0,48	0,50	0,55	0,60	180
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.024*	*590*
P3	P	0,36	0,42	0,46	0,50	0,50	0,55	155
	P	*0.014*	*0.017*	*0.018*	*0.020*	*0.020*	*0.022*	*510*
P4	P	0,28	0,30	0,34	0,36	0,38	0,40	210
	P	*0.011*	*0.012*	*0.013*	*0.014*	*0.015*	*0.016*	*690*
P5	P	0,26	0,30	0,32	0,34	0,36	0,38	205
	P	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*670*
P6	P	0,26	0,30	0,32	0,34	0,36	0,38	230
	P	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*750*
P7	P	0,26	0,30	0,32	0,34	0,36	0,38	215
	P	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*710*
P8	P	0,28	0,32	0,34	0,36	0,38	0,40	200
	P	*0.011*	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*660*
P11	P	0,16	0,18	0,20	0,22	0,24	0,24	105
	P	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*345*
P12	P	0,16	0,18	0,20	0,22	0,24	0,24	75
	P	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*245*
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	110
	MS	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*360*
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	90
	MS	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*295*
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	45
	MS	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*150*
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	50
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*165*
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	42
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*140*
K1	P	0,42	0,48	0,50	0,55	0,60	0,65	175
	P	*0.017*	*0.019*	*0.020*	*0.022*	*0.024*	*0.026*	*570*
K2	P	0,38	0,42	0,48	0,50	0,55	0,55	150
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*490*
K3	P	0,38	0,42	0,48	0,50	0,55	0,55	125
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*410*
K4	P	0,38	0,42	0,48	0,50	0,55	0,55	120
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*395*
K5	P	0,34	0,38	0,42	0,46	0,48	0,50	70
	P	*0.013*	*0.015*	*0.017*	*0.018*	*0.019*	*0.020*	*230*
N1	N	0,38	0,42	0,46	0,50	0,55	0,55	350
	N	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*1150*
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	225
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*740*
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	150
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*490*
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	285
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*940*
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	39
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*130*
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S11	MS	0,17	0,19	0,22	0,24	0,25	0,26	70
	MS	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*230*
S12	MS	0,17	0,19	0,22	0,24	0,25	0,26	55
	MS	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*180*
S13	MS	0,15	0,17	0,19	0,20	0,22	0,22	43
	MS	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*140*
H3	P	0,14	0,16	0,18	0,19	0,20	0,20	28
	P	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*90*
H5	P	0,22	0,24	0,26	0,28	0,30	0,32	55
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*180*
H7	P	0,14	0,16	0,18	0,19	0,20	0,20	28
	P	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*90*
H8	P	0,16	0,19	0,20	0,22	0,24	0,24	55
	P	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*180*
H11	P	0,22	0,24	0,26	0,28	0,30	0,32	65
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*215*
H12	P	0,16	0,19	0,20	0,22	0,24	0,24	80
	P	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*260*
H21	P	0,16	0,19	0,20	0,22	0,24	0,24	55
	P	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*180*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A – ∅ 2-8 mm / *0.079-0.315 Zoll*

SMG		f						v_c
		Ø 2,00 *Ø 0.079*	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 5,00 *Ø 0.197*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	
P1	P	0,14	0,17	0,20	0,24	0,26	0,32	170
	P	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.013*	*560*
P2	P	0,14	0,17	0,20	0,24	0,26	0,32	165
	P	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.013*	*540*
P3	P	0,14	0,16	0,19	0,22	0,25	0,32	140
	P	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*460*
P4	P	0,10	0,13	0,15	0,17	0,19	0,24	195
	P	*0.0040*	*0.0050*	*0.0060*	*0.0065*	*0.0075*	*0.0095*	*640*
P5	P	0,10	0,12	0,14	0,17	0,19	0,22	185
	P	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*610*
P6	P	0,10	0,12	0,14	0,16	0,19	0,22	210
	P	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*690*
P7	P	0,10	0,12	0,14	0,16	0,19	0,22	200
	P	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*660*
P8	P	0,11	0,13	0,15	0,17	0,19	0,24	185
	P	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0075*	*0.0095*	*610*
P11	P	0,060	0,075	0,085	0,10	0,11	0,14	95
	P	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*310*
P12	P	0,060	0,075	0,085	0,10	0,11	0,14	65
	P	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*215*
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	110
	MS	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0075*	*360*
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	90
	MS	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*295*
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	45
	MS	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0080*	*150*
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	50
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*165*
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	42
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*140*
K1	P	0,15	0,18	0,22	0,25	0,28	0,36	160
	P	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.014*	*520*
K2	P	0,14	0,17	0,20	0,22	0,26	0,32	135
	P	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.013*	*445*
K3	P	0,14	0,17	0,20	0,22	0,26	0,32	115
	P	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.013*	*375*
K4	P	0,14	0,17	0,20	0,22	0,26	0,32	110
	P	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.013*	*360*
K5	P	0,12	0,15	0,18	0,20	0,24	0,28	65
	P	*0.0048*	*0.0060*	*0.0070*	*0.0080*	*0.0095*	*0.011*	*215*
N1	N	0,13	0,16	0,19	0,22	0,26	0,32	350
	N	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*1150*
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	225
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*740*
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	150
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*490*
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	285
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*940*
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	39
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*130*
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S11	MS	0,070	0,085	0,095	0,11	0,12	0,14	70
	MS	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*230*
S12	MS	0,070	0,085	0,095	0,11	0,12	0,14	55
	MS	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*180*
S13	MS	0,065	0,075	0,085	0,095	0,10	0,12	43
	MS	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0040*	*0.0048*	*140*
H3	P	0,055	0,070	0,080	0,090	0,10	0,12	26
	P	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*85*
H5	P	0,085	0,10	0,12	0,13	0,15	0,18	48
	P	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0060*	*0.0070*	*155*
H7	P	0,055	0,070	0,080	0,090	0,10	0,12	26
	P	*0.0022*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*85*
H8	P	0,065	0,080	0,090	0,10	0,12	0,14	48
	P	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*155*
H11	P	0,085	0,10	0,12	0,13	0,15	0,18	60
	P	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0060*	*0.0070*	*195*
H12	P	0,065	0,080	0,090	0,10	0,12	0,14	70
	P	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*230*
H21	P	0,065	0,080	0,090	0,10	0,12	0,14	48
	P	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*155*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A – ∅ 10-20 mm / *0.394-0.787 Zoll*

SMG		f						v_c
		Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	P	0,38	0,44	0,48	0,50	0,55	0,55	170
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*560*
P2	P	0,38	0,44	0,48	0,50	0,55	0,60	165
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.024*	*540*
P3	P	0,36	0,42	0,46	0,50	0,50	0,55	140
	P	*0.014*	*0.017*	*0.018*	*0.020*	*0.020*	*0.022*	*460*
P4	P	0,28	0,30	0,34	0,36	0,38	0,40	195
	P	*0.011*	*0.012*	*0.013*	*0.014*	*0.015*	*0.016*	*640*
P5	P	0,26	0,30	0,32	0,34	0,36	0,38	185
	P	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*610*
P6	P	0,26	0,30	0,32	0,34	0,36	0,38	210
	P	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*690*
P7	P	0,26	0,30	0,32	0,34	0,36	0,38	200
	P	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*660*
P8	P	0,28	0,32	0,34	0,36	0,38	0,40	185
	P	*0.011*	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*610*
P11	P	0,16	0,18	0,20	0,22	0,24	0,24	95
	P	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*310*
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	110
	MS	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*360*
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	90
	MS	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*295*
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	45
	MS	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*150*
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	50
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*165*
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	42
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*140*
K1	P	0,42	0,48	0,50	0,55	0,60	0,65	160
	P	*0.017*	*0.019*	*0.020*	*0.022*	*0.024*	*0.026*	*520*
K2	P	0,38	0,42	0,48	0,50	0,55	0,55	135
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*445*
K3	P	0,38	0,42	0,48	0,50	0,55	0,55	115
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*375*
K4	P	0,38	0,42	0,48	0,50	0,55	0,55	110
	P	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*360*
K5	P	0,34	0,38	0,42	0,46	0,48	0,50	65
	P	*0.013*	*0.015*	*0.017*	*0.018*	*0.019*	*0.020*	*215*
N1	N	0,38	0,42	0,46	0,50	0,55	0,55	350
	N	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*1150*
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	225
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*740*
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	150
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*490*
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	285
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*940*
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	39
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*130*
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S11	MS	0,17	0,19	0,22	0,24	0,25	0,26	70
	MS	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*230*
S12	MS	0,17	0,19	0,22	0,24	0,25	0,26	55
	MS	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*180*
S13	MS	0,15	0,17	0,19	0,20	0,22	0,22	43
	MS	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*140*
H3	P	0,14	0,16	0,18	0,19	0,20	0,20	26
	P	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*85*
H5	P	0,22	0,24	0,26	0,28	0,30	0,32	48
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*155*
H7	P	0,14	0,16	0,18	0,19	0,20	0,20	26
	P	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*85*
H8	P	0,16	0,19	0,20	0,22	0,24	0,24	48
	P	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*155*
H11	P	0,22	0,24	0,26	0,28	0,30	0,32	60
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*195*
H12	P	0,16	0,19	0,20	0,22	0,24	0,24	70
	P	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*230*
H21	P	0,16	0,19	0,20	0,22	0,24	0,24	48
	P	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*155*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD206 – ∅ 0,7-2 mm / *0.0276-0.0787 Zoll*

SMG		f			v_c
		Ø 0,70 *Ø 0.0276*	Ø 1,00 *Ø 0.0394*	Ø 2,00 *Ø 0,0787*	
P1	P *P*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	140 *460*
P2	P *P*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*	140 *460*
P3	P *P*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*	120 *395*
P4	P *P*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*	105 *345*
P5	P *P*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	100 *330*
P6	P *P*	0,075 *0.0030*	0,080 *0.0032*	0,10 *0.0040*	110 *360*
P7	P *P*	0,075 *0.0030*	0,080 *0.0032*	0,10 *0.0040*	105 *345*
P8	P *P*	0,080 *0.0032*	0,085 *0.0034*	0,11 *0.0044*	100 *330*
P11	P *P*	0,075 *0.0030*	0,080 *0.0032*	0,10 *0.0040*	105 *345*
P12	P *P*	0,050 *0.0020*	0,055 *0.0022*	0,070 *0.0028*	60 *195*
K1	P *P*	0,085 *0.0034*	0,090 *0.0036*	0,12 *0.0048*	100 *330*
K2	P *P*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	85 *280*
K3	P *P*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	75 *245*
K4	P *P*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	70 *230*
K5	P *P*	0,070 *0.0028*	0,075 *0.0030*	0,095 *0.0038*	42 *140*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD206A – ∅ 1-2 mm / *0.0394-0.0787 Zoll*

SMG		f			v_c
		Ø 1,00 *Ø 0.0394*	Ø 1,50 *Ø 0.0591*	Ø 2,00 *Ø 0.0787*	
P1	P *P*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	175 *570*
P2	P *P*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	170 *560*
P3	P *P*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 *475*
P4	P *P*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	130 *425*
P5	P *P*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	125 *410*
P6	P *P*	0,080 *0.0032*	0,095 *0.0038*	0,10 *0.0040*	140 *460*
P7	P *P*	0,080 *0.0032*	0,095 *0.0038*	0,10 *0.0040*	130 *425*
P8	P *P*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 *410*
P11	P *P*	0,080 *0.0032*	0,095 *0.0038*	0,10 *0.0040*	125 *410*
P12	P *P*	0,055 *0.0022*	0,065 *0.0026*	0,070 *0.0028*	75 *245*
M1	P *P*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	95 *310*
M2	P *P*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	75 *245*
M3	P *P*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	60 *195*
M4	P *P*	0,036 *0.0014*	0,042 *0.0017*	0,048 *0.0019*	43 *140*
M5	P *P*	0,036 *0.0014*	0,042 *0.0017*	0,048 *0.0019*	36 *120*
K1	P *P*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	115 *375*
K2	P *P*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	100 *330*
K3	P *P*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	85 *280*
K4	P *P*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	80 *260*
K5	P *P*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	47 *155*
N2	P *P*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	190 *620*
N3	P *P*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	125 *410*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD207A – ∅ 3-20 mm / *0.118-0.787 Zoll*

SMG		f										v_c
		Ø 3,00 *Ø 0.118*	Ø 5,00 *Ø 0.197*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	P	0,17	0,24	0,26	0,32	0,38	0,44	0,48	0,50	0,55	0,55	155
	P	*0.0065*	*0.0095*	*0.010*	*0.013*	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*510*
P2	P	0,17	0,24	0,26	0,32	0,38	0,44	0,48	0,50	0,55	0,60	155
	P	*0.0065*	*0.0095*	*0.010*	*0.013*	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.024*	*510*
P3	P	0,16	0,22	0,25	0,32	0,36	0,42	0,46	0,50	0,50	0,55	130
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.014*	*0.017*	*0.018*	*0.020*	*0.020*	*0.022*	*425*
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	0,34	0,36	0,38	0,40	180
	P	*0.0050*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*0.013*	*0.014*	*0.015*	*0.016*	*590*
P5	P	0,12	0,17	0,19	0,22	0,26	0,30	0,32	0,34	0,36	0,38	175
	P	*0.0048*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*570*
P6	P	0,12	0,16	0,19	0,22	0,26	0,30	0,32	0,34	0,36	0,38	195
	P	*0.0048*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*640*
P7	P	0,12	0,16	0,19	0,22	0,26	0,30	0,32	0,34	0,36	0,38	185
	P	*0.0048*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*610*
P8	P	0,13	0,17	0,19	0,24	0,28	0,32	0,34	0,36	0,38	0,40	175
	P	*0.0050*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*570*
P11	P	0,075	0,10	0,11	0,14	0,16	0,18	0,20	0,22	0,24	0,24	90
	P	*0.0030*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*295*
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	0,28	0,30	0,30	0,32	50
	P	*0.0038*	*0.0050*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*165*
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	0,25	0,26	0,28	0,30	41
	P	*0.0034*	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*135*
M3	P	0,065	0,095	0,11	0,14	0,16	0,18	0,20	0,22	0,22	0,24	31
	P	*0.0026*	*0.0038*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*100*
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	0,17	0,19	0,20	0,20	24
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*80*
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	0,17	0,19	0,20	0,20	20
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*65*
K1	P	0,18	0,25	0,28	0,36	0,42	0,48	0,50	0,55	0,60	0,65	150
	P	*0.0070*	*0.010*	*0.011*	*0.014*	*0.017*	*0.019*	*0.020*	*0.022*	*0.024*	*0.026*	*490*
K2	P	0,17	0,22	0,26	0,32	0,38	0,42	0,48	0,50	0,55	0,55	130
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*425*
K3	P	0,17	0,22	0,26	0,32	0,38	0,42	0,48	0,50	0,55	0,55	110
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*360*
K4	P	0,17	0,22	0,26	0,32	0,38	0,42	0,48	0,50	0,55	0,55	105
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.019*	*0.020*	*0.022*	*0.022*	*345*
K5	P	0,15	0,20	0,24	0,28	0,34	0,38	0,42	0,46	0,48	0,50	60
	P	*0.0060*	*0.0080*	*0.0095*	*0.011*	*0.013*	*0.015*	*0.017*	*0.018*	*0.019*	*0.020*	*195*
H3	P	0,070	0,090	0,10	0,12	0,14	0,16	0,18	0,19	0,20	0,20	24
	P	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*80*
H5	P	0,10	0,13	0,15	0,18	0,22	0,24	0,26	0,28	0,30	0,32	45
	P	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*150*
H7	P	0,070	0,090	0,10	0,12	0,14	0,16	0,18	0,19	0,20	0,20	24
	P	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*80*
H8	P	0,080	0,10	0,12	0,14	0,16	0,19	0,20	0,22	0,24	0,24	45
	P	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*150*
H11	P	0,10	0,13	0,15	0,18	0,22	0,24	0,26	0,28	0,30	0,32	60
	P	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*195*
H12	P	0,080	0,10	0,12	0,14	0,16	0,19	0,20	0,22	0,24	0,24	65
	P	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*215*
H21	P	0,080	0,10	0,12	0,14	0,16	0,19	0,20	0,22	0,24	0,24	45
	P	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*150*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD2016A-SD2030A – ∅ 3-14 mm / *0.118-0.551 Zoll*

SMG		f							v_c
		Ø3,00 *Ø 0.118*	Ø5,00 *Ø 0.197*	Ø6,00 *Ø 0.236*	Ø8,00 *Ø 0.315*	Ø10,00 *Ø 0.394*	Ø12,00 *Ø 0.472*	Ø14,00 *Ø 0.551*	
P1	P	0,13	0,18	0,20	0,25	0,30	0,32	0,36	135
	P	*0.0050*	*0.0070*	*0.0080*	*0.010*	*0.012*	*0.013*	*0.014*	*445*
P2	P	0,14	0,18	0,20	0,26	0,30	0,34	0,36	130
	P	*0.0055*	*0.0070*	*0.0080*	*0.010*	*0.012*	*0.013*	*0.014*	*425*
P3	P	0,13	0,17	0,20	0,24	0,28	0,32	0,34	115
	P	*0.0050*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.013*	*0.013*	*375*
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	0,34	100
	P	*0.0050*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*0.013*	*330*
P5	P	0,12	0,17	0,19	0,24	0,28	0,30	0,34	95
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*0.013*	*310*
P6	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	105
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*0.013*	*345*
P7	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	100
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*0.013*	*330*
P8	P	0,13	0,17	0,20	0,24	0,28	0,32	0,34	95
	P	*0.0050*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.013*	*0.013*	*310*
P11	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	100
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*0.013*	*330*
P12	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	60
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*195*
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	0,28	100
	P	*0.0038*	*0.0050*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.011*	*330*
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	0,25	80
	P	*0.0034*	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*260*
M3	P	0,070	0,095	0,11	0,14	0,16	0,18	0,20	60
	P	*0.0028*	*0.0038*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*195*
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	0,18	46
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*150*
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	0,18	38
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*125*
K1	P	0,15	0,22	0,24	0,30	0,36	0,40	0,44	80
	P	*0.0060*	*0.0085*	*0.0095*	*0.012*	*0.014*	*0.016*	*0.017*	*260*
K2	P	0,14	0,19	0,22	0,28	0,32	0,36	0,40	70
	P	*0.0055*	*0.0075*	*0.0085*	*0.011*	*0.013*	*0.014*	*0.016*	*230*
K3	P	0,14	0,19	0,22	0,28	0,32	0,36	0,40	60
	P	*0.0055*	*0.0075*	*0.0085*	*0.011*	*0.013*	*0.014*	*0.016*	*195*
K4	P	0,14	0,19	0,22	0,28	0,32	0,36	0,40	55
	P	*0.0055*	*0.0075*	*0.0085*	*0.011*	*0.013*	*0.014*	*0.016*	*180*
K5	P	0,12	0,17	0,20	0,25	0,30	0,32	0,36	33
	P	*0.0048*	*0.0065*	*0.0080*	*0.010*	*0.012*	*0.013*	*0.014*	*110*
N1	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	105
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.018*	*345*
N2	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	105
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.018*	*345*
N3	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	70
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.018*	*230*
S3	P	0,048	0,065	0,075	0,095	0,11	0,13	0,15	25
	P	*0.0019*	*0.0026*	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*80*
S12	P	0,085	0,11	0,12	0,14	0,17	0,19	0,22	35
	P	*0.0034*	*0.0044*	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*115*
H3	P	0,055	0,075	0,085	0,10	0,12	0,14	0,15	33
	P	*0.0022*	*0.0030*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*110*
H5	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	60
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*195*
H7	P	0,055	0,075	0,085	0,10	0,12	0,14	0,15	33
	P	*0.0022*	*0.0030*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*110*
H8	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	60
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*195*
H11	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	75
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*245*
H12	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	70
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*230*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD2040-2060A – ∅ **3-8 mm** / *0.118-0.315 Zoll*

SMG	f				v_c
	Ø3,00 *Ø 0.118*	Ø5,00 *Ø 0.197*	Ø6,00 *Ø 0.236*	Ø8,00 *Ø 0.315*	
P1	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	0,25 *0.010*	85 *280*
P2	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	0,26 *0.010*	85 *280*
P3	0,13 *0.0050*	0,18 *0.0070*	0,20 *0.0080*	0,25 *0.010*	70 *230*
P4	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	65 *215*
P5	0,13 *0.0050*	0,17 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	60 *195*
P6	0,12 *0.0048*	0,17 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	65 *215*
P7	0,12 *0.0048*	0,17 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	65 *215*
P8	0,13 *0.0050*	0,18 *0.0070*	0,20 *0.0080*	0,25 *0.010*	60 *195*
P11	0,12 *0.0048*	0,17 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	60 *195*
P12	0,085 *0.0034*	0,12 *0.0048*	0,13 *0.0050*	0,16 *0.0065*	36 *120*
M1	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	37 *120*
M2	0,085 *0.0034*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	30 *100*
M3	0,070 *0.0028*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	23 *75*
M4	0,060 *0.0024*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0048*	17 *55*
M5	0,060 *0.0024*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0048*	14 *46*
K1	0,15 *0.0060*	0,22 *0.0085*	0,25 *0.010*	0,30 *0.012*	43 *140*
K2	0,14 *0.0055*	0,20 *0.0080*	0,22 *0.0085*	0,28 *0.011*	37 *120*
K3	0,14 *0.0055*	0,20 *0.0080*	0,22 *0.0085*	0,28 *0.011*	31 *100*
K4	0,14 *0.0055*	0,20 *0.0080*	0,22 *0.0085*	0,28 *0.011*	30 *100*
K5	0,13 *0.0050*	0,18 *0.0070*	0,20 *0.0080*	0,25 *0.010*	18 *60*
N2	0,16 *0.0065*	0,22 *0.0085*	0,26 *0.010*	0,32 *0.013*	105 *345*
N3	0,16 *0.0065*	0,22 *0.0085*	0,26 *0.010*	0,32 *0.013*	70 *230*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD245A – ∅ 4-16 mm / *0.157-0.630 Zoll*

SMG		f							v_c
		Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	
P1	P	0,11	0,15	0,19	0,22	0,26	0,28	0,32	185
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.011*	*0.013*	*610*
P2	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	180
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*590*
P3	P	0,11	0,14	0,18	0,22	0,25	0,28	0,30	155
	P	*0.0044*	*0.0055*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*510*
P4	P	0,11	0,14	0,18	0,22	0,24	0,26	0,30	135
	P	*0.0044*	*0.0055*	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.012*	*445*
P5	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	130
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*425*
P6	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	145
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*475*
P7	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	140
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*460*
P8	P	0,11	0,14	0,18	0,22	0,25	0,28	0,30	130
	P	*0.0044*	*0.0055*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*425*
P11	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	135
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*445*
P12	P	0,070	0,095	0,12	0,14	0,16	0,18	0,20	80
	P	*0.0028*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*260*
M1	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	100
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*330*
M2	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	80
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*260*
K1	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	120
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*395*
K2	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	105
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*345*
K3	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	90
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*295*
K4	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	85
	P	*0.0040*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.011*	*280*
K5	P	0,095	0,12	0,16	0,19	0,22	0,24	0,26	50
	P	*0.0038*	*0.0048*	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*165*
N2	P	0,14	0,19	0,24	0,28	0,34	0,38	0,40	200
	P	*0.0055*	*0.0075*	*0.0095*	*0.011*	*0.013*	*0.015*	*0.016*	*660*
N3	P	0,14	0,19	0,24	0,28	0,34	0,38	0,40	135
	P	*0.0055*	*0.0075*	*0.0095*	*0.011*	*0.013*	*0.015*	*0.016*	*445*
N11	P	0,14	0,19	0,24	0,28	0,34	0,38	0,40	255
	P	*0.0055*	*0.0075*	*0.0095*	*0.011*	*0.013*	*0.015*	*0.016*	*840*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD265A – ∅ 4-16 mm / *0.157-0.630 Zoll*

SMG		f							v_c
		Ø 4,00 *Ø 0.157*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	
P1	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	180
	P	*0.0048*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.012*	*0.013*	*590*
P2	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	175
	P	*0.0048*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.012*	*0.013*	*570*
P3	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	150
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*490*
P4	P	0,11	0,15	0,19	0,22	0,26	0,28	0,32	135
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.011*	*0.013*	*445*
P5	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	130
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*425*
P6	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	145
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*475*
P7	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	135
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*445*
P8	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	130
	P	*0.0044*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.012*	*0.013*	*425*
P11	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	130
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*425*
P12	P	0,075	0,10	0,12	0,15	0,17	0,19	0,20	80
	P	*0.0030*	*0.0040*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*260*
M1	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	100
	P	*0.0048*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.012*	*0.013*	*330*
M2	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	80
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*260*
K1	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	120
	P	*0.0048*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.012*	*0.013*	*395*
K2	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	100
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*330*
K3	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	85
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*280*
K4	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	85
	P	*0.0044*	*0.0060*	*0.0070*	*0.0085*	*0.010*	*0.011*	*0.012*	*280*
K5	P	0,10	0,13	0,17	0,20	0,22	0,25	0,28	49
	P	*0.0040*	*0.0050*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*0.011*	*160*
N2	P	0,15	0,20	0,26	0,30	0,36	0,40	0,42	195
	P	*0.0060*	*0.0080*	*0.010*	*0.012*	*0.014*	*0.016*	*0.017*	*640*
N3	P	0,15	0,20	0,26	0,30	0,36	0,40	0,42	130
	P	*0.0060*	*0.0080*	*0.010*	*0.012*	*0.014*	*0.016*	*0.017*	*425*
N11	P	0,15	0,20	0,26	0,30	0,36	0,40	0,42	250
	P	*0.0060*	*0.0080*	*0.010*	*0.012*	*0.014*	*0.016*	*0.017*	*820*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD203A -MS ∅ 2-8 mm / *0.079-0.315 Zoll*

SMG		f						v_c
		Ø 2,00 *Ø 0.079*	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 5,00 *Ø 0.197*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	
P11	MS	0,060	0,080	0,10	0,12	0,14	0,18	90
	MS	*0.0024*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*0.0070*	*295*
P12	MS	0,060	0,070	0,080	0,090	0,10	0,12	65
	MS	*0.0024*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*215*
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	110
	MS	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0075*	*360*
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	90
	MS	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*295*
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	45
	MS	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0080*	*150*
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	50
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*165*
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	42
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*140*
N1	MS	0,13	0,16	0,19	0,22	0,26	0,32	345
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*1125*
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	225
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*740*
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	150
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*490*
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	285
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*940*
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	39
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*130*
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S11	MS	0,070	0,085	0,095	0,11	0,12	0,14	70
	MS	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*230*
S12	MS	0,070	0,085	0,095	0,11	0,12	0,14	55
	MS	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*180*
S13	MS	0,065	0,075	0,085	0,095	0,10	0,12	43
	MS	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0040*	*0.0048*	*140*
H3	MS	0,046	0,055	0,065	0,075	0,085	0,10	36
	MS	*0.0018*	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0040*	*120*
H5	MS	0,070	0,085	0,10	0,11	0,13	0,16	65
	MS	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0050*	*0.0065*	*215*
H7	MS	0,046	0,055	0,065	0,075	0,085	0,10	36
	MS	*0.0018*	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0040*	*120*
H8	MS	0,055	0,065	0,075	0,085	0,095	0,12	65
	MS	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0048*	*215*
H11	MS	0,070	0,085	0,10	0,11	0,13	0,16	85
	MS	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0050*	*0.0065*	*280*
H12	MS	0,055	0,065	0,075	0,085	0,095	0,12	80
	MS	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0048*	*260*
H21	MS	0,055	0,065	0,075	0,085	0,095	0,12	65
	MS	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0048*	*215*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD203A -MS ∅ 10-20 mm / *0.394-0.787 Zoll*

SMG		f						v_c
		Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P11	MS	0,22	0,24	0,26	0,30	0,30	0,32	90
	MS	*0.0085*	*0.0095*	*0.010*	*0.012*	*0.012*	*0.013*	*295*
P12	MS	0,14	0,15	0,16	0,18	0,18	0,19	65
	MS	*0.0055*	*0.0060*	*0.0065*	*0.0070*	*0.0070*	*0.0075*	*215*
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	110
	MS	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*360*
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	90
	MS	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*295*
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	45
	MS	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*150*
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	50
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*165*
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	42
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*140*
N1	MS	0,38	0,42	0,46	0,50	0,55	0,55	345
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*1125*
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	225
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*740*
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	150
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*490*
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	285
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*940*
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	39
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*130*
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S11	MS	0,17	0,19	0,22	0,24	0,25	0,26	70
	MS	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*230*
S12	MS	0,17	0,19	0,22	0,24	0,25	0,26	55
	MS	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*180*
S13	MS	0,15	0,17	0,19	0,20	0,22	0,22	43
	MS	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*140*
H3	MS	0,12	0,13	0,15	0,16	0,17	0,17	36
	MS	*0.0048*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*120*
H5	MS	0,18	0,20	0,22	0,24	0,25	0,26	65
	MS	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*0.010*	*215*
H7	MS	0,12	0,13	0,15	0,16	0,17	0,17	36
	MS	*0.0048*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*120*
H8	MS	0,14	0,16	0,17	0,18	0,19	0,20	65
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*215*
H11	MS	0,18	0,20	0,22	0,24	0,25	0,26	85
	MS	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*0.010*	*280*
H12	MS	0,14	0,16	0,17	0,18	0,19	0,20	80
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*260*
H21	MS	0,14	0,16	0,17	0,18	0,19	0,20	65
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*215*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A -MS ∅ 2-8 mm / *0.079-0.315 Zoll*

SMG		f						v_c
		Ø 2,00 *Ø 0.079*	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 5,00 *Ø 0.197*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	
P11	MS	0,060	0,080	0,10	0,12	0,14	0,18	80
	MS	*0.0024*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*0.0070*	*260*
P12	MS	0,060	0,070	0,080	0,090	0,10	0,12	60
	MS	*0.0024*	*0.0028*	*0.0032*	*0.0036*	*0.0040*	*0.0048*	*195*
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	100
	MS	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0075*	*330*
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	80
	MS	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*260*
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	40
	MS	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0080*	*130*
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	46
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*150*
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	38
	MS	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*125*
N1	MS	0,13	0,16	0,19	0,22	0,26	0,32	310
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*1025*
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	200
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*660*
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	135
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*445*
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	255
	MS	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*840*
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	35
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*115*
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	25
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*80*
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	25
	MS	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*80*
S11	MS	0,020	0,030	0,040	0,050	0,060	0,080	45
	MS	*0.00080*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*150*
S12	MS	0,020	0,030	0,040	0,050	0,060	0,080	35
	MS	*0.00080*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*115*
S13	MS	0,017	0,026	0,035	0,044	0,050	0.070	27
	MS	*0.00068*	*0.0010*	*0.0014*	*0.0018*	*0.0020*	*0.0028*	*90*
H3	MS	0,046	0,055	0,065	0,075	0,085	0,10	33
	MS	*0.0018*	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0040*	*110*
H5	MS	0,070	0,085	0,10	0,11	0,13	0,16	60
	MS	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0050*	*0.0065*	*195*
H7	MS	0,046	0,055	0,065	0,075	0,085	0,10	33
	MS	*0.0018*	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0040*	*110*
H8	MS	0,055	0,065	0,075	0,085	0,095	0,12	60
	MS	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0048*	*195*
H11	MS	0,070	0,085	0,10	0,11	0,13	0,16	75
	MS	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0050*	*0.0065*	*245*
H12	MS	0,055	0,065	0,075	0,085	0,095	0,12	70
	MS	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0048*	*230*
H21	MS	0,055	0,065	0,075	0,085	0,095	0,12	60
	MS	*0.0022*	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0048*	*195*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A -MS ∅ 10-20 mm / *0.394-0.787 Zoll*

SMG		f						v_c
		Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P11	MS	0,22	0,24	0,26	0,30	0,30	0,32	80
	MS	*0.0085*	*0.0095*	*0.010*	*0.012*	*0.012*	*0.013*	*260*
P12	MS	0,14	0,15	0,16	0,18	0,18	0,19	60
	MS	*0.0055*	*0.0060*	*0.0065*	*0.0070*	*0.0070*	*0.0075*	*195*
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	100
	MS	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*330*
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	80
	MS	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*260*
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	40
	MS	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*130*
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	46
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*150*
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	38
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*125*
N1	MS	0,38	0,42	0,46	0,50	0,55	0,55	310
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*1025*
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	200
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*660*
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	135
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*445*
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	255
	MS	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*840*
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	35
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*115*
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	25
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*80*
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	25
	MS	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*80*
S11	MS	0,10	0,12	0,14	0,16	0,18	0,20	45
	MS	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*150*
S12	MS	0,10	0,12	0,14	0,16	0,18	0,20	35
	MS	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*115*
S13	MS	0,085	0,11	0,12	0,14	0,16	0,17	27
	MS	*0.0034*	*0.0044*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*90*
H3	MS	0,12	0,13	0,15	0,16	0,17	0,17	33
	MS	*0.0048*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*110*
H5	MS	0,18	0,20	0,22	0,24	0,25	0,26	60
	MS	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*0.010*	*195*
H7	MS	0,12	0,13	0,15	0,16	0,17	0,17	33
	MS	*0.0048*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*110*
H8	MS	0,14	0,16	0,17	0,18	0,19	0,20	60
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*195*
H11	MS	0,18	0,20	0,22	0,24	0,25	0,26	75
	MS	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*0.010*	*245*
H12	MS	0,14	0,16	0,17	0,18	0,19	0,20	70
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*230*
H21	MS	0,14	0,16	0,17	0,18	0,19	0,20	60
	MS	*0.0055*	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*195*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD203A – ∅ 2-8 mm / *0.079-0.315 Zoll*

SMG		f						v_c
		Ø 2,00 *Ø 0.079*	Ø 3,00 *Ø 0.118*	Ø 4,00 *Ø 0.157*	Ø 5,00 *Ø 0.197*	Ø 6,00 *Ø 0.236*	Ø 8,00 *Ø 0.315*	
P11	M	0,060	0,075	0,085	0,10	0,11	0,14	150
	M	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*490*
P12	M	0,060	0,075	0,085	0,10	0,11	0,14	90
	M	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*295*
M1	M	0,075	0,095	0,11	0,13	0,15	0,19	110
	M	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0075*	*360*
M2	M	0,065	0,085	0,10	0,12	0,14	0,17	90
	M	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*295*
M3	M	0,055	0,065	0,080	0,095	0,11	0,14	70
	M	*0.0022*	*0.0026*	*0.0032*	*0.0038*	*0.0044*	*0.0055*	*230*
M4	M	0,048	0,060	0,070	0,085	0,095	0,12	50
	M	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*165*
M5	M	0,048	0,060	0,070	0,085	0,095	0,12	42
	M	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*140*
N1	M	0,13	0,16	0,19	0,22	0,26	0,32	345
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*1125*
N2	M	0,13	0,16	0,19	0,22	0,26	0,32	225
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*740*
N3	M	0,13	0,16	0,19	0,22	0,26	0,32	150
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*490*
N11	M	0,13	0,16	0,19	0,22	0,26	0,32	285
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*940*
S1	M	0,040	0,048	0,055	0,065	0,075	0,095	39
	M	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*130*
S2	M	0,040	0,048	0,055	0,065	0,075	0,095	28
	M	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S3	M	0,040	0,048	0,055	0,065	0,075	0,095	28
	M	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*90*
S11	M	0,070	0,085	0,095	0,11	0,12	0,14	70
	M	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*230*
S12	M	0,070	0,085	0,095	0,11	0,12	0,14	55
	M	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*180*
S13	M	0,065	0,075	0,085	0,095	0,10	0,12	43
	M	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0040*	*0.0048*	*140*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD203A – ∅ 10-20 mm / *0.394-0.787 Zoll*

SMG		f						v_c
		Ø 10,00 *Ø 0.394*	Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P11	M	0,16	0,18	0,20	0,22	0,24	0,24	150
	M	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*490*
P12	M	0,16	0,18	0,20	0,22	0,24	0,24	90
	M	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*295*
M1	M	0,22	0,25	0,28	0,30	0,30	0,32	110
	M	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*360*
M2	M	0,20	0,22	0,25	0,26	0,28	0,30	90
	M	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*295*
M3	M	0,16	0,18	0,20	0,22	0,22	0,24	70
	M	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*230*
M4	M	0,14	0,16	0,17	0,19	0,20	0,20	50
	M	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*165*
M5	M	0,14	0,16	0,17	0,19	0,20	0,20	42
	M	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*140*
N1	M	0,38	0,42	0,46	0,50	0,55	0,55	345
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*1125*
N2	M	0,38	0,42	0,46	0,50	0,55	0,55	225
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*740*
N3	M	0,38	0,42	0,46	0,50	0,55	0,55	150
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*490*
N11	M	0,38	0,42	0,46	0,50	0,55	0,55	285
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*940*
S1	M	0,11	0,13	0,15	0,16	0,17	0,19	39
	M	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*130*
S2	M	0,11	0,13	0,15	0,16	0,17	0,19	28
	M	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S3	M	0,11	0,13	0,15	0,16	0,17	0,19	28
	M	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*90*
S11	M	0,17	0,19	0,22	0,24	0,25	0,26	70
	M	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*230*
S12	M	0,17	0,19	0,22	0,24	0,25	0,26	55
	M	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*180*
S13	M	0,15	0,17	0,19	0,20	0,22	0,22	43
	M	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*140*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A-M – ∅ 2-8 mm / *0.079-0.315 Zoll*

SMG		f						v_c
		Ø2,00 *Ø 0.079*	Ø3,00 *Ø 0.118*	Ø4,00 *Ø 0.157*	Ø5,00 *Ø 0.197*	Ø6,00 *Ø 0.236*	Ø8,00 *Ø 0.315*	
P11	M	0,060	0,075	0,085	0,10	0,11	0,14	135
	M	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*445*
P12	M	0,060	0,075	0,085	0,10	0,11	0,14	80
	M	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*0.0044*	*0.0055*	*260*
M1	M	0,075	0,095	0,11	0,13	0,15	0,19	100
	M	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*0.0075*	*330*
M2	M	0,065	0,085	0,10	0,12	0,14	0,17	80
	M	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*260*
M3	M	0,055	0,065	0,080	0,095	0,11	0,14	60
	M	*0.0022*	*0.0026*	*0.0032*	*0.0038*	*0.0044*	*0.0055*	*195*
M4	M	0,048	0,060	0,070	0,085	0,095	0,12	46
	M	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*150*
M5	M	0,048	0,060	0,070	0,085	0,095	0,12	38
	M	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0048*	*125*
N1	M	0,13	0,16	0,19	0,22	0,26	0,32	310
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*1025*
N2	M	0,13	0,16	0,19	0,22	0,26	0,32	200
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*660*
N3	M	0,13	0,16	0,19	0,22	0,26	0,32	135
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*445*
N11	M	0,13	0,16	0,19	0,22	0,26	0,32	255
	M	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.013*	*840*
S1	M	0,040	0,048	0,055	0,065	0,075	0,095	35
	M	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*115*
S2	M	0,040	0,048	0,055	0,065	0,075	0,095	25
	M	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*80*
S3	M	0,040	0,048	0,055	0,065	0,075	0,095	25
	M	*0.0016*	*0.0019*	*0.0022*	*0.0026*	*0.0030*	*0.0038*	*80*
S11	M	0,070	0,085	0,095	0,11	0,12	0,14	65
	M	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*215*
S12	M	0,070	0,085	0,095	0,11	0,12	0,14	50
	M	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0055*	*165*
S13	M	0,065	0,075	0,085	0,095	0,10	0,12	39
	M	*0.0026*	*0.0030*	*0.0034*	*0.0038*	*0.0040*	*0.0048*	*130*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A-M – ∅ 10-20 mm / *0.394-0.787 Zoll*

SMG		f						v_c
		Ø10,00 *Ø 0.394*	Ø12,00 *Ø 0.472*	Ø14,00 *Ø 0.551*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *Ø 0.787*	
P11	M	0,16	0,18	0,20	0,22	0,24	0,24	135
	M	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*445*
P12	M	0,16	0,18	0,20	0,22	0,24	0,24	80
	M	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*0.0095*	*260*
M1	M	0,22	0,25	0,28	0,30	0,30	0,32	100
	M	*0.0085*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*330*
M2	M	0,20	0,22	0,25	0,26	0,28	0,30	80
	M	*0.0080*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*260*
M3	M	0,16	0,18	0,20	0,22	0,22	0,24	60
	M	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*195*
M4	M	0,14	0,16	0,17	0,19	0,20	0,20	45
	M	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*150*
M5	M	0,14	0,16	0,17	0,19	0,20	0,20	37
	M	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0080*	*120*
N1	M	0,38	0,42	0,46	0,50	0,55	0,55	305
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*1000*
N2	M	0,38	0,42	0,46	0,50	0,55	0,55	195
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*640*
N3	M	0,38	0,42	0,46	0,50	0,55	0,55	130
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*425*
N11	M	0,38	0,42	0,46	0,50	0,55	0,55	250
	M	*0.015*	*0.017*	*0.018*	*0.020*	*0.022*	*0.022*	*820*
S1	M	0,11	0,13	0,15	0,16	0,17	0,19	34
	M	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*110*
S2	M	0,11	0,13	0,15	0,16	0,17	0,19	25
	M	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*80*
S3	M	0,11	0,13	0,15	0,16	0,17	0,19	25
	M	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0065*	*0.0075*	*80*
S11	M	0,17	0,19	0,22	0,24	0,25	0,26	65
	M	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*215*
S12	M	0,17	0,19	0,22	0,24	0,25	0,26	49
	M	*0.0065*	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.010*	*160*
S13	M	0,15	0,17	0,19	0,20	0,22	0,22	38
	M	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*125*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD205A-C1 – ∅ 3-13 mm / *0.118-0.512 Zoll*

SMG		f						v_c
		Ø 3,00 *Ø 0.118*	Ø 5,00 *Ø 0.197*	Ø 7,00 *Ø 0.276*	Ø 9,00 *Ø 0.354*	Ø 11,00 *Ø 0.433*	Ø 13,00 *Ø 0.512*	
TS2	C1 *C1*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,070 *0.0028*	0,075 *0.0030*	0,080 *0.0032*	65 *215*
TS3	C1 *C1*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,070 *0.0028*	0,075 *0.0030*	0,080 *0.0032*	50 *165*
TP2	C1 *C1*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,070 *0.0028*	0,075 *0.0030*	0,080 *0.0032*	65 *215*
TP3	C1 *C1*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,070 *0.0028*	0,075 *0.0030*	0,080 *0.0032*	50 *165*

SD205A-C2 – ∅ 3-13 mm / *0.118-0.512 Zoll*

SMG		f						v_c
		Ø 3,00 *Ø 0.118*	Ø 5,00 *Ø 0.197*	Ø 7,00 *Ø 0.276*	Ø 9,00 *Ø 0.354*	Ø 11,00 *Ø 0.433*	Ø 13,00 *Ø 0.512*	
N1	C2 *C2*	0,095 *0.0038*	0,10 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	80 *260*
N2	C2 *C2*	0,095 *0.0038*	0,10 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	50 *165*
N3	C2 *C2*	0,095 *0.0038*	0,10 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	0,13 *0.0050*	0,14 *0.0055*	33 *110*
S11	C2 *C2*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	50 *165*
S12	C2 *C2*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	40 *130*
S13	C2 *C2*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	31 *100*

SD203-CX1 – ∅ 3-9 mm / *0.118-0.354 Zoll*

SMG		f				v_c
		Ø 3,00 *Ø 0.118*	Ø 5,00 *Ø 0.197*	Ø 7,00 *Ø 0.276*	Ø 9,00 *Ø 0.354*	
TS2	CX1 *CX1*	0,075 *0.0030*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	150 *490*
TS3	CX1 *CX1*	0,075 *0.0030*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 *395*
TP2	CX1 *CX1*	0,075 *0.0030*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	150 *490*
TP3	CX1 *CX1*	0,075 *0.0030*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 *395*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD22 & SD26 – ∅ 0,1-0,3 mm / *0.0039-0.0118 Zoll*

SMG	f			v_c
	Ø 0,10 *Ø 0.0039*	Ø 0,20 *Ø 0.0079*	Ø 0,30 *Ø 0.0118*	
P1	0,0011 *0.000044*	0,0017 *0.000065*	0,0024 *0.000095*	11 *36*
P2	0,0011 *0.000044*	0,0017 *0.000065*	0,0024 *0.000095*	11 *36*
P3	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	10 *33*
P4	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	8 *26*
P5	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	8 *26*
P6	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	9 *30*
P7	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	8 *26*
P8	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	8 *26*
P11	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	8 *26*
P12	0,00070 *0.000028*	0,0011 *0.000044*	0,0015 *0.000060*	5 *16*
M1	0,0011 *0.000044*	0,0017 *0.000065*	0,0024 *0.000095*	2 *7*
M2	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	2 *7*
K1	0,0011 *0.000044*	0,0017 *0.000065*	0,0024 *0.000095*	6 *20*
K2	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	5 *16*
K3	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	4 *13*
K4	0,0010 *0.000040*	0,0016 *0.000065*	0,0022 *0.000085*	4 *13*
K5	0,00090 *0.000036*	0,0014 *0.000055*	0,0019 *0.000075*	3 *10*
N2	0,0014 *0.000055*	0,0022 *0.000085*	0,0030 *0.00012*	15 *49*
N3	0,0014 *0.000055*	0,0022 *0.000085*	0,0030 *0.00012*	10 *33*
S11	0,00080 *0.000032*	0,0013 *0.000050*	0,0017 *0.000065*	4 *13*
S12	0,00080 *0.000032*	0,0013 *0.000050*	0,0017 *0.000065*	3 *10*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD22 & SD26 – ∅ 0,4-0,5 mm / *0.0157-0.0197 Zoll*

SMG	f		v_c
	Ø 0,40 *Ø 0.0157*	Ø 0,50 *Ø 0.0197*	
P1	0,0030 *0.00012*	0,0036 *0.00014*	14 *46*
P2	0,0030 *0.00012*	0,0036 *0.00014*	14 *46*
P3	0,0028 *0.00011*	0,0034 *0.00013*	12 *39*
P4	0,0028 *0.00011*	0,0034 *0.00013*	10 *33*
P5	0,0028 *0.00011*	0,0034 *0.00013*	10 *33*
P6	0,0028 *0.00011*	0,0032 *0.00013*	11 *36*
P7	0,0028 *0.00011*	0,0032 *0.00013*	11 *36*
P8	0,0028 *0.00011*	0,0034 *0.00013*	10 *33*
P11	0,0028 *0.00011*	0,0032 *0.00013*	10 *33*
P12	0,0019 *0.000075*	0,0022 *0.000085*	6 *20*
M1	0,0030 *0.00012*	0,0036 *0.00014*	5 *16*
M2	0,0028 *0.00011*	0,0034 *0.00013*	4 *13*
K1	0,0030 *0.00012*	0,0036 *0.00014*	10 *33*
K2	0,0028 *0.00011*	0,0034 *0.00013*	9 *30*
K3	0,0028 *0.00011*	0,0034 *0.00013*	7 *23*
K4	0,0028 *0.00011*	0,0034 *0.00013*	7 *23*
K5	0,0025 *0.00010*	0,0030 *0.00012*	4 *13*
N2	0,0038 *0.00015*	0,0046 *0.00018*	30 *100*
N3	0,0038 *0.00015*	0,0046 *0.00018*	20 *65*
S11	0,0022 *0.000085*	0,0026 *0.00010*	8 *26*
S12	0,0022 *0.000085*	0,0026 *0.00010*	6 *20*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD22 & SD26 – ∅ 0,6-0,8 mm / *0.0236-0.0315 Zoll*

SMG	f			v_c
	Ø 0,60 *Ø 0.0236*	Ø 0,70 *Ø 0.0276*	Ø 0,80 *Ø 0.0315*	
P1	0,0042 *0.00017*	0,0048 *0.00019*	0,0055 *0.00022*	28 *90*
P2	0,0042 *0.00017*	0,0050 *0.00020*	0,0055 *0.00022*	28 *90*
P3	0,0040 *0.00016*	0,0046 *0.00018*	0,0055 *0.00022*	24 *80*
P4	0,0040 *0.00016*	0,0046 *0.00018*	0,0050 *0.00020*	21 *70*
P5	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	20 *65*
P6	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	22 *70*
P7	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	21 *70*
P8	0,0040 *0.00016*	0,0046 *0.00018*	0,0055 *0.00022*	20 *65*
P11	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	21 *70*
P12	0,0026 *0.00010*	0,0030 *0.00012*	0,0034 *0.00013*	12 *39*
M1	0,0042 *0.00017*	0,0050 *0.00020*	0,0055 *0.00022*	9 *30*
M2	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	7 *23*
K1	0,0042 *0.00017*	0,0050 *0.00020*	0,0055 *0.00022*	15 *49*
K2	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	13 *43*
K3	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	11 *36*
K4	0,0038 *0.00015*	0,0044 *0.00017*	0,0050 *0.00020*	10 *33*
K5	0,0036 *0.00014*	0,0040 *0.00016*	0,0046 *0.00018*	6 *20*
N2	0,0055 *0.00022*	0,0065 *0.00026*	0,0070 *0.00028*	60 *195*
N3	0,0055 *0.00022*	0,0065 *0.00026*	0,0070 *0.00028*	40 *130*
S11	0,0032 *0.00013*	0,0036 *0.00014*	0,0040 *0.00016*	13 *43*
S12	0,0032 *0.00013*	0,0036 *0.00014*	0,0040 *0.00016*	10 *33*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD22 & SD26 – ∅ 0,9-1,1 mm / *0.0354-0.0433 Zoll*

SMG	f			v_c
	Ø 0,90 *Ø 0.0354*	Ø 1,00 *Ø 0.0394*	Ø 1,10 *Ø 0.0433*	
P1	0,0060 *0.00024*	0,0065 *0.00026*	0,0075 *0.00030*	50 *165*
P2	0,0060 *0.00024*	0,0070 *0.00028*	0,0075 *0.00030*	48 *155*
P3	0,0060 *0.00024*	0,0065 *0.00026*	0,0070 *0.00028*	42 *140*
P4	0,0055 *0.00022*	0,0065 *0.00026*	0,0070 *0.00028*	37 *120*
P5	0,0055 *0.00022*	0,0060 *0.00024*	0,0070 *0.00028*	35 *115*
P6	0,0055 *0.00022*	0,0060 *0.00024*	0,0065 *0.00026*	39 *130*
P7	0,0055 *0.00022*	0,0060 *0.00024*	0,0065 *0.00026*	37 *120*
P8	0,0060 *0.00024*	0,0065 *0.00026*	0,0070 *0.00028*	35 *115*
P11	0,0055 *0.00022*	0,0060 *0.00024*	0,0065 *0.00026*	36 *120*
P12	0,0038 *0.00015*	0,0042 *0.00017*	0,0046 *0.00018*	21 *70*
M1	0,0060 *0.00024*	0,0070 *0.00028*	0,0075 *0.00030*	12 *39*
M2	0,0055 *0.00022*	0,0060 *0.00024*	0,0070 *0.00028*	10 *33*
K1	0,0060 *0.00024*	0,0070 *0.00028*	0,0075 *0.00030*	20 *65*
K2	0,0055 *0.00022*	0,0060 *0.00024*	0,0070 *0.00028*	17 *55*
K3	0,0055 *0.00022*	0,0060 *0.00024*	0,0070 *0.00028*	15 *49*
K4	0,0055 *0.00022*	0,0060 *0.00024*	0,0070 *0.00028*	14 *46*
K5	0,0050 *0.00020*	0,0055 *0.00022*	0,0060 *0.00024*	8 *26*
N2	0,0080 *0.00032*	0,0085 *0.00034*	0,0095 *0.00038*	80 *260*
N3	0,0080 *0.00032*	0,0085 *0.00034*	0,0095 *0.00038*	55 *180*
S11	0,0046 *0.00018*	0,0050 *0.00020*	0,0055 *0.00022*	19 *60*
S12	0,0046 *0.00018*	0,0050 *0.00020*	0,0055 *0.00022*	15 *49*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD22 & SD26 – ∅ 1,2-2,0 mm / *0.0472-0.0787 Zoll*

SMG	f					v_c
	Ø 1,20 *Ø 0.0472*	Ø 1,40 *Ø 0.0551*	Ø 1,60 *Ø 0.0630*	Ø 1,80 *Ø 0.0709*	Ø 2,00 *Ø 0.0787*	
P1	0,0080 *0.00032*	0,0090 *0.00036*	0,010 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	70 *230*
P2	0,0080 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	0,013 *0.00050*	70 *230*
P3	0,0075 *0.00030*	0,0090 *0.00036*	0,010 *0.00040*	0,011 *0.00044*	0,012 *0.00048*	60 *195*
P4	0,0075 *0.00030*	0,0085 *0.00034*	0,010 *0.00040*	0,011 *0.00044*	0,012 *0.00048*	50 *165*
P5	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	50 *165*
P6	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	55 *180*
P7	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	55 *180*
P8	0,0075 *0.00030*	0,0090 *0.00036*	0,010 *0.00040*	0,011 *0.00044*	0,012 *0.00048*	50 *165*
P11	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	50 *165*
P12	0,0050 *0.00020*	0,0060 *0.00024*	0,0065 *0.00026*	0,0075 *0.00030*	0,0080 *0.00032*	30 *100*
M1	0,0080 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	0,013 *0.00050*	15 *49*
M2	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	12 *39*
K1	0,0080 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	0,013 *0.00050*	35 *115*
K2	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	30 *100*
K3	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	26 *85*
K4	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	0,011 *0.00044*	0,012 *0.00048*	25 *80*
K5	0,0065 *0.00026*	0,0075 *0.00030*	0,0085 *0.00034*	0,010 *0.00040*	0,011 *0.00044*	15 *49*
N2	0,010 *0.00040*	0,012 *0.00048*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	100 *330*
N3	0,010 *0.00040*	0,012 *0.00048*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	65 *215*
S11	0,0060 *0.00024*	0,0070 *0.00028*	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	26 *85*
S12	0,0060 *0.00024*	0,0070 *0.00028*	0,0075 *0.00030*	0,0085 *0.00034*	0,0095 *0.00038*	20 *65*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Seco® X-Tip Bohrer

Der Seco® X-Tip Bohrer ist eine neue Generation von Bohrwerkzeugen mit austauschbaren Bohrköpfen. Die innovative, vorgespannte Schnittstelle sorgt für eine höhere Prozesssicherheit, verbessert die Stabilität des Bohrkopfes und verlängert die Lebensdauer des Bohrerkörpers.

- Werkzeuggeometrien lassen sich dank eines breiteren Schnittdatenbereichs über alle Werkstoffgruppen hinweg einfacher anwenden
- Robuste und prozesssichere Lösung für höhere Vorschubwerte, längere Werkzeugstandzeiten und niedrigere Kosten pro Bohrung
- Höhere Anzahl an Bohrkopfwechseln innerhalb eines Bohrerkörpers

Programmübersicht

Seco® X-Tip Drill	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD4103	Seite(n) 171, 172, 173	∅ 9,49-17,99 mm *(0.3736-0.7083")*	~ 3 x D	n7	H9/H10	Ra 0,6-5 µm *(Ra 24-197 µin)*
SD4105	Seite(n) 174, 175, 176	∅ 9,49-17,99 mm *(0.3736-0.7083")*	~ 5 x D	n7	H9/H10	Ra 0,6-5 µm *(Ra 24-197 µin)*
SD4108	Seite(n) 177, 178, 179	∅ 9,49-17,99 mm *(0.3736-0.7083")*	~ 8 x D	n7	H9/H10	Ra 0,6-5 µm *(Ra 24-197 µin)*

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Code-Schlüssel

Code-Schlüssel Bohrerkörper

Metrisch

SD4103	–	14.00/14.99	–	50	–	16	–	R	7
1		2		3		4		5	6

Zoll

				50	–	0750	–	R	7
				3		4		5	6

1.
Bohrertyp
SD4103: 3 x D
SD4105: 5 x D
SD4108: 8 x D

2.
Min./max.
Bohrkopf Durchmesser

3.
Bohrtiefe

4.
Schaftdurchmesser

5.
Rechtsdrehend

6
Schaftart
1. Zylindrisch
7. ISO 9766

Code-Schlüssel Bohrköpfe

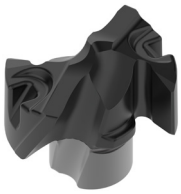
SD4100	–	14.00	–	P
		2		3

2.
Bohrerdurchmesser

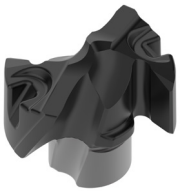
3.
Geometrie
P = Stahl
M = Rostfrei

Geometrien

P-Geometrie
Universelle Geometrie, erste Wahl für Stahl

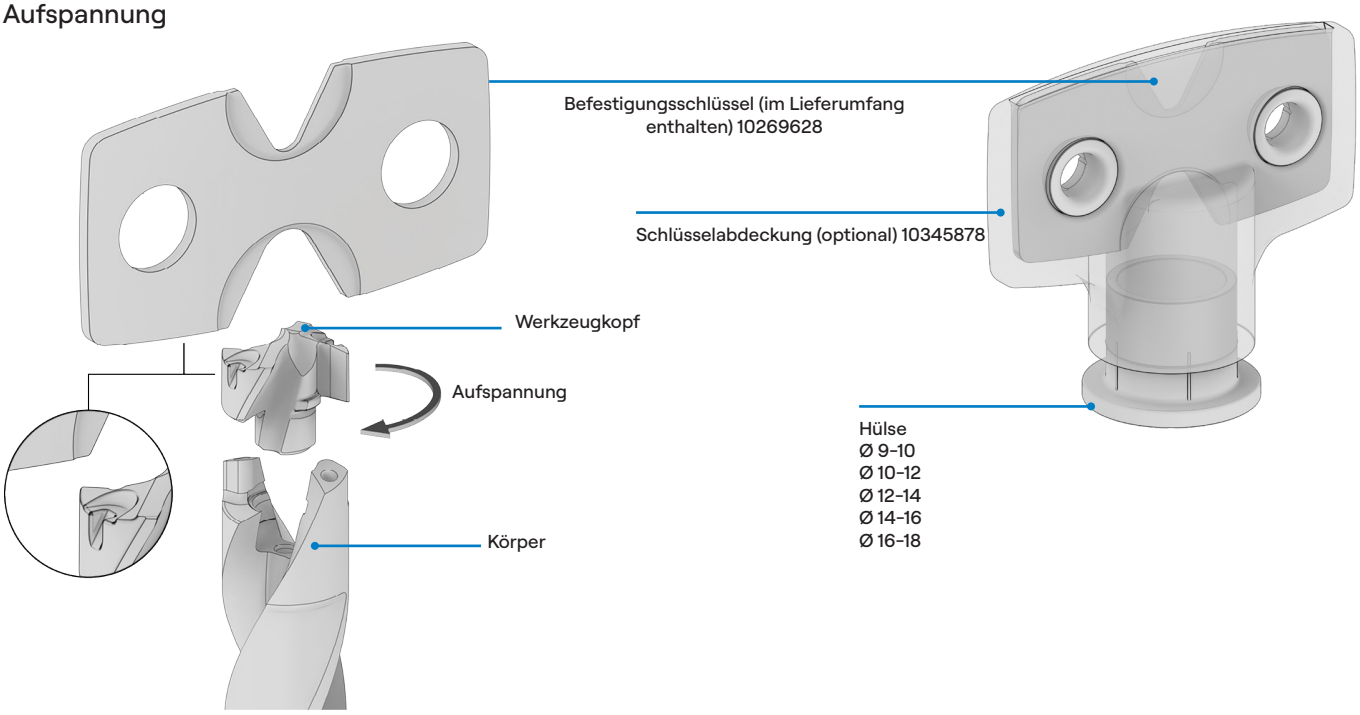


M-Geometrie
Erste Wahl für Rostfrei und Superlegierungen



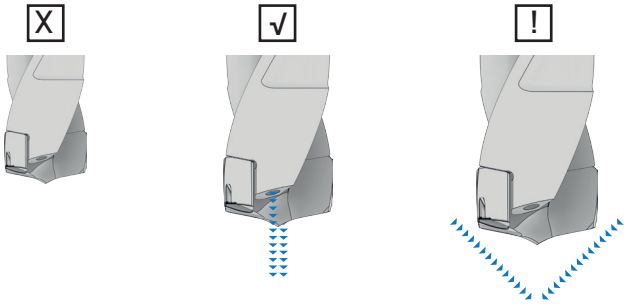
Montagehinweise

Aufspannung

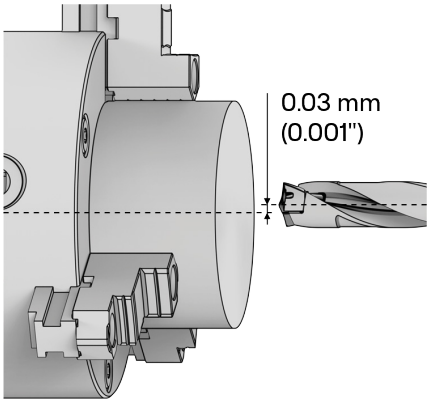


Anwendungstipps

1. Kühlmittelstrom



2. Statische Anwendungen

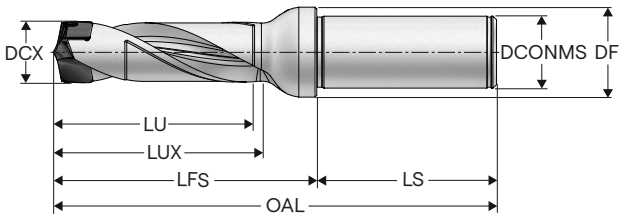


3. Spannfutter auswählen

	Körper	
ISO 9766 Spannfutter	■	–
Hydro-Dehnspannfutter	■ ■ (Mit Spannzangenfutter)	■ ■
Weldon Spannfutter	–	–

SD4103 – R1

Bohrtiefe ca. 3 x D – Metrischer/zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Hydro-Dehnspannfutter oder zylindrische Schaftaufnahmen
—Schnittdaten siehe Seite(n) 184

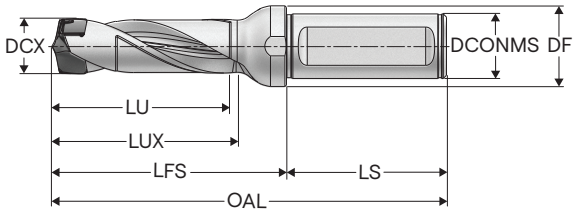
Bezeichnung	Produkt-nummer	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD4103-0900/0949-028-12R1	10333504	9,49 *0.374*	28 *1.102*	30,5 *1.201*	41,4 *1.630*	87,7 *3.453*	45,0 *1.772*	12,0 *0.472*	20,0 *0.787*
SD4103-0900/0949-028-0500R1	10333507	9,49 *0.374*	28 *1.102*	30,5 *1.201*	41,4 *1.630*	87,7 *3.453*	45,0 *1.772*	12,7 *0.500*	20,0 *0.787*
SD4103-0950/0999-030-12R1	10333510	9,99 *0.393*	30 *1.181*	32,2 *1.268*	43,1 *1.697*	89,4 *3.520*	45,0 *1.772*	12,0 *0.472*	20,0 *0.787*
SD4103-0950/0999-030-0500R1	10333513	9,99 *0.393*	30 *1.181*	32,3 *1.272*	43,2 *1.701*	89,4 *3.520*	45,0 *1.772*	12,7 *0.500*	20,0 *0.787*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Spannschlüssel
SD4103-..	SD4100-0900/1799-BASIC-KEY

SD4103 – R7

Bohrtiefe ca. 3 x D – Metrischer/zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 184

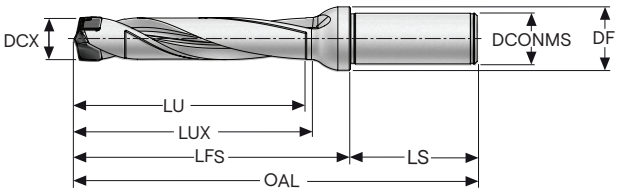
Bezeichnung	Produkt-nummer	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD4103-1000/1049-031-0625R7	10333519	10,49 *0.413*	31 *1.220*	33,8 *1.331*	46,7 *1.839*	96,1 *3.783*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1000/1049-031-16R7	10333516	10,49 *0.413*	31 *1.220*	33,9 *1.335*	46,7 *1.839*	96,1 *3.783*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1050/1099-033-0625R7	10333525	10,99 *0.433*	33 *1.299*	35,6 *1.402*	48,3 *1.902*	97,7 *3.846*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1050/1099-033-16R7	10333522	10,99 *0.433*	33 *1.299*	35,5 *1.398*	48,2 *1.898*	97,7 *3.846*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1100/1149-034-0625R7	10333531	11,49 *0.452*	34 *1.339*	37,1 *1.461*	49,8 *1.961*	99,4 *3.913*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1100/1149-034-16R7	10333528	11,49 *0.452*	34 *1.339*	37,1 *1.461*	49,8 *1.961*	99,4 *3.913*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1150/1199-036-0625R7	10333537	11,99 *0.472*	36 *1.417*	38,9 *1.531*	51,3 *2.020*	100,9 *3.972*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1150/1199-036-16R7	10333534	11,99 *0.472*	36 *1.417*	38,7 *1.524*	51,3 *2.020*	100,9 *3.972*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1200/1249-037-0625R7	10333543	12,49 *0.492*	37 *1.457*	40,4 *1.591*	52,8 *2.079*	102,6 *4.039*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1200/1249-037-16R7	10333540	12,49 *0.492*	37 *1.457*	40,4 *1.591*	52,9 *2.083*	102,6 *4.039*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1250/1299-039-0625R7	10333549	12,99 *0.511*	39 *1.535*	41,9 *1.650*	54,4 *2.142*	104,2 *4.102*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1250/1299-039-16R7	10333546	12,99 *0.511*	39 *1.535*	41,9 *1.650*	54,4 *2.142*	104,2 *4.102*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1300/1349-040-0625R7	10333555	13,49 *0.531*	40 *1.575*	43,7 *1.720*	56,1 *2.209*	104,0 *4.094*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1300/1349-040-16R7	10333552	13,49 *0.531*	40 *1.575*	43,6 *1.717*	56,0 *2.205*	104,0 *4.094*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1350/1399-042-0625R7	10333561	13,99 *0.551*	42 *1.654*	45,2 *1.780*	57,5 *2.264*	105,6 *4.157*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4103-1350/1399-042-16R7	10333558	13,99 *0.551*	42 *1.654*	45,2 *1.780*	57,6 *2.268*	105,6 *4.157*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4103-1400/1499-045-0750R7	10333567	14,99 *0.590*	45 *1.772*	48,2 *1.898*	64,4 *2.535*	114,2 *4.496*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4103-1400/1499-045-20R7	10333564	14,99 *0.590*	45 *1.772*	48,4 *1.906*	64,2 *2.528*	114,2 *4.496*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4103-1500/1599-048-0750R7	10333573	15,99 *0.630*	48 *1.890*	51,7 *2.035*	67,4 *2.654*	117,3 *4.618*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4103-1500/1599-048-20R7	10333570	15,99 *0.630*	48 *1.890*	51,6 *2.031*	67,3 *2.650*	117,3 *4.618*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4103-1600/1699-051-0750R7	10333579	16,99 *0.669*	51 *2.008*	54,9 *2.161*	70,5 *2.776*	120,4 *4.740*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4103-1600/1699-051-20R7	10333576	16,99 *0.669*	51 *2.008*	54,9 *2.161*	70,4 *2.772*	120,4 *4.740*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4103-1700/1799-054-0750R7	10333585	17,99 *0.708*	54 *2.126*	58,2 *2.291*	73,7 *2.902*	123,5 *4.862*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4103-1700/1799-054-20R7	10333582	17,99 *0.708*	54 *2.126*	58,1 *2.287*	73,5 *2.894*	123,5 *4.862*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Spannschlüssel
SD4103-..	SD4100-0900/1799-BASIC-KEY

SD4105 – R1

Bohrtiefe ca. 5 x D – Metrischer/zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Hydro-Dehnspannfutter oder zylindrische Schaftaufnahmen
—Schnittdaten siehe Seite(n) 184

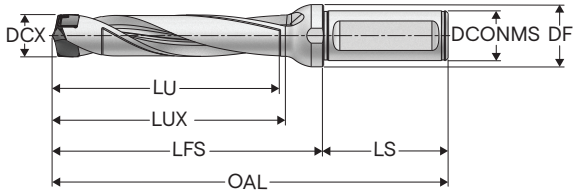
Bezeichnung	Produkt-nummer	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD4105-0900/0949-047-12R1	10333505	9,49 *0.374*	47 *1.850*	49,3 *1.941*	60,2 *2.370*	106,5 *4.193*	45,0 *1.772*	12,0 *0.472*	20,0 *0.787*
SD4105-0900/0949-047-0500R1	10333508	9,49 *0.374*	47 *1.850*	49,3 *1.941*	60,2 *2.370*	106,5 *4.193*	45,0 *1.772*	12,7 *0.500*	20,0 *0.787*
SD4105-0950/0999-050-12R1	10333511	9,99 *0.393*	50 *1.969*	52,0 *2.047*	62,9 *2.476*	109,2 *4.299*	45,0 *1.772*	12,0 *0.472*	20,0 *0.787*
SD4105-0950/0999-050-0500R1	10333514	9,99 *0.393*	50 *1.969*	52,1 *2.051*	63,0 *2.480*	109,2 *4.299*	45,0 *1.772*	12,7 *0.500*	20,0 *0.787*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Spannschlüssel
SD4105-..	SD4100-0900/1799-BASIC-KEY

SD4105 – R7

Bohrtiefe ca. 5 x D – Metrischer/zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 184

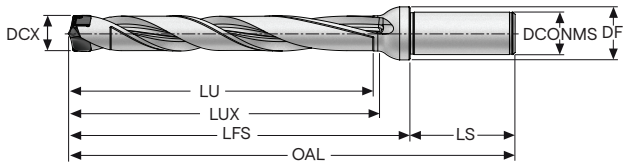
Bezeichnung	Produkt-nummer	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD4105-1000/1049-052-0625R7	10333520	10,49 *0.413*	52 *2.047*	54,6 *2.150*	67,6 *2.661*	116,9 *4.602*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1000/1049-052-16R7	10333517	10,49 *0.413*	52 *2.047*	54,7 *2.154*	67,5 *2.657*	116,9 *4.602*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1050/1099-055-0625R7	10333526	10,99 *0.433*	55 *2.165*	57,4 *2.260*	70,1 *2.760*	119,5 *4.705*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1050/1099-055-16R7	10333523	10,99 *0.433*	55 *2.165*	57,3 *2.256*	70,0 *2.756*	119,5 *4.705*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1100/1149-057-0625R7	10333532	11,49 *0.452*	57 *2.244*	59,9 *2.358*	72,6 *2.858*	122,2 *4.811*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1100/1149-057-16R7	10333529	11,49 *0.452*	57 *2.244*	59,9 *2.358*	72,6 *2.858*	122,2 *4.811*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1150/1199-060-0625R7	10333538	11,99 *0.472*	60 *2.362*	62,5 *2.461*	75,2 *2.961*	124,7 *4.909*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1150/1199-060-16R7	10333535	11,99 *0.472*	60 *2.362*	62,5 *2.461*	75,1 *2.957*	124,7 *4.909*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1200/1249-062-0625R7	10333544	12,49 *0.492*	62 *2.441*	65,3 *2.571*	77,7 *3.059*	127,4 *5.016*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1200/1249-062-16R7	10333541	12,49 *0.492*	62 *2.441*	65,2 *2.567*	77,7 *3.059*	127,4 *5.016*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1250/1299-065-0625R7	10333550	12,99 *0.511*	65 *2.559*	67,8 *2.669*	80,3 *3.161*	130,0 *5.118*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1250/1299-065-16R7	10333547	12,99 *0.511*	65 *2.559*	67,7 *2.665*	80,2 *3.157*	130,0 *5.118*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1300/1349-067-0625R7	10333556	13,49 *0.531*	67 *2.638*	70,6 *2.780*	82,9 *3.264*	130,8 *5.150*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1300/1349-067-16R7	10333553	13,49 *0.531*	67 *2.638*	70,4 *2.772*	82,8 *3.260*	130,8 *5.150*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1350/1399-070-0625R7	10333562	13,99 *0.551*	70,0 *2.756*	73,0 *2.874*	85,3 *3.358*	133,4 *5.252*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4105-1350/1399-070-16R7	10333559	13,99 *0.551*	70 *2.756*	73,0 *2.874*	85,4 *3.362*	133,4 *5.252*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4105-1400/1499-075-0750R7	10333568	14,99 *0.590*	75 *2.953*	78,2 *3.079*	94,1 *3.705*	144,0 *5.669*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4105-1400/1499-075-20R7	10333565	14,99 *0.590*	75 *2.953*	78,2 *3.079*	94,0 *3.701*	144,0 *5.669*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4105-1500/1599-080-0750R7	10333574	15,99 *0.630*	80 *3.150*	83,6 *3.291*	99,3 *3.909*	149,1 *5.870*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4105-1500/1599-080-20R7	10333571	15,99 *0.630*	80 *3.150*	83,4 *3.283*	99,1 *3.902*	149,1 *5.870*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4105-1600/1699-085-0750R7	10333580	16,99 *0.669*	85 *3.346*	88,6 *3.488*	104,3 *4.106*	154,2 *6.071*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4105-1600/1699-085-20R7	10333577	16,99 *0.669*	85 *3.346*	88,7 *3.492*	104,2 *4.102*	154,2 *6.071*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4105-1700/1799-090-0750R7	10333586	17,99 *0.708*	90 *3.543*	94,0 *3.701*	109,5 *4.311*	159,3 *6.272*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4105-1700/1799-090-20R7	10333583	17,99 *0.708*	90 *3.543*	93,9 *3.697*	109,3 *4.303*	159,3 *6.272*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Spannschlüssel
SD4105-..	SD4100-0900/1799-BASIC-KEY

SD4108 – R1

Bohrtiefe ca. 8 x D – Metrischer/zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Hydro-Dehnspannfutter oder zylindrische Schaftaufnahmen
—Schnittdaten siehe Seite(n) 184

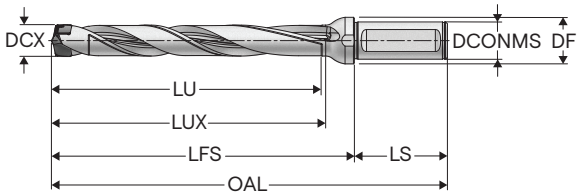
Bezeichnung	Produkt-nummer	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD4108-0900/0949-076-12R1	10333506	9,49 *0.374*	76 *2.992*	77,5 *3.051*	88,4 *3.480*	134,7 *5.303*	45,0 *1.772*	12,0 *0.472*	20,0 *0.787*
SD4108-0900/0949-077-0500R1	10333509	9,49 *0.374*	77 *3.031*	77,5 *3.051*	88,4 *3.480*	134,7 *5.303*	45,0 *1.772*	12,7 *0.500*	20,0 *0.787*
SD4108-0950/0999-080-12R1	10333512	9,99 *0.393*	80 *3.150*	81,7 *3.217*	92,6 *3.646*	138,9 *5.469*	45,0 *1.772*	12,0 *0.472*	20,0 *0.787*
SD4108-0950/0999-080-0500R1	10333515	9,99 *0.393*	80 *3.150*	81,7 *3.217*	92,7 *3.650*	138,9 *5.469*	45,0 *1.772*	12,7 *0.500*	20,0 *0.787*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Spannschlüssel
SD4108-..	SD4100-0900/1799-BASIC-KEY

SD4108 – R7

Bohrtiefe ca. 8 x D – Metrischer/zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 184

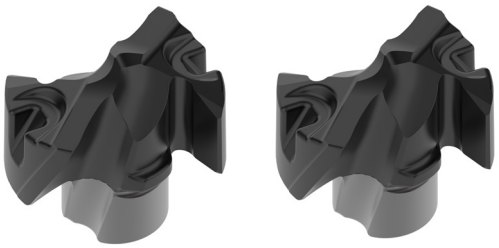
Bezeichnung	Produkt-nummer	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD4108-1000/1049-084-0625R7	10333521	10,49 *0.413*	84 *3.307*	85,7 *3.374*	98,6 *3.882*	148,1 *5.831*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1000/1049-084-16R7	10333518	10,49 *0.413*	84 *3.307*	85,9 *3.382*	98,7 *3.886*	148,1 *5.831*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1050/1099-088-0625R7	10333527	10,99 *0.433*	88 *3.465*	90,0 *3.543*	102,9 *4.051*	152,2 *5.992*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1050/1099-088-16R7	10333524	10,99 *0.433*	88 *3.465*	90,0 *3.543*	102,7 *4.043*	152,2 *5.992*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1100/1149-092-0625R7	10333533	11,49 *0.452*	92 *3.622*	94,1 *3.705*	106,9 *4.209*	156,4 *6.157*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1100/1149-092-16R7	10333530	11,49 *0.452*	92 *3.622*	94,1 *3.705*	106,8 *4.205*	156,4 *6.157*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1150/1199-096-0625R7	10333539	11,99 *0.472*	96 *3.780*	98,3 *3.870*	111,0 *4.370*	160,4 *6.315*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1150/1199-096-16R7	10333536	11,99 *0.472*	96 *3.780*	98,2 *3.866*	110,8 *4.362*	160,4 *6.315*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1200/1249-100-0625R7	10333545	12,49 *0.492*	100 *3.937*	102,4 *4.031*	115,1 *4.531*	164,6 *6.480*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1200/1249-100-16R7	10333542	12,49 *0.492*	100 *3.937*	102,4 *4.031*	114,9 *4.524*	164,6 *6.480*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1250/1299-104-0625R7	10333551	12,99 *0.511*	104 *4.094*	106,4 *4.189*	118,9 *4.681*	168,7 *6.642*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1250/1299-104-16R7	10333548	12,99 *0.511*	104 *4.094*	106,4 *4.189*	118,9 *4.681*	168,7 *6.642*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1300/1349-108-0625R7	10333557	13,49 *0.531*	108 *4.252*	110,6 *4.354*	123,1 *4.846*	171,0 *6.732*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1300/1349-108-16R7	10333554	13,49 *0.531*	108 *4.252*	110,6 *4.354*	123,0 *4.843*	171,0 *6.732*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1350/1399-112-0625R7	10333563	13,99 *0.551*	112 *4.409*	114,7 *4.516*	127,0 *5.000*	175,1 *6.894*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1350/1399-112-16R7	10333560	13,99 *0.551*	112 *4.409*	114,7 *4.516*	127,1 *5.004*	175,1 *6.894*	48,0 *1.890*	16,0 *0.630*	20,0 *0.787*
SD4108-1400/1499-120-0750R7	10333569	14,99 *0.590*	120 *4.724*	122,9 *4.839*	138,8 *5.465*	188,7 *7.429*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4108-1400/1499-120-20R7	10333566	14,99 *0.590*	120 *4.724*	122,9 *4.839*	138,7 *5.461*	188,7 *7.429*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4108-1500/1599-128-0750R7	10333575	15,99 *0.630*	128 *5.039*	131,2 *5.165*	146,9 *5.783*	196,8 *7.748*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4108-1500/1599-128-20R7	10333572	15,99 *0.630*	128 *5.039*	131,1 *5.161*	146,8 *5.780*	196,8 *7.748*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4108-1600/1699-136-0750R7	10333581	16,99 *0.669*	136 *5.354*	139,3 *5.484*	154,9 *6.098*	204,9 *8.067*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4108-1600/1699-136-20R7	10333578	16,99 *0.669*	136 *5.354*	139,3 *5.484*	154,9 *6.098*	204,9 *8.067*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*
SD4108-1700/1799-144-0750R7	10333587	17,99 *0.708*	144 *5.669*	147,7 *5.815*	163,2 *6.425*	213,0 *8.386*	50,0 *1.969*	19,05 *0.750*	25,0 *0.984*
SD4108-1700/1799-144-20R7	10333584	17,99 *0.708*	144 *5.669*	147,6 *5.811*	163,0 *6.417*	213,0 *8.386*	50,0 *1.969*	20,0 *0.787*	25,0 *0.984*

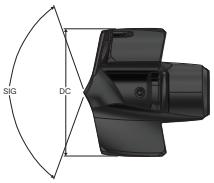
Ersatzteile, im Lieferumfang enthalten

Für Halter	Spannschlüssel
SD4108-..	SD4100-0900/1799-BASIC-KEY

Bohrköpfe – P- und M-Geometrie

Spitzenwinkel: 158°





Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD4100-0900-M	10333588	–	■	9,0	*0.354*
SD4100-0900-P	10333686	■	–	9,0	*0.354*
SD4100-0910-M	10333589	–	■	9,1	*0.358*
SD4100-0910-P	10333687	■	–	9,1	*0.358*
SD4100-0920-M	10333590	–	■	9,2	*0.362*
SD4100-0920-P	10333688	■	–	9,2	*0.362*
SD4100-0930-M	10333591	–	■	9,3	*0.366*
SD4100-0930-P	10333689	■	–	9,3	*0.366*
SD4100-0940-M	10333592	–	■	9,4	*0.370*
SD4100-0940-P	10333690	■	–	9,4	*0.370*
SD4100-0950-M	10333593	–	■	9,5	*0.374*
SD4100-0950-P	10333691	■	–	9,5	*0.374*
SD4100-0952-M	10333594	–	■	9,52	*0.375*
SD4100-0952-P	10333692	■	–	9,52	*0.375*
SD4100-0960-M	10333595	–	■	9,6	*0.378*
SD4100-0960-P	10333693	■	–	9,6	*0.378*
SD4100-0970-M	10333596	–	■	9,7	*0.382*
SD4100-0970-P	10333694	■	–	9,7	*0.382*
SD4100-0980-M	10333597	–	■	9,8	*0.386*
SD4100-0980-P	10333695	■	–	9,8	*0.386*
SD4100-0990-M	10333598	–	■	9,9	*0.390*
SD4100-0990-P	10333696	■	–	9,9	*0.390*
SD4100-1000-M	10333599	–	■	10,0	*0.394*
SD4100-1000-P	10333697	■	–	10,0	*0.394*
SD4100-1010-M	10333600	–	■	10,1	*0.398*
SD4100-1010-P	10333698	■	–	10,1	*0.398*
SD4100-1020-M	10333601	–	■	10,2	*0.402*
SD4100-1020-P	10333699	■	–	10,2	*0.402*
SD4100-1030-M	10333602	–	■	10,3	*0.406*
SD4100-1030-P	10333700	■	–	10,3	*0.406*
SD4100-1040-M	10333603	–	■	10,4	*0.409*
SD4100-1040-P	10333701	■	–	10,4	*0.409*
SD4100-1050-M	10333604	–	■	10,5	*0.413*
SD4100-1050-P	10333702	■	–	10,5	*0.413*
SD4100-1060-M	10333605	–	■	10,6	*0.417*
SD4100-1060-P	10333703	■	–	10,6	*0.417*
SD4100-1070-M	10333606	–	■	10,7	*0.421*
SD4100-1070-P	10333704	■	–	10,7	*0.421*
SD4100-1080-M	10333607	–	■	10,8	*0.425*
SD4100-1080-P	10333705	■	–	10,8	*0.425*
SD4100-1090-M	10333608	–	■	10,9	*0.429*
SD4100-1090-P	10333706	■	–	10,9	*0.429*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD4100-1100-M	10333609	–	■	11,0	*0.433*
SD4100-1100-P	10333707	■	–	11,0	*0.433*
SD4100-1110-M	10333610	–	■	11,1	*0.437*
SD4100-1110-P	10333708	■	–	11,1	*0.437*
SD4100-1111-M	10333611	–	■	11,11	*0.437*
SD4100-1111-P	10333709	■	–	11,11	*0.437*
SD4100-1120-M	10333612	–	■	11,2	*0.441*
SD4100-1120-P	10333710	■	–	11,2	*0.441*
SD4100-1130-M	10333613	–	■	11,3	*0.445*
SD4100-1130-P	10333711	■	–	11,3	*0.445*
SD4100-1140-M	10333614	–	■	11,4	*0.449*
SD4100-1140-P	10333712	■	–	11,4	*0.449*
SD4100-1150-M	10333615	–	■	11,5	*0.453*
SD4100-1150-P	10333713	■	–	11,5	*0.453*
SD4100-1160-M	10333616	–	■	11,6	*0.457*
SD4100-1160-P	10333714	■	–	11,6	*0.457*
SD4100-1170-M	10333617	–	■	11,7	*0.461*
SD4100-1170-P	10333715	■	–	11,7	*0.461*
SD4100-1180-M	10333618	–	■	11,8	*0.465*
SD4100-1180-P	10333716	■	–	11,8	*0.465*
SD4100-1190-M	10333619	–	■	11,9	*0.469*
SD4100-1190-P	10333717	■	–	11,9	*0.469*
SD4100-1200-M	10333620	–	■	12,0	*0.472*
SD4100-1200-P	10333718	■	–	12,0	*0.472*
SD4100-1210-M	10333621	–	■	12,1	*0.476*
SD4100-1210-P	10333719	■	–	12,1	*0.476*
SD4100-1220-M	10333622	–	■	12,2	*0.480*
SD4100-1220-P	10333720	■	–	12,2	*0.480*
SD4100-1230-M	10333623	–	■	12,3	*0.484*
SD4100-1230-P	10333721	■	–	12,3	*0.484*
SD4100-1240-M	10333624	–	■	12,4	*0.488*
SD4100-1240-P	10333722	■	–	12,4	*0.488*
SD4100-1250-M	10333625	–	■	12,5	*0.492*
SD4100-1250-P	10333723	■	–	12,5	*0.492*
SD4100-1260-M	10333626	–	■	12,6	*0.496*
SD4100-1260-P	10333724	■	–	12,6	*0.496*
SD4100-1270-M	10333627	–	■	12,7	*0.500*
SD4100-1270-P	10333725	■	–	12,7	*0.500*
SD4100-1280-M	10333628	–	■	12,8	*0.504*
SD4100-1280-P	10333726	■	–	12,8	*0.504*
SD4100-1290-M	10333629	–	■	12,9	*0.508*
SD4100-1290-P	10333727	■	–	12,9	*0.508*
SD4100-1300-M	10333630	–	■	13,0	*0.512*
SD4100-1300-P	10333728	■	–	13,0	*0.512*
SD4100-1310-M	10333631	–	■	13,1	*0.516*
SD4100-1310-P	10333729	■	–	13,1	*0.516*
SD4100-1320-M	10333632	–	■	13,2	*0.520*
SD4100-1320-P	10333730	■	–	13,2	*0.520*
SD4100-1330-M	10333633	–	■	13,3	*0.524*
SD4100-1330-P	10333731	■	–	13,3	*0.524*
SD4100-1340-M	10333634	–	■	13,4	*0.528*
SD4100-1340-P	10333732	■	–	13,4	*0.528*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD4100-1350-M	10333635	–	■	13,5	*0.531*
SD4100-1350-P	10333733	■	–	13,5	*0.531*
SD4100-1360-M	10333636	–	■	13,6	*0.535*
SD4100-1360-P	10333734	■	–	13,6	*0.535*
SD4100-1370-M	10333637	–	■	13,7	*0.539*
SD4100-1370-P	10333735	■	–	13,7	*0.539*
SD4100-1380-M	10333638	–	■	13,8	*0.543*
SD4100-1380-P	10333736	■	–	13,8	*0.543*
SD4100-1390-M	10333639	–	■	13,9	*0.547*
SD4100-1390-P	10333737	■	–	13,9	*0.547*
SD4100-1400-M	10333640	–	■	14,0	*0.551*
SD4100-1400-P	10333738	■	–	14,0	*0.551*
SD4100-1410-M	10333642	–	■	14,1	*0.555*
SD4100-1410-P	10333739	■	–	14,1	*0.555*
SD4100-1420-M	10333643	–	■	14,2	*0.559*
SD4100-1420-P	10333740	■	–	14,2	*0.559*
SD4100-1429-M	10333644	–	■	14,29	*0.563*
SD4100-1429-P	10333741	■	–	14,29	*0.563*
SD4100-1430-M	10333645	–	■	14,3	*0.563*
SD4100-1430-P	10333742	■	–	14,3	*0.563*
SD4100-1440-M	10333646	–	■	14,4	*0.567*
SD4100-1440-P	10333743	■	–	14,4	*0.567*
SD4100-1450-M	10333647	–	■	14,5	*0.571*
SD4100-1450-P	10333744	■	–	14,5	*0.571*
SD4100-1460-M	10333648	–	■	14,6	*0.575*
SD4100-1460-P	10333745	■	–	14,6	*0.575*
SD4100-1470-M	10333649	–	■	14,7	*0.579*
SD4100-1470-P	10333746	■	–	14,7	*0.579*
SD4100-1480-M	10333650	–	■	14,8	*0.583*
SD4100-1480-P	10333747	■	–	14,8	*0.583*
SD4100-1490-M	10333651	–	■	14,9	*0.587*
SD4100-1490-P	10333748	■	–	14,9	*0.587*
SD4100-1500-M	10333652	–	■	15,0	*0.591*
SD4100-1500-P	10333749	■	–	15,0	*0.591*
SD4100-1510-M	10333653	–	■	15,1	*0.594*
SD4100-1510-P	10333750	■	–	15,1	*0.594*
SD4100-1520-M	10333654	–	■	15,2	*0.598*
SD4100-1520-P	10333751	■	–	15,2	*0.598*
SD4100-1530-M	10333655	–	■	15,3	*0.602*
SD4100-1530-P	10333752	■	–	15,3	*0.602*
SD4100-1540-M	10333656	–	■	15,4	*0.606*
SD4100-1540-P	10333753	■	–	15,4	*0.606*
SD4100-1550-M	10333657	–	■	15,5	*0.610*
SD4100-1550-P	10333754	■	–	15,5	*0.610*
SD4100-1560-M	10333658	–	■	15,6	*0.614*
SD4100-1560-P	10333755	■	–	15,6	*0.614*
SD4100-1570-M	10333659	–	■	15,7	*0.618*
SD4100-1570-P	10333756	■	–	15,7	*0.618*
SD4100-1580-M	10333661	–	■	15,8	*0.622*
SD4100-1580-P	10333757	■	–	15,8	*0.622*
SD4100-1588-M	10333662	–	■	15,88	*0.625*
SD4100-1588-P	10333758	■	–	15,88	*0.625*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD4100-1590-M	10333663	–	■	15,9	*0.626*
SD4100-1590-P	10333759	■	–	15,9	*0.626*
SD4100-1600-M	10333664	–	■	16,0	*0.630*
SD4100-1600-P	10333760	■	–	16,0	*0.630*
SD4100-1610-M	10333665	–	■	16,1	*0.634*
SD4100-1610-P	10333761	■	–	16,1	*0.634*
SD4100-1613-M	10333666	–	■	16,13	*0.635*
SD4100-1613-P	10333762	■	–	16,13	*0.635*
SD4100-1620-M	10333667	–	■	16,2	*0.638*
SD4100-1620-P	10333763	■	–	16,2	*0.638*
SD4100-1630-M	10333668	–	■	16,3	*0.642*
SD4100-1630-P	10333764	■	–	16,3	*0.642*
SD4100-1640-M	10333669	–	■	16,4	*0.646*
SD4100-1640-P	10333765	■	–	16,4	*0.646*
SD4100-1650-M	10333670	–	■	16,5	*0.650*
SD4100-1650-P	10333766	■	–	16,5	*0.650*
SD4100-1660-M	10333671	–	■	16,6	*0.654*
SD4100-1660-P	10333767	■	–	16,6	*0.654*
SD4100-1670-M	10333672	–	■	16,7	*0.657*
SD4100-1670-P	10333768	■	–	16,7	*0.657*
SD4100-1680-M	10333673	–	■	16,8	*0.661*
SD4100-1680-P	10333769	■	–	16,8	*0.661*
SD4100-1690-M	10333674	–	■	16,9	*0.665*
SD4100-1690-P	10333770	■	–	16,9	*0.665*
SD4100-1700-M	10333675	–	■	17,0	*0.669*
SD4100-1700-P	10333771	■	–	17,0	*0.669*
SD4100-1710-M	10333676	–	■	17,1	*0.673*
SD4100-1710-P	10333772	■	–	17,1	*0.673*
SD4100-1720-M	10333677	–	■	17,2	*0.677*
SD4100-1720-P	10333773	■	–	17,2	*0.677*
SD4100-1730-M	10333678	–	■	17,3	*0.681*
SD4100-1730-P	10333774	■	–	17,3	*0.681*
SD4100-1740-M	10333679	–	■	17,4	*0.685*
SD4100-1740-P	10333775	■	–	17,4	*0.685*
SD4100-1746-M	10333680	–	■	17,46	*0.687*
SD4100-1746-P	10333776	■	–	17,46	*0.687*
SD4100-1750-M	10333681	–	■	17,5	*0.689*
SD4100-1750-P	10333777	■	–	17,5	*0.689*
SD4100-1760-M	10333682	–	■	17,6	*0.693*
SD4100-1760-P	10333778	■	–	17,6	*0.693*
SD4100-1770-M	10333683	–	■	17,7	*0.697*
SD4100-1770-P	10333779	■	–	17,7	*0.697*
SD4100-1780-M	10333684	–	■	17,8	*0.701*
SD4100-1780-P	10333780	■	–	17,8	*0.701*
SD4100-1790-M	10333685	–	■	17,9	*0.705*
SD4100-1790-P	10333781	■	–	17,9	*0.705*

■ Lagerstandard.

SD4103, SD4105, SD4108 – ∅ 9-17,99 mm / *0.354-0.708 Zoll*

SMG		f			v_c
		Ø9.00-11.99 *Ø 0.354-0.471*	Ø12,00-14.99 *Ø 0.472-0,590*	Ø15,00-17.99 *Ø 0.591-0,708*	
P1	P	0,26	0,30	0,34	150
	P	*0.010*	*0.012*	*0.013*	*490*
P2	P	0,28	0,32	0,36	145
	P	*0.011*	*0.013*	*0.014*	*475*
P3	P	0,32	0,36	0,40	155
	P	*0.013*	*0.014*	*0.016*	*510*
P4	P	0,32	0,36	0,38	135
	P	*0.013*	*0.014*	*0.015*	*445*
P5	P	0,32	0,34	0,38	130
	P	*0.013*	*0.013*	*0.015*	*425*
P6	P	0,30	0,34	0,38	145
	P	*0.012*	*0.013*	*0.015*	*475*
P7	P	0,30	0,34	0,38	140
	P	*0.012*	*0.013*	*0.015*	*460*
P8	P	0,32	0,36	0,40	130
	P	*0.013*	*0.014*	*0.016*	*425*
P11	P	0,11	0,14	0,17	95
	P	*0.0044*	*0.0055*	*0.0065*	*310*
P12	P	0,075	0,095	0,12	55
	P	*0.0030*	*0.0038*	*0.0048*	*180*
M1	M	0,13	0,18	0,24	105
	M	*0.0050*	*0.0070*	*0.0095*	*345*
M2	M	0,12	0,17	0,22	85
	M	*0.0048*	*0.0065*	*0.0085*	*280*
M3	M	0,095	0,13	0,17	65
	M	*0.0038*	*0.0050*	*0.0065*	*215*
M4	M	0,12	0,15	0,18	40
	M	*0.0048*	*0.0060*	*0.0070*	*130*
M5	M	0,12	0,15	0,18	33
	M	*0.0048*	*0.0060*	*0.0070*	*110*
K1	P	0,26	0,32	0,36	150
	P	*0.010*	*0.013*	*0.014*	*490*
K2	P	0,24	0,28	0,34	130
	P	*0.0095*	*0.011*	*0.013*	*425*
K3	P	0,28	0,34	0,40	150
	P	*0.011*	*0.013*	*0.016*	*490*
K4	P	0,28	0,34	0,40	145
	P	*0.011*	*0.013*	*0.016*	*475*
K5	P	0,26	0,30	0,36	85
	P	*0.010*	*0.012*	*0.014*	*280*
N1	M	0,34	0,36	0,40	360
	M	*0.013*	*0.014*	*0.016*	*1175*
N2	M	0,34	0,36	0,40	230
	M	*0.013*	*0.014*	*0.016*	*750*
N3	M	0,34	0,36	0,40	155
	M	*0.013*	*0.014*	*0.016*	*510*
N11	M	0,34	0,36	0,40	205
	M	*0.013*	*0.014*	*0.016*	*670*
S1	M	0,090	0,11	0,13	29
	M	*0.0036*	*0.0044*	*0.0050*	*95*
S2	M	0,090	0,11	0,13	23
	M	*0.0036*	*0.0044*	*0.0050*	*75*
S3	M	0,085	0,10	0,12	20
	M	*0.0034*	*0.0040*	*0.0048*	*65*
S11	M	0,12	0,15	0,19	50
	M	*0.0048*	*0.0060*	*0.0075*	*165*
S12	M	0,12	0,15	0,19	40
	M	*0.0048*	*0.0060*	*0.0075*	*130*
S13	M	0,11	0,14	0,16	31
	M	*0.0044*	*0.0055*	*0.0065*	*100*
H3	P	0,14	0,16	0,17	27
	P	*0.0055*	*0.0065*	*0.0065*	*90*
H5	P	0,22	0,24	0,26	49
	P	*0.0085*	*0.0095*	*0.010*	*160*
H7	P	0,14	0,16	0,17	27
	P	*0.0055*	*0.0065*	*0.0065*	*90*
H8	P	0,16	0,18	0,20	49
	P	*0.0065*	*0.0070*	*0.0080*	*160*
H11	P	0,22	0,24	0,26	65
	P	*0.0085*	*0.0095*	*0.010*	*215*
H12	P	0,16	0,18	0,20	55
	P	*0.0065*	*0.0070*	*0.0080*	*180*
H21	P	0,16	0,18	0,20	49
	P	*0.0065*	*0.0070*	*0.0080*	*160*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Crownloc®

Seco Crownloc® sind Bohrer mit auswechselbaren Kronen für hohe Bohrungsqualität bei geringeren Kosten. Crownloc bietet die gleiche Qualität wie Hochpräzisionsbohrer jedoch ohne Bedarf und Kosten für Nachschleifen.

— Doppelte Kühlschmierstoff-Bohrungen ermöglichen eine hohe Kühlschmierstoffzufuhr auf die Schneiden.
— Crownloc® beinhaltet ein großes Produktprogramm an optimierten Spitzengeometrien für verschiedene Anwendungen und Werkstoffe.

Programmübersicht

Crownloc®	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD101	Seite(n) 189-190	∅ 12,00-25,99 mm *(0.472-1.023")*	1,5 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD103	Seite(n) 191-192	∅ 9,52-25,99 mm *(0.375-1.023")*	3 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD105	Seite(n) 193-194	∅ 10,00-25,99 mm *(0.394-1.023")*	5 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD107	Seite(n) 195-196	∅ 12,00-25,99 mm *(0.472-1.023")*	7 x D	k7	IT 10	Ra 1-4 µm *(Ra 39-157 µin)*
Fasringe	Seite(n) 203	∅ 12.00-19,99 mm *(0.472-0.787")*	–	–	–	–

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Code-Schlüssel

Code-Schlüssel Bohrerkörper

Metrisch

SD103	–	14.00/14.99	–	50	–	16	–	R	7
1		2		3		4		5	6

Zoll

				50	–	0750	–	R	7
				3		4		5	6

1.
Bohrertyp
SD101: 1,5 x D
SD103: 3 x D
SD105: 5 x D
SD107: 7 x D

2.
Min./max.
Durchmesser Krone

3.
Bohrtiefe

4.
Schaftdurchmesser mm/Zoll

5.
Rechtsdrehend

6
Schaftart
1. Zylindrisch
7. ISO 9766

Code-Schlüssel Kronen

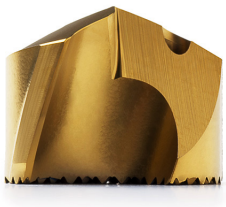
SD100	–	14.00	–	P
		2		3

2.
(Kronen)Bohrerdurchmesser in mm

3.
Geometrie
P = Stahl
M = Rostfrei
K = Guss

Geometrien

P-Geometrie
Universelle Geometrie, erste Wahl für Stahl



M-Geometrie
Erste Wahl für Rostfrei und Superlegierungen

K-Geometrie
Erste Wahl für Guss

Ersatzteil-Kits

Bohrerdurchmesser mm	SD101	SD103	SD105	SD107
10,00-11,99	–	SD103-SP-4.0	SD105-SP-4.0	–
12,00-13,99	SD101-SP-5.0	SD103-SP-5.0	SD105-SP-5.0	SD107-SP-5.0
14,00-16,99	SD101-SP-6.0	SD103-SP-6.0	SD105-SP-6.0	SD107-SP-6.0
17,00-19,99	SD101-SP-7.0	SD103-SP-7.0	SD105-SP-7.0	SD107-SP-7.0
20,00-25,99	SD101-SP-8.0	SD103-SP-8.0	SD105-SP-8.0	SD107-SP-8.0

Montagehinweise

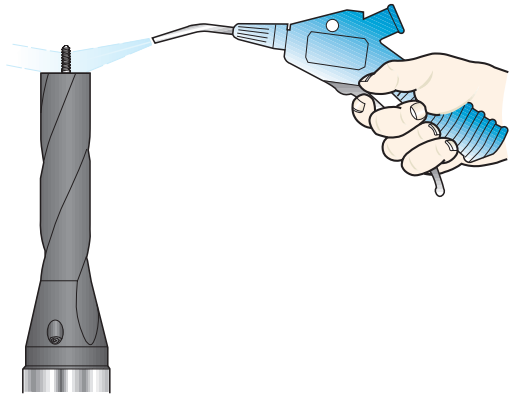
1. Kontaktfläche des Bohrerkörpers sorgfältig mit Pressluft reinigen.
2. Die Zugstange muss komplett herausschauen.
3. Neue Krone auf die Zugstange setzen und bis zum Ende des Gewindes aufschrauben.

Die Krone leicht zurückdrehen (gegen den Uhrzeigersinn), bis die Verzahnungen übereinstimmen.
Klemmschraube leicht spannen und dabei die Krone mit leichtem Druck in die Verzahnung führen.
Die Verzahnungen müssen einrasten.
Die Klemmschraube mit Hilfe des Drehmomentschlüssels fest anziehen.

Stabilität
Stabilität ist entscheidend für Standzeit und Bohrungsqualität. Bitte vorher den Zustand von Maschinenspindel und Aufspannvorrichtung prüfen, um die bestmöglichen Bearbeitungsbedingungen zu garantieren. Instabile Bedingungen können zu Werkzeugbruch führen.

Rotierender Einsatz
Bei rotierendem Einsatz darf die maximale Rundlaufabweichung (TIR) nicht mehr als 0,06 mm *(0.002")* betragen, gemessen am eingespannten Bohrer. Rundlauf des Bohrers im montierten Zustand messen.

1.



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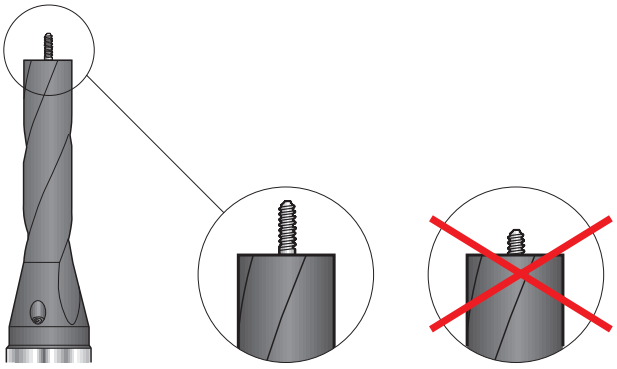

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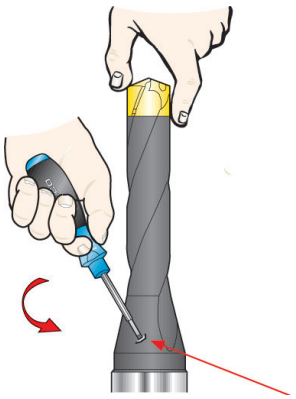
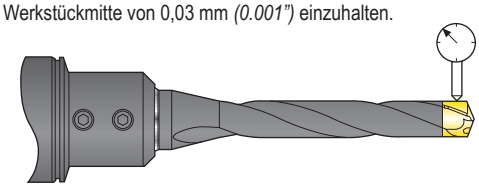


Bohrdurchmesser DC mm	M_c Nm	Bohrdurchmesser DC *Zoll*	M_c *in/lbs*
10,00-13,99	0,8-1,0	*0.394-0.551*	*7-9*
14,00-16,99	1,8-2,2	*0.551-0.669*	*16-19.5*
17,00-25,99	2,5-3,0	*0.669-1.023*	*22-26*

Statischer Einsatz
Bei statischem Einsatz ist ein radialer Abstand zwischen Bohrerspitze und rotierender Werkstückmitte von 0,03 mm *(0.001")* einzuhalten.

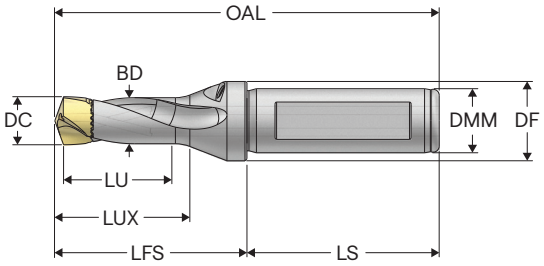


Empfehlungen für Werkzeugaufnahmen
Beste Ergebnisse erzielen Sie mit Aufnahmen Typ DIN 1835 B/DIN 6535 HB (Weldon). Weitere Informationen, siehe Katalog Werkzeug-Systeme.

Weldon

SD101 – R7

Bohrtiefe ca. 1,5 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 206

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD101-12.00/12.49-20-16R7	02445790	12,0-12,49	20,0	96,0	32,0	11,5	48,0	48,0	16,0	20,0
SD101-12.50/12.99-20-16R7	02445791	12,5-12,99	20,0	96,4	32,4	12,0	48,4	48,0	16,0	20,0
SD101-13.00/13.99-20-16R7	02445792	13,0-13,99	20,0	96,8	32,8	12,5	48,8	48,0	16,0	20,0
SD101-14.00/14.99-25-16R7	02445793	14,0-14,99	25,0	102,4	38,4	13,5	54,4	48,0	16,0	20,0
SD101-15.00/15.99-25-16R7	02445794	15,0-15,99	25,0	103,3	39,3	14,5	55,3	48,0	16,0	20,0
SD101-16.00/16.99-25-16R7	02445795	16,0-16,99	25,0	104,0	40,0	15,5	56,0	48,0	16,0	20,0
SD101-17.00/17.99-30-20R7	02445796	17,0-17,99	30,0	110,7	44,7	16,5	60,7	50,0	20,0	25,0
SD101-18.00/18.99-30-20R7	02445797	18,0-18,99	30,0	111,7	45,7	17,5	61,7	50,0	20,0	25,0
SD101-19.00/19.99-30-20R7	02445798	19,0-19,99	30,0	112,5	46,5	18,5	62,5	50,0	20,0	25,0
SD101-20.00/21.99-40-25R7	02462832	20,0-21,99	40,0	129,5	53,5	19,5	73,5	56,0	25,0	31,0
SD101-22.00/23.99-40-25R7	02462833	22,0-23,99	40,0	129,5	53,5	21,5	73,5	56,0	25,0	31,0
SD101-24.00/25.99-40-25R7	02462834	24,0-25,99	40,0	129,5	53,5	23,5	73,5	56,0	25,0	31,0

Ersatzteile, im Lieferumfang enthalten

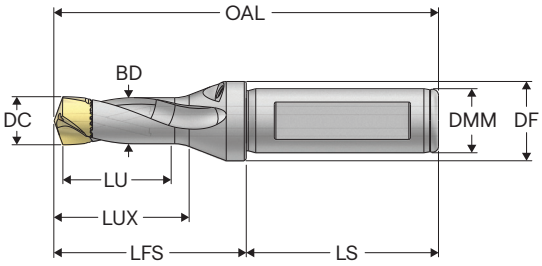
Bohrer-durchmesser (mm)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
12,00-13,99	H1.5-2D	MP6SS3X12	SD101-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD101-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD101-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD101-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD101 – R7

Bohrtiefe ca. 1,5 x D – Zölliger Schaft



–Kühlmittelzufuhr
–ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
–Schnittdaten siehe Seite(n) 206

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD101-12.00/12.49-20-0625R7	02445817	0.472-0.492	0.787	3.780	1.260	0.453	1.890	1.890	0.625	0.787
SD101-12.50/12.99-20-0625R7	02445818	0.492-0.511	0.787	3.795	1.276	0.472	1.906	1.890	0.625	0.787
SD101-13.00/13.99-20-0625R7	02445819	0.512-0.551	0.787	3.811	1.291	0.492	1.921	1.890	0.625	0.787
SD101-14.00/14.99-25-0625R7	02445820	0.551-0.590	0.984	4.031	1.512	0.531	2.142	1.890	0.625	0.787
SD101-15.00/15.99-25-0625R7	02445821	0.591-0.630	0.984	4.067	1.547	0.571	2.177	1.890	0.625	0.787
SD101-16.00/16.99-25-0625R7	02445822	0.630-0.669	0.984	4.094	1.575	0.610	2.205	1.890	0.625	0.787
SD101-17.00/17.99-30-0750R7	02445823	0.669-0.708	1.181	4.358	1.760	0.650	2.390	1.969	0.750	0.984
SD101-18.00/18.99-30-0750R7	02445824	0.709-0.748	1.181	4.398	1.799	0.689	2.429	1.969	0.750	0.984
SD101-19.00/19.99-30-0750R7	02445825	0.748-0.787	1.181	4.429	1.831	0.728	2.461	1.969	0.750	0.984
SD101-20.00/21.99-40-1000R7	02466044	0.787-0.866	1.575	5.098	2.106	0.768	2.894	2.205	1.000	1.220
SD101-22.00/23.99-40-1000R7	02466045	0.866-0.944	1.575	5.098	2.106	0.846	2.894	2.205	1.000	1.220
SD101-24.00/25.99-40-1000R7	02466046	0.945-1.023	1.575	5.098	2.106	0.925	2.894	2.205	1.000	1.220

Ersatzteile, im Lieferumfang enthalten

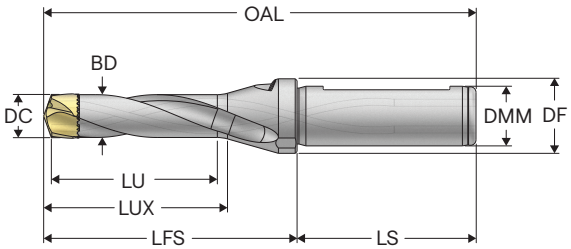
Bohrerdurch-messer (Zoll)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
0.472-0.551	H1.5-2D	MP6SS3X12	SD101-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD101-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD101-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD101-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD103 – R7

Bohrtiefe ca. 3 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 207

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD103-10.00/10.49-30-16R7	02462815	10,0-10,49	30,0	101,0	38,0	9,5	53,0	48,0	16,0	20,0
SD103-10.50/10.99-30-16R7	02462818	10,5-10,99	30,0	101,0	38,0	10,0	53,0	48,0	16,0	20,0
SD103-11.00/11.49-30-16R7	02462819	11,0-11,49	30,0	101,0	38,0	10,5	53,0	48,0	16,0	20,0
SD103-11.50/11.99-30-16R7	02462820	11,5-11,99	30,0	101,0	38,0	11,0	53,0	48,0	16,0	20,0
SD103-12.00/12.49-40-16R7	02445799	12,0-12,49	40,0	116,0	48,0	11,5	68,0	48,0	16,0	20,0
SD103-12.50/12.99-40-16R7	02445800	12,5-12,99	40,0	116,4	48,4	12,0	68,4	48,0	16,0	20,0
SD103-13.00/13.99-40-16R7	02445801	13,0-13,99	40,0	116,8	48,8	12,5	68,8	48,0	16,0	20,0
SD103-14.00/14.99-50-16R7	02445802	14,0-14,99	50,0	127,4	59,4	13,5	79,4	48,0	16,0	20,0
SD103-15.00/15.99-50-16R7	02445803	15,0-15,99	50,0	128,3	60,3	14,5	80,3	48,0	16,0	20,0
SD103-16.00/16.99-50-16R7	02445804	16,0-16,99	50,0	129,0	61,0	15,5	81,0	48,0	16,0	20,0
SD103-17.00/17.99-60-20R7	02445805	17,0-17,99	60,0	140,7	67,7	16,5	90,7	50,0	20,0	25,0
SD103-18.00/18.99-60-20R7	02445806	18,0-18,99	60,0	141,7	68,7	17,5	91,7	50,0	20,0	25,0
SD103-19.00/19.99-60-20R7	02445807	19,0-19,99	60,0	142,5	69,5	18,5	92,7	50,0	20,0	25,0
SD103-20.00/21.99-75-25R7	02462836	20,0-21,99	75,0	164,5	88,5	19,5	108,5	56,0	25,0	31,0
SD103-22.00/23.99-75-25R7	02462838	22,0-23,99	75,0	164,5	88,5	21,5	108,5	56,0	25,0	31,0
SD103-24.00/25.99-75-25R7	02462841	24,0-25,99	75,0	164,5	88,5	23,5	108,5	56,0	25,0	31,0

Ersatzteile, im Lieferumfang enthalten

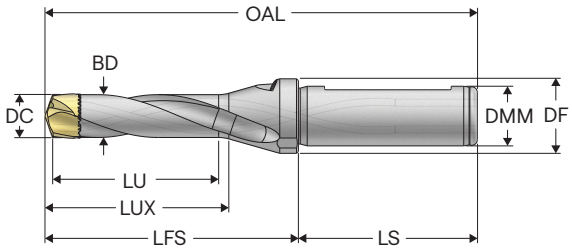
Bohrer-durchmesser (mm)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
10,00-11,99	H1.5-2D	MP6SS3X12	SD103-SP-4.0
12,00-13,99	H1.5-2D	MP6SS3X12	SD103-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD103-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD103-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD103-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD103 – R7

Bohrtiefe ca. 3 x D – Zölliger Schaft



–Kühlmittelzufuhr
–ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
–Schnittdaten siehe Seite(n) 207

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD103-09.50/09.99-30-0625R7	02673828	0.374-0.393	1.181	4.252	1.835	0.354	2.323	1.969	0.625	0.787
SD103-10.00/10.49-30-0625R7	02466011	0.394-0.413	1.181	3.976	1.496	0.374	2.087	1.890	0.625	0.787
SD103-10.50/10.99-30-0625R7	02466012	0.413-0.433	1.181	3.976	1.496	0.394	2.087	1.890	0.625	0.787
SD103-11.00/11.49-30-0625R7	02466013	0.433-0.452	1.181	3.976	1.496	0.413	2.087	1.890	0.625	0.787
SD103-11.50/11.99-30-0625R7	02466014	0.453-0.472	1.181	3.976	1.496	0.433	2.087	1.890	0.625	0.787
SD103-12.00/12.49-40-0625R7	02445826	0.472-0.492	1.575	4.567	1.890	0.453	2.677	1.890	0.625	0.787
SD103-12.50/12.99-40-0625R7	02445827	0.492-0.511	1.575	4.583	1.906	0.472	2.693	1.890	0.625	0.787
SD103-13.00/13.99-40-0625R7	02445828	0.512-0.551	1.575	4.598	1.921	0.492	2.709	1.890	0.625	0.787
SD103-14.00/14.99-50-0625R7	02445829	0.551-0.590	1.969	5.016	2.339	0.531	3.126	1.890	0.625	0.787
SD103-15.00/15.99-50-0625R7	02445830	0.591-0.630	1.969	5.051	2.374	0.571	3.161	1.890	0.625	0.787
SD103-16.00/16.99-50-0625R7	02445831	0.630-0.669	1.969	5.079	2.402	0.610	3.189	1.890	0.625	0.787
SD103-17.00/17.99-60-0750R7	02445832	0.669-0.708	2.362	5.539	2.665	0.650	3.571	1.969	0.750	0.984
SD103-18.00/18.99-60-0750R7	02445833	0.709-0.748	2.362	5.579	2.705	0.689	3.610	1.969	0.750	0.984
SD103-19.00/19.99-60-0750R7	02445834	0.748-0.787	2.362	5.610	2.736	0.728	3.650	1.969	0.750	0.984
SD103-20.00/21.99-75-1000R7	02466049	0.787-0.866	2.953	6.476	3.484	0.768	4.272	2.205	1.000	1.220
SD103-22.00/23.99-75-1000R7	02466050	0.866-0.944	2.953	6.476	3.484	0.846	4.272	2.205	1.000	1.220
SD103-24.00/25.99-75-1000R7	02466051	0.945-1.023	2.953	6.476	3.484	0.925	4.272	2.205	1.000	1.220

Ersatzteile, im Lieferumfang enthalten

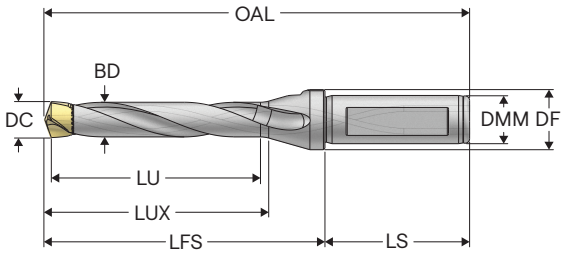
Bohrerdurch-messer (Zoll)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
0.374-0.393	H1.5-2D	MP6SS3X12	–
0.394-0.472	H1.5-2D	MP6SS3X12	SD103-SP-4.0
0.472-0.551	H1.5-2D	MP6SS3X12	SD103-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD103-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD103-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD103-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD105 – R7

Bohrtiefe ca. 5 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 208

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD105-10.00/10.49-50-16R7	02462822	10,0-10,49	50,0	120,1	57,3	9,5	72,1	48,0	16,0	20,0
SD105-10.50/10.99-50-16R7	02462824	10,5-10,99	50,0	120,6	57,3	10,0	72,6	48,0	16,0	20,0
SD105-11.00/11.49-50-16R7	02462828	11,0-11,49	50,0	120,9	57,3	10,5	72,9	48,0	16,0	20,0
SD105-11.50/11.99-50-16R7	02462830	11,5-11,99	50,0	121,3	58,3	11,0	73,3	48,0	16,0	20,0
SD105-12.00/12.49-65-16R7	02445808	12,0-12,49	65,0	141,0	73,0	11,5	93,0	48,0	16,0	20,0
SD105-12.50/12.99-65-16R7	02445809	12,5-12,99	65,0	141,4	73,4	12,0	93,4	48,0	16,0	20,0
SD105-13.00/13.99-65-16R7	02445810	13,0-13,99	65,0	141,8	73,8	12,5	93,8	48,0	16,0	20,0
SD105-14.00/14.99-80-16R7	02445811	14,0-14,99	80,0	157,4	89,4	13,5	109,4	48,0	16,0	20,0
SD105-15.00/15.99-80-16R7	02445812	15,0-15,99	80,0	158,3	90,3	14,5	110,3	48,0	16,0	20,0
SD105-16.00/16.99-80-16R7	02445813	16,0-16,99	80,0	159,0	91,0	15,5	111,0	48,0	16,0	20,0
SD105-17.00/17.99-95-20R7	02445814	17,0-17,99	95,0	176,7	107,7	16,5	126,7	50,0	20,0	25,0
SD105-18.00/18.99-95-20R7	02445815	18,0-18,99	95,0	177,7	108,7	17,5	127,7	50,0	20,0	25,0
SD105-19.00/19.99-95-20R7	02445816	19,0-19,99	95,0	178,5	109,5	18,5	128,5	50,0	20,0	25,0
SD105-20.00/21.99-125-25R7	02462843	20,0-21,99	125,0	214,5	138,5	19,5	158,5	56,0	25,0	31,0
SD105-22.00/23.99-125-25R7	02462848	22,0-23,99	125,0	214,5	138,5	21,5	158,5	56,0	25,0	31,0
SD105-24.00/25.99-125-25R7	02462850	24,0-25,99	125,0	214,5	138,5	23,5	158,5	56,0	25,0	31,0

Ersatzteile, im Lieferumfang enthalten

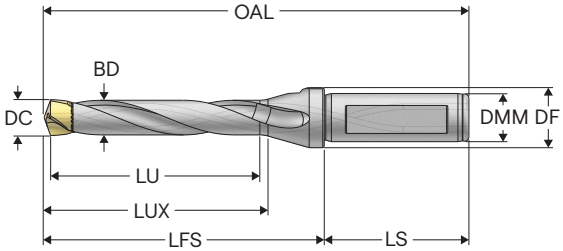
Bohrer-durchmesser (mm)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
10,00-11,99	H1.5-2D	MP6SS3X12	SD105-SP-4.0
12,00-13,99	H1.5-2D	MP6SS3X12	SD105-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD105-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD105-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD105-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD105 – R7

Bohrtiefe ca. 5 x D – Zölliger Schaft



–Kühlmittelzufuhr
–ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
–Schnittdaten siehe Seite(n) 208

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD105-10.00/10.49-50-0625R7	02466034	0.394-0.413	1.969	4.728	2.256	0.374	2.839	1.890	0.625	0.787
SD105-10.50/10.99-50-0625R7	02466037	0.413-0.433	1.969	4.748	2.256	0.394	2.858	1.890	0.625	0.787
SD105-11.00/11.49-50-0625R7	02466041	0.433-0.452	1.969	4.760	2.256	0.413	2.870	1.890	0.625	0.787
SD105-11.50/11.99-50-0625R7	02466042	0.453-0.472	1.969	4.776	2.295	0.433	2.886	1.890	0.625	0.787
SD105-12.00/12.49-65-0625R7	02445835	0.472-0.492	2.559	5.551	2.874	0.453	3.661	1.890	0.625	0.787
SD105-12.50/12.99-65-0625R7	02445836	0.492-0.511	2.559	5.567	2.890	0.472	3.677	1.890	0.625	0.787
SD105-13.00/13.99-65-0625R7	02445837	0.512-0.551	2.559	5.583	2.906	0.492	3.693	1.890	0.625	0.787
SD105-14.00/14.99-80-0625R7	02445838	0.551-0.590	3.150	6.197	3.520	0.531	4.307	1.890	0.625	0.787
SD105-15.00/15.99-80-0625R7	02445839	0.591-0.630	3.150	6.232	3.555	0.571	4.343	1.890	0.625	0.787
SD105-16.00/16.99-80-0625R7	02445840	0.630-0.669	3.150	6.260	3.583	0.610	4.370	1.890	0.625	0.787
SD105-17.00/17.99-95-0750R7	02445841	0.669-0.708	3.740	6.957	4.240	0.650	4.988	1.969	0.750	0.984
SD105-18.00/18.99-95-0750R7	02445842	0.709-0.748	3.740	6.996	4.280	0.689	5.028	1.969	0.750	0.984
SD105-19.00/19.99-95-0750R7	02445843	0.748-0.787	3.740	7.028	4.311	0.728	5.059	1.969	0.750	0.984
SD105-20.00/21.99-125-1000R7	02466052	0.787-0.866	4.921	8.445	5.453	0.768	6.240	2.205	1.000	1.220
SD105-22.00/23.99-125-1000R7	02466053	0.866-0.944	4.921	8.445	5.453	0.846	6.240	2.205	1.000	1.220
SD105-24.00/25.99-125-1000R7	02466054	0.945-1.023	4.921	8.445	5.453	0.925	6.240	2.205	1.000	1.220

Ersatzteile, im Lieferumfang enthalten

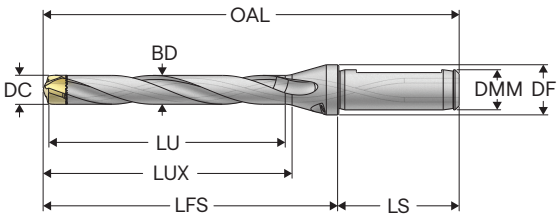
Bohrerdurch-messer (Zoll)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
0.394-0.472	H1.5-2D	MP6SS3X12	SD105-SP-4.0
0.472-0.551	H1.5-2D	MP6SS3X12	SD105-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD105-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD105-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD105-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD107 – R7

Bohrtiefe ca. 7 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 209

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD107-12.00/12.49-90-16R7	02427470	12,0-12,49	90,0	166,5	100,5	11,5	118,5	48,0	16,0	20,0
SD107-12.50/12.99-90-16R7	02427472	12,5-12,99	90,0	167,0	101,0	12,0	119,0	48,0	16,0	20,0
SD107-13.00/13.99-90-16R7	02427473	13,0-13,99	90,0	167,5	101,5	12,5	119,5	48,0	16,0	20,0
SD107-14.00/14.99-110-16R7	02427474	14,0-14,99	110,0	188,0	122,0	13,5	140,0	48,0	16,0	20,0
SD107-15.00/15.99-110-16R7	02427476	15,0-15,99	110,0	189,0	123,0	14,5	141,0	48,0	16,0	20,0
SD107-16.00/16.99-110-16R7	02427443	16,0-16,99	110,0	189,5	123,5	15,5	141,5	48,0	16,0	20,0
SD107-17.00/17.99-130-20R7	02427478	17,0-17,99	130,0	212,5	144,5	16,5	162,5	50,0	20,0	25,0
SD107-18.00/18.99-130-20R7	02427479	18,0-18,99	130,0	213,5	145,5	17,5	163,5	50,0	20,0	25,0
SD107-19.00/19.99-130-20R7	02427480	19,0-19,99	130,0	214,5	146,5	18,5	164,5	50,0	20,0	25,0
SD107-20.00/21.99-175-25R7	02530422	20,0-21,99	175,0	264,5	188,5	19,5	208,5	56,0	25,0	31,0
SD107-22.00/23.99-175-25R7	02530423	22,0-23,99	175,0	264,5	188,5	21,5	208,5	56,0	25,0	31,0
SD107-24.00/25.99-175-25R7	02517867	24,0-25,99	175,0	264,5	188,5	23,5	208,5	56,0	25,0	31,0

Ersatzteile, im Lieferumfang enthalten

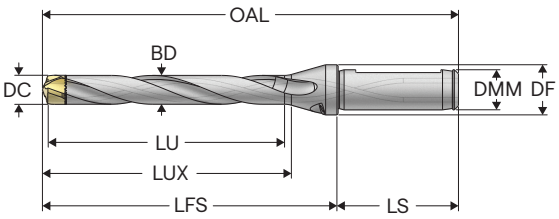
Bohrer-durchmesser (mm)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
12,00-13,99	H1.5-2D	MP6SS3X12	SD107-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD107-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD107-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD107-SP-8.0

Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD107 – R7

Bohrtiefe ca. 7 x D – Zölliger Schaft



–Kühlmittelzufuhr
–ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
–Schnittdaten siehe Seite(n) 209

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD107-12.00/12.49-90-0625R7	00040003	0.472-0.492	3.543	6.555	3.957	0.453	4.665	1.890	0.625	0.787
SD107-12.50/12.99-90-0625R7	00040004	0.492-0.511	3.543	6.575	3.976	0.472	4.685	1.890	0.625	0.787
SD107-13.00/13.99-90-0625R7	00040005	0.512-0.551	3.543	6.594	3.996	0.492	4.705	1.890	0.625	0.787
SD107-14.00/14.99-110-0625R7	00040006	0.551-0.590	4.331	7.402	4.803	0.531	5.512	1.890	0.625	0.787
SD107-15.00/15.99-110-0625R7	00040007	0.591-0.630	4.331	7.441	4.843	0.571	5.551	1.890	0.625	0.787
SD107-16.00/16.99-110-0625R7	00040008	0.630-0.669	4.331	7.461	4.862	0.610	5.571	1.890	0.625	0.787
SD107-17.00/17.99-130-0750R7	00040009	0.669-0.708	5.118	8.366	5.689	0.650	6.398	1.969	0.750	0.984
SD107-18.00/18.99-130-0750R7	00040010	0.709-0.748	5.118	8.406	5.728	0.689	6.437	1.969	0.750	0.984
SD107-19.00/19.99-130-0750R7	00040011	0.748-0.787	5.118	8.445	5.768	0.728	6.476	1.969	0.750	0.984
SD107-20.00/21.99-175-1000R7	02529095	0.787-0.866	6.890	10.413	7.421	0.768	8.209	2.205	1.000	1.220
SD107-22.00/23.99-175-1000R7	02530424	0.866-0.944	6.890	10.413	7.421	0.846	8.209	2.205	1.000	1.220
SD107-24.00/25.99-175-1000R7	02530425	0.945-1.023	6.890	10.413	7.421	0.925	8.209	2.205	1.000	1.220

Ersatzteile, im Lieferumfang enthalten

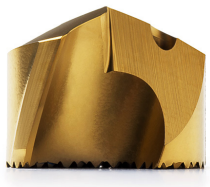
Bohrerdurch-messer (Zoll)	Spannschlüssel	Befestigungsschraube	Satz Ersatzteile
0.472-0.551	H1.5-2D	MP6SS3X12	SD107-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD107-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD107-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD107-SP-8.0

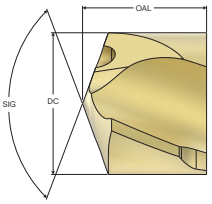
Zubehör

Ersatzklinge	Drehmoment-schlüssel
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

Kronen – Geometrie -P, -M und -K

Spitzenwinkel: 140°





Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-9.52-M	02700334	–	■	–	9,52	*0.375*	8,08	*0.318*
SD100-9.52-P	02673829	■	–	–	9,52	*0.375*	8,08	*0.318*
SD100-10.00-M	02469072	–	■	–	10,0	*0.394*	8,1	*0.319*
SD100-10.00-P	02469022	■	–	–	10,0	*0.394*	8,1	*0.319*
SD100-10.10-P	02469024	■	–	–	10,1	*0.398*	8,1	*0.319*
SD100-10.20-K	02544440	–	–	■	10,2	*0.402*	8,1	*0.319*
SD100-10.20-M	02469074	–	■	–	10,2	*0.402*	8,1	*0.319*
SD100-10.20-P	02469025	■	–	–	10,2	*0.402*	8,1	*0.319*
SD100-10.30-P	02469026	■	–	–	10,3	*0.406*	8,1	*0.319*
SD100-10.319-M	02469075	–	■	–	10,319	*0.406*	8,1	*0.319*
SD100-10.319-P	02469027	■	–	–	10,319	*0.406*	8,1	*0.319*
SD100-10.40-P	02592734	■	–	–	10,4	*0.409*	8,1	*0.319*
SD100-10.50-K	02556726	–	–	■	10,5	*0.413*	8,5	*0.335*
SD100-10.50-M	02469076	–	■	–	10,5	*0.413*	8,5	*0.335*
SD100-10.50-P	02469034	■	–	–	10,5	*0.413*	8,5	*0.335*
SD100-10.70-P	02469036	■	–	–	10,7	*0.421*	8,5	*0.335*
SD100-10.716-P	02469037	■	–	–	10,716	*0.422*	8,5	*0.335*
SD100-10.80-M	02469078	–	■	–	10,8	*0.425*	8,5	*0.335*
SD100-10.80-P	02469038	■	–	–	10,8	*0.425*	8,5	*0.335*
SD100-10.90-P	02469041	■	–	–	10,9	*0.429*	8,5	*0.335*
SD100-11.00-M	02469079	–	■	–	11,0	*0.433*	8,8	*0.346*
SD100-11.00-P	02469052	■	–	–	11,0	*0.433*	8,8	*0.346*
SD100-11.113-M	02469080	–	■	–	11,113	*0.438*	8,8	*0.346*
SD100-11.113-P	02469056	■	–	–	11,113	*0.438*	8,8	*0.346*
SD100-11.20-M	02469082	–	■	–	11,2	*0.441*	8,8	*0.346*
SD100-11.20-P	02469058	■	–	–	11,2	*0.441*	8,8	*0.346*
SD100-11.30-P	02469063	■	–	–	11,3	*0.445*	8,8	*0.346*
SD100-11.50-P	02469065	■	–	–	11,5	*0.453*	9,4	*0.370*
SD100-11.509-M	02469083	–	■	–	11,509	*0.453*	9,4	*0.370*
SD100-11.509-P	02469067	■	–	–	11,509	*0.453*	9,4	*0.370*
SD100-11.70-P	02469068	■	–	–	11,7	*0.461*	9,4	*0.370*
SD100-11.80-K	02542583	–	–	■	11,8	*0.465*	9,4	*0.370*
SD100-11.80-M	02469085	–	■	–	11,8	*0.465*	9,4	*0.370*
SD100-11.80-P	02469069	■	–	–	11,8	*0.465*	9,4	*0.370*
SD100-11.907-M	02592744	–	■	–	11,907	*0.469*	9,4	*0.370*
SD100-11.907-P	02469070	■	–	–	11,907	*0.469*	9,4	*0.370*
SD100-12.00-K	00090316	–	–	■	12,0	*0.472*	9,6	*0.378*
SD100-12.00-M	00090315	–	■	–	12,0	*0.472*	9,6	*0.378*
SD100-12.00-P	00090314	■	–	–	12,0	*0.472*	9,6	*0.378*
SD100-12.10-P	00039002	■	–	–	12,1	*0.476*	9,6	*0.378*
SD100-12.20-P	00048248	■	–	–	12,2	*0.480*	9,6	*0.378*
SD100-12.30-M	00071559	–	■	–	12,3	*0.484*	9,6	*0.378*
SD100-12.30-P	00071546	■	–	–	12,3	*0.484*	9,6	*0.378*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-12.41-M	00059768	–	■	–	12,41	*0.489*	9,6	*0.378*
SD100-12.41-P	00059767	■	–	–	12,41	*0.489*	9,6	*0.378*
SD100-12.50-K	00090319	–	–	■	12,5	*0.492*	10,0	*0.394*
SD100-12.50-M	00090318	–	■	–	12,5	*0.492*	10,0	*0.394*
SD100-12.50-P	00090317	■	–	–	12,5	*0.492*	10,0	*0.394*
SD100-12.60-P	02207212	■	–	–	12,6	*0.496*	10,0	*0.394*
SD100-12.70-K	00059633	–	–	■	12,7	*0.500*	10,0	*0.394*
SD100-12.70-M	00059632	–	■	–	12,7	*0.500*	10,0	*0.394*
SD100-12.70-P	00059631	■	–	–	12,7	*0.500*	10,0	*0.394*
SD100-12.80-K	00059636	–	–	■	12,8	*0.504*	10,0	*0.394*
SD100-12.80-M	00059635	–	■	–	12,8	*0.504*	10,0	*0.394*
SD100-12.80-P	00059634	■	–	–	12,8	*0.504*	10,0	*0.394*
SD100-12.90-M	02503935	–	■	–	12,9	*0.508*	10,0	*0.394*
SD100-12.90-P	00030891	■	–	–	12,9	*0.508*	10,0	*0.394*
SD100-13.00-K	00098529	–	–	■	13,0	*0.512*	10,4	*0.409*
SD100-13.00-M	00098528	–	■	–	13,0	*0.512*	10,4	*0.409*
SD100-13.00-P	00098527	■	–	–	13,0	*0.512*	10,4	*0.409*
SD100-13.10-K	00059639	–	–	■	13,1	*0.516*	10,4	*0.409*
SD100-13.10-M	00059638	–	■	–	13,1	*0.516*	10,4	*0.409*
SD100-13.10-P	00059637	■	–	–	13,1	*0.516*	10,4	*0.409*
SD100-13.20-P	00030894	■	–	–	13,2	*0.520*	10,4	*0.409*
SD100-13.30-M	00059641	–	■	–	13,3	*0.524*	10,4	*0.409*
SD100-13.30-P	00059640	■	–	–	13,3	*0.524*	10,4	*0.409*
SD100-13.50-K	00098532	–	–	■	13,5	*0.531*	10,4	*0.409*
SD100-13.50-M	00098531	–	■	–	13,5	*0.531*	10,4	*0.409*
SD100-13.50-P	00098530	■	–	–	13,5	*0.531*	10,4	*0.409*
SD100-13.70-M	00059644	–	■	–	13,7	*0.539*	10,4	*0.409*
SD100-13.70-P	00059643	■	–	–	13,7	*0.539*	10,4	*0.409*
SD100-13.80-K	00059648	–	–	■	13,8	*0.543*	10,4	*0.409*
SD100-13.80-M	00059647	–	■	–	13,8	*0.543*	10,4	*0.409*
SD100-13.80-P	00059646	■	–	–	13,8	*0.543*	10,4	*0.409*
SD100-13.89-M	00059771	–	■	–	13,89	*0.547*	10,4	*0.409*
SD100-13.89-P	00059770	■	–	–	13,89	*0.547*	10,4	*0.409*
SD100-14.00-K	00090322	–	–	■	14,0	*0.551*	11,0	*0.433*
SD100-14.00-M	00090321	–	■	–	14,0	*0.551*	11,0	*0.433*
SD100-14.00-P	00090320	■	–	–	14,0	*0.551*	11,0	*0.433*
SD100-14.10-P	00082712	■	–	–	14,1	*0.555*	11,0	*0.433*
SD100-14.20-K	00071549	–	–	■	14,2	*0.559*	11,0	*0.433*
SD100-14.20-M	00071561	–	■	–	14,2	*0.559*	11,0	*0.433*
SD100-14.20-P	00071548	■	–	–	14,2	*0.559*	11,0	*0.433*
SD100-14.29-K	00059675	–	–	■	14,29	*0.563*	11,0	*0.433*
SD100-14.29-M	00059674	–	■	–	14,29	*0.563*	11,0	*0.433*
SD100-14.29-P	00059673	■	–	–	14,29	*0.563*	11,0	*0.433*
SD100-14.40-P	02207869	■	–	–	14,4	*0.567*	11,0	*0.433*
SD100-14.50-K	00090325	–	–	■	14,5	*0.571*	11,0	*0.433*
SD100-14.50-M	00090324	–	■	–	14,5	*0.571*	11,0	*0.433*
SD100-14.50-P	00090323	■	–	–	14,5	*0.571*	11,0	*0.433*
SD100-14.68-K	00059775	–	–	■	14,68	*0.578*	11,0	*0.433*
SD100-14.68-M	00059774	–	■	–	14,68	*0.578*	11,0	*0.433*
SD100-14.68-P	00059773	■	–	–	14,68	*0.578*	11,0	*0.433*
SD100-14.70-M	00059650	–	■	–	14,7	*0.579*	11,0	*0.433*
SD100-14.70-P	00059649	■	–	–	14,7	*0.579*	11,0	*0.433*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-14.80-M	00059653	–	■	–	14,8	*0.583*	11,0	*0.433*
SD100-14.80-P	00059652	■	–	–	14,8	*0.583*	11,0	*0.433*
SD100-14.90-M	02592745	–	■	–	14,9	*0.587*	11,0	*0.433*
SD100-14.90-P	00030895	■	–	–	14,9	*0.587*	11,0	*0.433*
SD100-15.00-K	00090328	–	–	■	15,0	*0.591*	11,9	*0.469*
SD100-15.00-M	00090327	–	■	–	15,0	*0.591*	11,9	*0.469*
SD100-15.00-P	00090326	■	–	–	15,0	*0.591*	11,9	*0.469*
SD100-15.08-M	00059777	–	■	–	15,08	*0.594*	11,9	*0.469*
SD100-15.08-P	00059776	■	–	–	15,08	*0.594*	11,9	*0.469*
SD100-15.10-P	00079342	■	–	–	15,1	*0.594*	11,9	*0.469*
SD100-15.20-P	00030896	■	–	–	15,2	*0.598*	11,9	*0.469*
SD100-15.25-K	00071551	–	–	■	15,25	*0.600*	11,9	*0.469*
SD100-15.25-M	00071562	–	■	–	15,25	*0.600*	11,9	*0.469*
SD100-15.25-P	00071550	■	–	–	15,25	*0.600*	11,9	*0.469*
SD100-15.48-K	00022926	–	–	■	15,48	*0.609*	11,9	*0.469*
SD100-15.48-M	00059780	–	■	–	15,48	*0.609*	11,9	*0.469*
SD100-15.48-P	00059779	■	–	–	15,48	*0.609*	11,9	*0.469*
SD100-15.50-K	00098535	–	–	■	15,5	*0.610*	11,9	*0.469*
SD100-15.50-M	00098534	–	■	–	15,5	*0.610*	11,9	*0.469*
SD100-15.50-P	00098533	■	–	–	15,5	*0.610*	11,9	*0.469*
SD100-15.70-M	00059656	–	■	–	15,7	*0.618*	11,9	*0.469*
SD100-15.70-P	00059655	■	–	–	15,7	*0.618*	11,9	*0.469*
SD100-15.80-K	00059660	–	–	■	15,8	*0.622*	11,9	*0.469*
SD100-15.80-M	00059659	–	■	–	15,8	*0.622*	11,9	*0.469*
SD100-15.80-P	00059658	■	–	–	15,8	*0.622*	11,9	*0.469*
SD100-15.88-K	00059678	–	–	■	15,88	*0.625*	11,9	*0.469*
SD100-15.88-M	00059677	–	■	–	15,88	*0.625*	11,9	*0.469*
SD100-15.88-P	00059676	■	–	–	15,88	*0.625*	11,9	*0.469*
SD100-16.00-K	00098538	–	–	■	16,0	*0.630*	12,6	*0.496*
SD100-16.00-M	00098537	–	■	–	16,0	*0.630*	12,6	*0.496*
SD100-16.00-P	00098536	■	–	–	16,0	*0.630*	12,6	*0.496*
SD100-16.10-P	00077964	■	–	–	16,1	*0.634*	12,6	*0.496*
SD100-16.20-P	00047365	■	–	–	16,2	*0.638*	12,6	*0.496*
SD100-16.25-P	00034081	■	–	–	16,25	*0.640*	12,6	*0.496*
SD100-16.27-K	00022929	–	–	■	16,27	*0.641*	12,6	*0.496*
SD100-16.27-M	00022928	–	■	–	16,27	*0.641*	12,6	*0.496*
SD100-16.27-P	00022927	■	–	–	16,27	*0.641*	12,6	*0.496*
SD100-16.40-P	02301114	■	–	–	16,4	*0.646*	12,6	*0.496*
SD100-16.50-K	00098541	–	–	■	16,5	*0.650*	12,6	*0.496*
SD100-16.50-M	00098540	–	■	–	16,5	*0.650*	12,6	*0.496*
SD100-16.50-P	00098539	■	–	–	16,5	*0.650*	12,6	*0.496*
SD100-16.67-K	00059681	–	–	■	16,67	*0.656*	12,6	*0.496*
SD100-16.67-M	00059680	–	■	–	16,67	*0.656*	12,6	*0.496*
SD100-16.67-P	00059679	■	–	–	16,67	*0.656*	12,6	*0.496*
SD100-16.70-K	00059663	–	–	■	16,7	*0.657*	12,6	*0.496*
SD100-16.70-M	00059662	–	■	–	16,7	*0.657*	12,6	*0.496*
SD100-16.70-P	00059661	■	–	–	16,7	*0.657*	12,6	*0.496*
SD100-16.80-K	00059666	–	–	■	16,8	*0.661*	12,6	*0.496*
SD100-16.80-M	00059665	–	■	–	16,8	*0.661*	12,6	*0.496*
SD100-16.80-P	00059664	■	–	–	16,8	*0.661*	12,6	*0.496*
SD100-16.90-M	02593463	–	■	–	16,9	*0.665*	12,6	*0.496*
SD100-16.90-P	00030898	■	–	–	16,9	*0.665*	12,6	*0.496*

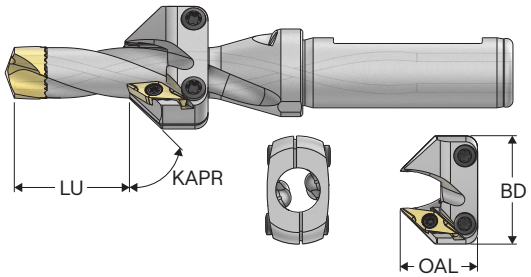
Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-17.00-K	00090331	–	–	■	17,0	*0.669*	13,3	*0.524*
SD100-17.00-M	00090330	–	■	–	17,0	*0.669*	13,3	*0.524*
SD100-17.00-P	00090329	■	–	–	17,0	*0.669*	13,3	*0.524*
SD100-17.07-K	00022933	–	–	■	17,07	*0.672*	13,3	*0.524*
SD100-17.07-M	00022932	–	■	–	17,07	*0.672*	13,3	*0.524*
SD100-17.07-P	00022931	■	–	–	17,07	*0.672*	13,3	*0.524*
SD100-17.10-P	00034083	■	–	–	17,1	*0.673*	13,3	*0.524*
SD100-17.20-K	02515762	–	–	■	17,2	*0.677*	13,3	*0.524*
SD100-17.20-P	00047714	■	–	–	17,2	*0.677*	13,3	*0.524*
SD100-17.30-K	02203711	–	–	■	17,3	*0.681*	13,3	*0.524*
SD100-17.46-M	00059683	–	■	–	17,46	*0.687*	13,3	*0.524*
SD100-17.46-P	00059682	■	–	–	17,46	*0.687*	13,3	*0.524*
SD100-17.50-K	00090334	–	–	■	17,5	*0.689*	13,3	*0.524*
SD100-17.50-M	00090333	–	■	–	17,5	*0.689*	13,3	*0.524*
SD100-17.50-P	00090332	■	–	–	17,5	*0.689*	13,3	*0.524*
SD100-17.70-K	00059669	–	–	■	17,7	*0.697*	13,3	*0.524*
SD100-17.70-M	00059668	–	■	–	17,7	*0.697*	13,3	*0.524*
SD100-17.70-P	00059667	■	–	–	17,7	*0.697*	13,3	*0.524*
SD100-17.80-K	00059672	–	–	■	17,8	*0.701*	13,3	*0.524*
SD100-17.80-M	00059671	–	■	–	17,8	*0.701*	13,3	*0.524*
SD100-17.80-P	00059670	■	–	–	17,8	*0.701*	13,3	*0.524*
SD100-17.86-K	00022936	–	–	■	17,86	*0.703*	13,3	*0.524*
SD100-17.86-M	00022935	–	■	–	17,86	*0.703*	13,3	*0.524*
SD100-17.86-P	00022934	■	–	–	17,86	*0.703*	13,3	*0.524*
SD100-17.90-M	02442098	–	■	–	17,9	*0.705*	13,3	*0.524*
SD100-17.90-P	00047693	■	–	–	17,9	*0.705*	13,3	*0.524*
SD100-18.00-K	00090337	–	–	■	18,0	*0.709*	14,4	*0.567*
SD100-18.00-M	00090336	–	■	–	18,0	*0.709*	14,4	*0.567*
SD100-18.00-P	00090335	■	–	–	18,0	*0.709*	14,4	*0.567*
SD100-18.10-P	00030900	■	–	–	18,1	*0.713*	14,4	*0.567*
SD100-18.20-P	00038469	■	–	–	18,2	*0.717*	14,4	*0.567*
SD100-18.26-K	00035196	–	–	■	18,26	*0.719*	14,4	*0.567*
SD100-18.26-M	00022938	–	■	–	18,26	*0.719*	14,4	*0.567*
SD100-18.26-P	00022937	■	–	–	18,26	*0.719*	14,4	*0.567*
SD100-18.50-K	00059687	–	–	■	18,5	*0.728*	14,4	*0.567*
SD100-18.50-M	00059686	–	■	–	18,5	*0.728*	14,4	*0.567*
SD100-18.50-P	00059685	■	–	–	18,5	*0.728*	14,4	*0.567*
SD100-18.65-M	00035198	–	■	–	18,65	*0.734*	14,4	*0.567*
SD100-18.65-P	00035197	■	–	–	18,65	*0.734*	14,4	*0.567*
SD100-18.70-M	00059689	–	■	–	18,7	*0.736*	14,4	*0.567*
SD100-18.70-P	00059688	■	–	–	18,7	*0.736*	14,4	*0.567*
SD100-18.80-K	00059693	–	–	■	18,8	*0.740*	14,4	*0.567*
SD100-18.80-M	00059692	–	■	–	18,8	*0.740*	14,4	*0.567*
SD100-18.80-P	00059691	■	–	–	18,8	*0.740*	14,4	*0.567*
SD100-18.90-M	02592746	–	■	–	18,9	*0.744*	14,4	*0.567*
SD100-18.90-P	00030901	■	–	–	18,9	*0.744*	14,4	*0.567*
SD100-19.00-K	00059696	–	–	■	19,0	*0.748*	15,2	*0.598*
SD100-19.00-M	00059695	–	■	–	19,0	*0.748*	15,2	*0.598*
SD100-19.00-P	00059694	■	–	–	19,0	*0.748*	15,2	*0.598*
SD100-19.05-K	00059699	–	–	■	19,05	*0.750*	15,2	*0.598*
SD100-19.05-M	00059698	–	■	–	19,05	*0.750*	15,2	*0.598*
SD100-19.05-P	00059697	■	–	–	19,05	*0.750*	15,2	*0.598*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-19.10-P	00030902	■	–	–	19,1	*0.752*	15,2	*0.598*
SD100-19.20-K	00071566	–	–	■	19,2	*0.756*	15,2	*0.598*
SD100-19.20-M	00071564	–	■	–	19,2	*0.756*	15,2	*0.598*
SD100-19.20-P	00071563	■	–	–	19,2	*0.756*	15,2	*0.598*
SD100-19.25-P	00048318	■	–	–	19,25	*0.758*	15,2	*0.598*
SD100-19.45-K	00035202	–	–	■	19,45	*0.766*	15,2	*0.598*
SD100-19.45-M	00035201	–	■	–	19,45	*0.766*	15,2	*0.598*
SD100-19.45-P	00035200	■	–	–	19,45	*0.766*	15,2	*0.598*
SD100-19.50-K	00059702	–	–	■	19,5	*0.768*	15,2	*0.598*
SD100-19.50-M	00059701	–	■	–	19,5	*0.768*	15,2	*0.598*
SD100-19.50-P	00059700	■	–	–	19,5	*0.768*	15,2	*0.598*
SD100-19.70-K	00059705	–	–	■	19,7	*0.776*	15,2	*0.598*
SD100-19.70-M	00059704	–	■	–	19,7	*0.776*	15,2	*0.598*
SD100-19.70-P	00059703	■	–	–	19,7	*0.776*	15,2	*0.598*
SD100-19.80-K	00059708	–	–	■	19,8	*0.780*	15,2	*0.598*
SD100-19.80-M	00059707	–	■	–	19,8	*0.780*	15,2	*0.598*
SD100-19.80-P	00059706	■	–	–	19,8	*0.780*	15,2	*0.598*
SD100-19.84-M	00035204	–	■	–	19,84	*0.781*	15,2	*0.598*
SD100-19.84-P	00035203	■	–	–	19,84	*0.781*	15,2	*0.598*
SD100-19.90-M	02592747	–	■	–	19,9	*0.783*	15,2	*0.598*
SD100-19.90-P	00010065	■	–	–	19,9	*0.783*	15,2	*0.598*
SD100-19.99-P	00081744	■	–	–	19,99	*0.787*	15,2	*0.598*
SD100-20.00-K	02433368	–	–	■	20,0	*0.787*	15,2	*0.598*
SD100-20.00-M	02469176	–	■	–	20,0	*0.787*	15,2	*0.598*
SD100-20.00-P	02469095	■	–	–	20,0	*0.787*	15,2	*0.598*
SD100-20.241-P	02469096	■	–	–	20,241	*0.797*	15,2	*0.598*
SD100-20.50-K	02569177	–	–	■	20,5	*0.807*	15,2	*0.598*
SD100-20.50-M	02469178	–	■	–	20,5	*0.807*	15,2	*0.598*
SD100-20.50-P	02469098	■	–	–	20,5	*0.807*	15,2	*0.598*
SD100-20.638-M	02469179	–	■	–	20,638	*0.813*	15,2	*0.598*
SD100-20.638-P	02469100	■	–	–	20,638	*0.813*	15,2	*0.598*
SD100-20.80-P	02508750	■	–	–	20,8	*0.819*	15,2	*0.598*
SD100-20.90-P	02586615	■	–	–	20,9	*0.823*	15,2	*0.598*
SD100-21.00-K	02523183	–	–	■	21,0	*0.827*	15,2	*0.598*
SD100-21.00-M	02469180	–	■	–	21,0	*0.827*	15,2	*0.598*
SD100-21.00-P	02469118	■	–	–	21,0	*0.827*	15,2	*0.598*
SD100-21.034-P	02469120	■	–	–	21,034	*0.828*	15,2	*0.598*
SD100-21.20-P	02469121	■	–	–	21,2	*0.835*	15,2	*0.598*
SD100-21.30-P	02521624	■	–	–	21,3	*0.839*	15,2	*0.598*
SD100-21.430-M	02469182	–	■	–	21,43	*0.844*	15,2	*0.598*
SD100-21.430-P	02469122	■	–	–	21,43	*0.844*	15,2	*0.598*
SD100-21.50-K	02521338	–	–	■	21,5	*0.846*	15,2	*0.598*
SD100-21.50-M	02469183	–	■	–	21,5	*0.846*	15,2	*0.598*
SD100-21.50-P	02469124	■	–	–	21,5	*0.846*	15,2	*0.598*
SD100-21.80-K	02592763	–	–	■	21,8	*0.858*	15,2	*0.598*
SD100-21.80-M	02555978	–	■	–	21,8	*0.858*	15,2	*0.598*
SD100-21.80-P	02592735	■	–	–	21,8	*0.858*	15,2	*0.598*
SD100-21.829-P	02469125	■	–	–	21,829	*0.859*	15,2	*0.598*
SD100-21.90-M	02592752	–	■	–	21,9	*0.862*	15,2	*0.598*
SD100-21.90-P	02592736	■	–	–	21,9	*0.862*	15,2	*0.598*
SD100-22.00-K	02511599	–	–	■	22,0	*0.866*	15,2	*0.598*
SD100-22.00-M	02469185	–	■	–	22,0	*0.866*	15,2	*0.598*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-22.00-P	02469128	■	–	–	22,0	*0.866*	15,2	*0.598*
SD100-22.225-M	02469186	–	■	–	22,225	*0.875*	15,2	*0.598*
SD100-22.225-P	02469129	■	–	–	22,225	*0.875*	15,2	*0.598*
SD100-22.50-K	02569178	–	–	■	22,5	*0.886*	15,2	*0.598*
SD100-22.50-M	02469188	–	■	–	22,5	*0.886*	15,2	*0.598*
SD100-22.50-P	02469132	■	–	–	22,5	*0.886*	15,2	*0.598*
SD100-22.621-P	02469133	■	–	–	22,621	*0.891*	15,2	*0.598*
SD100-22.80-M	02592754	–	■	–	22,8	*0.898*	15,2	*0.598*
SD100-22.80-P	02539323	■	–	–	22,8	*0.898*	15,2	*0.598*
SD100-22.90-P	02592738	■	–	–	22,9	*0.902*	15,2	*0.598*
SD100-23.00-K	02515181	–	–	■	23,0	*0.906*	15,2	*0.598*
SD100-23.00-M	02469189	–	■	–	23,0	*0.906*	15,2	*0.598*
SD100-23.00-P	02469134	■	–	–	23,0	*0.906*	15,2	*0.598*
SD100-23.416-P	02469136	■	–	–	23,416	*0.922*	15,2	*0.598*
SD100-23.50-K	02551252	–	–	■	23,5	*0.925*	15,2	*0.598*
SD100-23.50-M	02469190	–	■	–	23,5	*0.925*	15,2	*0.598*
SD100-23.50-P	02469138	■	–	–	23,5	*0.925*	15,2	*0.598*
SD100-23.813-K	02592766	–	–	■	23,813	*0.938*	15,2	*0.598*
SD100-23.813-M	02554971	–	■	–	23,813	*0.938*	15,2	*0.598*
SD100-23.813-P	02469140	■	–	–	23,813	*0.938*	15,2	*0.598*
SD100-23.90-M	02592756	–	■	–	23,9	*0.941*	15,2	*0.598*
SD100-23.90-P	02592739	■	–	–	23,9	*0.941*	15,2	*0.598*
SD100-24.00-K	02569179	–	–	■	24,0	*0.945*	15,2	*0.598*
SD100-24.00-M	02469191	–	■	–	24,0	*0.945*	15,2	*0.598*
SD100-24.00-P	02469141	■	–	–	24,0	*0.945*	15,2	*0.598*
SD100-24.209-P	02469142	■	–	–	24,209	*0.953*	15,2	*0.598*
SD100-24.50-K	02569180	–	–	■	24,5	*0.965*	15,2	*0.598*
SD100-24.50-M	02469192	–	■	–	24,5	*0.965*	15,2	*0.598*
SD100-24.50-P	02469144	■	–	–	24,5	*0.965*	15,2	*0.598*
SD100-24.605-P	02469145	■	–	–	24,605	*0.969*	15,2	*0.598*
SD100-24.80-K	02592767	–	–	■	24,8	*0.976*	15,2	*0.598*
SD100-24.80-M	02508165	–	■	–	24,8	*0.976*	15,2	*0.598*
SD100-24.80-P	02529665	■	–	–	24,8	*0.976*	15,2	*0.598*
SD100-24.90-M	02592757	–	■	–	24,9	*0.980*	15,2	*0.598*
SD100-24.90-P	02592740	■	–	–	24,9	*0.980*	15,2	*0.598*
SD100-25.00-K	02524629	–	–	■	25,0	*0.984*	15,2	*0.598*
SD100-25.00-M	02469193	–	■	–	25,0	*0.984*	15,2	*0.598*
SD100-25.00-P	02469146	■	–	–	25,0	*0.984*	15,2	*0.598*
SD100-25.40-K	02569181	–	–	■	25,4	*1.000*	15,2	*0.598*
SD100-25.400-M	02469194	–	■	–	25,4	*1.000*	15,2	*0.598*
SD100-25.400-P	02469147	■	–	–	25,4	*1.000*	15,2	*0.598*
SD100-25.50-P	02536609	■	–	–	25,5	*1.004*	15,2	*0.598*
SD100-25.60-P	02519477	■	–	–	25,6	*1.008*	15,2	*0.598*
SD100-25.80-M	02592758	–	■	–	25,8	*1.016*	15,2	*0.598*
SD100-25.80-P	02581593	■	–	–	25,8	*1.016*	15,2	*0.598*
SD100-25.90-M	02592759	–	■	–	25,9	*1.020*	15,2	*0.598*
SD100-25.90-P	02592741	■	–	–	25,9	*1.020*	15,2	*0.598*
SD100-25.99-K	02516403	–	–	■	25,99	*1.023*	15,2	*0.598*
SD100-25.99-P	02516402	■	–	–	25,99	*1.023*	15,2	*0.598*

■ Lagerstandard.

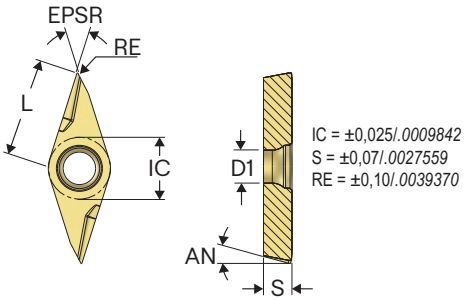
Fasringe



Bezeichnung	Produkt-nummer	Für Bohrer	KAPR°	Bohrtiefe LU SD101 (min-max)		SD103 (min-max)		SD105 (min-max)		SD107 (min-max)		Max. Fastiefe (mm)	OAL	BD
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD100-C45-12.00/12.49	00014922	SD10x-12.00/12.49	45 °	12,0 *0.472*	13,0 *0.512*	12,0 *0.472*	28,0 *1.102*	28,0 *1.102*	53,0 *2.087*	53,0 *2.087*	78,0 *3.071*	1,5 *0.059*	19,0 *0.748*	28,0 *1.102*
SD100-C45-12.50/12.99	00014923	SD10x-12.50/12.99	45 °	12,0 *0.472*	14,0 *0.551*	12,0 *0.472*	29,0 *1.142*	29,0 *1.142*	54,0 *2.126*	54,0 *2.126*	79,0 *3.110*	1,5 *0.059*	19,0 *0.748*	28,0 *1.102*
SD100-C45-13.00/13.99	00014924	SD10x-13.00/13.99	45 °	13,0 *0.512*	14,0 *0.551*	13,0 *0.512*	29,0 *1.142*	29,0 *1.142*	54,0 *2.126*	54,0 *2.126*	79,0 *3.110*	1,5 *0.059*	19,0 *0.748*	28,0 *1.102*
SD100-C45-14.00/14.99	00014928	SD10x-14.00/14.99	45 °	14,0 *0.551*	20,0 *0.787*	14,0 *0.551*	40,0 *1.575*	40,0 *1.575*	70,0 *2.756*	70,0 *2.756*	100,0 *3.937*	2,0 *0.079*	19,0 *0.748*	31,0 *1.220*
SD100-C45-15.00/15.99	00014931	SD10x-15.00/15.99	45 °	14,0 *0.551*	21,0 *0.827*	14,0 *0.551*	41,0 *1.614*	41,0 *1.614*	71,0 *2.795*	71,0 *2.795*	101,0 *3.976*	2,0 *0.079*	19,0 *0.748*	31,0 *1.220*
SD100-C45-16.00/16.99	00014932	SD10x-16.00/16.99	45 °	15,0 *0.591*	22,0 *0.866*	15,0 *0.591*	42,0 *1.654*	42,0 *1.654*	72,0 *2.835*	72,0 *2.835*	102,0 *4.016*	2,0 *0.079*	19,0 *0.748*	31,0 *1.220*
SD100-C45-17.00/17.99	00014933	SD10x-17.00/17.99	45 °	16,0 *0.630*	25,0 *0.984*	16,0 *0.630*	51,0 *2.008*	51,0 *2.008*	87,0 *3.425*	87,0 *3.425*	123,0 *4.843*	2,0 *0.079*	19,0 *0.748*	36,0 *1.417*
SD100-C45-18.00/18.99	00014935	SD10x-18.00/18.99	45 °	17,0 *0.669*	26,0 *1.024*	17,0 *0.669*	52,0 *2.047*	52,0 *2.047*	88,0 *3.465*	88,0 *3.465*	124,0 *4.882*	2,0 *0.079*	19,0 *0.748*	36,0 *1.417*
SD100-C45-19.00/19.99	00014936	SD10x-19.00/19.99	45 °	18,0 *0.709*	27,0 *1.063*	18,0 *0.709*	53,0 *2.087*	53,0 *2.087*	89,0 *3.504*	89,0 *3.504*	125,0 *4.921*	2,0 *0.079*	19,0 *0.748*	36,0 *1.417*

Wendeschneidplatte

Toleranzen:
mm/*Zoll*



IC = ±0,025/*.0009842*
S = ±0,07/*.0027559*
RE = ±0,10/*.0039370*

Größe	L mm/*Zoll*	EPSR	RE mm/*Zoll*	IC mm/*Zoll*	D1 mm/*Zoll*	AN	S mm/*Zoll*
09	**9,0**/*.2187*	**35°**	**0,2**/*.0078*	**5,556**/*.2187*	**2,9**/*.1141*	**7°**	**2,5**/*.0984*

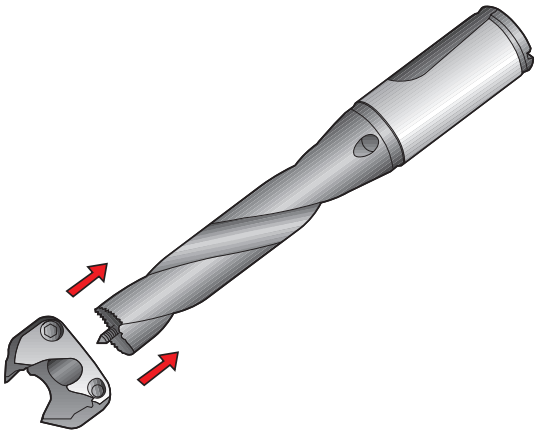
Sorte: T400D

Bezeichnung: VCGX090202-D1

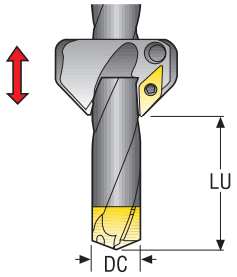
Produktnummer: 00014948

Montagehinweis/Fasring

1. Befestigen Sie den Fasring auf dem Bohrerschaft ohne Faswendeplatte oder Bohrkrone.

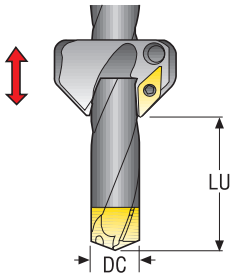


2.1 Fasring so eng wie möglich am Schaft befestigen.



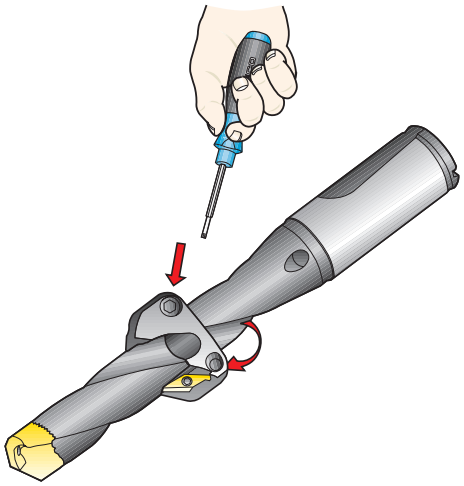
DC		LU Bohrtiefe (min.-max.)			
		SD101		SD103	
mm	*Zoll*	mm	*Zoll*	mm	*Zoll*
12	*.472*	12-13	*.472-.512*	12-28	*.472-1.102*
12,5	*.492*	12-14	*.472-.551*	12-29	*.472-1.142*
13	*.512*	13-14	*.512-.551*	13-29	*.512-1.142*
14	*.551*	14-20	*.551-.787*	14-40	*.551-1.575*
15	*.591*	14-21	*.551-.827*	14-41	*.551-1.614*
16	*.630*	15-22	*.591-.866*	15-42	*.591-1.654*
17	*.669*	16-25	*.630-.984*	16-51	*.630-2.008*
18	*.709*	17-26	*.669-1.024*	17-52	*.669-2.047*
19	*.748*	18-27	*.709-1.063*	18-53	*.709-2.087*

2.2 Fasring so eng wie möglich am Schaft befestigen.



DC		LU Bohrtiefe (min.-max.)			
		SD105		SD107	
mm	*Zoll*	mm	*Zoll*	mm	*Zoll*
12	*.472*	28-53	*1.102-2.087*	53-78	*2.087-3.071*
12,5	*.492*	29-54	*1.142-2.126*	54-79	*2.126-3.110*
13	*.512*	29-54	*1.142-2.126*	54-79	*2.126-3.110*
14	*.551*	40-70	*1.575-2.756*	70-100	*2.756-3.937*
15	*.591*	41-71	*1.614-2.785*	71-101	*2.795-3.976*
16	*.630*	42-72	*1.654-2.835*	72-102	*2.835-4.016*
17	*.669*	51-87	*2.008-3.425*	87-123	*3.425-4.843*
18	*.709*	52-88	*2.047-3.465*	88-124	*3.465-4.882*
19	*.748*	53-89	*2.087-3.504*	89-125	*3.504-4.921*

3. Beide Schrauben gemäß obiger Tabelle anziehen.



DC		M	
mm	*Zoll*	Nm	*in-lbs*
12-19	*.472-.748*	3-4	*26-35*

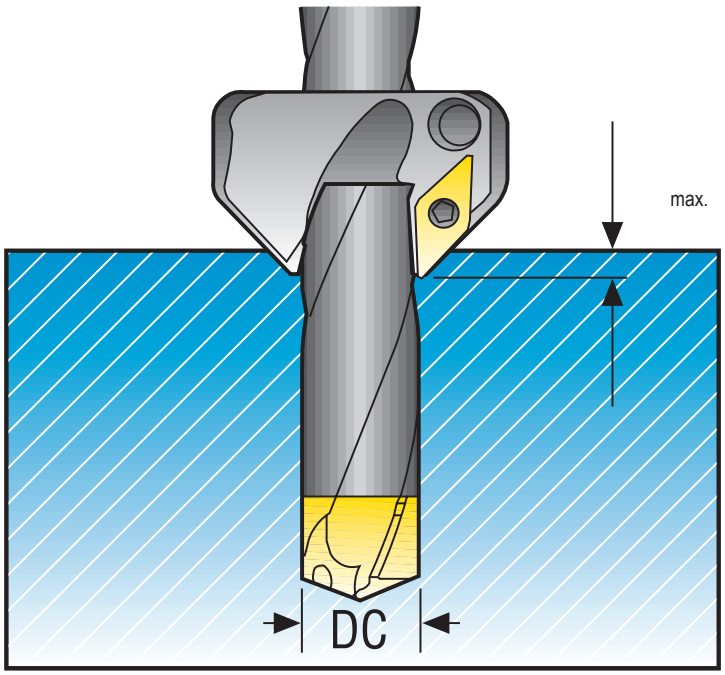
Fasringe

Die für Crownloc® empfohlenen Schnittgeschwindigkeiten und Vorschübe auf Seiten 206-209 müssen auch zum Fasen eingesetzt werden.

Fehlerbehebung

Vibrationen beim Fasen	• Schnittgeschwindigkeit reduzieren • Falls möglich, den Fasring enger am Schaft befestigen. • Falls möglich, kürzeren Bohrer einsetzen.

Maximale Fastiefe



DC		Max.	
mm	*Zoll*	mm	*Zoll*
12-13	*.472-512*	1,5	*.059*
14-19	*.551-.748*	2	*.079*

SD101 – ∅ 10-26 mm / *0.394-1.024 Zoll*

SMG		f									v_c
		Ø 10.00 *Ø 0.394*	Ø 12.00 *Ø 0.472*	Ø 14.00 *Ø 0.551*	Ø 16.00 *Ø 0.630*	Ø 18.00 *Ø 0.709*	Ø 20.00 *Ø 0.787*	Ø 22.00 *Ø 0.866*	Ø 24.00 *Ø 0.945*	Ø 26.00 *Ø 1.024*	
P1	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	125
	P	*0.0080*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*410*
P2	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	120
	P	*0.0080*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*395*
P3	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	105
	P	*0.0075*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*345*
P4	P	0,19	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	95
	P	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*310*
P5	P	0,19	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	90
	P	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*295*
P6	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	100
	P	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*330*
P7	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	95
	P	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*310*
P8	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	90
	P	*0.0075*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*295*
P11	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	90
	P	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*295*
P12	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	55
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*180*
M1	M	0,14	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	85
	M	*0.0055*	*0.0060*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*280*
M2	M	0,13	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	70
	M	*0.0050*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0060*	*0.0060*	*0.0065*	*0.0065*	*230*
M3	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	50
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*165*
M4	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	39
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*130*
M5	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	33
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*110*
K1	K	0,28	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	100
	K	*0.011*	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*0.017*	*0.017*	*0.017*	*330*
K2	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	85
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*280*
K3	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	70
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*230*
K4	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	70
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*230*
K5	K	0,24	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	41
	K	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*0.014*	*135*
N1	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	335
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*1100*
N2	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	215
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*710*
N3	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	145
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*475*
N11	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	170
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*560*
S1	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	34
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*110*
S2	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	25
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*80*
S3	M	0,085	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	25
	M	*0.0034*	*0.0034*	*0.0036*	*0.0038*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*80*
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	65
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*215*
S12	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	49
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*160*
S13	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	38
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*125*
H3	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	27
	P	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*90*
H5	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	50
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*165*
H7	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	27
	P	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*90*
H8	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	50
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*165*
H11	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	65
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*215*
H12	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	32
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*105*
H21	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	50
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*165*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD103 – ∅ 10-26 mm / *0.394-1.024 Zoll*

SMG		f									v_c
		Ø 10.00 *Ø 0.394*	Ø 12.00 *Ø 0.472*	Ø 14.00 *Ø 0.551*	Ø 16.00 *Ø 0.630*	Ø 18.00 *Ø 0.709*	Ø 20.00 *Ø 0.787*	Ø 22.00 *Ø 0.866*	Ø 24.00 *Ø 0.945*	Ø 26.00 *Ø 1.024*	
P1	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	120
	P	*0.008*	*0.0095*	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*395*
P2	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	115
	P	*0.008*	*0.0095*	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*375*
P3	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	100
	P	*0.0075*	*0.0085*	*0.01*	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*330*
P4	P	0,19	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	85
	P	*0.0075*	*0.0085*	*0.0095*	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*280*
P5	P	0,19	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	85
	P	*0.0075*	*0.0085*	*0.0095*	*0.01*	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*280*
P6	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	95
	P	*0.007*	*0.0085*	*0.0095*	*0.01*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*310*
P7	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	90
	P	*0.007*	*0.0085*	*0.0095*	*0.01*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*295*
P8	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	85
	P	*0.0075*	*0.0085*	*0.01*	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*280*
P11	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	85
	P	*0.007*	*0.0085*	*0.0095*	*0.01*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*280*
P12	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	50
	P	*0.005*	*0.006*	*0.0065*	*0.007*	*0.0075*	*0.008*	*0.008*	*0.0085*	*0.0085*	*165*
M1	M	0,14	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	80
	M	*0.0055*	*0.006*	*0.006*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*260*
M2	M	0,13	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	65
	M	*0.005*	*0.005*	*0.0055*	*0.0055*	*0.006*	*0.006*	*0.006*	*0.0065*	*0.0065*	*215*
M3	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	49
	M	*0.004*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.005*	*160*
M4	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	37
	M	*0.0036*	*0.0038*	*0.0038*	*0.004*	*0.004*	*0.004*	*0.0044*	*0.0044*	*0.0044*	*120*
M5	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	31
	M	*0.0036*	*0.0038*	*0.0038*	*0.004*	*0.004*	*0.004*	*0.0044*	*0.0044*	*0.0044*	*100*
K1	K	0,28	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	90
	K	*0.011*	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*0.017*	*0.017*	*0.017*	*295*
K2	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	80
	K	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*260*
K3	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	65
	K	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*215*
K4	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	65
	K	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*215*
K5	K	0,24	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	38
	K	*0.0095*	*0.01*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*0.014*	*125*
N1	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	315
	M	*0.007*	*0.0075*	*0.0075*	*0.008*	*0.008*	*0.008*	*0.0085*	*0.0085*	*0.0085*	*1025*
N2	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	200
	M	*0.007*	*0.0075*	*0.0075*	*0.008*	*0.008*	*0.008*	*0.0085*	*0.0085*	*0.0085*	*660*
N3	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	135
	M	*0.007*	*0.0075*	*0.0075*	*0.008*	*0.008*	*0.008*	*0.0085*	*0.0085*	*0.0085*	*445*
N11	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	160
	M	*0.007*	*0.0075*	*0.0075*	*0.008*	*0.008*	*0.008*	*0.0085*	*0.0085*	*0.0085*	*520*
S1	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	32
	M	*0.0036*	*0.0038*	*0.0038*	*0.004*	*0.004*	*0.004*	*0.0044*	*0.0044*	*0.0044*	*105*
S2	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	23
	M	*0.0036*	*0.0038*	*0.0038*	*0.004*	*0.004*	*0.004*	*0.0044*	*0.0044*	*0.0044*	*75*
S3	M	0,085	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	23
	M	*0.0034*	*0.0034*	*0.0036*	*0.0038*	*0.0038*	*0.0038*	*0.004*	*0.004*	*0.004*	*75*
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	60
	M	*0.004*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.005*	*195*
S12	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	46
	M	*0.004*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.005*	*150*
S13	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	36
	M	*0.0036*	*0.0038*	*0.0038*	*0.004*	*0.004*	*0.004*	*0.0044*	*0.0044*	*0.0044*	*120*
H3	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	25
	P	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.005*	*0.0055*	*0.0055*	*0.006*	*80*
H5	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	46
	P	*0.005*	*0.006*	*0.0065*	*0.007*	*0.0075*	*0.008*	*0.008*	*0.0085*	*0.0085*	*150*
H7	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	25
	P	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.005*	*0.0055*	*0.0055*	*0.006*	*80*
H8	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	46
	P	*0.0038*	*0.0044*	*0.0048*	*0.005*	*0.0055*	*0.006*	*0.0065*	*0.0065*	*0.0065*	*150*
H11	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	60
	P	*0.005*	*0.006*	*0.0065*	*0.007*	*0.0075*	*0.008*	*0.008*	*0.0085*	*0.0085*	*195*
H12	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	30
	P	*0.0038*	*0.0044*	*0.0048*	*0.005*	*0.0055*	*0.006*	*0.0065*	*0.0065*	*0.0065*	*100*
H21	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	46
	P	*0.0038*	*0.0044*	*0.0048*	*0.005*	*0.0055*	*0.006*	*0.0065*	*0.0065*	*0.0065*	*150*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD105 – ∅ 10-26 mm / *0.394-1.024 Zoll*

SMG		f									v_c
		Ø 10.00 *Ø 0.394*	Ø 12.00 *Ø 0.472*	Ø 14.00 *Ø 0.551*	Ø 16.00 *Ø 0.630*	Ø 18.00 *Ø 0.709*	Ø 20.00 *Ø 0.787*	Ø 22.00 *Ø 0.866*	Ø 24.00 *Ø 0.945*	Ø 26.00 *Ø 1.024*	
P1	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	110
	P	*0.0080*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*360*
P2	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	110
	P	*0.0080*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*360*
P3	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	95
	P	*0.0075*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*310*
P4	P	0,19	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	85
	P	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*280*
P5	P	0,19	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	80
	P	*0.0075*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*260*
P6	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	90
	P	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*295*
P7	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	85
	P	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*280*
P8	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	80
	P	*0.0075*	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*260*
P11	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	80
	P	*0.0070*	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*260*
P12	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	48
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*155*
M1	M	0,14	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	75
	M	*0.0055*	*0.0060*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*245*
M2	M	0,13	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	60
	M	*0.0050*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0060*	*0.0060*	*0.0065*	*0.0065*	*195*
M3	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	46
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*150*
M4	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	35
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*115*
M5	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	29
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*95*
K1	K	0,28	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	90
	K	*0.011*	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*0.017*	*0.017*	*0.017*	*295*
K2	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	75
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*245*
K3	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	65
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*215*
K4	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	60
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*195*
K5	K	0,24	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	36
	K	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*0.014*	*120*
N1	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	300
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*980*
N2	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	190
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*620*
N3	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	130
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*425*
N11	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	150
	M	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*490*
S1	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	30
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*100*
S2	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	22
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*70*
S3	M	0,085	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	22
	M	*0.0034*	*0.0034*	*0.0036*	*0.0038*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*70*
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	55
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*180*
S12	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	44
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*145*
S13	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	34
	M	*0.0036*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*110*
H3	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	24
	P	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*80*
H5	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	44
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*145*
H7	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	24
	P	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*80*
H8	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	44
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*145*
H11	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	55
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*180*
H12	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	29
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*95*
H21	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	44
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*145*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD107 – ∅ 10-26 mm / *0.394-1.024 Zoll*

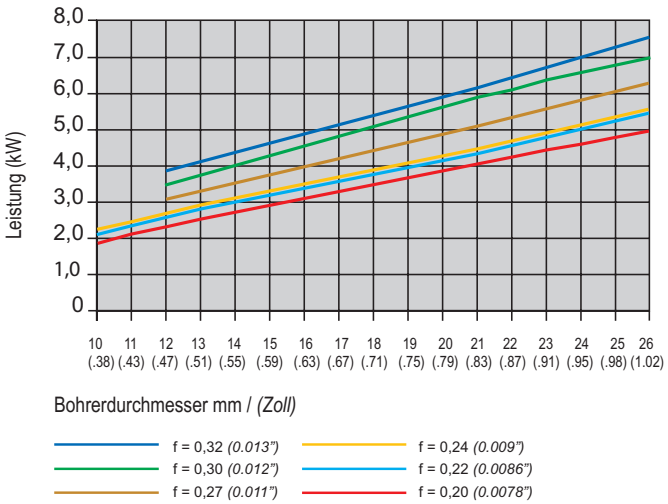
SMG		f								v_c
		Ø 12.00 *Ø 0.472*	Ø 14.00 *Ø 0.551*	Ø 16.00 *Ø 0.630*	Ø 18.00 *Ø 0.709*	Ø 20.00 *Ø 0.787*	Ø 22.00 *Ø 0.866*	Ø 24.00 *Ø 0.945*	Ø 26.00 *Ø 1.024*	
P1	P	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	110
	P	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*360*
P2	P	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	105
	P	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*345*
P3	P	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	90
	P	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*295*
P4	P	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	80
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*260*
P5	P	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	75
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*245*
P6	P	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	85
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*280*
P7	P	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	80
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*260*
P8	P	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	75
	P	*0.0085*	*0.010*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*245*
P11	P	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	80
	P	*0.0085*	*0.0095*	*0.010*	*0.011*	*0.011*	*0.012*	*0.013*	*0.013*	*260*
P12	P	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	47
	P	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*155*
M1	M	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	75
	M	*0.0060*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*0.0065*	*245*
M2	M	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	60
	M	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0060*	*0.0060*	*0.0065*	*0.0065*	*195*
M3	M	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	45
	M	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*150*
M4	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	34
	M	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*110*
M5	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	28
	M	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*90*
K1	K	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	85
	K	*0.013*	*0.013*	*0.014*	*0.015*	*0.016*	*0.017*	*0.017*	*0.017*	*280*
K2	K	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	75
	K	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*245*
K3	K	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	60
	K	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*195*
K4	K	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	60
	K	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*0.015*	*0.016*	*195*
K5	K	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	35
	K	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*0.014*	*115*
N1	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	290
	M	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*950*
N2	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	185
	M	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*610*
N3	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	125
	M	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*410*
N11	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	145
	M	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*0.0085*	*475*
S1	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	29
	M	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*95*
S2	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	21
	M	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*70*
S3	M	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	21
	M	*0.0034*	*0.0036*	*0.0038*	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*70*
S11	M	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	55
	M	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*180*
S12	M	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	42
	M	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*140*
S13	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	33
	M	*0.0038*	*0.0038*	*0.0040*	*0.0040*	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*110*
H3	P	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	23
	P	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*75*
H5	P	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	43
	P	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*140*
H7	P	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	23
	P	*0.0038*	*0.0044*	*0.0048*	*0.0048*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*75*
H8	P	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	43
	P	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*140*
H11	P	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	55
	P	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*0.0085*	*0.0085*	*180*
H12	P	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	28
	P	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*90*
H21	P	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	43
	P	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*140*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

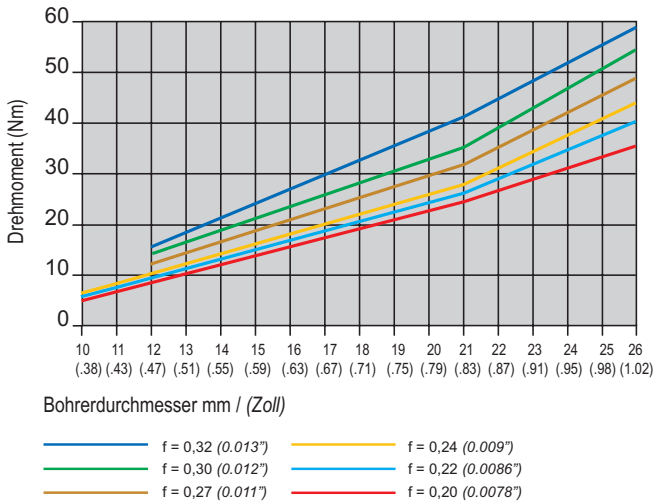
Bearbeitungsparameter

Die Grafiken zeigen Basiswerte, die, abhängig von Werkstoff und Schnittdaten sowie den individuellen Bearbeitungsbedingungen, angepasst werden müssen. Die Werte in den Tabellen sind gültig für die Seco Werkstoff-Gruppe (SMG) P5-P6 und Schnittgeschwindigkeiten von 90 m/min (*295 sf/min*).

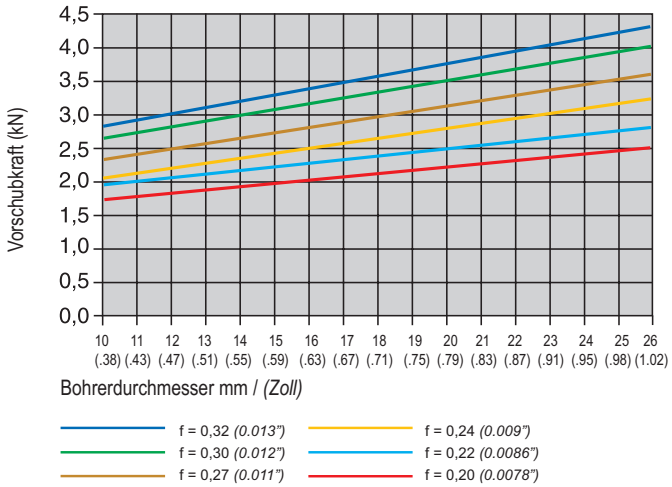
Leistungsbedarf



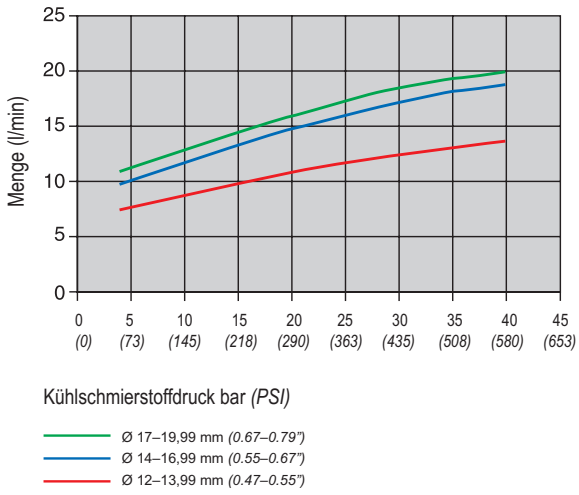
Drehmoment



Vorschubkraft



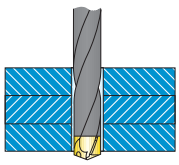
Kühlmittelmenge und Druck



Empfohlene Kühlmittelmenge: Dx1 l/min
Mindest-Kühlmittelmenge: D/2 l/min
D = Bohrerdurchmesser
Minimaler Kühlmitteldruck von 10 bar *(145 psi)* bei < 3 x D
Minimaler Kühlmitteldruck von 20 bar *(290 psi)* bei > 3 x D
Minimaler Kühlmitteldruck von 40 bar *(580 psi)* bei > 5 x D

Kühlschmierstoffmischung
Wir empfehlen für diese Bearbeitung allgemein eine Kühlschmierstoffkonzentration von 6 bis 8%.
Bei der Bearbeitung von hochlegierten und rostfreien Stählen empfehlen wir eine Konzentration von 10%.

Einsatzhinweise
Das Bohren von Plattenpaketen ist möglich, vorausgesetzt, es gibt keine Zwischenräume zwischen den Platten und die Aufspannung ist sehr stabil. Zwischenräume können die Spanabfuhr behindern und den Bohrer dabei beschädigen.



Bohrungstoleranz/Oberflächengüte

SD101, SD103, SD105 und SD107
IT9-10 / R_a 1-4*, *R_a 39-157 µin

Bohrerdurchmesser DC (mm)	IT9 Toleranz (µm)	IT10 Toleranz (µm)	Bohrdurchmesser DC *(Zoll)*	Toleranz IT9 *(Zoll)*	Toleranz IT10 *(Zoll)*
0 – +10-18	0 – +43	0 – +70	*0 – +0.394-0.709*	*0 – +0.0017*	*0 – +0.0028*
0 – +18-30	0 – +52	0 – +84	*0 – +0.709-1.181*	*0 – +0.0020*	*0 – +0.0033*

* Bei Stahl mit niedrigem Kohlenstoffanteil und Rostfrei können die Werte für die Oberflächengüte geringer ausfallen. Setzen Sie für die bestmögliche Bohrungsqualität immer den kürzest möglichen Bohrer ein.

Herausforderungen – Einsatzhinweise:

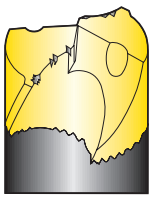
- Stabilität der Aufspannung
- Zustand der Maschinenspindel
- Zustand der Aufnahme

- Aufspannung:
  - Max. Rundlauffehler 0,06 TIR

- Spanabfuhr:
  - Schnittdaten

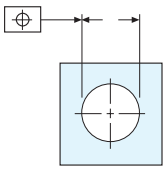
- Kühlung:
  - Druck
  - Durchfluss
  - Konzentration

Schneidenausbrüche



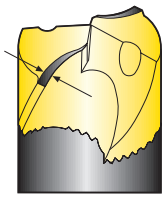
- Vorschub/U reduzieren
- Bei Vibrationen die Schnittgeschwindigkeit senken und den Vorschub erhöhen.
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30-50% senken.

Durchmesser außer Toleranz



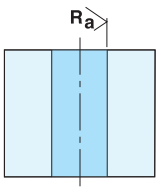
- Vorschub/U erhöhen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 19-22
- Reibbearbeitung einsetzen, siehe Seite(n) 328
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 479-480

Schneller Freiflächenverschleiß



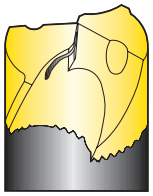
- Eingesetzte Geometrie prüfen
- Schnittgeschwindigkeit reduzieren

Geringe Oberflächengüte



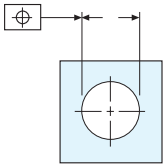
- Vorschub/U reduzieren
- Schnittgeschwindigkeit erhöhen
- Eingesetzte Geometrie prüfen
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 19-22.
- Reibbearbeitung einsetzen, siehe Seite(n) 328

Spanflächenverschleiß



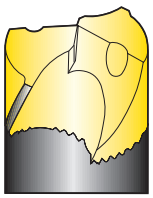
- Vorschub/U senken
- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen

Mittenversatz der Bohrung



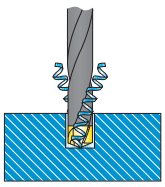
- Vorschub/U reduzieren
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30%-50% senken.
- Vorzentrieren mit einem Zentrierbohrer mit 140° Spitzenwinkel nutzen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 19-22
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 479-480

Verschleiß der Führungsfase



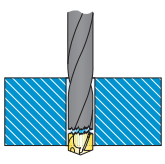
- Eingesetzte Geometrie prüfen
- Schnittgeschwindigkeit reduzieren
- Kühlmittelkonzentration erhöhen
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30-50% senken.

Spänestau durch lange Späne



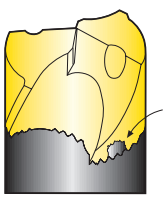
- Vorschub erhöhen
- Bei langspanenden Werkstoffen SMG P1-P4, SMG M1-M2:
  - Schnittgeschwindigkeit erhöhen und Vorschub reduzieren
  - L-Geometrie einsetzen (Sonderlösung)

Bruch bei Bohreraustritt



- Wenn die Verbindung Bohrerkörper/Krone bei Bohreraustritt bricht. Mögliche Ursachen:
  - Die Anlagefläche wurde nicht sorgfältig gereinigt, zwischen Bohrerkörper und Krone befinden sich Späne.
  - Die Krone wurde nicht fest genug gespannt. Drehmomentschlüssel verwenden.
  - Die Krone wurde nicht vollständig auf die Zugstange geschraubt

Ausbrüche an Kontaktflächen



- Minimale Ausbrüche sind harmlos für das Spannsystem. Das Bohrergebnis wird nicht beeinflusst.
- Falls größere Ausbrüche bei hohen Vorschüben oder beim Bohren durch winkelige Oberflächen auftreten, den Vorschub reduzieren.

Crownloc® Plus

Seco Crownloc® Plus ist die neue Generation an Bohrern mit Wechselkronen. Crownloc Plus ist mit einer neuen Schnittstelle ausgestattet und bietet verbesserte Spanabfuhr und Verschleißfestigkeit in einer Vielzahl an Werkstoffen.

- Starker Bohrerkörper, hochstarke Schnittstelle mit tiefen und breiten Spankammern und poliertem Körper.
- Als erste Wahl für allgemeine Anwendungen ist die P-Geometrie eine starke und vielseitige Lösung.
- Die M-Geometrie bietet exzellente Leistung in Superlegierungen, Titan, Titanlegierungen und Rostfrei.

Programmübersicht

Crownloc® Plus	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz (1)	Oberflächengüte (2)
SD403	Seite(n) 216-219	∅ 12,00-19,99 mm *(0.472-0.787")*	~ 3 x D	k7	IT 9-10	Ra 1-3 µm *(Ra 39-118 µin)*
SD405	Seite(n) 220-223	∅ 12,00-19,99 mm *(0.472-0.787")*	~ 5 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD408	Seite(n) 224-227	∅ 12,00-19,99 mm *(0.472-0.787")*	~ 8 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*

1) Je nach Material und verwendeten Schnittdaten können Abweichungen auftreten.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können zu einer verringerten Oberflächengüte führen.

Code-Schlüssel

Crownloc® Plus Bohrerkörper

Metrisch

SD403	14.00/14.99	45	16	R	7
1	2	3	4	5	6

Zoll

45	0750	R	7
3	4	5	6

1.
Bohrertyp
SD403: 3 x D
SD405: 5 x D
SD408: 8 x D

2.
Min./max.
Durchmesser Krone

3.
Bohrtiefe

4.
Schaftdurchmesser mm/Zoll

5.
Rechtsdrehend

6
Schaftart
1. Zylindrisch
7. ISO 9766

Code-Schlüssel Kronen

SD400	14.00	P
	2	3

2.
(Kronen)Bohrerdurchmesser in mm

3.
Geometrie
P = Stahl
M = Rostfrei

Geometrien

P-Geometrie
Universelle Geometrie, erste Wahl für Stahl

M-Geometrie
Erste Wahl für Rostfrei und Superlegierungen

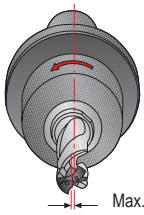
Montagehinweise

1. Stabilität

Stabilität ist entscheidend für Standzeit und Bohrungsqualität. Bitte vorher den Zustand von Maschinenspindel und Aufspannvorrichtung prüfen, um die bestmöglichen Bearbeitungsbedingungen zu garantieren.
Instabile Bedingungen können zu Werkzeugbruch führen.

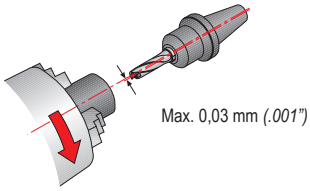
2. Rotierender Einsatz

Bei rotierendem Einsatz darf die maximale Rundlaufabweichung (TIR) nicht mehr als 0,06 mm *(0.002")* betragen, gemessen am eingespannten Bohrer.
Rundlauf des Bohrers im montierten Zustand messen.



3. Statischer Einsatz

Bei statischem Einsatz ist ein radialer Abstand zwischen Bohrerspitze und rotierender Werkstückmitte von 0,03 mm *(0.001")* einzuhalten.



4. Empfehlungen für Werkzeugaufnahmen

Seco Tools bietet ein umfassendes Produktprogramm an Aufnahmen (Spannzangen, Schrumpfaufnahmen, Weldon Hydrodehnspannfutter) für eine große Anzahl an Maschinenspindeln.
Für beste Ergebnisse verwenden Sie Aufnahmen ERHP 5672, Hochpräzisionsspannzangenfutter.
Weitere Informationen, siehe Katalog Werkzeug-Systeme.

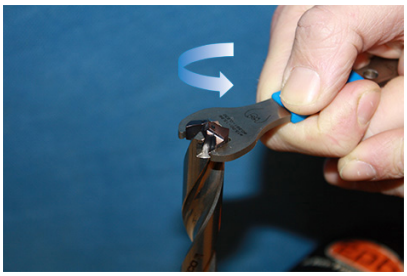
Hochpräzisionsspannzangenfutter
(Für zylindrische Aufnahmen, nur -R1 Schäfte verwenden)

Hydro-Dehnspannfutter
(Für zylindrische Aufnahmen, nur -R1 Schäfte verwenden)

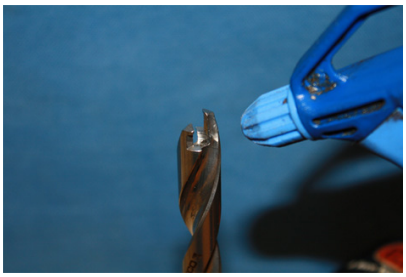
Weldon

1. Zum Entfernen der Krone, den Schlüssel an die zwei Anflächungen der Krone ansetzen.

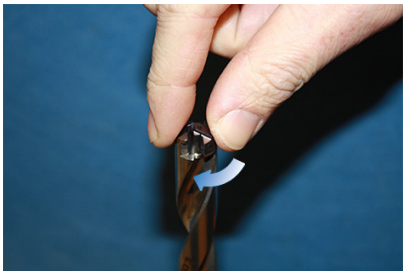
2. Krone mit dem Schlüssel gegen den Uhrzeigersinn um 1/4-Drehung lösen.



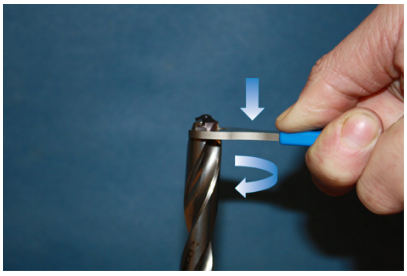
3. Vor Montage der neuen Krone die Kontaktflächen reinigen.



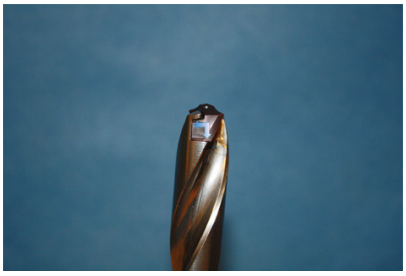
4. Achtung! Die Schneidkanten der Krone sind scharf. Die Krone von Hand einsetzen. Dann den Schlüssel verwenden.



5. Krone leicht herunterdrücken, dabei gleichzeitig mit dem Schlüssel um 1/4 Drehung im Uhrzeigersinn anziehen und dabei senkrecht zum Bohrerkörper halten.

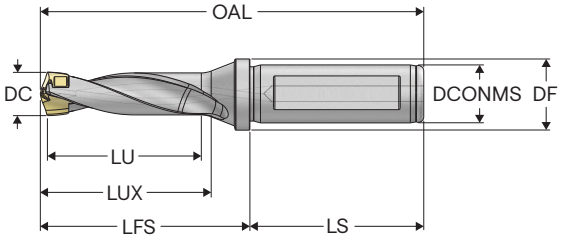


6. Bei Einsatz der Krone im Bohrerkörper muss voller Kontakt zwischen den Kontaktflächen des Bohrerkörpers und der Krone bestehen, siehe Abbildung.



SD403 – R7

Bohrtiefe ca. 3 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 232

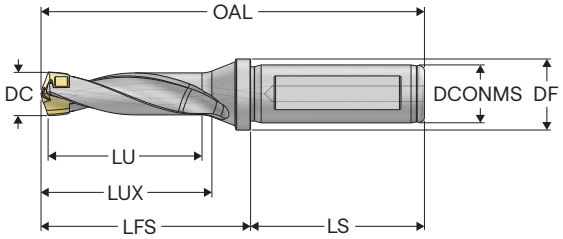
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD403-12.00/12.49-38-16R7	02622894	12,0-12,49	38,0	106,2	46,2	58,2	48,0	16,0	20,0
SD403-12.50/12.99-39-16R7	02622895	12,5-12,99	39,0	108,0	47,5	60,0	48,0	16,0	20,0
SD403-13.00/13.99-42-16R7	02622896	13,0-13,99	42,0	111,9	50,9	63,9	48,0	16,0	20,0
SD403-14.00/14.99-45-16R7	02622898	14,0-14,99	45,0	116,5	54,5	68,5	48,0	16,0	20,0
SD403-15.00/15.99-48-16R7	02622899	15,0-15,99	48,0	121,2	58,2	73,2	48,0	16,0	20,0
SD403-16.00/16.99-51-20R7	02622900	16,0-16,99	51,0	127,9	61,9	77,9	50,0	20,0	24,0
SD403-17.00/17.99-54-20R7	02622902	17,0-17,99	54,0	132,6	65,6	82,6	50,0	20,0	24,0
SD403-18.00/18.99-57-20R7	02622903	18,0-18,99	57,0	137,3	69,3	87,3	50,0	20,0	24,0
SD403-19.00/19.99-60-20R7	02622905	19,0-19,99	60,0	142,0	73,0	92,0	50,0	20,0	24,0

Zubehör

Bohrer-durchmesser (mm)	Schlüssel
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD403 – R7

Bohrtiefe ca. 3 x D – Zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 232

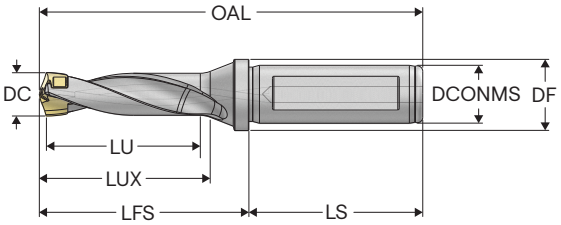
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD403-12.00/12.49-38-0625R7	02622942	0.472-0.492	1.496	4.181	1.819	2.291	1.890	0.625	0.787
SD403-12.50/12.99-39-0625R7	02622943	0.492-0.511	1.535	4.252	1.870	2.362	1.890	0.625	0.787
SD403-13.00/13.99-42-0625R7	02622944	0.512-0.551	1.654	4.406	2.004	2.516	1.890	0.625	0.787
SD403-14.00/14.99-45-0625R7	02622945	0.551-0.590	1.772	4.587	2.146	2.697	1.890	0.625	0.787
SD403-15.00/15.99-48-0625R7	02622946	0.591-0.630	1.890	4.772	2.291	2.882	1.890	0.625	0.787
SD403-16.00/16.99-51-0750R7	02622947	0.630-0.669	2.008	5.035	2.437	3.067	1.969	0.750	0.945
SD403-17.00/17.99-54-0750R7	02622948	0.669-0.708	2.126	5.220	2.583	3.252	1.969	0.750	0.945
SD403-18.00/18.99-57-0750R7	02622949	0.709-0.748	2.244	5.406	2.728	3.437	1.969	0.750	0.945
SD403-19.00/19.99-60-0750R7	02622950	0.748-0.787	2.362	5.591	2.874	3.622	1.969	0.750	0.945

Zubehör

Bohrerdurchmesser (Zoll)	Schlüssel
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

SD403 – R1

Bohrtiefe ca. 3 x D – Metrischer Schaft



–Kühlmittelzufuhr
–Zylinderschaft (R1) passend für Halter: HC,HCR und 5672
–Schnittdaten siehe Seite(n) 232

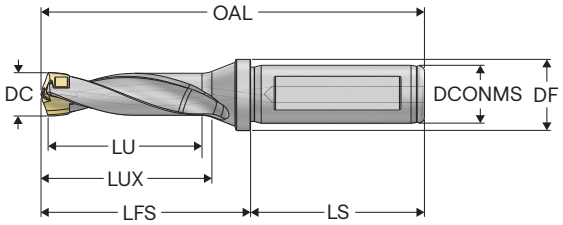
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD403-12.00/12.49-38-16R1	02622920	12,0-12,49	38,0	106,2	46,2	58,2	48,0	16,0	20,0
SD403-12.50/12.99-39-16R1	02622921	12,5-12,99	39,0	108,0	47,5	60,0	48,0	16,0	20,0
SD403-13.00/13.99-42-16R1	02622922	13,0-13,99	42,0	111,9	50,9	63,9	48,0	16,0	20,0
SD403-14.00/14.99-45-16R1	02622923	14,0-14,99	45,0	116,5	54,5	68,5	48,0	16,0	20,0
SD403-15.00/15.99-48-16R1	02622924	15,0-15,99	48,0	121,2	58,2	73,2	48,0	16,0	20,0
SD403-16.00/16.99-51-20R1	02622927	16,0-16,99	51,0	127,9	61,9	77,9	50,0	20,0	24,0
SD403-17.00/17.99-54-20R1	02622928	17,0-17,99	54,0	132,6	65,6	82,6	50,0	20,0	24,0
SD403-18.00/18.99-57-20R1	02622930	18,0-18,99	57,0	137,3	69,3	87,3	50,0	20,0	24,0
SD403-19.00/19.99-60-20R1	02622931	19,0-19,99	60,0	142,0	73,0	92,0	50,0	20,0	24,0

Zubehör

Bohrer-durchmesser (mm)	Schlüssel
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD403 – R1

Bohrtiefe ca. 3 x D – Zölliger Schaft



—Kühlmittelzufuhr
—Zylinderschaft (R1) passend für Halter: HC,HCR und 5672
—Schnittdaten siehe Seite(n) 232

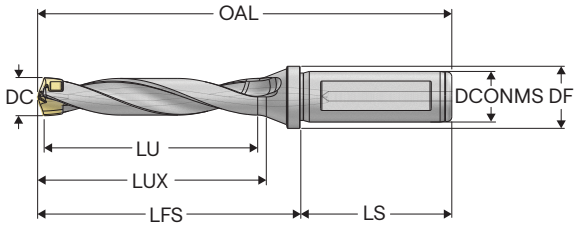
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD403-12.00/12.49-38-0625R1	02623538	0.472-0.492	1.496	4.181	1.819	2.291	1.890	0.625	0.787
SD403-12.50/12.99-39-0625R1	02623539	0.492-0.511	1.535	4.252	1.870	2.362	1.890	0.625	0.787
SD403-13.00/13.99-42-0625R1	02623540	0.512-0.551	1.654	4.406	2.004	2.516	1.890	0.625	0.787
SD403-14.00/14.99-45-0625R1	02623541	0.551-0.590	1.772	4.587	2.146	2.697	1.890	0.625	0.787
SD403-15.00/15.99-48-0625R1	02623542	0.591-0.630	1.890	4.772	2.291	2.882	1.890	0.625	0.787
SD403-16.00/16.99-51-0750R1	02623543	0.630-0.669	2.008	5.035	2.437	3.067	1.969	0.750	0.945
SD403-17.00/17.99-54-0750R1	02623544	0.669-0.708	2.126	5.220	2.583	3.252	1.969	0.750	0.945
SD403-18.00/18.99-57-0750R1	02623545	0.709-0.748	2.244	5.406	2.728	3.437	1.969	0.750	0.945
SD403-19.00/19.99-60-0750R1	02623546	0.748-0.787	2.362	5.591	2.874	3.622	1.969	0.750	0.945

Zubehör

Bohrerdurchmesser (Zoll)	Schlüssel
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

SD405 – R7

Bohrtiefe ca. 5 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 233

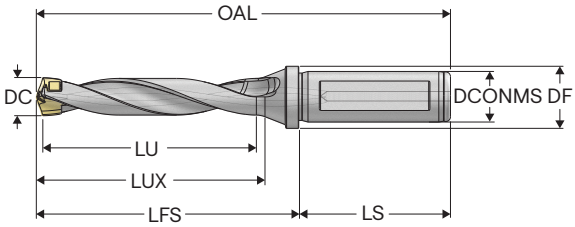
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD405-12.00/12.49-63-16R7	02623554	12,0-12,49	63,0	131,2	71,2	83,2	48,0	16,0	20,0
SD405-12.50/12.99-65-16R7	02623555	12,5-12,99	65,0	134,0	73,5	86,0	48,0	16,0	20,0
SD405-13.00/13.99-70-16R7	02623556	13,0-13,99	70,0	139,9	78,9	91,9	48,0	16,0	20,0
SD405-14.00/14.99-75-16R7	02623557	14,0-14,99	75,0	146,5	84,5	98,5	48,0	16,0	20,0
SD405-15.00/15.99-80-16R7	02623558	15,0-15,99	80,0	153,2	90,2	105,2	48,0	16,0	20,0
SD405-16.00/16.99-85-20R7	02623559	16,0-16,99	85,0	161,9	95,9	111,9	50,0	20,0	24,0
SD405-17.00/17.99-90-20R7	02623560	17,0-17,99	90,0	168,6	101,6	118,6	50,0	20,0	24,0
SD405-18.00/18.99-95-20R7	02623561	18,0-18,99	95,0	175,3	107,3	125,3	50,0	20,0	24,0
SD405-19.00/19.99-100-20R7	02623562	19,0-19,99	100,0	182,0	113,0	132,0	50,0	20,0	24,0

Zubehör

Bohrer-durchmesser (mm)	Schlüssel
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD405 – R7

Bohrtiefe ca. 5 x D – Zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 233

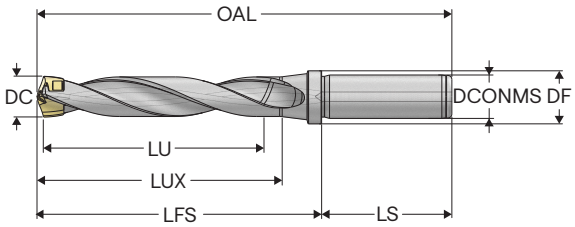
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD405-12.00/12.49-63-0625R7	02623586	0.472-0.492	2.480	5.165	2.803	3.276	1.890	0.625	0.787
SD405-12.50/12.99-65-0625R7	02623587	0.492-0.511	2.559	5.276	2.894	3.386	1.890	0.625	0.787
SD405-13.00/13.99-70-0625R7	02623588	0.512-0.551	2.756	5.508	3.106	3.618	1.890	0.625	0.787
SD405-14.00/14.99-75-0625R7	02623589	0.551-0.590	2.953	5.768	3.327	3.878	1.890	0.625	0.787
SD405-15.00/15.99-80-0625R7	02623590	0.591-0.630	3.150	6.031	3.551	4.142	1.890	0.625	0.787
SD405-16.00/16.99-85-0750R7	02623591	0.630-0.669	3.346	6.374	3.776	4.406	1.969	0.750	0.945
SD405-17.00/17.99-90-0750R7	02623592	0.669-0.708	3.543	6.638	4.000	4.669	1.969	0.750	0.945
SD405-18.00/18.99-95-0750R7	02623593	0.709-0.748	3.740	6.902	4.224	4.933	1.969	0.750	0.945
SD405-19.00/19.99-100-0750R7	02623594	0.748-0.787	3.937	7.165	4.449	5.197	1.969	0.750	0.945

Zubehör

Bohrerdurchmesser (Zoll)	Schlüssel
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

SD405 – R1

Bohrtiefe ca. 5 x D – Metrischer Schaft



—Kühlmittelzufuhr
—Zylinderschaft (R1) passend für Halter: HC,HCR und 5672
—Schnittdaten siehe Seite(n) 233

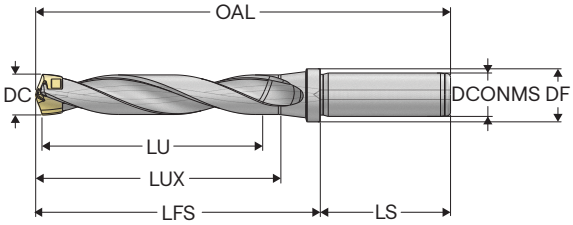
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD405-12.00/12.49-63-16R1	02623570	12,0-12,49	63,0	131,2	71,2	83,2	48,0	16,0	20,0
SD405-12.50/12.99-65-16R1	02623571	12,5-12,99	65,0	134,0	73,5	86,0	48,0	16,0	20,0
SD405-13.00/13.99-70-16R1	02623572	13,0-13,99	70,0	139,9	78,9	91,9	48,0	16,0	20,0
SD405-14.00/14.99-75-16R1	02623573	14,0-14,99	75,0	146,5	84,5	98,5	48,0	16,0	20,0
SD405-15.00/15.99-80-16R1	02623574	15,0-15,99	80,0	153,2	90,2	105,2	48,0	16,0	20,0
SD405-16.00/16.99-85-20R1	02623575	16,0-16,99	85,0	161,9	95,9	111,9	50,0	20,0	24,0
SD405-17.00/17.99-90-20R1	02623576	17,0-17,99	90,0	168,6	101,6	118,6	50,0	20,0	24,0
SD405-18.00/18.99-95-20R1	02623577	18,0-18,99	95,0	175,3	107,3	125,3	50,0	20,0	24,0
SD405-19.00/19.99-100-20R1	02623578	19,0-19,99	100,0	182,0	113,0	132,0	50,0	20,0	24,0

Zubehör

Bohrer-durchmesser (mm)	Schlüssel
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD405 – R1

Bohrtiefe ca. 5 x D – Zölliger Schaft



—Kühlmittelzufuhr
—Zylinderschaft (R1) passend für Halter: HC,HCR und 5672
—Schnittdaten siehe Seite(n) 233

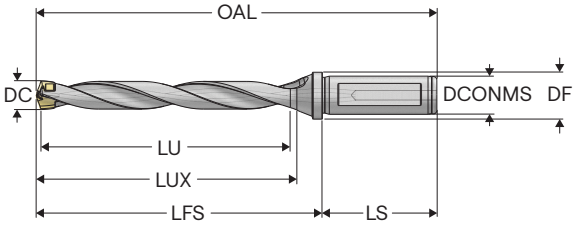
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD405-12.00/12.49-63-0625R1	02623603	0.472-0.492	2.480	5.165	2.803	3.276	1.890	0.625	0.787
SD405-12.50/12.99-65-0625R1	02623604	0.492-0.511	2.559	5.276	2.894	3.386	1.890	0.625	0.787
SD405-13.00/13.99-70-0625R1	02623605	0.512-0.551	2.756	5.508	3.106	3.618	1.890	0.625	0.787
SD405-14.00/14.99-75-0625R1	02623606	0.551-0.590	2.953	5.768	3.327	3.878	1.890	0.625	0.787
SD405-15.00/15.99-80-0625R1	02623607	0.591-0.630	3.150	6.031	3.551	4.142	1.890	0.625	0.787
SD405-16.00/16.99-85-0750R1	02623608	0.630-0.669	3.346	6.374	3.776	4.406	1.969	0.750	0.945
SD405-17.00/17.99-90-0750R1	02623609	0.669-0.708	3.543	6.638	4.000	4.669	1.969	0.750	0.945
SD405-18.00/18.99-95-0750R1	02623610	0.709-0.748	3.740	6.902	4.224	4.933	1.969	0.750	0.945
SD405-19.00/19.99-100-0750R1	02623611	0.748-0.787	3.937	7.165	4.449	5.197	1.969	0.750	0.945

Zubehör

Bohrerdurchmesser (Zoll)	Schlüssel
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

SD408 – R7

Bohrtiefe ca. 8 x D – Metrischer Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 234

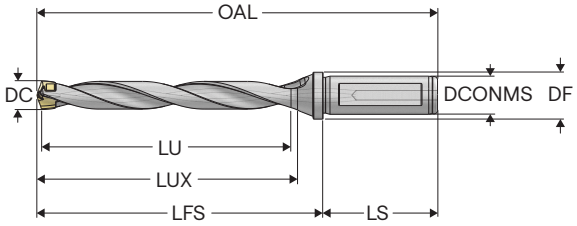
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD408-12.00/12.49-100-16R7	02623615	12,0-12,49	100,0	168,2	108,2	120,2	48,0	16,0	20,0
SD408-12.50/12.99-104-16R7	02623616	12,5-12,99	104,0	173,0	112,5	125,0	48,0	16,0	20,0
SD408-13.00/13.99-112-16R7	02623617	13,0-13,99	112,0	181,9	120,9	133,9	48,0	16,0	20,0
SD408-14.00/14.99-120-16R7	02623618	14,0-14,99	120,0	191,5	129,5	143,5	48,0	16,0	20,0
SD408-15.00/15.99-128-16R7	02623619	15,0-15,99	128,0	201,2	138,2	153,2	48,0	16,0	20,0
SD408-16.00/16.99-136-20R7	02623620	16,0-16,99	136,0	212,9	146,9	162,9	50,0	20,0	24,0
SD408-17.00/17.99-144-20R7	02623621	17,0-17,99	144,0	222,6	155,6	172,6	50,0	20,0	24,0
SD408-18.00/18.99-152-20R7	02623622	18,0-18,99	152,0	232,3	164,3	182,3	50,0	20,0	24,0
SD408-19.00/19.99-160-20R7	02623623	19,0-19,99	160,0	242,0	173,0	192,0	50,0	20,0	24,0

Zubehör

Bohrer-durchmesser (mm)	Schlüssel
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD408 – R7

Bohrtiefe ca. 8 x D – Zölliger Schaft



—Kühlmittelzufuhr
—ISO 9766 passt zu Halter: Weldon 1835B, ISO 5414, DIN 60880
—Schnittdaten siehe Seite(n) 234

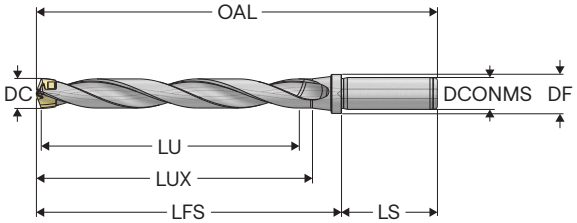
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD408-12.00/12.49-100-0625R7	02623639	0.472-0.492	3.937	6.622	4.260	4.732	1.890	0.625	0.787
SD408-12.50/12.99-104-0625R7	02623640	0.492-0.511	4.094	6.811	4.429	4.921	1.890	0.625	0.787
SD408-13.00/13.99-112-0625R7	02623641	0.512-0.551	4.409	7.161	4.760	5.272	1.890	0.625	0.787
SD408-14.00/14.99-120-0625R7	02623642	0.551-0.590	4.724	7.539	5.098	5.650	1.890	0.625	0.787
SD408-15.00/15.99-128-0625R7	02623643	0.591-0.630	5.039	7.921	5.441	6.031	1.890	0.625	0.787
SD408-16.00/16.99-136-0750R7	02623644	0.630-0.669	5.354	8.382	5.783	6.413	1.969	0.750	0.945
SD408-17.00/17.99-144-0750R7	02623645	0.669-0.708	5.669	8.764	6.126	6.795	1.969	0.750	0.945
SD408-18.00/18.99-152-0750R7	02623646	0.709-0.748	5.984	9.146	6.469	7.177	1.969	0.750	0.945
SD408-19.00/19.99-160-0750R7	02623647	0.748-0.787	6.299	9.528	6.811	7.559	1.969	0.750	0.945

Zubehör

Bohrerdurchmesser (Zoll)	Schlüssel
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

SD408 – R1

Bohrtiefe ca. 8 x D – Metrischer Schaft



—Kühlmittelzufuhr
—Zylinderschaft (R1) passend für Halter: HC,HCR und 5672
—Schnittdaten siehe Seite(n) 234

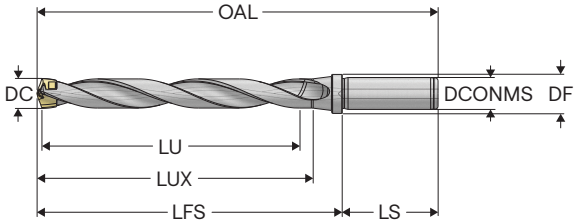
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD408-12.00/12.49-100-16R1	02623627	12,0-12,49	100,0	168,2	108,2	120,2	48,0	16,0	20,0
SD408-12.50/12.99-104-16R1	02623628	12,5-12,99	104,0	173,0	112,5	125,0	48,0	16,0	20,0
SD408-13.00/13.99-112-16R1	02623629	13,0-13,99	112,0	181,9	120,9	133,9	48,0	16,0	20,0
SD408-14.00/14.99-120-16R1	02623630	14,0-14,99	120,0	191,5	129,5	143,5	48,0	16,0	20,0
SD408-15.00/15.99-128-16R1	02623631	15,0-15,99	128,0	201,2	138,2	153,2	48,0	16,0	20,0
SD408-16.00/16.99-136-20R1	02623632	16,0-16,99	136,0	212,9	146,9	162,9	50,0	20,0	24,0
SD408-17.00/17.99-144-20R1	02623633	17,0-17,99	144,0	222,6	155,6	172,6	50,0	20,0	24,0
SD408-18.00/18.99-152-20R1	02623634	18,0-18,99	152,0	232,3	164,3	182,3	50,0	20,0	24,0
SD408-19.00/19.99-160-20R1	02623635	19,0-19,99	160,0	242,0	173,0	192,0	50,0	20,0	24,0

Zubehör

Bohrer-durchmesser (mm)	Schlüssel
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD408 – R1

Bohrtiefe ca. 8 x D – Zölliger Schaft



—Kühlmittelzufuhr
—Zylinderschaft (R1) passend für Halter: HC,HCR und 5672
—Schnittdaten siehe Seite(n) 234

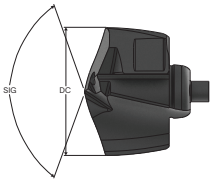
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD408-12.00/12.49-100-0625R1	02623651	0.472-0.492	3.937	6.622	4.260	4.732	1.890	0.625	0.787
SD408-12.50/12.99-104-0625R1	02623652	0.492-0.511	4.094	6.811	4.429	4.921	1.890	0.625	0.787
SD408-13.00/13.99-112-0625R1	02623653	0.512-0.551	4.409	7.161	4.760	5.272	1.890	0.625	0.787
SD408-14.00/14.99-120-0625R1	02623654	0.551-0.590	4.724	7.539	5.098	5.650	1.890	0.625	0.787
SD408-15.00/15.99-128-0625R1	02623655	0.591-0.630	5.039	7.921	5.441	6.031	1.890	0.625	0.787
SD408-16.00/16.99-136-0750R1	02623656	0.630-0.669	5.354	8.382	5.783	6.413	1.969	0.750	0.945
SD408-17.00/17.99-144-0750R1	02623657	0.669-0.708	5.669	8.764	6.126	6.795	1.969	0.750	0.945
SD408-18.00/18.99-152-0750R1	02623658	0.709-0.748	5.984	9.146	6.469	7.177	1.969	0.750	0.945
SD408-19.00/19.99-160-0750R1	02623659	0.748-0.787	6.299	9.528	6.811	7.559	1.969	0.750	0.945

Zubehör

Bohrerdurchmesser (Zoll)	Schlüssel
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

Kronen – Geometrie -P und -M

Spitzenwinkel: 140°



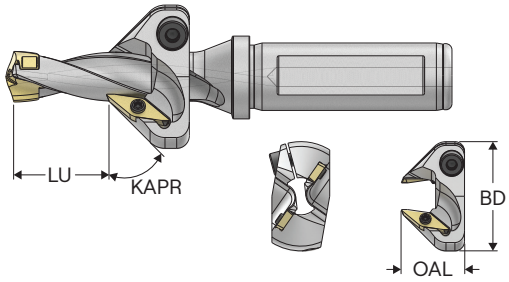
Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD400-12.00-M	02826210	–	■	12,0	*0.472*
SD400-12.00-P	02630908	■	–	12,0	*0.472*
SD400-12.10-P	02630910	■	–	12,1	*0.476*
SD400-12.20-P	02630911	■	–	12,2	*0.480*
SD400-12.30-M	02826211	–	■	12,3	*0.484*
SD400-12.30-P	02630912	■	–	12,3	*0.484*
SD400-12.41-P	02630913	■	–	12,41	*0.489*
SD400-12.50-M	02826213	–	■	12,5	*0.492*
SD400-12.50-P	02630915	■	–	12,5	*0.492*
SD400-12.60-P	02630916	■	–	12,6	*0.496*
SD400-12.70-M	02826214	–	■	12,7	*0.500*
SD400-12.70-P	02630917	■	–	12,7	*0.500*
SD400-12.80-M	02826215	–	■	12,8	*0.504*
SD400-12.80-P	02630918	■	–	12,8	*0.504*
SD400-12.90-P	02630919	■	–	12,9	*0.508*
SD400-13.00-M	02826217	–	■	13,0	*0.512*
SD400-13.00-P	02634577	■	–	13,0	*0.512*
SD400-13.10-M	02826218	–	■	13,1	*0.516*
SD400-13.10-P	02634578	■	–	13,1	*0.516*
SD400-13.20-P	02634579	■	–	13,2	*0.520*
SD400-13.30-M	02826219	–	■	13,3	*0.524*
SD400-13.30-P	02634580	■	–	13,3	*0.524*
SD400-13.50-M	02826220	–	■	13,5	*0.531*
SD400-13.50-P	02634581	■	–	13,5	*0.531*
SD400-13.70-P	02634582	■	–	13,7	*0.539*
SD400-13.80-M	02826222	–	■	13,8	*0.543*
SD400-13.80-P	02634583	■	–	13,8	*0.543*
SD400-13.89-M	02826223	–	■	13,89	*0.547*
SD400-13.89-P	02634584	■	–	13,89	*0.547*
SD400-14.00-M	02826224	–	■	14,0	*0.551*
SD400-14.00-P	02634589	■	–	14,0	*0.551*
SD400-14.10-P	02634590	■	–	14,1	*0.555*
SD400-14.20-M	02826225	–	■	14,2	*0.559*
SD400-14.20-P	02634591	■	–	14,2	*0.559*
SD400-14.288-M	02826226	–	■	14,29	*0.563*
SD400-14.288-P	02634592	■	–	14,288	*0.563*
SD400-14.40-P	02634593	■	–	14,4	*0.567*
SD400-14.50-M	02826227	–	■	14,5	*0.571*
SD400-14.50-P	02634594	■	–	14,5	*0.571*
SD400-14.70-M	02826229	–	■	14,7	*0.579*
SD400-14.80-M	02826230	–	■	14,8	*0.583*
SD400-14.80-P	02634597	■	–	14,8	*0.583*
SD400-14.90-P	02634598	■	–	14,9	*0.587*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD400-15.00-M	02826232	–	■	15,0	*0.591*
SD400-15.00-P	02634599	■	–	15,0	*0.591*
SD400-15.08-M	02826233	–	■	15,08	*0.594*
SD400-15.08-P	02634600	■	–	15,08	*0.594*
SD400-15.10-P	02634601	■	–	15,1	*0.594*
SD400-15.20-P	02634602	■	–	15,2	*0.598*
SD400-15.25-M	02826234	–	■	15,25	*0.600*
SD400-15.25-P	02634603	■	–	15,25	*0.600*
SD400-15.478-M	02826235	–	■	15,48	*0.609*
SD400-15.478-P	02634604	■	–	15,478	*0.609*
SD400-15.50-M	02826236	–	■	15,5	*0.610*
SD400-15.50-P	02634605	■	–	15,5	*0.610*
SD400-15.70-M	02826237	–	■	15,7	*0.618*
SD400-15.70-P	02634607	■	–	15,7	*0.618*
SD400-15.80-P	02634608	■	–	15,8	*0.622*
SD400-15.875-M	02826239	–	■	15,88	*0.625*
SD400-15.875-P	02634609	■	–	15,875	*0.625*
SD400-16.00-M	02826240	–	■	16,0	*0.630*
SD400-16.00-P	02635956	■	–	16,0	*0.630*
SD400-16.10-P	02635957	■	–	16,1	*0.634*
SD400-16.20-P	02635958	■	–	16,2	*0.638*
SD400-16.25-P	02635959	■	–	16,25	*0.640*
SD400-16.27-M	02826241	–	■	16,27	*0.641*
SD400-16.50-M	02826242	–	■	16,5	*0.650*
SD400-16.50-P	02635963	■	–	16,5	*0.650*
SD400-16.669-M	02826243	–	■	16,67	*0.656*
SD400-16.669-P	02635964	■	–	16,669	*0.656*
SD400-16.70-M	02826244	–	■	16,7	*0.657*
SD400-16.70-P	02635966	■	–	16,7	*0.657*
SD400-16.80-P	02635968	■	–	16,8	*0.661*
SD400-16.90-P	02635969	■	–	16,9	*0.665*
SD400-17.00-M	02826246	–	■	17,0	*0.669*
SD400-17.00-P	02635970	■	–	17,0	*0.669*
SD400-17.065-M	02826247	–	■	17,07	*0.672*
SD400-17.10-P	02635973	■	–	17,1	*0.673*
SD400-17.20-P	02635974	■	–	17,2	*0.677*
SD400-17.35-P	02888828	■	–	17,35	*0.683*
SD400-17.463-M	02826248	–	■	17,46	*0.687*
SD400-17.463-P	02635975	■	–	17,463	*0.688*
SD400-17.50-M	02826249	–	■	17,5	*0.689*
SD400-17.50-P	02635976	■	–	17,5	*0.689*
SD400-17.70-M	02826250	–	■	17,7	*0.697*
SD400-17.70-P	02635977	■	–	17,7	*0.697*
SD400-17.80-M	02826251	–	■	17,8	*0.701*
SD400-17.90-M	02826253	–	■	17,9	*0.705*
SD400-17.90-P	02635980	■	–	17,9	*0.705*
SD400-18.00-M	02826254	–	■	18,0	*0.709*
SD400-18.00-P	02635981	■	–	18,0	*0.709*
SD400-18.10-P	02635982	■	–	18,1	*0.713*
SD400-18.20-P	02635983	■	–	18,2	*0.717*
SD400-18.256-M	02826255	–	■	18,26	*0.719*
SD400-18.50-M	02826256	–	■	18,5	*0.728*
SD400-18.50-P	02635985	■	–	18,5	*0.728*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
SD400-18.70-P	02635987	■	–	18,7	*0.736*
SD400-18.80-P	02635988	■	–	18,8	*0.740*
SD400-18.90-M	02826260	–	■	18,9	*0.744*
SD400-19.00-M	02826261	–	■	19,0	*0.748*
SD400-19.00-P	02635991	■	–	19,0	*0.748*
SD400-19.05-M	02826262	–	■	19,05	*0.750*
SD400-19.05-P	02635992	■	–	19,05	*0.750*
SD400-19.10-P	02635993	■	–	19,1	*0.752*
SD400-19.20-M	02826263	–	■	19,2	*0.756*
SD400-19.20-P	02635995	■	–	19,2	*0.756*
SD400-19.447-P	02635997	■	–	19,447	*0.766*
SD400-19.50-M	02826265	–	■	19,5	*0.768*
SD400-19.50-P	02635998	■	–	19,5	*0.768*
SD400-19.70-P	02635999	■	–	19,7	*0.776*
SD400-19.80-M	02826267	–	■	19,8	*0.780*
SD400-19.80-P	02636000	■	–	19,8	*0.780*
SD400-19.844-M	02826268	–	■	19,84	*0.781*
SD400-19.844-P	02636001	■	–	19,844	*0.781*
SD400-19.90-M	02826269	–	■	19,9	*0.783*
SD400-19.90-P	02636002	■	–	19,9	*0.783*

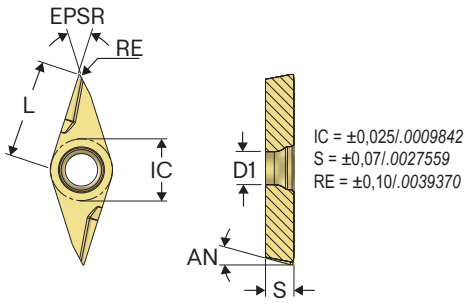
■ Lagerstandard.

Fasringe



Bezeichnung	Produkt-nummer	Für Bohrer	Bohrtiefe LU SD403 (min-max)		SD405 (min-max)		SD408 (min-max)		Max. Fastiefe (mm)	OAL	BD	KAPR°
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	
SD400-C45-12.00/12.49	02846075	SD40x-12.00/12.49	6,0 *0.236*	22,0 *0.866*	6,0 *0.236*	47,0 *1.850*	47,0 *1.850*	84,0 *3.307*	1,5 *0.059*	20,0 *0.787*	34,0 *1.339*	45
SD400-C45-12.50/12.99	02846076	SD40x-12.50/12.99	7,0 *0.276*	23,0 *0.906*	7,0 *0.276*	48,0 *1.890*	48,0 *1.890*	88,0 *3.465*	1,5 *0.059*	20,0 *0.787*	34,0 *1.339*	45
SD400-C45-13.00/13.99	02846077	SD40x-13.00/13.99	7,0 *0.276*	27,0 *1.063*	7,0 *0.276*	55,0 *2.165*	55,0 *2.165*	97,0 *3.819*	1,5 *0.059*	20,0 *0.787*	34,0 *1.339*	45
SD400-C45-14.00/14.99	02846078	SD40x-14.00/14.99	7,0 *0.276*	33,0 *1.299*	7,0 *0.276*	60,0 *2.362*	60,0 *2.362*	105,0 *4.134*	1,5 *0.059*	20,0 *0.787*	36,0 *1.417*	45
SD400-C45-15.00/15.99	02846079	SD40x-15.00/15.99	8,0 *0.315*	35,0 *1.378*	8,0 *0.315*	67,0 *2.638*	67,0 *2.638*	114,0 *4.488*	1,5 *0.059*	20,0 *0.787*	36,0 *1.417*	45
SD400-C45-16.00/16.99	02846080	SD40x-16.00/16.99	8,0 *0.315*	38,0 *1.496*	8,0 *0.315*	72,0 *2.835*	72,0 *2.835*	123,0 *4.843*	1,5 *0.059*	20,0 *0.787*	38,0 *1.496*	45
SD400-C45-17.00/17.99	02846117	SD40x-17.00/17.99	9,0 *0.354*	43,0 *1.693*	9,0 *0.354*	79,0 *3.110*	79,0 *3.110*	132,0 *5.197*	1,5 *0.059*	20,0 *0.787*	38,0 *1.496*	45
SD400-C45-18.00/18.99	02846082	SD40x-18.00/18.99	9,0 *0.354*	45,0 *1.772*	9,0 *0.354*	83,0 *3.268*	83,0 *3.268*	140,0 *5.512*	1,5 *0.059*	20,0 *0.787*	40,0 *1.575*	45
SD400-C45-19.00/19.99	02846083	SD40x-19.00/19.99	10,0 *0.394*	49,0 *1.929*	10,0 *0.394*	89,0 *3.504*	89,0 *3.504*	149,0 *5.866*	1,5 *0.059*	20,0 *0.787*	40,0 *1.575*	45

Wendeschneidplatte



IC = ±0,025/*.0009842*
S = ±0,07/*.0027559*
RE = ±0,10/*.0039370*

Toleranzen: mm/*Zoll*	Größe	L mm/*Zoll*	EPSR	RE mm/*Zoll*	IC mm/*Zoll*	D1 mm/*Zoll*	AN	S mm/*Zoll*
	09	**9,0**/*.2187*	**35°**	**0,2**/*.0078*	**5,556**/*.2187*	**2,9**/*.1141*	**7°**	**2,5**/*.0984*
	Sorte: T400D							
	Bezeichnung: VCGX090202-D1							
	Produktnummer: 00014948							

SD403 – ∅ 12-20 mm / *0.472-0.787 Zoll*

SMG		f					v_c
		Ø12,00 *Ø 0.472*	Ø14,00 *Ø 0.551*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *Ø 0.787*	
P1	P	0,30	0,32	0,34	0,36	0,36	155
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*510*
P2	P	0,30	0,32	0,34	0,36	0,38	150
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*490*
P3	P	0,28	0,30	0,32	0,34	0,36	130
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*425*
P4	P	0,28	0,30	0,32	0,34	0,34	115
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*375*
P5	P	0,28	0,30	0,32	0,32	0,34	110
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*360*
P6	P	0,28	0,30	0,30	0,32	0,34	120
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*395*
P7	P	0,28	0,30	0,30	0,32	0,34	115
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*375*
P8	P	0,28	0,30	0,32	0,34	0,36	110
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*360*
P11	P	0,28	0,30	0,30	0,32	0,34	110
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*360*
P12	P	0,19	0,20	0,22	0,22	0,24	65
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*215*
M1	M	0,17	0,19	0,20	0,22	0,22	95
	M	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*310*
M2	M	0,16	0,17	0,18	0,19	0,20	80
	M	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*260*
M3	M	0,13	0,14	0,14	0,15	0,16	60
	M	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0065*	*195*
M4	M	0,11	0,12	0,13	0,13	0,14	45
	M	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*0.0055*	*150*
M5	M	0,11	0,12	0,13	0,13	0,14	37
	M	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*0.0055*	*120*
K1	P	0,28	0,30	0,32	0,34	0,36	110
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*360*
K2	P	0,26	0,28	0,30	0,32	0,32	95
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*310*
K3	P	0,26	0,28	0,30	0,32	0,32	80
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*260*
K4	P	0,26	0,28	0,30	0,32	0,32	75
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*245*
K5	P	0,24	0,25	0,26	0,28	0,30	45
	P	*0.0095*	*0.010*	*0.010*	*0.011*	*0.012*	*150*
N2	M	0,26	0,28	0,30	0,32	0,34	215
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*710*
N3	M	0,26	0,28	0,30	0,32	0,34	145
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*475*
N11	M	0,26	0,28	0,30	0,32	0,34	170
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*560*
S1	M	0,095	0,11	0,12	0,13	0,13	34
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*110*
S2	M	0,095	0,11	0,12	0,13	0,13	24
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*80*
S3	M	0,095	0,11	0,12	0,13	0,13	24
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*80*
S11	M	0,16	0,17	0,19	0,20	0,22	65
	M	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*215*
S12	M	0,16	0,17	0,19	0,20	0,22	49
	M	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*160*
S13	M	0,14	0,15	0,17	0,18	0,19	38
	M	*0.0055*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*125*
H3	P	0,12	0,13	0,14	0,15	0,15	32
	P	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0060*	*105*
H5	P	0,19	0,20	0,22	0,22	0,24	60
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*195*
H7	P	0,12	0,13	0,14	0,15	0,15	32
	P	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0060*	*105*
H8	P	0,14	0,15	0,16	0,17	0,18	60
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*195*
H11	P	0,19	0,20	0,22	0,22	0,24	75
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*245*
H12	P	0,14	0,15	0,16	0,17	0,18	39
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*130*
H21	P	0,14	0,15	0,16	0,17	0,18	60
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*195*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD405 – ∅ 12-20 mm / *0.472-0.787 Zoll*

SMG		f					v_c
		Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	P	0,30	0,32	0,34	0,36	0,36	125
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*410*
P2	P	0,30	0,32	0,34	0,36	0,38	120
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*395*
P3	P	0,28	0,30	0,32	0,34	0,36	105
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*345*
P4	P	0,28	0,30	0,32	0,34	0,34	95
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*310*
P5	P	0,28	0,30	0,32	0,32	0,34	90
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*295*
P6	P	0,28	0,30	0,30	0,32	0,34	100
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*330*
P7	P	0,28	0,30	0,30	0,32	0,34	95
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*310*
P8	P	0,28	0,30	0,32	0,34	0,36	90
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*295*
P11	P	0,28	0,30	0,30	0,32	0,34	90
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*295*
P12	P	0,19	0,20	0,22	0,22	0,24	55
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*180*
M1	M	0,17	0,19	0,20	0,22	0,22	80
	M	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*260*
M2	M	0,16	0,17	0,18	0,19	0,20	65
	M	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*215*
M3	M	0,13	0,14	0,14	0,15	0,16	49
	M	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0065*	*160*
M4	M	0,11	0,12	0,13	0,13	0,14	37
	M	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*0.0055*	*120*
M5	M	0,11	0,12	0,13	0,13	0,14	31
	M	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*0.0055*	*100*
K1	P	0,28	0,30	0,32	0,34	0,36	90
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*295*
K2	P	0,26	0,28	0,30	0,32	0,32	75
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*245*
K3	P	0,26	0,28	0,30	0,32	0,32	65
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*215*
K4	P	0,26	0,28	0,30	0,32	0,32	60
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*195*
K5	P	0,24	0,25	0,26	0,28	0,30	37
	P	*0.0095*	*0.010*	*0.010*	*0.011*	*0.012*	*120*
N2	M	0,26	0,28	0,30	0,32	0,34	175
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*570*
N3	M	0,26	0,28	0,30	0,32	0,34	120
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*395*
N11	M	0,26	0,28	0,30	0,32	0,34	140
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*460*
S1	M	0,095	0,11	0,12	0,13	0,13	28
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*90*
S2	M	0,095	0,11	0,12	0,13	0,13	20
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*65*
S3	M	0,095	0,11	0,12	0,13	0,13	20
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*65*
S11	M	0,16	0,17	0,19	0,20	0,22	50
	M	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*165*
S12	M	0,16	0,17	0,19	0,20	0,22	40
	M	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*130*
S13	M	0,14	0,15	0,17	0,18	0,19	31
	M	*0.0055*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*100*
H3	P	0,12	0,13	0,14	0,15	0,15	26
	P	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0060*	*85*
H5	P	0,19	0,20	0,22	0,22	0,24	49
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*160*
H7	P	0,12	0,13	0,14	0,15	0,15	26
	P	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0060*	*85*
H8	P	0,14	0,15	0,16	0,17	0,18	49
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*160*
H11	P	0,19	0,20	0,22	0,22	0,24	60
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*195*
H12	P	0,14	0,15	0,16	0,17	0,18	32
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*105*
H21	P	0,14	0,15	0,16	0,17	0,18	49
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*160*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD408 – ∅ 12-20 mm / *0.472-0.787 Zoll*

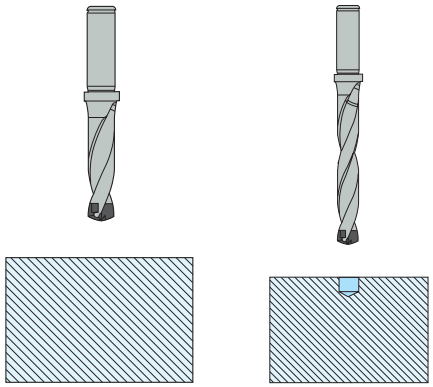
SMG		f					v_c
		Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	P	0,30	0,32	0,34	0,36	0,36	100
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*330*
P2	P	0,30	0,32	0,34	0,36	0,38	100
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*330*
P3	P	0,28	0,30	0,32	0,34	0,36	85
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*280*
P4	P	0,28	0,30	0,32	0,34	0,34	75
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*245*
P5	P	0,28	0,30	0,32	0,32	0,34	70
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*230*
P6	P	0,28	0,30	0,30	0,32	0,34	80
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*260*
P7	P	0,28	0,30	0,30	0,32	0,34	75
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*245*
P8	P	0,28	0,30	0,32	0,34	0,36	70
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*230*
P11	P	0,28	0,30	0,30	0,32	0,34	75
	P	*0.011*	*0.012*	*0.012*	*0.013*	*0.013*	*245*
P12	P	0,19	0,20	0,22	0,22	0,24	43
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*140*
M1	M	0,17	0,19	0,20	0,22	0,22	65
	M	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*215*
M2	M	0,16	0,17	0,18	0,19	0,20	50
	M	*0.0065*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*165*
M3	M	0,13	0,14	0,14	0,15	0,16	39
	M	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0065*	*130*
M4	M	0,11	0,12	0,13	0,13	0,14	29
	M	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*0.0055*	*95*
M5	M	0,11	0,12	0,13	0,13	0,14	24
	M	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*0.0055*	*80*
K1	P	0,28	0,30	0,32	0,34	0,36	70
	P	*0.011*	*0.012*	*0.013*	*0.013*	*0.014*	*230*
K2	P	0,26	0,28	0,30	0,32	0,32	60
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*195*
K3	P	0,26	0,28	0,30	0,32	0,32	50
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*165*
K4	P	0,26	0,28	0,30	0,32	0,32	49
	P	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*160*
K5	P	0,24	0,25	0,26	0,28	0,30	29
	P	*0.0095*	*0.010*	*0.010*	*0.011*	*0.012*	*95*
N2	M	0,26	0,28	0,30	0,32	0,34	140
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*460*
N3	M	0,26	0,28	0,30	0,32	0,34	95
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*310*
N11	M	0,26	0,28	0,30	0,32	0,34	110
	M	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*360*
S1	M	0,095	0,11	0,12	0,13	0,13	22
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*70*
S2	M	0,095	0,11	0,12	0,13	0,13	16
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*50*
S3	M	0,095	0,11	0,12	0,13	0,13	16
	M	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0050*	*50*
S11	M	0,16	0,17	0,19	0,20	0,22	42
	M	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*140*
S12	M	0,16	0,17	0,19	0,20	0,22	32
	M	*0.0065*	*0.0065*	*0.0075*	*0.0080*	*0.0085*	*105*
S13	M	0,14	0,15	0,17	0,18	0,19	25
	M	*0.0055*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*80*
H3	P	0,12	0,13	0,14	0,15	0,15	21
	P	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0060*	*70*
H5	P	0,19	0,20	0,22	0,22	0,24	39
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*130*
H7	P	0,12	0,13	0,14	0,15	0,15	21
	P	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*0.0060*	*70*
H8	P	0,14	0,15	0,16	0,17	0,18	39
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*130*
H11	P	0,19	0,20	0,22	0,22	0,24	49
	P	*0.0075*	*0.0080*	*0.0085*	*0.0085*	*0.0095*	*160*
H12	P	0,14	0,15	0,16	0,17	0,18	26
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*85*
H21	P	0,14	0,15	0,16	0,17	0,18	39
	P	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0070*	*130*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

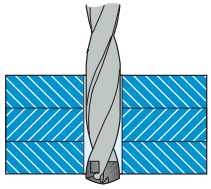
Anwendungsinformationen

Anwendungsinformationen

Bearbeitete Oberfläche
Bei Einsatz des SD403 und SD405 ist keine Zentrierbohrung oder Senkung des Vorschubs im Eintritt erforderlich. Bei Einsatz des SD408 wird stets eine Vorbohrung empfohlen. (Bei Einsatz eines SD405 in Rostfrei ist unter Umständen eine Zentrierbohrung erforderlich.)



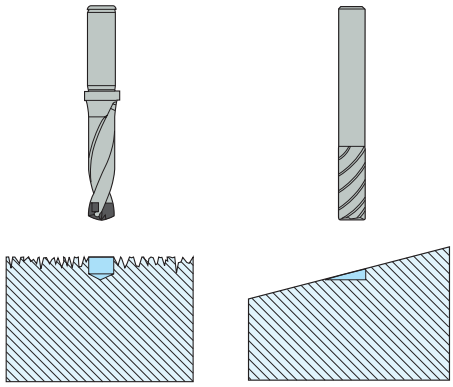
Plattenpakete
Das Bohren von Plattenpaketen ist möglich, vorausgesetzt, es gibt keine Zwischenräume zwischen den Platten und die Aufspannung ist sehr stabil. Zwischenräume können die Spanabfuhr behindern und den Bohrer dabei beschädigen.



Ungleichmäßige/winkelige Eintrittsflächen

Bei ungleichmäßigen oder winkeligen Eintrittsflächen wählen Sie die entsprechende Vorbearbeitung. Beim Einsatz von Bohrern > 3 x D wird eine Vorbearbeitung mit einem Standardwerkzeug, z. B. SD403, empfohlen.

Alternative Vorbearbeitungen



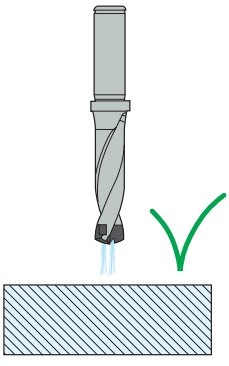
Ungleichmäßige Eintrittsfläche

Ungleichmäßige Eintrittsfläche

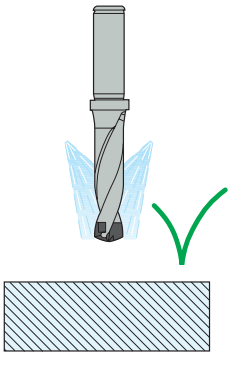
Fräsen einer ebenen Fläche mit einem Seco Vollhartmetallfräser.

Kühlmittelempfehlungen

Kühlmitteldruck
Minimaler Kühlmitteldruck von 10 bar (145 psi) bei ≤ 3 x D
Minimaler Kühlmitteldruck von 30 bar (435 psi) bei > 3 x D

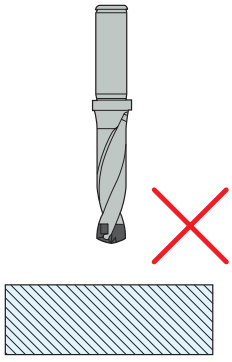


Erste Wahl



< 3 x D

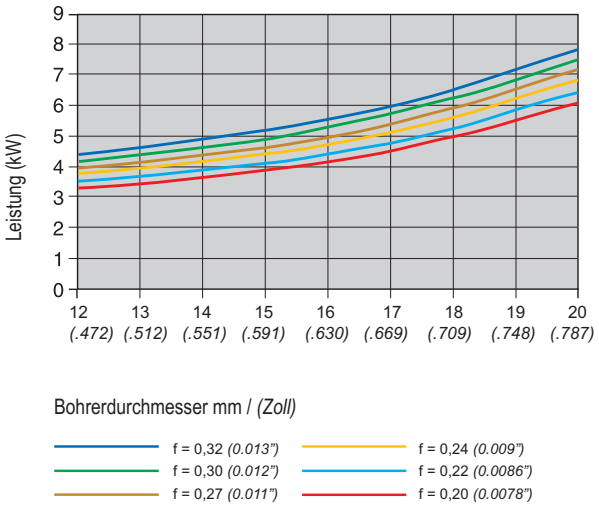
Kühlmittelmischung
Wir empfehlen für diese Bearbeitung allgemein eine Kühlmittelkonzentration von 6 bis 8 %. Bei hochlegierten und rostfreien Stählen empfehlen wir eine Kühlschmierstoffkonzentration von 10%



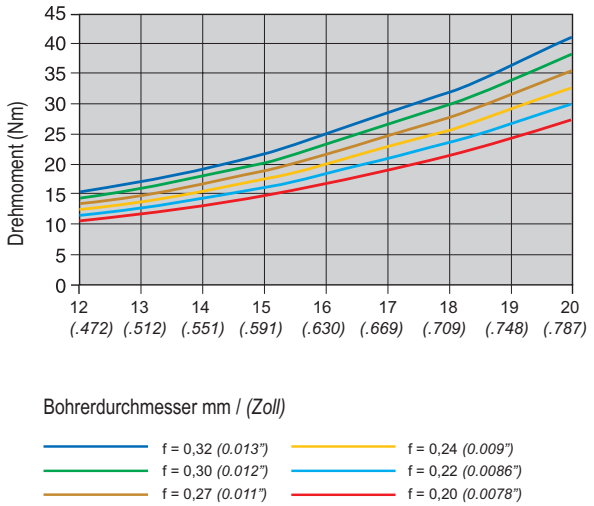
Bearbeitungsparameter

Die Grafiken zeigen Basiswerte, die, abhängig von Werkstoff und Schnittdaten sowie den individuellen Bearbeitungsbedingungen, angepasst werden müssen. Die Werte in den Tabellen sind gültig für die Seco Werkstoff-Gruppe (SMG) P5-P6 und Schnittgeschwindigkeiten von 90 m/min (*295 sf/min*).

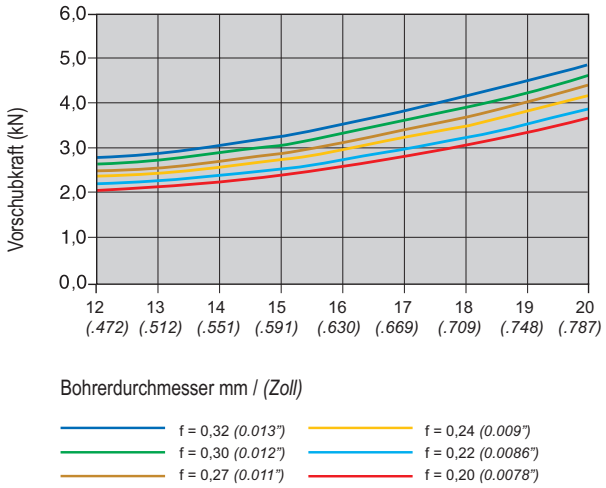
Leistungsbedarf



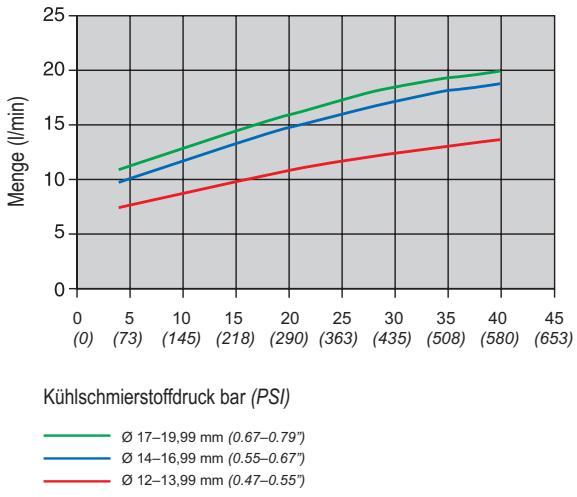
Drehmoment



Vorschubkraft



Kühlmittelmenge und Druck



Empfohlene Kühlschmierstoffmenge: Dx1 l/min
Mindest-Kühlschmierstoffmenge: D/2 l/min
D = Bohrerdurchmesser
Minimaler Kühlschmierstoffdruck von 10 bar *(145 PSI)* mit ≤ 3 x D.
Minimaler Kühlschmierstoffdruck von 20 bar *(290 PSI)* mit ≤ 5 x D.
Minimaler Kühlschmierstoffdruck von 40 bar *(580 PSI)* mit > 5 x D

Kühlschmierstoffmischung
Wir empfehlen für diese Bearbeitung allgemein eine Kühlschmierstoffkonzentration von 6 bis 8%.
Bei der Bearbeitung von hochlegierten und rostfreien Stählen empfehlen wir eine Konzentration von 10%.

Bohrungstoleranz/Oberflächengüte

Bohrerdurchmesser DC (mm)	IT9 Toleranz (µm)	IT10 Toleranz (µm)	Bohrdurchmesser DC *(Zoll)*	Toleranz IT9 *(Zoll)*	Toleranz IT10 *(Zoll)*
	SD403, SD405 und SD408 IT9-10 / R_a 1-4*, *R_a 39-157 µin**				
10-18	0 – +43	0 – +70	*0 – +0.394-0.709*	*0 – +0.0017*	*0 – +0.0028*
18-30	0 – +52	0 – +84	*0 – +0.709-1.181*	*0 – +0.0020*	*0 – +0.0033*

* Bei Stahl mit niedrigem Kohlenstoffanteil und Rostfrei können die Werte für die Oberflächengüte geringer ausfallen. Für bestmögliche Bohrungsqualität immer den kürzestmöglichen Bohrer einsetzen.

Herausforderungen – Einsatzhinweise:

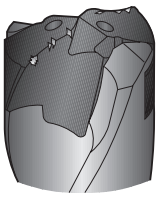
- Stabilität der Aufspannung
- Zustand der Maschinenspindel
- Zustand der Aufnahme

- Aufspannung:
  - Max. Rundlauffehler 0,06 TIR

- Spanabfuhr:
  - Schnittdaten

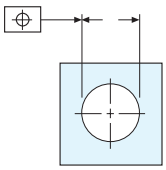
- Kühlung:
  - Druck
  - Durchfluss
  - Konzentration

Schneidenausbrüche



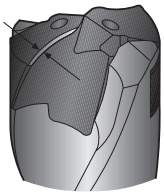
- Vorschub/U reduzieren
- Bei Vibrationen die Schnittgeschwindigkeit senken und den Vorschub erhöhen.
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30-50% senken.

Durchmesser außer Toleranz



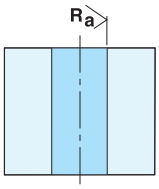
- Vorschub/U erhöhen
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 19-22
- Reibbearbeitung einsetzen, siehe Seite(n) 328
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 479-480

Schneller Freiflächenverschleiß



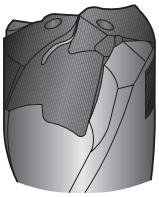
- Eingesetzte Geometrie prüfen
- Schnittgeschwindigkeit reduzieren

Geringe Oberflächengüte



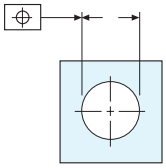
- Vorschub/U reduzieren
- Schnittgeschwindigkeit erhöhen
- Eingesetzte Geometrie prüfen
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 19-22
- Reibbearbeitung einsetzen, siehe Seite(n) 328

Spanflächenverschleiß



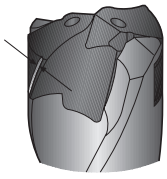
- Vorschub/U senken
- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen

Mittenversatz der Bohrung



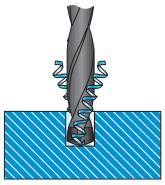
- Vorschub/U reduzieren
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30%-50% senken.
- Vorzentrieren mit einem Zentrierbohrer mit 140° Spitzenwinkel nutzen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 19-22
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 479-480

Verschleiß der Führungsfase



- Eingesetzte Geometrie prüfen
- Schnittgeschwindigkeit reduzieren
- Kühlmittelkonzentration erhöhen
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30-50% senken.

Spänestau durch lange Späne



- Vorschub erhöhen
- Bei langspanenden Werkstoffen SMG P1-P4, SMG M1-M2:
  - Schnittgeschwindigkeit erhöhen und Vorschub reduzieren
  - L-Geometrie einsetzen

Perfomax®

Perfomax® ist eine bewährte Serie an wirtschaftlichen Wendeplatten-Bohrern.

- Die viereckigen Wendeschneidplatten mit vier Schneidkanten sind äußerst zuverlässig.
- Moderne Schneidstoffe und Geometrien für verschiedene Werkstoffe
- Der Körper ist mit einer einzigartigen Spankammerausführung versehen. Kühlschmierstoffbohrungen in allen Größen optimieren die Spanabfuhr.

Programmübersicht

Perfomax®	Typ	Seite(n)	Durchmesser-bereich	Bohrtiefe	Durchmessertoleranz des Bohrers	Bohrungstoleranz
	SD522	Seite(n) 244, 245, 246-250, 251	∅ 15-59 mm *(0.594-2.375“)*	~ 2 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD523	Seite(n) 252, 253, 254, 255-266, 267	∅ 15-59 mm *(0.594-2.375“)*	~ 3 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,3 mm *(+0/+ 0.012”)*
	SD524	Seite(n) 268, 269-279, 280	∅ 17-59 mm *(0.594-2.375“)*	~ 4 x D	+/- 0,1 mm *(+/- 0.004”)*	+ 0,4 mm *(+0/+ 0.016”)*
	SD525	Seite(n) 281, 282-283	∅ 19-45 mm *(0.750-2.000“)*	~ 5 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,5 mm *(+0/+ 0.020”)*
	SD5301	Seite(n) 284-285	∅ 64-84 mm *(2.250-3.500“)*	∅ 84 mm *(3.307“)*	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD5402	Seite(n) 286-287	∅ 60-85 mm *(2.250-3.500“)*	~ 2.5 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD5702	Seite(n) 288-290	∅ 15-47 mm *(0.591“-1.850”)*	~ 2 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD602	Seite(n) 291-295	∅ 60-160 mm *(2.362“-4.000“)*	~ 1-10 x D	+/- 0,2 mm *(+/- 0.008”)*	–

Code Schlüssel – Wendeplatten-Bohrer

Metrisch

SD522	–	20	–	40	–	25	–	R	7
1		2		3		4		5	6

1.
Bohrertyp
SD522: 2 x D
SD523: 3 x D
SD524: 4 x D
SD525: 5 x D
SD5301: 84 mm (3,307”)
SD5402: 2,5 x D
SD5702: 2 x D

2.
(Kronen)Bohrerdurchmesser in mm

3.
Bohrtiefe

4.
Schaftdurchmesser mm/Zoll

5.
Rechtsdrehend

6
Schaftart
2. ABS-kompatibel
7. ISO 9766
8. VDI-kompatibel
G. Graflex

Zoll

SD522	–	0750	–	150	–	1000	R	7	–	C
1		2		3		4	5	6		7

1.
Bohrertyp
SD522: 2 x D
SD523: 3 x D
SD524: 4 x D
SD525: 5 x D
SD5301: 84 mm (3,307”)
SD5402: 2,5 x D
SD5702: 2 x D

2.
(Kronen)Bohr-erdurchmesser in mm

3.
Bohrtiefe

4.
Schaftdurchmesser mm/ Zoll

5.
Rechtsdrehend

6
Schaftart
2. ABS-kompatibel
7. ISO 9766
8. VDI-kompatibel
G. Graflex

7
Einsatz
C. Drehen

Capto™

SD523	–	20	–	60	–	C5
1		2		3		4

1.
Bohrertyp
SD5702: 2 x D
SD523: 3 x D
SD524: 4 x D

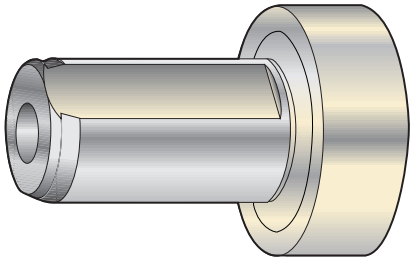
2.
(Kronen)Bohrerdurchmesser in mm

3.
Bohrtiefe

4.
Anschluss für Capto:
C4, C5, C6

Schäfte

-R7

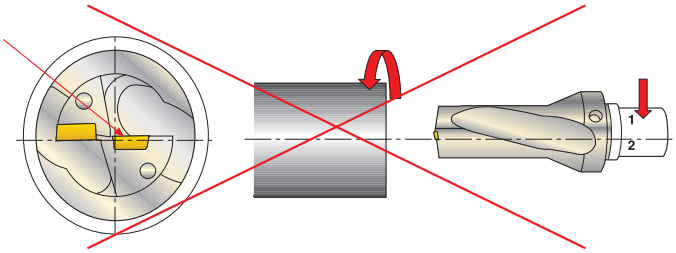


ISO 9766
Universell einsetzbar, passend für viele Aufnahmen:

- Weldon 1835B
- ISO 5414
- DIN 69880

Interne Kühlschmierstoffzufuhr

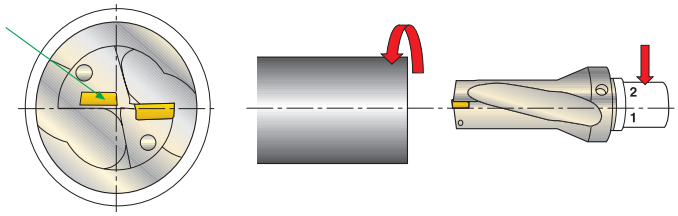
R7 und R7-C



Schäfte mit zwei oder vier Anflächungen
Schneidkante der Wendeschneidplatte über der Werkstückmitte zentrieren.

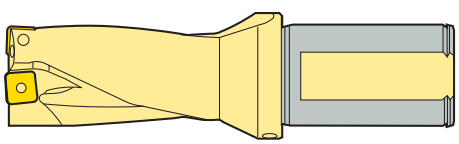
Statischer Einsatz:

- Eine zusätzliche Anlagefläche erhöht die Flexibilität des Bohrers bei statischem Einsatz.
- Bohrermitte und Werkstückmitte müssen in einer Linie sein,
- andernfalls ergibt sich ein schlechtes Bohrungsergebnis.



Durch die zweite Anlagefläche ist es möglich, den Schaft um 180° zu drehen und den Bohrer einfach und schnell auf der Drehmaschine auszurichten.

Schäfte mit vier Anflächungen
Schneidkante der Wendeschneidplatte über der Werkstückmitte zentrieren.

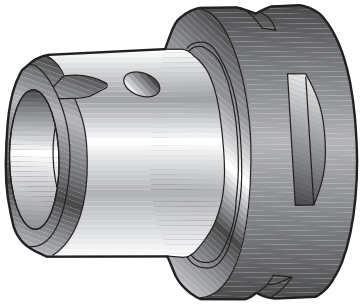


ANMERKUNG:

- Wird der Bohrer mit Schaft R7 zusammen mit unserer einstellbaren Aufnahme eingesetzt, muss die Anlagefläche auf der gleichen Seite wie die Zentrumsschneide sein.
- Andernfalls wird der Bohrer falsch eingestellt.

Schäfte

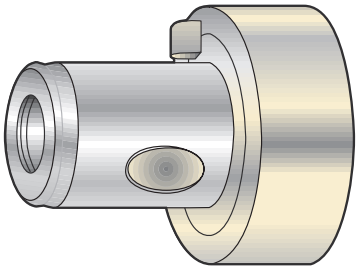
Seco Capto™



Seco Capto™ C4, C5, C6

- Mehr Flexibilität - ein und dieselbe Aufnahme ist auf verschiedenen Maschinen einsetzbar
- Modulares System - das Werkzeug kann mit verschiedenen Adaptern und Aufnahmen kombiniert werden.
- Hohe Drehmomentübertragung
- Hohe Stabilität - feste spielfreie Klemmung
- Hohe Genauigkeit - Polygon-Schnittstelle garantiert eine selbstzentrierende stabile Verbindung mit einer Wiederholgenauigkeit von max. 2 mm

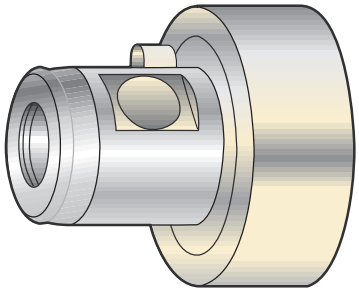
Graflex



- G

- Passt direkt in eine Graflex-Aufnahme mit zwei Spannschrauben, die um 120° versetzt sind.
- Modulares System für Steifigkeit und Rundlaufgenauigkeit.
- Zylindrische Anlagefläche - hohe Genauigkeit.
- Schnelle und einfach Montage/Demontage der Module für mehr Flexibilität.
- Interne Kühlschmierstoffzufuhr

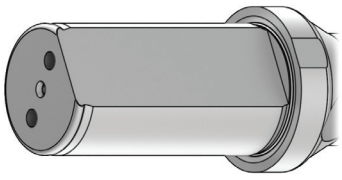
ABS 50 (kompatibel)



- 2

- ABS 50 kompatibel.
- Passt direkt in eine ABS50 Aufnahme mit einer Spannschraube.
- Interne Kühlschmierstoffzufuhr

VDI 30 und VDI 40 (kompatibel)



- 8

- VDI kompatibler Schaft
- Passt direkt in die Aufnahmen:
  – VDI 3425 bl.2
  – DIN 69880

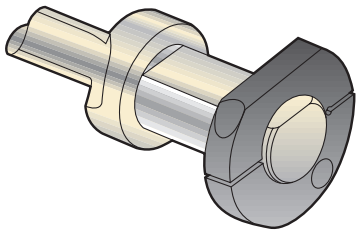
ANMERKUNG:
Der Kühlmittelring muss separat bestellt werden.

Zubehör – Kühlring

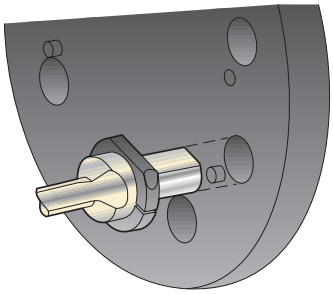
VDI 30			
Bohrtiefe	Bohrerdurchmesser mm	Bohrerdurchmesser *Zoll*	Zubehör Kühlring
2 x D	15-31	*0.591-1,220*	SDA5-30R8
3 x D	15-31	*0.591-1,220*	SDA5-30R8
4 x D	17-31	*0.669-1,220*	SDA5-30R8
5 x D	19-31	*0.748-1,220*	SDA5-30R8

VDI 40					
Bohrtiefe	Bohrerdurchmesser mm	Bohrerdurchmesser *Zoll*	Stopfen	Spannschraube	Zubehör Kühlring
2 x D	15-31	*0.591-1,220*			SDA5-40R8
3 x D	15-31	*0.591-1,220*			SDA5-40R8
4 x D	17-31	*0.669-1,220*			SDA5-40R8
5 x D	19-31	*0.748-1,220*			SDA5-40R8
2 x D	41-59	*1.614-2,323*	R1/4”	P6SS8x8	SDA5-40R8
3 x D	41-59	*1.614-2,323*	R1/4”	P6SS8x8	SDA5-40R8

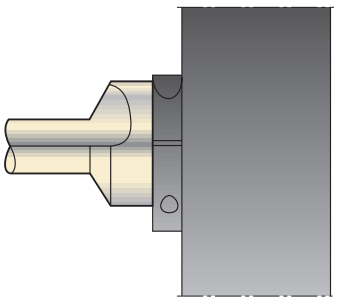
1. Ring über den Schaft schieben. Schraube nicht festziehen.



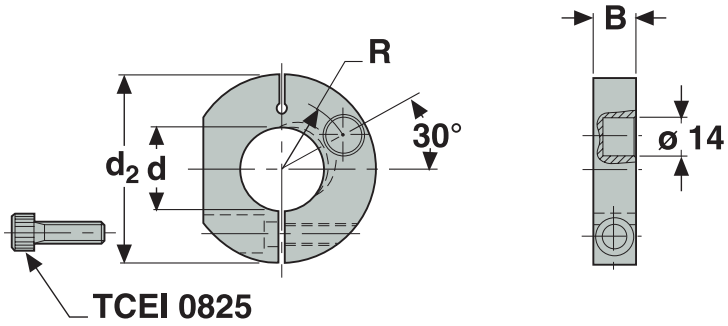
2. Bohrer in die Revolverscheibe montieren.



3. Ringschraube fest anziehen.

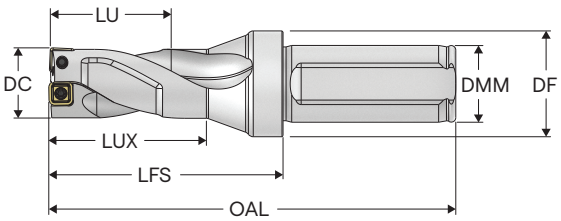


Kühlmittelring



SD522

Bohrtiefe ca. 2 x D – Metrisch/Zoll



– Schaft ISO 9766, -7
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 305, 306
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-15-30-20R7	03080744	15,0 *0.591*	30,0 *1.181*	110,0 *4.331*	35,0 *1.378*	60,0 *2.362*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD522-15-30-25R7	03080745	15,0 *0.591*	30,0 *1.181*	116,0 *4.567*	35,0 *1.378*	60,0 *2.362*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD522-15.5-31-20R7	03080740	15,5 *0.610*	31,0 *1.220*	111,0 *4.370*	36,0 *1.417*	61,0 *2.402*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD522-15.5-31-25R7	03080741	15,5 *0.610*	31,0 *1.220*	117,0 *4.606*	36,0 *1.417*	61,0 *2.402*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD522-16-32-20R7	03080749	16,0 *0.630*	32,0 *1.260*	112,0 *4.409*	37,0 *1.457*	62,0 *2.441*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD522-16-32-25R7	03080750	16,0 *0.630*	32,0 *1.260*	118,0 *4.646*	37,0 *1.457*	62,0 *2.441*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD522-16.5-33-20R7	03080746	16,5 *0.650*	33,0 *1.299*	113,0 *4.449*	38,0 *1.496*	63,0 *2.480*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD522-16.5-33-25R7	03080747	16,5 *0.650*	33,0 *1.299*	119,0 *4.685*	38,0 *1.496*	63,0 *2.480*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD522-17-34-20R7	03080754	17,0 *0.669*	34,0 *1.339*	114,0 *4.488*	39,0 *1.535*	64,0 *2.520*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD522-17-34-25R7	03080755	17,0 *0.669*	34,0 *1.339*	120,0 *4.724*	39,0 *1.535*	64,0 *2.520*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD522-17.5-35-20R7	03080752	17,5 *0.689*	35,0 *1.378*	115,0 *4.528*	40,0 *1.575*	65,0 *2.559*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD522-17.5-35-25R7	03080753	17,5 *0.689*	35,0 *1.378*	121,0 *4.764*	40,0 *1.575*	65,0 *2.559*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD522-18-36-20R7	03080760	18,0 *0.709*	36,0 *1.417*	116,0 *4.567*	41,0 *1.614*	66,0 *2.598*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD522-18-36-25R7	03080761	18,0 *0.709*	36,0 *1.417*	122,0 *4.803*	41,0 *1.614*	66,0 *2.598*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD522-18.5-37-20R7	03080758	18,5 *0.728*	37,0 *1.457*	117,0 *4.606*	42,0 *1.654*	67,0 *2.638*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD522-18.5-37-25R7	03080759	18,5 *0.728*	37,0 *1.457*	123,0 *4.843*	42,0 *1.654*	67,0 *2.638*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD522-19-38-20R7	03080765	19,0 *0.748*	38,0 *1.496*	118,0 *4.646*	43,0 *1.693*	68,0 *2.677*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD522-19-38-25R7	03080766	19,0 *0.748*	38,0 *1.496*	124,0 *4.882*	43,0 *1.693*	68,0 *2.677*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD522-19.5-39-20R7	03080764	19,5 *0.768*	39,0 *1.535*	119,0 *4.685*	44,0 *1.732*	69,0 *2.717*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX060204	0,11 *0.004*	0,42 *0.017*
SD522-20-40-25R7	03080771	20,0 *0.787*	40,0 *1.575*	126,0 *4.961*	45,0 *1.772*	70,0 *2.756*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD522-21-42-25R7	03080775	21,0 *0.827*	42,0 *1.654*	128,0 *5.039*	47,0 *1.850*	72,0 *2.835*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD522-22-44-25R7	03080777	22,0 *0.866*	44,0 *1.732*	130,0 *5.118*	49,0 *1.929*	74,0 *2.913*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*
SD522-23-46-25R7	03080781	23,0 *0.906*	46,0 *1.811*	132,0 *5.197*	51,0 *2.008*	76,0 *2.992*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD522-23.5-47-25R7	03192517	23,5 *0.925*	47,0 *1.850*	133,0 *5.236*	52,0 *2.047*	77,0 *3.031*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,23 *0.009*	0,5 *0.020*
SD522-24-48-25R7	03080785	24,0 *0.945*	48,0 *1.890*	134,0 *5.276*	53,0 *2.087*	78,0 *3.071*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-25-50-32R7	03080788	25,0 *0.984*	50,0 *1.969*	140,0 *5.512*	55,0 *2.165*	80,0 *3.150*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD522-26-52-32R7	03080790	26,0 *1.024*	52,0 *2.047*	142,0 *5.591*	57,0 *2.244*	82,0 *3.228*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD522-27-54-32R7	03080792	27,0 *1.063*	54,0 *2.126*	144,0 *5.669*	59,0 *2.323*	84,0 *3.307*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD522-28-56-32R7	03080795	28,0 *1.102*	56,0 *2.205*	146,0 *5.748*	61,0 *2.402*	86,0 *3.386*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD522-29-58-32R7	03080796	29,0 *1.142*	58,0 *2.283*	148,0 *5.827*	63,0 *2.480*	88,0 *3.465*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD522-30-60-32R7	03080798	30,0 *1.181*	60,0 *2.362*	150,0 *5.906*	65,0 *2.559*	90,0 *3.543*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD522-31-62-32R7	03080801	31,0 *1.220*	62,0 *2.441*	152,0 *5.984*	67,0 *2.638*	92,0 *3.622*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD522-32-64-32R7	03080802	32,0 *1.260*	64,0 *2.520*	154,0 *6.063*	69,0 *2.717*	94,0 *3.701*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD522-32-64-40R7	03080803	32,0 *1.260*	64,0 *2.520*	162,0 *6.378*	69,0 *2.717*	94,0 *3.701*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD522-33-66-32R7	03080805	33,0 *1.299*	66,0 *2.598*	156,0 *6.142*	71,0 *2.795*	96,0 *3.780*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD522-33-66-40R7	03080806	33,0 *1.299*	66,0 *2.598*	164,0 *6.457*	71,0 *2.795*	96,0 *3.780*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD522-34-68-32R7	03080808	34,0 *1.339*	68,0 *2.677*	158,0 *6.220*	73,0 *2.874*	98,0 *3.858*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD522-34-68-40R7	03080809	34,0 *1.339*	68,0 *2.677*	166,0 *6.535*	73,0 *2.874*	98,0 *3.858*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD522-35-70-32R7	03080810	35,0 *1.378*	70,0 *2.756*	160,0 *6.299*	75,0 *2.953*	100,0 *3.937*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD522-35-70-40R7	03080811	35,0 *1.378*	70,0 *2.756*	168,0 *6.614*	75,0 *2.953*	100,0 *3.937*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD522-36-72-32R7	03080813	36,0 *1.417*	72,0 *2.835*	162,0 *6.378*	77,0 *3.031*	102,0 *4.016*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD522-36-72-40R7	03080814	36,0 *1.417*	72,0 *2.835*	170,0 *6.693*	77,0 *3.031*	102,0 *4.016*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD522-37-74-32R7	03080816	37,0 *1.457*	74,0 *2.913*	164,0 *6.457*	79,0 *3.110*	104,0 *4.094*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD522-37-74-40R7	03080817	37,0 *1.457*	74,0 *2.913*	172,0 *6.772*	79,0 *3.110*	104,0 *4.094*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD522-38-76-32R7	03080818	38,0 *1.496*	76,0 *2.992*	166,0 *6.535*	81,0 *3.189*	106,0 *4.173*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD522-38-76-40R7	03080819	38,0 *1.496*	76,0 *2.992*	174,0 *6.850*	81,0 *3.189*	106,0 *4.173*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD522-39-78-32R7	03080821	39,0 *1.535*	78,0 *3.071*	168,0 *6.614*	83,0 *3.268*	108,0 *4.252*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD522-39-78-40R7	03080822	39,0 *1.535*	78,0 *3.071*	176,0 *6.929*	83,0 *3.268*	108,0 *4.252*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD522-40-80-32R7	03080823	40,0 *1.575*	80,0 *3.150*	170,0 *6.693*	85,0 *3.346*	110,0 *4.331*	60,0 *2.362*	32,0 *1.260*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*
SD522-40-80-40R7	03080824	40,0 *1.575*	80,0 *3.150*	178,0 *7.008*	85,0 *3.346*	110,0 *4.331*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*
SD522-41-82-40R7	03080826	41,0 *1.614*	82,0 *3.228*	180,0 *7.087*	87,0 *3.425*	112,0 *4.409*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD522-42-84-40R7	03080828	42,0 *1.654*	84,0 *3.307*	182,0 *7.165*	89,0 *3.504*	114,0 *4.488*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD522-43-86-40R7	03080830	43,0 *1.693*	86,0 *3.386*	184,0 *7.244*	91,0 *3.583*	116,0 *4.567*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,05 *0.002*	0,5 *0.020*
SD522-44-88-40R7	03080832	44,0 *1.732*	88,0 *3.465*	186,0 *7.323*	93,0 *3.661*	118,0 *4.646*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX120408	0,5 *0.020*	0,41 *0.016*
SD522-45-90-40R7	03080834	45,0 *1.772*	90,0 *3.543*	188,0 *7.402*	95,0 *3.740*	120,0 *4.724*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,41 *0.016*
SD522-46-92-40R7	03080835	46,0 *1.811*	92,0 *3.622*	190,0 *7.480*	97,0 *3.819*	122,0 *4.803*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD522-47-94-40R7	03080836	47,0 *1.850*	94,0 *3.701*	192,0 *7.559*	99,0 *3.898*	124,0 *4.882*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD522-48-96-40R7	03080837	48,0 *1.890*	96,0 *3.780*	194,0 *7.638*	101,0 *3.976*	126,0 *4.961*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,45 *0.018*	0,5 *0.020*
SD522-49-98-40R7	03080838	49,0 *1.929*	98,0 *3.858*	196,0 *7.717*	103,0 *4.055*	128,0 *5.039*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,2 *0.008*	0,5 *0.020*
SD522-50-100-40R7	03080839	50,0 *1.969*	100,0 *3.937*	198,0 *7.795*	105,0 *4.134*	130,0 *5.118*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,2 *0.008*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-51-102-40R7	03080840	51,0 *2.008*	102,0 *4.016*	200,0 *7.874*	107,0 *4.213*	132,0 *5.197*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,2 *0.008*	0,5 *0.020*
SD522-52-104-40R7	03080841	52,0 *2.047*	104,0 *4.094*	202,0 *7.953*	109,0 *4.291*	134,0 *5.276*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,42 *0.017*
SD522-53-106-40R7	03080842	53,0 *2.087*	106,0 *4.173*	204,0 *8.031*	111,0 *4.370*	136,0 *5.354*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,42 *0.017*
SD522-54-108-40R7	03080843	54,0 *2.126*	108,0 *4.252*	206,0 *8.110*	113,0 *4.449*	138,0 *5.433*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD522-55-110-40R7	03080844	55,0 *2.165*	110,0 *4.331*	208,0 *8.189*	115,0 *4.528*	140,0 *5.512*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD522-56-112-40R7	03080845	56,0 *2.205*	112,0 *4.409*	210,0 *8.268*	117,0 *4.606*	142,0 *5.591*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD522-57-114-40R7	03080846	57,0 *2.244*	114,0 *4.488*	212,0 *8.346*	119,0 *4.685*	144,0 *5.669*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,39 *0.015*	0,5 *0.020*
SD522-58-116-40R7	03080847	58,0 *2.283*	116,0 *4.567*	214,0 *8.425*	121,0 *4.764*	146,0 *5.748*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX1904	SCGX150512	0,09 *0.004*	0,5 *0.020*
SD522-59-118-40R7	03080848	59,0 *2.323*	118,0 *4.646*	216,0 *8.504*	123,0 *4.843*	148,0 *5.827*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX1904	SCGX150512	0,09 *0.004*	0,5 *0.020*

Ersatzteile, im Lieferumfang enthalten

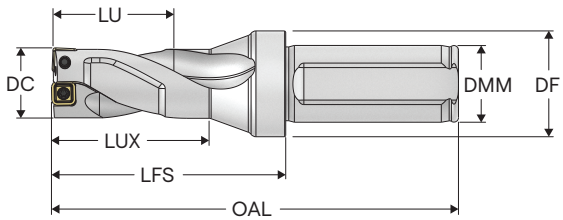
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,5-19,00	C02205-T07P	C02245-T07P	T07P-2
19,5-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
29,00-31,00	C03007-T09P	C03009-T09P	T09P-2
32,00-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
42,00-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
15,00-17,00	T00-07P09
17,5-19,00	T00-07P09
19,5-21,00	T00-07P09
22,00	T00-08P12
23,00-25,00	T00-08P12
26,00-28,00	T00-09P20
29,00-31,00	T00-09P20
32,00-40,00	T00-15P30
41,00-43,00	T00-15P30
42,00-59,00	T00-15P35

SD522

Bohrtiefe ca. 2 x D – Zoll



– Schaft ISO 9766, R7
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 305, 306
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zentrums-schneide	Peripherie-schneide	Zoll -	Zoll +
SD522-0594-119-1000R7	03080704	0.594	1.190	4.621	1.387	2.371	2.250	1.000	1.378	SPGX0502	SCGX050204	0.008	0.013
SD522-0625-125-1000R7	03080705	0.625	1.250	4.681	1.447	2.431	2.250	1.000	1.378	SPGX0502	SCGX050204	0.005	0.015
SD522-0656-131-1000R7	03080707	0.656	1.310	4.741	1.507	2.491	2.250	1.000	1.378	SPGX0502	SCGX050204	0.002	0.019
SD522-0687-137-1000R7	03080709	0.687	1.370	4.801	1.567	2.551	2.250	1.000	1.378	SPGX0502	SCGX050204	0	0.020
SD522-0709-142-1000R7	03080710	0.709	1.420	4.851	1.617	2.601	2.250	1.000	1.378	SPGX0602	SCGX050204	0.013	0.008
SD522-0750-150-1000R7	03080712	0.750	1.500	4.931	1.697	2.681	2.250	1.000	1.378	SPGX0602	SCGX050204	0.004	0.017
SD522-0766-153-1000R7	03080713	0.766	1.530	4.961	1.727	2.711	2.250	1.000	1.378	SPGX0602	SCGX050204	0.001	0.020
SD522-0787-157-1000R7	03080714	0.787	1.570	5.001	1.767	2.751	2.250	1.000	1.378	SPGX0602	SCGX060204	0.003	0.018
SD522-0812-162-1000R7	03080715	0.812	1.620	5.051	1.817	2.801	2.250	1.000	1.378	SPGX0602	SCGX060204	0.001	0.020
SD522-0827-165-1000R7	03080717	0.827	1.650	5.081	1.847	2.831	2.250	1.000	1.378	SPGX0602	SCGX060204	0	0.020
SD522-0875-175-1000R7	03080718	0.875	1.750	5.181	1.947	2.931	2.250	1.000	1.378	SPGX0703	SCGX060204	0.015	0.020
SD522-0906-181-1000R7	03080720	0.906	1.810	5.241	2.007	2.991	2.250	1.000	1.378	SPGX0703	SCGX070308	0.013	0.020
SD522-0922-184-1000R7	03080721	0.922	1.840	5.271	2.037	3.021	2.250	1.000	1.378	SPGX0703	SCGX070308	0.010	0.020
SD522-0937-187-1000R7	03080722	0.937	1.870	5.301	2.067	3.051	2.250	1.000	1.378	SPGX0703	SCGX070308	0.004	0.020
SD522-0984-197-1250R7	03080724	0.984	1.970	5.526	2.167	3.151	2.375	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD522-1000-200-1250R7	03080725	1.000	2.000	5.556	2.197	3.181	2.375	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD522-1032-206-1250R7	03080727	1.032	2.060	5.616	2.257	3.241	2.375	1.250	1.654	SPGX0903	SCGX070308	0.020	0.004
SD522-1062-212-1250R7	03080728	1.062	2.120	5.676	2.317	3.301	2.375	1.250	1.654	SPGX0903	SCGX070308	0.020	0.010
SD522-1125-225-1250R7	03080730	1.125	2.250	5.806	2.447	3.431	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.008	0.020
SD522-1187-237-1250R7	03080732	1.187	2.370	5.926	2.567	3.551	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD522-1250-250-1500R7	03080735	1.250	2.500	6.306	2.697	3.681	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.011
SD522-1312-262-1500R7	03080736	1.312	2.620	6.426	2.817	3.801	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.020
SD522-1375-275-1500R7	03080737	1.375	2.750	6.556	2.947	3.931	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.009	0.020
SD522-1437-287-1500R7	03080739	1.437	2.870	6.676	3.067	4.051	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.004	0.020
SD522-1500-300-1500R7	03080743	1.500	3.000	6.806	3.197	4.181	2.625	1.500	1.969	SPGX12T3	SCGX11T308	0.020	0.020
SD522-1625-325-1500R7	03080748	1.625	3.250	7.056	3.447	4.431	2.625	1.500	1.969	SPGX12T3	SCGX120408	0.007	0.020
SD522-1750-350-1500R7	03080756	1.750	3.500	7.306	3.697	4.681	2.625	1.500	1.969	SPGX1504	SCGX120408	0.020	0.016
SD522-1875-375-1500R7	03080763	1.875	3.750	7.556	3.947	4.931	2.625	1.500	1.969	SPGX1504	SCGX150512	0.020	0.020
SD522-2000-400-1500R7	03080769	2.000	4.000	7.806	4.197	5.181	2.625	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD522-2125-425-1500R7	03080773	2.125	4.250	8.056	4.447	5.431	2.625	1.500	2.337	SPGX1904	SCGX150512	0.020	0.020
SD522-2250-450-1500R7	03080779	2.250	4.500	8.306	4.697	5.681	2.625	1.500	2.337	SPGX1904	SCGX150512	0.013	0.020
SD522-2375-475-1500R7	03080783	2.375	4.750	8.556	4.947	5.931	2.625	1.500	2.480	SPGX1904	SCGX150512	0.004	0.020

Ersatzteile, im Lieferumfang enthalten

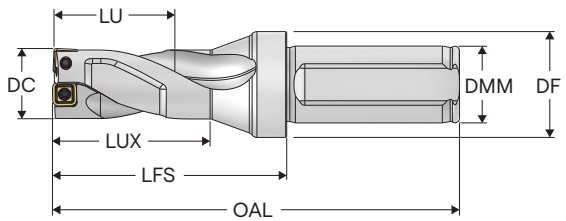
Bohrerdurchmesser (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.875	C02205-T07P	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.062	–	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.500	–	C03508-T15P	T15P-2D
1.625	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrerdurchmesser (Zoll)	Drehmomentschlüssel
0.594-0.687	T00-07P09
0.709-0.766	T00-07P09
0.787-0.827	T00-07P09
0.875	T00-08P12
0.906-1.000	T00-08P12
1.032-1.062	T00-09P20
1.125-1.187	T00-09P20
1.250-1.500	T00-15P30
1.625	T00-15P30
1.750-2.375	T00-15P35

SD522

Bohrtiefe ca. 2 x D – Zoll



- Schaft ISO 9766, R7-C
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 305-306
- Zwischendurchmesser siehe MyDesign-Software
- Für statische Anwendungen

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zentrums-schneide	Peripherie-schneide	Zoll -	Zoll +
SD522-0625-125-1000R7-C	03080706	0.625	1.250	5.378	1.447	2.628	2.750	1.000	1.378	SPGX0502	SCGX050204	0.005	0.015
SD522-0687-137-1000R7-C	03080708	0.687	1.370	5.498	1.567	2.748	2.750	1.000	1.378	SPGX0502	SCGX050204	0	0.020
SD522-0750-150-1000R7-C	03080711	0.750	1.500	5.628	1.697	2.878	2.750	1.000	1.378	SPGX0602	SCGX050204	0.004	0.017
SD522-0812-162-1000R7-C	03080716	0.812	1.620	5.748	1.817	2.998	2.750	1.000	1.378	SPGX0602	SCGX060204	0.001	0.020
SD522-0875-175-1000R7-C	03080719	0.875	1.750	5.878	1.947	3.128	2.750	1.000	1.378	SPGX0703	SCGX060204	0.015	0.020
SD522-0937-187-1000R7-C	03080723	0.937	1.870	5.998	2.067	3.248	2.750	1.000	1.378	SPGX0703	SCGX070308	0.004	0.020
SD522-1000-200-1250R7-C	03080726	1.000	2.000	6.128	2.197	3.378	2.750	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD522-1062-212-1250R7-C	03080729	1.062	2.120	6.248	2.317	3.498	2.750	1.250	1.654	SPGX0903	SCGX070308	0.020	0.010
SD522-1125-225-1250R7-C	03080731	1.125	2.250	6.378	2.447	3.628	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.008	0.020
SD522-1187-237-1250R7-C	03080733	1.187	2.370	6.498	2.567	3.748	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD522-1250-250-1500R7-C	03080734	1.250	2.500	6.628	2.697	3.878	2.750	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.011
SD522-1375-275-1500R7-C	03080738	1.375	2.750	6.878	2.947	4.128	2.750	1.500	1.969	SPGX11T3	SCGX11T308	0.009	0.020
SD522-1500-300-1500R7-C	03080742	1.500	3.000	7.128	3.197	4.378	2.750	1.500	1.969	SPGX12T3	SCGX11T308	0.020	0.020
SD522-1750-350-1500R7-C	03080757	1.750	3.500	7.628	3.697	4.878	2.750	1.500	1.969	SPGX1504	SCGX120408	0.020	0.016
SD522-2000-400-1500R7-C	03080770	2.000	4.000	8.128	4.197	5.378	2.750	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD522-2125-425-1500R7-C	03080774	2.125	4.250	8.378	4.447	5.628	2.750	1.500	2.337	SPGX1904	SCGX150512	0.020	0.020
SD522-2250-450-1500R7-C	03080780	2.250	4.500	8.628	4.697	5.878	2.750	1.500	2.337	SPGX1904	SCGX150512	0.013	0.020
SD522-2375-475-1500R7-C	03080784	2.375	4.750	8.878	4.947	6.128	2.750	1.500	2.480	SPGX1904	SCGX150512	0.004	0.020

Ersatzteile, im Lieferumfang enthalten

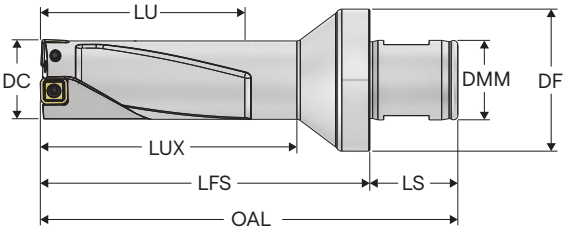
Bohrerdurch-messer (Zoll)	Schlauchadapter	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Dichtschraube
0.625	C02245-T07P	C02245-T07P	C02245-T07P	T07P-2	R1/4
0.687	–	–	C02245-T07P	T07P-2	R1/4
0.750	C02205-T07P	C02205-T07P	C02245-T07P	T07P-2	R1/4
0.812	C02506-T08P	C02506-T08P	C02205-T07P	T07P-2	R1/4
0.875	–	–	C02506-T08P	T08P-2	R1/4
0.937	C03007-T09P	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.062	C03508-T15P	C03508-T15P	C03007-T09P	T09P-2	R1/4
1.125-1.187	–	C03007-T09P	C03009-T09P	T09P-2	R1/4
1.250-1.500	–	–	C03508-T15P	T15P-2D	R1/4
1.750-2.375	–	C04011-T15P	C05012-T15P	T15P-2D	R1/4

Zubehör

Schlauchadapter	Drehmomentschlüssel
1310	T00-07P09
1310	T00-07P09
1310	T00-07P09
1310	T00-07P09
1310	T00-08P12
1310	T00-08P12
–	T00-08P12
1310	T00-09P20
1310	T00-09P20
1310	T00-15P30
1310	T00-15P35

SD522

Bohrtiefe ca. 2 x D – Metrisch/Zoll



- Mit ABS 50 kompatibler Schaft, R2
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301–304
- Schnittdaten siehe Seite(n) 305, 306
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-15-30-50R2	03081056	15,0 *0.591*	30,0 *1.181*	91,0 *3.583*	35,0 *1.378*	60,0 *2.362*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD522-15.5-31-50R2	03081057	15,5 *0.610*	31,0 *1.220*	92,0 *3.622*	36,0 *1.417*	61,0 *2.402*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD522-16-32-50R2	03080751	16,0 *0.630*	32,0 *1.260*	93,0 *3.661*	37,0 *1.457*	62,0 *2.441*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD522-16.5-33-50R2	03081058	16,5 *0.650*	33,0 *1.299*	94,0 *3.701*	38,0 *1.496*	63,0 *2.480*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD522-17-34-50R2	03081059	17,0 *0.669*	34,0 *1.339*	95,0 *3.740*	39,0 *1.535*	64,0 *2.520*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD522-17.5-35-50R2	03081060	17,5 *0.689*	35,0 *1.378*	96,0 *3.780*	40,0 *1.575*	65,0 *2.559*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD522-18-36-50R2	03080762	18,0 *0.709*	36,0 *1.417*	97,0 *3.819*	41,0 *1.614*	66,0 *2.598*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD522-18.5-37-50R2	03081061	18,5 *0.728*	37,0 *1.457*	98,0 *3.858*	42,0 *1.654*	67,0 *2.638*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD522-19-38-50R2	03080767	19,0 *0.748*	38,0 *1.496*	99,0 *3.898*	43,0 *1.693*	68,0 *2.677*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD522-20-40-50R2	03080772	20,0 *0.787*	40,0 *1.575*	101,0 *3.976*	45,0 *1.772*	70,0 *2.756*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD522-20.62-42-50R2	03080768	20,62 *0.812*	42,0 *1.654*	103,0 *4.055*	47,0 *1.850*	72,0 *2.835*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204	0,03 *0.001*	0,5 *0.020*
SD522-21-42-50R2	03081062	21,0 *0.827*	42,0 *1.654*	103,0 *4.055*	47,0 *1.850*	72,0 *2.835*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD522-22-44-50R2	03080778	22,0 *0.866*	44,0 *1.732*	105,0 *4.134*	49,0 *1.929*	74,0 *2.913*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*
SD522-22.23-45-50R2	03080776	22,23 *0.875*	45,0 *1.772*	106,0 *4.173*	50,0 *1.969*	75,0 *2.953*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX060204	0,39 *0.015*	0,5 *0.020*
SD522-23-46-50R2	03080782	23,0 *0.906*	46,0 *1.811*	107,0 *4.213*	51,0 *2.008*	76,0 *2.992*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD522-24-48-50R2	03080786	24,0 *0.945*	48,0 *1.890*	109,0 *4.291*	53,0 *2.087*	78,0 *3.071*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD522-25-50-50R2	03080789	25,0 *0.984*	50,0 *1.969*	111,0 *4.370*	55,0 *2.165*	80,0 *3.150*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD522-25.40-51-50R2	03080787	25,4 *1.000*	51,0 *2.008*	112,0 *4.409*	56,0 *2.205*	81,0 *3.189*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD522-26-52-50R2	03080791	26,0 *1.024*	52,0 *2.047*	113,0 *4.449*	57,0 *2.244*	82,0 *3.228*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD522-27-54-50R2	03080793	27,0 *1.063*	54,0 *2.126*	115,0 *4.528*	59,0 *2.323*	84,0 *3.307*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD522-28-56-50R2	03081087	28,0 *1.102*	56,0 *2.205*	117,0 *4.606*	61,0 *2.402*	86,0 *3.386*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD522-28.59-58-50R2	03080794	28,59 *1.126*	58,0 *2.283*	119,0 *4.685*	63,0 *2.480*	88,0 *3.465*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,21 *0.008*	0,5 *0.020*
SD522-29-58-50R2	03080797	29,0 *1.142*	58,0 *2.283*	119,0 *4.685*	63,0 *2.480*	88,0 *3.465*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD522-30-60-50R2	03080799	30,0 *1.181*	60,0 *2.362*	121,0 *4.764*	65,0 *2.559*	90,0 *3.543*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD522-31-62-50R2	03081063	31,0 *1.220*	62,0 *2.441*	123,0 *4.843*	67,0 *2.638*	92,0 *3.622*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-31.75-64-50R2	03080800	31,75 *1.250*	64,0 *2.520*	125,0 *4.921*	69,0 *2.717*	94,0 *3.701*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,28 *0.011*
SD522-32-64-50R2	03080804	32,0 *1.260*	64,0 *2.520*	125,0 *4.921*	69,0 *2.717*	94,0 *3.701*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD522-33-66-50R2	03080807	33,0 *1.299*	66,0 *2.598*	127,0 *5.000*	71,0 *2.795*	96,0 *3.780*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD522-34-68-50R2	03081064	34,0 *1.339*	68,0 *2.677*	129,0 *5.079*	73,0 *2.874*	98,0 *3.858*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD522-35-70-50R2	03080812	35,0 *1.378*	70,0 *2.756*	131,0 *5.157*	75,0 *2.953*	100,0 *3.937*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD522-36-72-50R2	03080815	36,0 *1.417*	72,0 *2.835*	133,0 *5.236*	77,0 *3.031*	102,0 *4.016*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD522-37-74-50R2	03081065	37,0 *1.457*	74,0 *2.913*	135,0 *5.315*	79,0 *3.110*	104,0 *4.094*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD522-38-76-50R2	03080820	38,0 *1.496*	76,0 *2.992*	137,0 *5.394*	81,0 *3.189*	106,0 *4.173*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD522-39-78-50R2	03081066	39,0 *1.535*	78,0 *3.071*	139,0 *5.472*	83,0 *3.268*	108,0 *4.252*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD522-40-80-50R2	03080825	40,0 *1.575*	80,0 *3.150*	141,0 *5.551*	85,0 *3.346*	110,0 *4.331*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*
SD522-41-82-50R2	03080827	41,0 *1.614*	82,0 *3.228*	143,0 *5.630*	87,0 *3.425*	112,0 *4.409*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD522-42-84-50R2	03080829	42,0 *1.654*	84,0 *3.307*	145,0 *5.709*	89,0 *3.504*	114,0 *4.488*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD522-43-86-50R2	03081067	43,0 *1.693*	86,0 *3.386*	147,0 *5.787*	91,0 *3.583*	116,0 *4.567*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX120408	0,05 *0.002*	0,5 *0.020*
SD522-44.45-89-50R2	03080831	44,45 *1.750*	89,0 *3.504*	150,0 *5.906*	94,0 *3.701*	119,0 *4.685*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX1504	SCGX120408	0,5 *0.020*	0,41 *0.016*

Ersatzteile, im Lieferumfang enthalten

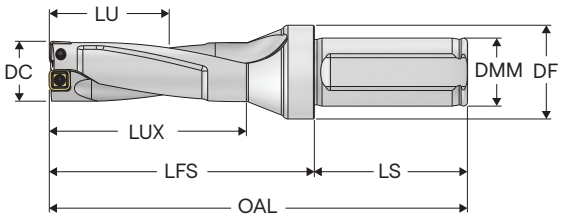
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,45	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Drehmomentschlüssel
T00-07P09
T00-07P09
T00-07P09
T00-08P12
T00-08P12
T00-09P20
T00-09P20
T00-15P30
T00-15P30
T00-15P35

SD523

Bohrtiefe ca. 3 x D – Metrisch/Zoll



– Schaft ISO 9766, -7
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 307-308
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-15-45-20R7	03080548	15,0 *0.591*	45,0 *1.772*	125,0 *4.921*	50,0 *1.969*	75,0 *2.953*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-15-45-25R7	03080549	15,0 *0.591*	45,0 *1.772*	131,0 *5.157*	50,0 *1.969*	75,0 *2.953*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-15.5-47-20R7	03080544	15,5 *0.610*	47,0 *1.850*	127,0 *5.000*	52,0 *2.047*	77,0 *3.031*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD523-15.5-47-25R7	03080545	15,5 *0.610*	47,0 *1.850*	133,0 *5.236*	52,0 *2.047*	77,0 *3.031*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD523-16-48-20R7	03080557	16,0 *0.630*	48,0 *1.890*	128,0 *5.039*	53,0 *2.087*	78,0 *3.071*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD523-16-48-25R7	03080558	16,0 *0.630*	48,0 *1.890*	134,0 *5.276*	53,0 *2.087*	78,0 *3.071*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD523-16.5-50-20R7	03080552	16,5 *0.650*	50,0 *1.969*	130,0 *5.118*	55,0 *2.165*	80,0 *3.150*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD523-16.5-50-25R7	03080554	16,5 *0.650*	50,0 *1.969*	136,0 *5.354*	55,0 *2.165*	80,0 *3.150*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD523-17-51-20R7	03080568	17,0 *0.669*	51,0 *2.008*	131,0 *5.157*	56,0 *2.205*	81,0 *3.189*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD523-17-51-25R7	03080569	17,0 *0.669*	51,0 *2.008*	137,0 *5.394*	56,0 *2.205*	81,0 *3.189*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD523-17.5-53-20R7	03080562	17,5 *0.689*	53,0 *2.087*	133,0 *5.236*	58,0 *2.283*	83,0 *3.268*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD523-17.5-53-25R7	03080563	17,5 *0.689*	53,0 *2.087*	139,0 *5.472*	58,0 *2.283*	83,0 *3.268*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD523-18-54-20R7	03080574	18,0 *0.709*	54,0 *2.126*	134,0 *5.276*	59,0 *2.323*	84,0 *3.307*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD523-18-54-25R7	03080575	18,0 *0.709*	54,0 *2.126*	140,0 *5.512*	59,0 *2.323*	84,0 *3.307*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD523-18.5-56-20R7	03080570	18,5 *0.728*	56,0 *2.205*	136,0 *5.354*	61,0 *2.402*	86,0 *3.386*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-18.5-56-25R7	03080571	18,5 *0.728*	56,0 *2.205*	142,0 *5.591*	61,0 *2.402*	86,0 *3.386*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-19-57-20R7	03080583	19,0 *0.748*	57,0 *2.244*	137,0 *5.394*	62,0 *2.441*	87,0 *3.425*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD523-19-57-25R7	03080584	19,0 *0.748*	57,0 *2.244*	143,0 *5.630*	62,0 *2.441*	87,0 *3.425*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD523-19.5-59-20R7	03080579	19,5 *0.768*	59,0 *2.323*	139,0 *5.472*	64,0 *2.520*	89,0 *3.504*	50,0 *1.969*	20,0 *0.787*	30,0 *1.181*	SPGX0602	SCGX060204	0,11 *0.004*	0,42 *0.017*
SD523-19.5-59-25R7	03080580	19,5 *0.768*	59,0 *2.323*	145,0 *5.709*	64,0 *2.520*	89,0 *3.504*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204	0,11 *0.004*	0,42 *0.017*
SD523-20-60-25R7	03080590	20,0 *0.787*	60,0 *2.362*	146,0 *5.748*	65,0 *2.559*	90,0 *3.543*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD523-20.5-62-25R7	03080586	20,5 *0.807*	62,0 *2.441*	148,0 *5.827*	67,0 *2.638*	92,0 *3.622*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204	0,04 *0.002*	0,49 *0.019*
SD523-21-63-25R7	03080599	21,0 *0.827*	63,0 *2.480*	149,0 *5.866*	68,0 *2.677*	93,0 *3.661*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD523-21.5-65-25R7	03080595	21,5 *0.846*	65,0 *2.559*	151,0 *5.945*	70,0 *2.756*	95,0 *3.740*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX060204	0,5 *0.020*	0,36 *0.014*
SD523-22-66-25R7	03080605	22,0 *0.866*	66,0 *2.598*	152,0 *5.984*	71,0 *2.795*	96,0 *3.780*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-22.5-68-25R7	03080602	22,5 *0.886*	68,0 *2.677*	154,0 *6.063*	73,0 *2.874*	98,0 *3.858*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,42 *0.017*	0,47 *0.019*
SD523-23-69-25R7	03080608	23,0 *0.906*	69,0 *2.717*	155,0 *6.102*	74,0 *2.913*	99,0 *3.898*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD523-23.5-71-25R7	03080607	23,5 *0.925*	71,0 *2.795*	157,0 *6.181*	76,0 *2.992*	101,0 *3.976*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,23 *0.009*	0,5 *0.020*
SD523-24-72-25R7	03080612	24,0 *0.945*	72,0 *2.835*	158,0 *6.220*	77,0 *3.031*	102,0 *4.016*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-24.5-74-25R7	03080611	24,5 *0.965*	74,0 *2.913*	160,0 *6.299*	79,0 *3.110*	104,0 *4.094*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25-75-32R7	03080616	25,0 *0.984*	75,0 *2.953*	165,0 *6.496*	80,0 *3.150*	105,0 *4.134*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25.5-77-32R7	03080615	25,5 *1.004*	77,0 *3.031*	167,0 *6.575*	82,0 *3.228*	107,0 *4.213*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD523-26-78-32R7	03080619	26,0 *1.024*	78,0 *3.071*	168,0 *6.614*	83,0 *3.268*	108,0 *4.252*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD523-26.5-80-32R7	03080618	26,5 *1.043*	80,0 *3.150*	170,0 *6.693*	85,0 *3.346*	110,0 *4.331*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,5 *0.020*	0,19 *0.007*
SD523-27-81-32R7	03080622	27,0 *1.063*	81,0 *3.189*	171,0 *6.732*	86,0 *3.386*	111,0 *4.370*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD523-27.5-83-32R7	03080621	27,5 *1.083*	83,0 *3.268*	173,0 *6.811*	88,0 *3.465*	113,0 *4.449*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,46 *0.018*	0,44 *0.017*
SD523-28-84-32R7	03080626	28,0 *1.102*	84,0 *3.307*	174,0 *6.850*	89,0 *3.504*	114,0 *4.488*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD523-28.5-86-32R7	03080624	28,5 *1.122*	86,0 *3.386*	176,0 *6.929*	91,0 *3.583*	116,0 *4.567*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,21 *0.008*	0,5 *0.020*
SD523-29-87-32R7	03080629	29,0 *1.142*	87,0 *3.425*	177,0 *6.969*	92,0 *3.622*	117,0 *4.606*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD523-29.5-89-32R7	03080628	29,5 *1.161*	89,0 *3.504*	179,0 *7.047*	94,0 *3.701*	119,0 *4.685*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,15 *0.006*	0,5 *0.020*
SD523-30-90-32R7	03080632	30,0 *1.181*	90,0 *3.543*	180,0 *7.087*	95,0 *3.740*	120,0 *4.724*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD523-30.5-92-32R7	03080631	30,5 *1.201*	92,0 *3.622*	182,0 *7.165*	97,0 *3.819*	122,0 *4.803*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD523-31-93-32R7	03080636	31,0 *1.220*	93,0 *3.661*	183,0 *7.205*	98,0 *3.858*	123,0 *4.843*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD523-31.5-95-32R7	03080634	31,5 *1.240*	95,0 *3.740*	185,0 *7.283*	100,0 *3.937*	125,0 *4.921*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,24 *0.009*
SD523-32-96-32R7	03080638	32,0 *1.260*	96,0 *3.780*	186,0 *7.323*	101,0 *3.976*	126,0 *4.961*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD523-32-96-40R7	03080639	32,0 *1.260*	96,0 *3.780*	194,0 *7.638*	101,0 *3.976*	126,0 *4.961*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD523-33-99-32R7	03080641	33,0 *1.299*	99,0 *3.898*	189,0 *7.441*	104,0 *4.094*	129,0 *5.079*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD523-33-99-40R7	03080642	33,0 *1.299*	99,0 *3.898*	197,0 *7.756*	104,0 *4.094*	129,0 *5.079*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD523-34-102-32R7	03080644	34,0 *1.339*	102,0 *4.016*	192,0 *7.559*	107,0 *4.213*	132,0 *5.197*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD523-34-102-40R7	03080645	34,0 *1.339*	102,0 *4.016*	200,0 *7.874*	107,0 *4.213*	132,0 *5.197*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD523-35-105-32R7	03080648	35,0 *1.378*	105,0 *4.134*	195,0 *7.677*	110,0 *4.331*	135,0 *5.315*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD523-35-105-40R7	03080649	35,0 *1.378*	105,0 *4.134*	203,0 *7.992*	110,0 *4.331*	135,0 *5.315*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD523-35.5-107-40R7	03080647	35,5 *1.398*	107,0 *4.213*	205,0 *8.071*	112,0 *4.409*	137,0 *5.394*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-36-108-32R7	03080651	36,0 *1.417*	108,0 *4.252*	198,0 *7.795*	113,0 *4.449*	138,0 *5.433*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-36-108-40R7	03080652	36,0 *1.417*	108,0 *4.252*	206,0 *8.110*	113,0 *4.449*	138,0 *5.433*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-37-111-32R7	03080653	37,0 *1.457*	111,0 *4.370*	201,0 *7.913*	116,0 *4.567*	141,0 *5.551*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-37-111-40R7	03080654	37,0 *1.457*	111,0 *4.370*	209,0 *8.228*	116,0 *4.567*	141,0 *5.551*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-38-114-32R7	03080655	38,0 *1.496*	114,0 *4.488*	204,0 *8.031*	119,0 *4.685*	144,0 *5.669*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD523-38-114-40R7	03080656	38,0 *1.496*	114,0 *4.488*	212,0 *8.346*	119,0 *4.685*	144,0 *5.669*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD523-39-117-32R7	03080658	39,0 *1.535*	117,0 *4.606*	207,0 *8.150*	122,0 *4.803*	147,0 *5.787*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-39-117-40R7	03080659	39,0 *1.535*	117,0 *4.606*	215,0 *8.465*	122,0 *4.803*	147,0 *5.787*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD523-40-120-32R7	03080661	40,0 *1.575*	120,0 *4.724*	210,0 *8.268*	125,0 *4.921*	150,0 *5.906*	60,0 *2.362*	32,0 *1.260*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*
SD523-40-120-40R7	03080662	40,0 *1.575*	120,0 *4.724*	218,0 *8.583*	125,0 *4.921*	150,0 *5.906*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*
SD523-41-123-40R7	03080665	41,0 *1.614*	123,0 *4.843*	221,0 *8.701*	128,0 *5.039*	153,0 *6.024*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD523-41.5-125-40R7	03080663	41,5 *1.634*	125,0 *4.921*	223,0 *8.780*	130,0 *5.118*	155,0 *6.102*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD523-42-126-40R7	03080666	42,0 *1.654*	126,0 *4.961*	224,0 *8.819*	131,0 *5.157*	156,0 *6.142*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD523-43-129-40R7	03080667	43,0 *1.693*	129,0 *5.079*	227,0 *8.937*	134,0 *5.276*	159,0 *6.260*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408	0,05 *0.002*	0,5 *0.020*
SD523-44-132-40R7	03080670	44,0 *1.732*	132,0 *5.197*	230,0 *9.055*	137,0 *5.394*	162,0 *6.378*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX120408	0,5 *0.020*	0,41 *0.016*
SD523-44.5-134-40R7	03080669	44,5 *1.752*	134,0 *5.276*	232,0 *9.134*	139,0 *5.472*	164,0 *6.457*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,41 *0.016*
SD523-45-135-40R7	03080672	45,0 *1.772*	135,0 *5.315*	233,0 *9.173*	140,0 *5.512*	165,0 *6.496*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,41 *0.016*
SD523-46-138-40R7	03080673	46,0 *1.811*	138,0 *5.433*	236,0 *9.291*	143,0 *5.630*	168,0 *6.614*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD523-47-141-40R7	03080675	47,0 *1.850*	141,0 *5.551*	239,0 *9.409*	146,0 *5.748*	171,0 *6.732*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD523-47.5-143-40R7	03080674	47,5 *1.870*	143,0 *5.630*	241,0 *9.488*	148,0 *5.827*	173,0 *6.811*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD523-48-144-40R7	03080676	48,0 *1.890*	144,0 *5.669*	242,0 *9.528*	149,0 *5.866*	174,0 *6.850*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,45 *0.018*	0,5 *0.020*
SD523-49-147-40R7	03080677	49,0 *1.929*	147,0 *5.787*	245,0 *9.646*	152,0 *5.984*	177,0 *6.969*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,2 *0.008*	0,5 *0.020*
SD523-50-150-40R7	03080678	50,0 *1.969*	150,0 *5.906*	248,0 *9.764*	155,0 *6.102*	180,0 *7.087*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,2 *0.008*	0,5 *0.020*
SD523-51-153-40R7	03080679	51,0 *2.008*	153,0 *6.024*	251,0 *9.882*	158,0 *6.220*	183,0 *7.205*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512	0,2 *0.008*	0,5 *0.020*
SD523-52-156-40R7	03080680	52,0 *2.047*	156,0 *6.142*	254,0 *10.000*	161,0 *6.339*	186,0 *7.323*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,42 *0.017*
SD523-53-159-40R7	03080681	53,0 *2.087*	159,0 *6.260*	257,0 *10.118*	164,0 *6.457*	189,0 *7.441*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,42 *0.017*
SD523-54-162-40R7	03080682	54,0 *2.126*	162,0 *6.378*	260,0 *10.236*	167,0 *6.575*	192,0 *7.559*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD523-55-165-40R7	03080683	55,0 *2.165*	165,0 *6.496*	263,0 *10.354*	170,0 *6.693*	195,0 *7.677*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD523-56-168-40R7	03080684	56,0 *2.205*	168,0 *6.614*	266,0 *10.472*	173,0 *6.811*	198,0 *7.795*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,5 *0.020*	0,5 *0.020*
SD523-57-171-40R7	03080685	57,0 *2.244*	171,0 *6.732*	269,0 *10.591*	176,0 *6.929*	201,0 *7.913*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512	0,39 *0.015*	0,5 *0.020*
SD523-58-174-40R7	03080686	58,0 *2.283*	174,0 *6.850*	272,0 *10.709*	179,0 *7.047*	204,0 *8.031*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX1904	SCGX150512	0,09 *0.004*	0,5 *0.020*
SD523-59-177-40R7	03080687	59,0 *2.323*	177,0 *6.969*	275,0 *10.827*	182,0 *7.165*	207,0 *8.150*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX1904	SCGX150512	0,09 *0.004*	0,5 *0.020*

Ersatzteile, im Lieferumfang enthalten

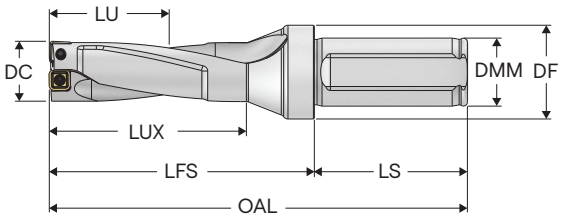
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
19,50-21,00	C02205-T07P	C02205-T07P	T07P-2
21,50-22,00	C02506-T08P	C02506-T08P	T08P-2
22,50-25,00	C02507-T08P	C03007-T08P	T08P-2
25,50-28,00	C03007-T09P	C03007-T09P	T09P-2
28,50-31,00	C03007-T09P	C03009-T09P	T09P-2
31,50-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,50-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,00-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
15,00-17,00	T00-07P09
17,50-19,00	T00-07P09
19,50-21,00	T00-07P09
21,50-22,00	T00-08P12
22,50-25,00	T00-08P12
25,50-28,00	T00-09P20
28,50-31,00	T00-09P20
31,50-40,00	T00-15P30
41,50-43,00	T00-15P30
44,00-59,00	T00-15P35

SD523

Bohrtiefe ca. 3 x D – Zoll



– Schaft ISO 9766, -7
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 307-308
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zentrums-schneide	Peripherie-schneide	Zoll -	Zoll +
SD523-0562-169-1000R7	03080485	0.562	1.686	5.117	1.883	2.867	2.250	1.000	1.378	SPGX0502	SCGX050204	0.011	0.009
SD523-0594-178-1000R7	03080486	0.594	1.780	5.211	1.977	2.961	2.250	1.000	1.378	SPGX0502	SCGX050204	0.008	0.013
SD523-0625-188-1000R7	03080488	0.625	1.880	5.311	2.077	3.061	2.250	1.000	1.378	SPGX0502	SCGX050204	0.005	0.015
SD523-0656-197-1000R7	03080490	0.656	1.970	5.401	2.167	3.151	2.250	1.000	1.378	SPGX0502	SCGX050204	0.002	0.019
SD523-0687-206-1000R7	03080493	0.687	2.030	5.461	2.227	3.211	2.250	1.000	1.378	SPGX0502	SCGX050204	0	0.020
SD523-0709-213-1000R7	03080494	0.709	2.130	5.561	2.327	3.311	2.250	1.000	1.378	SPGX0602	SCGX050204	0.013	0.008
SD523-0750-225-1000R7	03080497	0.750	2.250	5.681	2.447	3.431	2.250	1.000	1.378	SPGX0602	SCGX050204	0.004	0.017
SD523-0766-230-1000R7	03080499	0.766	2.300	5.731	2.497	3.481	2.250	1.000	1.378	SPGX0602	SCGX050204	0.001	0.020
SD523-0787-236-1000R7	03080501	0.787	2.360	5.791	2.557	3.541	2.250	1.000	1.378	SPGX0602	SCGX060204	0.003	0.018
SD523-0812-244-1000R7	03080503	0.812	2.440	5.871	2.637	3.621	2.250	1.000	1.378	SPGX0602	SCGX060204	0.001	0.020
SD523-0827-248-1000R7	03080505	0.827	2.480	5.911	2.677	3.661	2.250	1.000	1.378	SPGX0602	SCGX060204	0	0.020
SD523-0875-263-1000R7	03080507	0.875	2.630	6.061	2.827	3.811	2.250	1.000	1.378	SPGX0703	SCGX060204	0.015	0.020
SD523-0906-272-1000R7	03080509	0.906	2.720	6.151	2.917	3.901	2.250	1.000	1.378	SPGX0703	SCGX070308	0.013	0.020
SD523-0922-276-1000R7	03080512	0.922	2.760	6.191	2.957	3.941	2.250	1.000	1.378	SPGX0703	SCGX070308	0.010	0.020
SD523-0937-281-1000R7	03080514	0.937	2.810	6.241	3.007	3.991	2.250	1.000	1.378	SPGX0703	SCGX070308	0.004	0.020
SD523-0984-295-1250R7	03080516	0.984	2.950	6.506	3.147	4.131	2.375	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD523-1000-300-1250R7	03080518	1.000	3.000	6.556	3.197	4.181	2.375	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD523-1032-310-1250R7	03080521	1.032	3.100	6.656	3.297	4.281	2.375	1.250	1.654	SPGX0903	SCGX070308	0.020	0.004
SD523-1062-319-1250R7	03080522	1.062	3.190	6.746	3.387	4.371	2.375	1.250	1.654	SPGX0903	SCGX070308	0.020	0.010
SD523-1109-332-1250R7	03080525	1.109	3.320	6.876	3.517	4.501	2.375	1.250	1.654	SPGX0903	SCGX070308	0.009	0.020
SD523-1125-338-1250R7	03080526	1.125	3.380	6.936	3.577	4.561	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.008	0.020
SD523-1172-351-1250R7	03080528	1.172	3.510	7.066	3.707	4.691	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD523-1187-356-1250R7	03080530	1.187	3.560	7.116	3.757	4.741	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD523-1250-375-1500R7	03080533	1.250	3.750	7.556	3.947	4.931	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.011
SD523-1312-394-1500R7	03080535	1.312	3.940	7.746	4.137	5.121	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.020
SD523-1344-403-1500R7	03080537	1.344	4.030	7.836	4.227	5.211	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.006	0.020
SD523-1375-413-1500R7	03080539	1.375	4.130	7.936	4.327	5.311	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.009	0.020
SD523-1422-426-1500R7	03080541	1.422	4.260	8.066	4.457	5.441	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.004	0.020
SD523-1437-431-1500R7	03080542	1.437	4.310	8.116	4.507	5.491	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.004	0.020
SD523-1500-450-1500R7	03080547	1.500	4.500	8.306	4.697	5.681	2.625	1.500	1.969	SPGX12T3	SCGX11T308	0.020	0.020
SD523-1562-469-1500R7	03080550	1.562	4.690	8.496	4.887	5.871	2.625	1.500	1.969	SPGX12T3	SCGX11T308	0.010	0.020
SD523-1625-488-1500R7	03080555	1.625	4.880	8.686	5.077	6.061	2.625	1.500	1.969	SPGX12T3	SCGX120408	0.007	0.020
SD523-1687-506-1500R7	03080560	1.687	5.060	8.866	5.257	6.241	2.625	1.500	1.969	SPGX12T3	SCGX120408	0.004	0.020
SD523-1750-525-1500R7	03080565	1.750	5.250	9.056	5.447	6.431	2.625	1.500	1.969	SPGX1504	SCGX120408	0.020	0.016
SD523-1812-544-1500R7	03080572	1.812	5.440	9.246	5.637	6.621	2.625	1.500	1.969	SPGX1504	SCGX150512	0.020	0.020
SD523-1875-563-1500R7	03080577	1.875	5.630	9.436	5.827	6.811	2.625	1.500	1.969	SPGX1504	SCGX150512	0.020	0.020
SD523-1937-581-1500R7	03080581	1.937	5.810	9.616	6.007	6.991	2.625	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide	*Zoll -*	*Zoll +*
SD523-2000-600-1500R7	03080588	*2.000*	*6.000*	*9.806*	*6.197*	*7.181*	*2.625*	*1.500*	*2.337*	SPGX1504	SCGX150512	*0.008*	*0.020*
SD523-2062-619-1500R7	03080593	*2.062*	*6.190*	*9.996*	*6.387*	*7.371*	*2.625*	*1.500*	*2.337*	SPGX1904	SCGX150512	*0.020*	*0.017*
SD523-2125-638-1500R7	03080596	*2.125*	*6.380*	*10.186*	*6.577*	*7.561*	*2.625*	*1.500*	*2.337*	SPGX1904	SCGX150512	*0.020*	*0.020*
SD523-2250-675-1500R7	03080603	*2.250*	*6.750*	*10.556*	*6.947*	*7.931*	*2.625*	*1.500*	*2.337*	SPGX1904	SCGX150512	*0.013*	*0.020*
SD523-2375-713-1500R7	03080609	*2.375*	*7.130*	*10.936*	*7.327*	*8.311*	*2.625*	*1.500*	*2.480*	SPGX1904	SCGX150512	*0.004*	*0.020*

Ersatzteile, im Lieferumfang enthalten

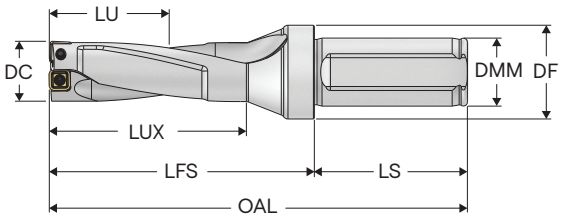
Bohrerdurchmesser (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
0.562	C02245-T07P	C02245-T07P	T07P-2
0.594-0.687	–	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787-0.827	C02506-T08P	C02205-T07P	T07P-2
0.875	–	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.109	–	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.562	–	C03508-T15P	T15P-2D
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrerdurchmesser (Zoll)	Ersatzklinge	Drehmomentschlüssel
0.562	T00-07P	T00-07P09
0.594-0.687	–	T00-07P09
0.709-0.766	–	T00-07P09
0.787-0.827	–	T00-07P09
0.875	–	T00-08P12
0.906-1.000	–	T00-08P12
1.032-1.109	–	T00-09P20
1.125-1.187	–	T00-09P20
1.250-1.562	–	T00-15P30
1.625-1.687	–	T00-15P30
1.750-2.375	–	T00-15P35

SD523

Bohrtiefe ca. 3 x D – Zoll



- Schaft ISO 9766, R7-C
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 307-308
- Zwischendurchmesser siehe MyDesign-Software
- Für statische Anwendungen

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zentrums-schneide	Peripherie-schneide	Zoll -	Zoll +
SD523-0594-178-1000R7-C	03080487	0.594	1.780	5.908	1.977	3.158	2.750	1.000	1.378	SPGX0502	SCGX050204	0.008	0.013
SD523-0625-188-1000R7-C	03080489	0.625	1.880	6.008	2.077	3.258	2.750	1.000	1.378	SPGX0502	SCGX050204	0.005	0.015
SD523-0656-197-1000R7-C	03080491	0.656	1.970	6.098	2.167	3.348	2.750	1.000	1.378	SPGX0502	SCGX050204	0.002	0.019
SD523-0687-206-1000R7-C	03080492	0.687	2.060	6.188	2.257	3.438	2.750	1.000	1.378	SPGX0502	SCGX050204	0	0.020
SD523-0709-213-1000R7-C	03080495	0.709	2.130	6.258	2.327	3.508	2.750	1.000	1.378	SPGX0602	SCGX050204	0.013	0.008
SD523-0750-225-1000R7-C	03080496	0.750	2.250	6.378	2.447	3.628	2.750	1.000	1.378	SPGX0602	SCGX050204	0.004	0.017
SD523-0766-230-1000R7-C	03080500	0.766	2.300	6.428	2.497	3.678	2.750	1.000	1.378	SPGX0602	SCGX050204	0.001	0.020
SD523-0787-236-1000R7-C	03080502	0.787	2.360	6.488	2.557	3.738	2.750	1.000	1.378	SPGX0602	SCGX060204	0.003	0.018
SD523-0812-244-1000R7-C	03080504	0.812	2.440	6.568	2.637	3.818	2.750	1.000	1.378	SPGX0602	SCGX060204	0.001	0.020
SD523-0827-248-1000R7-C	03080506	0.827	2.480	6.608	2.677	3.858	2.750	1.000	1.378	SPGX0602	SCGX060204	0	0.020
SD523-0875-263-1000R7-C	03080508	0.875	2.630	6.758	2.827	4.008	2.750	1.000	1.378	SPGX0703	SCGX060204	0.015	0.020
SD523-0906-272-1000R7-C	03080511	0.906	2.720	6.848	2.917	4.098	2.750	1.000	1.378	SPGX0703	SCGX070308	0.013	0.020
SD523-0922-276-1000R7-C	03080513	0.922	2.760	6.888	2.957	4.138	2.750	1.000	1.378	SPGX0703	SCGX070308	0.010	0.020
SD523-0937-281-1000R7-C	03080515	0.937	2.810	6.938	3.007	4.188	2.750	1.000	1.378	SPGX0703	SCGX070308	0.004	0.020
SD523-0984-295-1250R7-C	03080517	0.984	2.950	7.078	3.147	4.328	2.750	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD523-1000-300-1250R7-C	03080519	1.000	3.000	7.128	3.197	4.378	2.750	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD523-1032-310-1250R7-C	03080520	1.032	3.100	7.228	3.297	4.478	2.750	1.250	1.654	SPGX0903	SCGX070308	0.020	0.004
SD523-1062-319-1250R7-C	03080523	1.062	3.190	7.318	3.387	4.568	2.750	1.250	1.654	SPGX0903	SCGX070308	0.020	0.010
SD523-1109-332-1250R7-C	03080524	1.109	3.320	7.448	3.517	4.698	2.750	1.250	1.654	SPGX0903	SCGX070308	0.009	0.020
SD523-1125-338-1250R7-C	03080527	1.125	3.380	7.508	3.577	4.758	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.008	0.020
SD523-1172-351-1250R7-C	03080529	1.172	3.510	7.638	3.707	4.888	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD523-1187-356-1250R7-C	03080531	1.187	3.560	7.688	3.757	4.938	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD523-1250-375-1500R7-C	03080532	1.250	3.750	7.878	3.947	5.128	2.750	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.011
SD523-1312-394-1500R7-C	03080536	1.312	3.940	8.068	4.137	5.318	2.750	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.020
SD523-1344-403-1500R7-C	03080538	1.344	4.030	8.158	4.227	5.408	2.750	1.500	1.969	SPGX11T3	SCGX09T308	0.006	0.020
SD523-1375-413-1500R7-C	03080540	1.375	4.130	8.258	4.327	5.508	2.750	1.500	1.969	SPGX11T3	SCGX11T308	0.009	0.020
SD523-1422-426-1500R7-C	03080900	1.422	4.260	8.388	4.457	5.638	2.750	1.500	1.969	SPGX11T3	SCGX11T308	0.004	0.020
SD523-1437-431-1500R7-C	03080543	1.437	4.310	8.438	4.507	5.688	2.750	1.500	1.969	SPGX11T3	SCGX11T308	0.004	0.020
SD523-1500-450-1500R7-C	03080546	1.500	4.500	8.628	4.697	5.878	2.750	1.500	1.969	SPGX12T3	SCGX11T308	0.020	0.020
SD523-1562-469-1500R7-C	03080551	1.562	4.690	8.818	4.887	6.068	2.750	1.500	1.969	SPGX12T3	SCGX11T308	0.010	0.020
SD523-1625-488-1500R7-C	03080556	1.625	4.880	9.008	5.077	6.258	2.750	1.500	1.969	SPGX12T3	SCGX120408	0.007	0.020
SD523-1687-506-1500R7-C	03080561	1.687	5.060	9.188	5.257	6.438	2.750	1.500	1.969	SPGX12T3	SCGX120408	0.004	0.020
SD523-1750-525-1500R7-C	03080566	1.750	5.250	9.378	5.447	6.628	2.750	1.500	1.969	SPGX1504	SCGX120408	0.020	0.016
SD523-1812-544-1500R7-C	03080573	1.812	5.440	9.568	5.637	6.818	2.750	1.500	1.969	SPGX1504	SCGX150512	0.020	0.020
SD523-1875-563-1500R7-C	03080578	1.875	5.630	9.758	5.827	7.008	2.750	1.500	1.969	SPGX1504	SCGX150512	0.020	0.020
SD523-1937-581-1500R7-C	03080582	1.937	5.810	9.938	6.007	7.188	2.750	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide	*Zoll -*	*Zoll +*
SD523-2000-600-1500R7-C	03080589	*2.000*	*6.000*	*10.128*	*6.197*	*7.378*	*2.750*	*1.500*	*2.337*	SPGX1504	SCGX150512	*0.008*	*0.020*
SD523-2125-638-1500R7-C	03080598	*2.125*	*6.380*	*10.508*	*6.577*	*7.758*	*2.750*	*1.500*	*2.337*	SPGX1904	SCGX150512	*0.020*	*0.020*
SD523-2250-675-1500R7-C	03080604	*2.250*	*6.750*	*10.878*	*6.947*	*8.128*	*2.750*	*1.500*	*2.337*	SPGX1904	SCGX150512	*0.013*	*0.020*
SD523-2375-713-1500R7-C	03080610	*2.375*	*7.130*	*11.258*	*7.327*	*8.508*	*2.750*	*1.500*	*2.480*	SPGX1904	SCGX150512	*0.004*	*0.020*

Ersatzteile, im Lieferumfang enthalten

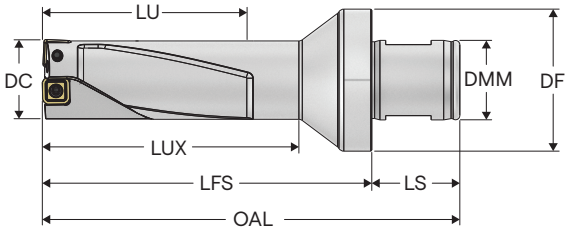
Bohrerdurchmesser (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Dichtschraube
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2	R1/4
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2	R1/4
0.787-0.827	C02205-T07P	C02205-T07P	T07P-2	R1/4
0.875	C02506-T08P	C02506-T08P	T08P-2	R1/4
0.906	C02507-T08P	C03007-T08P	T08P-2	R1/4
0.922	C02506-T08P	C03007-T08P	T08P-2	R1/4
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.032-1.109	C03007-T09P	C03007-T09P	T09P-2	R1/4
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2	R1/4
1.250-1.562	C03508-T15P	C03508-T15P	T15P-2D	R1/4
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D	R1/4
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D	R1/4

Zubehör

Bohrerdurchmesser (Zoll)	Schlauchadapter	Drehmomentschlüssel
0.594-0.687	1310	T00-07P09
0.709-0.766	1310	T00-07P09
0.787-0.827	1310	T00-07P09
0.875	1310	T00-08P12
0.906	1310	T00-08P12
0.922	1310	T00-08P12
0.937-1.000	1310	T00-08P12
1.032-1.109	1310	T00-09P20
1.125-1.187	1310	T00-09P20
1.250-1.562	1310	T00-15P30
1.625-1.687	1310	T00-15P30
1.750-2.375	1310	T00-15P35

SD523

Bohrtiefe ca. 3 x D – Metrisch/Zoll



– Mit ABS 50 kompatibler Schaft, -2
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 307-308
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-15-45-50R2	03080864	15,0 *0.591*	45,0 *1.772*	106,0 *4.173*	50,0 *1.969*	75,0 *2.953*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-15.5-47-50R2	03080865	15,5 *0.610*	47,0 *1.850*	108,0 *4.252*	52,0 *2.047*	77,0 *3.031*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD523-16-48-50R2	03080559	16,0 *0.630*	48,0 *1.890*	109,0 *4.291*	53,0 *2.087*	78,0 *3.071*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD523-16.5-50-50R2	03080866	16,5 *0.650*	50,0 *1.969*	111,0 *4.370*	55,0 *2.165*	80,0 *3.150*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD523-17-51-50R2	03080867	17,0 *0.669*	51,0 *2.008*	112,0 *4.409*	56,0 *2.205*	81,0 *3.189*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD523-17.5-53-50R2	03080564	17,5 *0.689*	53,0 *2.087*	114,0 *4.488*	58,0 *2.283*	83,0 *3.268*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD523-18-54-50R2	03080576	18,0 *0.709*	54,0 *2.126*	115,0 *4.528*	59,0 *2.323*	84,0 *3.307*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD523-18.5-56-50R2	03080868	18,5 *0.728*	56,0 *2.205*	117,0 *4.606*	61,0 *2.402*	86,0 *3.386*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-19-57-50R2	03080585	19,0 *0.748*	57,0 *2.244*	118,0 *4.646*	62,0 *2.441*	87,0 *3.425*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD523-20-60-50R2	03080591	20,0 *0.787*	60,0 *2.362*	121,0 *4.764*	65,0 *2.559*	90,0 *3.543*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD523-20.62-62-50R2	03080587	20,62 *0.812*	62,0 *2.441*	123,0 *4.843*	67,0 *2.638*	92,0 *3.622*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204	0,03 *0.001*	0,5 *0.020*
SD523-21-63-50R2	03080600	21,0 *0.827*	63,0 *2.480*	124,0 *4.882*	68,0 *2.677*	93,0 *3.661*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD523-22-66-50R2	03080606	22,0 *0.866*	66,0 *2.598*	127,0 *5.000*	71,0 *2.795*	96,0 *3.780*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*
SD523-22.23-67-50R2	03080601	22,23 *0.875*	67,0 *2.638*	128,0 *5.039*	72,0 *2.835*	97,0 *3.819*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX060204	0,39 *0.015*	0,5 *0.020*
SD523-23-69-50R2	03080869	23,0 *0.906*	69,0 *2.717*	130,0 *5.118*	74,0 *2.913*	99,0 *3.898*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD523-24-72-50R2	03080613	24,0 *0.945*	72,0 *2.835*	133,0 *5.236*	77,0 *3.031*	102,0 *4.016*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25-75-50R2	03080617	25,0 *0.984*	75,0 *2.953*	136,0 *5.354*	80,0 *3.150*	105,0 *4.134*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25.40-77-50R2	03080614	25,4 *1.000*	77,0 *3.031*	138,0 *5.433*	82,0 *3.228*	107,0 *4.213*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-26-78-50R2	03080620	26,0 *1.024*	78,0 *3.071*	139,0 *5.472*	83,0 *3.268*	108,0 *4.252*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD523-27-81-50R2	03080623	27,0 *1.063*	81,0 *3.189*	142,0 *5.591*	86,0 *3.386*	111,0 *4.370*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD523-28-84-50R2	03080627	28,0 *1.102*	84,0 *3.307*	145,0 *5.709*	89,0 *3.504*	114,0 *4.488*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD523-28.59-86-50R2	03080625	28,59 *1.126*	86,0 *3.386*	147,0 *5.787*	91,0 *3.583*	116,0 *4.567*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,21 *0.008*	0,5 *0.020*
SD523-29-87-50R2	03080630	29,0 *1.142*	87,0 *3.425*	148,0 *5.827*	92,0 *3.622*	117,0 *4.606*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD523-30-90-50R2	03080633	30,0 *1.181*	90,0 *3.543*	151,0 *5.945*	95,0 *3.740*	120,0 *4.724*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD523-31-93-50R2	03080637	31,0 *1.220*	93,0 *3.661*	154,0 *6.063*	98,0 *3.858*	123,0 *4.843*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-31.75-96-50R2	03080635	31,75 *1.250*	96,0 *3.780*	157,0 *6.181*	101,0 *3.976*	126,0 *4.961*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,28 *0.011*
SD523-32-96-50R2	03080640	32,0 *1.260*	96,0 *3.780*	157,0 *6.181*	101,0 *3.976*	126,0 *4.961*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD523-33-99-50R2	03080643	33,0 *1.299*	99,0 *3.898*	160,0 *6.299*	104,0 *4.094*	129,0 *5.079*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD523-34-102-50R2	03080646	34,0 *1.339*	102,0 *4.016*	163,0 *6.417*	107,0 *4.213*	132,0 *5.197*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD523-35-105-50R2	03080650	35,0 *1.378*	105,0 *4.134*	166,0 *6.535*	110,0 *4.331*	135,0 *5.315*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD523-36-108-50R2	03080870	36,0 *1.417*	108,0 *4.252*	169,0 *6.654*	113,0 *4.449*	138,0 *5.433*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-37-111-50R2	03080871	37,0 *1.457*	111,0 *4.370*	172,0 *6.772*	116,0 *4.567*	141,0 *5.551*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-38-114-50R2	03080657	38,0 *1.496*	114,0 *4.488*	175,0 *6.890*	119,0 *4.685*	144,0 *5.669*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD523-39-117-50R2	03080660	39,0 *1.535*	117,0 *4.606*	178,0 *7.008*	122,0 *4.803*	147,0 *5.787*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD523-40-120-50R2	03080872	40,0 *1.575*	120,0 *4.724*	181,0 *7.126*	125,0 *4.921*	150,0 *5.906*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*
SD523-41-123-50R2	03080873	41,0 *1.614*	123,0 *4.843*	184,0 *7.244*	128,0 *5.039*	153,0 *6.024*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD523-42-126-50R2	03080874	42,0 *1.654*	126,0 *4.961*	187,0 *7.362*	131,0 *5.157*	156,0 *6.142*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX120408	0,19 *0.007*	0,5 *0.020*
SD523-43-129-50R2	03080875	43,0 *1.693*	129,0 *5.079*	190,0 *7.480*	134,0 *5.276*	159,0 *6.260*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX120408	0,05 *0.002*	0,5 *0.020*
SD523-44-132-50R2	03080671	44,0 *1.732*	132,0 *5.197*	193,0 *7.598*	137,0 *5.394*	162,0 *6.378*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX1504	SCGX120408	0,5 *0.020*	0,41 *0.016*
SD523-44.45-134-50R2	03080668	44,45 *1.750*	134,0 *5.276*	195,0 *7.677*	139,0 *5.472*	164,0 *6.457*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX1504	SCGX120408	0,5 *0.020*	0,41 *0.016*

Ersatzteile, im Lieferumfang enthalten

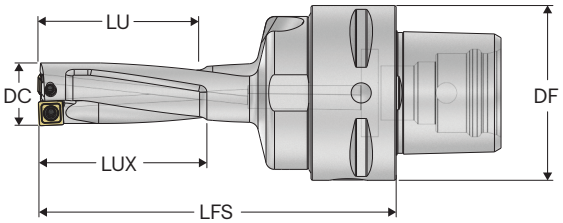
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00	C02506-T08P	C03007-T08P	T08P-2
24,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,00-44,45	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Drehmomentschlüssel
T00-07P09
T00-07P09
T00-07P09
T00-08P12
T00-08P12
T00-08P12
T00-09P20
T00-09P20
T00-15P30
T00-15P30
T00-15P35

SD523

Bohrtiefe ca. 3 x D – Metrisch/Zoll



- Seco Capto™ C4-Schaft
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 307-308
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-15-45-C4	03080920	15,0 *0.591*	45,0 *1.772*	50,0 *1.969*	82,0 *3.228*	40,0 *1.575*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-15.5-47-C4	03080921	15,5 *0.610*	47,0 *1.850*	52,0 *2.047*	84,0 *3.307*	40,0 *1.575*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD523-16-48-C4	03080922	16,0 *0.630*	48,0 *1.890*	53,0 *2.087*	86,0 *3.386*	40,0 *1.575*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD523-16.5-50-C4	03080923	16,5 *0.650*	50,0 *1.969*	55,0 *2.165*	88,0 *3.465*	40,0 *1.575*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD523-17-51-C4	03080925	17,0 *0.669*	51,0 *2.008*	56,0 *2.205*	89,0 *3.504*	40,0 *1.575*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD523-17.5-53-C4	03080926	17,5 *0.689*	53,0 *2.087*	58,0 *2.283*	92,0 *3.622*	40,0 *1.575*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD523-18-54-C4	03080927	18,0 *0.709*	54,0 *2.126*	59,0 *2.323*	93,0 *3.661*	40,0 *1.575*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD523-18.5-56-C4	03080928	18,5 *0.728*	56,0 *2.205*	61,0 *2.402*	95,0 *3.740*	40,0 *1.575*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-19-57-C4	03080929	19,0 *0.748*	57,0 *2.244*	62,0 *2.441*	96,0 *3.780*	40,0 *1.575*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD523-20-60-C4	03080930	20,0 *0.787*	60,0 *2.362*	65,0 *2.559*	101,0 *3.976*	40,0 *1.575*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD523-20.62-62-C4	03081006	20,62 *0.812*	62,0 *2.441*	67,0 *2.638*	103,0 *4.055*	40,0 *1.575*	SPGX0602	SCGX060204	0,03 *0.001*	0,5 *0.020*
SD523-21-63-C4	03080931	21,0 *0.827*	63,0 *2.480*	68,0 *2.677*	104,0 *4.094*	40,0 *1.575*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD523-22-66-C4	03080932	22,0 *0.866*	66,0 *2.598*	71,0 *2.795*	107,0 *4.213*	40,0 *1.575*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*
SD523-22.23-67-C4	03081008	22,23 *0.875*	67,0 *2.638*	72,0 *2.835*	108,0 *4.252*	40,0 *1.575*	SPGX0703	SCGX060204	0,39 *0.015*	0,5 *0.020*
SD523-23-69-C4	03080933	23,0 *0.906*	69,0 *2.717*	74,0 *2.913*	111,0 *4.370*	40,0 *1.575*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD523-24-72-C4	03080934	24,0 *0.945*	72,0 *2.835*	77,0 *3.031*	115,0 *4.528*	40,0 *1.575*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25-75-C4	03080935	25,0 *0.984*	75,0 *2.953*	80,0 *3.150*	119,0 *4.685*	40,0 *1.575*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25.4-77-C4	03081009	25,4 *1.000*	77,0 *3.031*	82,0 *3.228*	121,0 *4.764*	40,0 *1.575*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-26-78-C4	03080936	26,0 *1.024*	78,0 *3.071*	83,0 *3.268*	122,0 *4.803*	40,0 *1.575*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD523-27-81-C4	03080937	27,0 *1.063*	81,0 *3.189*	86,0 *3.386*	125,0 *4.921*	40,0 *1.575*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD523-28-84-C4	03080938	28,0 *1.102*	84,0 *3.307*	89,0 *3.504*	129,0 *5.079*	40,0 *1.575*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD523-28.59-86-C4	03081010	28,59 *1.126*	86,0 *3.386*	91,0 *3.583*	131,0 *5.157*	40,0 *1.575*	SPGX0903	SCGX09T308	0,21 *0.008*	0,5 *0.020*
SD523-29-87-C4	03080939	29,0 *1.142*	87,0 *3.425*	92,0 *3.622*	132,0 *5.197*	40,0 *1.575*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD523-30-90-C4	03080940	30,0 *1.181*	90,0 *3.543*	95,0 *3.740*	135,0 *5.315*	40,0 *1.575*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*

Ersatzteile, im Lieferumfang enthalten

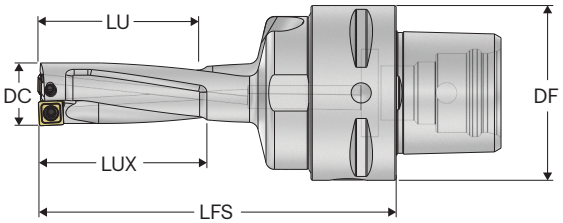
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,00-16,50	C02245-T07P	C02245-T07P	T07P-2
17,50	C02205-T07P	C02245-T07P	T07P-2
17,51	C02245-T07P	C02245-T07P	T07P-2
18,00-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-30,00	C03007-T09P	C03009-T09P	T09P-2

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
15,00-16,50	T00-07P09
17,50	T00-07P09
17,51	T00-07P09
18,00-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-30,00	T00-09P20

SD523

Bohrtiefe ca. 3 x D – Metrisch/Zoll



- Seco Capto™ C5-Schaft
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- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 307-308
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-15-45-C5	03080941	15,0 *0.591*	45,0 *1.772*	50,0 *1.969*	82,0 *3.228*	50,0 *1.969*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-15.5-47-C5	03080942	15,5 *0.610*	47,0 *1.850*	52,0 *2.047*	84,0 *3.307*	50,0 *1.969*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD523-16-48-C5	03080943	16,0 *0.630*	48,0 *1.890*	53,0 *2.087*	86,0 *3.386*	50,0 *1.969*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD523-16.5-50-C5	03080944	16,5 *0.650*	50,0 *1.969*	55,0 *2.165*	88,0 *3.465*	50,0 *1.969*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD523-17-51-C5	03080945	17,0 *0.669*	51,0 *2.008*	56,0 *2.205*	89,0 *3.504*	50,0 *1.969*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD523-17.5-53-C5	03080946	17,5 *0.689*	53,0 *2.087*	58,0 *2.283*	92,0 *3.622*	50,0 *1.969*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD523-18-54-C5	03080947	18,0 *0.709*	54,0 *2.126*	59,0 *2.323*	93,0 *3.661*	50,0 *1.969*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD523-18.5-56-C5	03080948	18,5 *0.728*	56,0 *2.205*	61,0 *2.402*	95,0 *3.740*	50,0 *1.969*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-19-57-C5	03080949	19,0 *0.748*	57,0 *2.244*	62,0 *2.441*	96,0 *3.780*	50,0 *1.969*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD523-20-60-C5	03080950	20,0 *0.787*	60,0 *2.362*	65,0 *2.559*	101,0 *3.976*	50,0 *1.969*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD523-20.62-62-C5	03081001	20,62 *0.812*	62,0 *2.441*	67,0 *2.638*	103,0 *4.055*	50,0 *1.969*	SPGX0602	SCGX060204	0,03 *0.001*	0,5 *0.020*
SD523-21-63-C5	03080951	21,0 *0.827*	63,0 *2.480*	68,0 *2.677*	104,0 *4.094*	50,0 *1.969*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD523-22-66-C5	03080952	22,0 *0.866*	66,0 *2.598*	71,0 *2.795*	107,0 *4.213*	50,0 *1.969*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*
SD523-22.23-67-C5	03081002	22,23 *0.875*	67,0 *2.638*	72,0 *2.835*	108,0 *4.252*	50,0 *1.969*	SPGX0703	SCGX060204	0,39 *0.015*	0,5 *0.020*
SD523-23-69-C5	03080953	23,0 *0.906*	69,0 *2.717*	74,0 *2.913*	111,0 *4.370*	50,0 *1.969*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD523-24-72-C5	03080954	24,0 *0.945*	72,0 *2.835*	77,0 *3.031*	115,0 *4.528*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25-75-C5	03080955	25,0 *0.984*	75,0 *2.953*	80,0 *3.150*	119,0 *4.685*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25.4-77-C5	03081003	25,4 *1.000*	77,0 *3.031*	82,0 *3.228*	121,0 *4.764*	50,0 *1.969*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-26-78-C5	03080956	26,0 *1.024*	78,0 *3.071*	83,0 *3.268*	122,0 *4.803*	50,0 *1.969*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD523-27-81-C5	03080957	27,0 *1.063*	81,0 *3.189*	86,0 *3.386*	125,0 *4.921*	50,0 *1.969*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD523-28-84-C5	03080958	28,0 *1.102*	84,0 *3.307*	89,0 *3.504*	129,0 *5.079*	50,0 *1.969*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD523-28.59-86-C5	03081004	28,59 *1.126*	86,0 *3.386*	91,0 *3.583*	131,0 *5.157*	50,0 *1.969*	SPGX0903	SCGX09T308	0,21 *0.008*	0,5 *0.020*
SD523-29-87-C5	03080959	29,0 *1.142*	87,0 *3.425*	92,0 *3.622*	132,0 *5.197*	50,0 *1.969*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD523-30-90-C5	03080960	30,0 *1.181*	90,0 *3.543*	95,0 *3.740*	135,0 *5.315*	50,0 *1.969*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD523-31-93-C5	03080961	31,0 *1.220*	93,0 *3.661*	98,0 *3.858*	138,0 *5.433*	50,0 *1.969*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-31.75-96-C5	03081005	31,75 *1.250*	96,0 *3.780*	101,0 *3.976*	142,0 *5.591*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,28 *0.011*
SD523-32-96-C5	03080962	32,0 *1.260*	96,0 *3.780*	101,0 *3.976*	142,0 *5.591*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD523-33-99-C5	03080963	33,0 *1.299*	99,0 *3.898*	104,0 *4.094*	145,0 *5.709*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD523-34-102-C5	03080964	34,0 *1.339*	102,0 *4.016*	107,0 *4.213*	148,0 *5.827*	50,0 *1.969*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD523-35-105-C5	03080965	35,0 *1.378*	105,0 *4.134*	110,0 *4.331*	151,0 *5.945*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD523-36-108-C5	03080966	36,0 *1.417*	108,0 *4.252*	113,0 *4.449*	154,0 *6.063*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-37-111-C5	03080967	37,0 *1.457*	111,0 *4.370*	116,0 *4.567*	157,0 *6.181*	50,0 *1.969*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-38-114-C5	03080968	38,0 *1.496*	114,0 *4.488*	119,0 *4.685*	160,0 *6.299*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD523-39-117-C5	03080969	39,0 *1.535*	117,0 *4.606*	122,0 *4.803*	163,0 *6.417*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD523-40-120-C5	03080970	40,0 *1.575*	120,0 *4.724*	125,0 *4.921*	166,0 *6.535*	50,0 *1.969*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*

Ersatzteile, im Lieferumfang enthalten

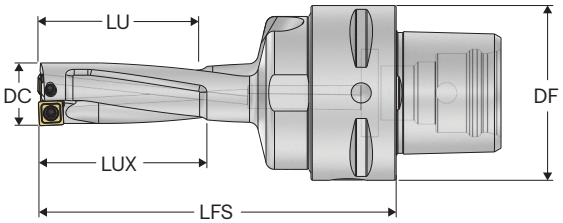
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
15,00-17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD523

Bohrtiefe ca. 3 x D – Metrisch/Zoll



- Seco Capto™ C6-Schaft
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 307-308
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-15-45-C6	03080971	15,0 *0.591*	45,0 *1.772*	50,0 *1.969*	84,0 *3.307*	63,0 *2.480*	SPGX0502	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-15.5-47-C6	03080972	15,5 *0.610*	47,0 *1.850*	52,0 *2.047*	86,0 *3.386*	63,0 *2.480*	SPGX0502	SCGX050204	0,17 *0.007*	0,36 *0.014*
SD523-16-48-C6	03080973	16,0 *0.630*	48,0 *1.890*	53,0 *2.087*	88,0 *3.465*	63,0 *2.480*	SPGX0502	SCGX050204	0,12 *0.005*	0,41 *0.016*
SD523-16.5-50-C6	03080974	16,5 *0.650*	50,0 *1.969*	55,0 *2.165*	90,0 *3.543*	63,0 *2.480*	SPGX0502	SCGX050204	0,07 *0.003*	0,46 *0.018*
SD523-17-51-C6	03080975	17,0 *0.669*	51,0 *2.008*	56,0 *2.205*	91,0 *3.583*	63,0 *2.480*	SPGX0502	SCGX050204	0,02 *0.001*	0,5 *0.020*
SD523-17.5-53-C6	03080976	17,5 *0.689*	53,0 *2.087*	58,0 *2.283*	94,0 *3.701*	63,0 *2.480*	SPGX0602	SCGX050204	0,43 *0.017*	0,1 *0.004*
SD523-18-54-C6	03080977	18,0 *0.709*	54,0 *2.126*	59,0 *2.323*	95,0 *3.740*	63,0 *2.480*	SPGX0602	SCGX050204	0,32 *0.013*	0,21 *0.008*
SD523-18.5-56-C6	03080978	18,5 *0.728*	56,0 *2.205*	61,0 *2.402*	97,0 *3.819*	63,0 *2.480*	SPGX0602	SCGX050204	0,22 *0.009*	0,31 *0.012*
SD523-19-57-C6	03080979	19,0 *0.748*	57,0 *2.244*	62,0 *2.441*	98,0 *3.858*	63,0 *2.480*	SPGX0602	SCGX050204	0,11 *0.004*	0,42 *0.017*
SD523-20-60-C6	03080980	20,0 *0.787*	60,0 *2.362*	65,0 *2.559*	103,0 *4.055*	63,0 *2.480*	SPGX0602	SCGX060204	0,07 *0.003*	0,46 *0.018*
SD523-20.62-62-C6	03081011	20,62 *0.812*	62,0 *2.441*	67,0 *2.638*	105,0 *4.134*	63,0 *2.480*	SPGX0602	SCGX060204	0,03 *0.001*	0,5 *0.020*
SD523-21-63-C6	03080981	21,0 *0.827*	63,0 *2.480*	68,0 *2.677*	106,0 *4.173*	63,0 *2.480*	SPGX0602	SCGX060204	0,01 *0*	0,5 *0.020*
SD523-22-66-C6	03080982	22,0 *0.866*	66,0 *2.598*	71,0 *2.795*	109,0 *4.291*	63,0 *2.480*	SPGX0703	SCGX060204	0,44 *0.017*	0,46 *0.018*
SD523-22.23-67-C6	03081012	22,23 *0.875*	67,0 *2.638*	72,0 *2.835*	110,0 *4.331*	63,0 *2.480*	SPGX0703	SCGX060204	0,39 *0.015*	0,5 *0.020*
SD523-23-69-C6	03080983	23,0 *0.906*	69,0 *2.717*	74,0 *2.913*	113,0 *4.449*	63,0 *2.480*	SPGX0703	SCGX070308	0,33 *0.013*	0,5 *0.020*
SD523-24-72-C6	03080984	24,0 *0.945*	72,0 *2.835*	77,0 *3.031*	117,0 *4.606*	63,0 *2.480*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25-75-C6	03080985	25,0 *0.984*	75,0 *2.953*	80,0 *3.150*	121,0 *4.764*	63,0 *2.480*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-25.4-77-C6	03081013	25,4 *1.000*	77,0 *3.031*	82,0 *3.228*	123,0 *4.843*	63,0 *2.480*	SPGX0703	SCGX070308	0,11 *0.004*	0,5 *0.020*
SD523-26-78-C6	03080986	26,0 *1.024*	78,0 *3.071*	83,0 *3.268*	124,0 *4.882*	63,0 *2.480*	SPGX0903	SCGX070308	0,5 *0.020*	0,11 *0.004*
SD523-27-81-C6	03080987	27,0 *1.063*	81,0 *3.189*	86,0 *3.386*	127,0 *5.000*	63,0 *2.480*	SPGX0903	SCGX070308	0,5 *0.020*	0,26 *0.010*
SD523-28-84-C6	03080988	28,0 *1.102*	84,0 *3.307*	89,0 *3.504*	131,0 *5.157*	63,0 *2.480*	SPGX0903	SCGX070308	0,28 *0.011*	0,5 *0.020*
SD523-28.59-86-C6	03081014	28,59 *1.126*	86,0 *3.386*	91,0 *3.583*	133,0 *5.236*	63,0 *2.480*	SPGX0903	SCGX09T308	0,21 *0.008*	0,5 *0.020*
SD523-29-87-C6	03080989	29,0 *1.142*	87,0 *3.425*	92,0 *3.622*	134,0 *5.276*	63,0 *2.480*	SPGX0903	SCGX09T308	0,18 *0.007*	0,5 *0.020*
SD523-30-90-C6	03080990	30,0 *1.181*	90,0 *3.543*	95,0 *3.740*	137,0 *5.394*	63,0 *2.480*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*
SD523-31-93-C6	03080991	31,0 *1.220*	93,0 *3.661*	98,0 *3.858*	140,0 *5.512*	63,0 *2.480*	SPGX0903	SCGX09T308	0,12 *0.005*	0,5 *0.020*

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Mittenversatz	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-31.75-96-C6	03081015	31,75 *1.250*	96,0 *3.780*	101,0 *3.976*	144,0 *5.669*	63,0 *2.480*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,28 *0.011*
SD523-32-96-C6	03080992	32,0 *1.260*	96,0 *3.780*	101,0 *3.976*	144,0 *5.669*	63,0 *2.480*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,31 *0.012*
SD523-33-99-C6	03080993	33,0 *1.299*	99,0 *3.898*	104,0 *4.094*	147,0 *5.787*	63,0 *2.480*	SPGX11T3	SCGX09T308	0,5 *0.020*	0,46 *0.018*
SD523-34-102-C6	03080994	34,0 *1.339*	102,0 *4.016*	107,0 *4.213*	150,0 *5.906*	63,0 *2.480*	SPGX11T3	SCGX09T308	0,22 *0.009*	0,5 *0.020*
SD523-35-105-C6	03080995	35,0 *1.378*	105,0 *4.134*	110,0 *4.331*	153,0 *6.024*	63,0 *2.480*	SPGX11T3	SCGX11T308	0,22 *0.009*	0,5 *0.020*
SD523-36-108-C6	03080996	36,0 *1.417*	108,0 *4.252*	113,0 *4.449*	156,0 *6.142*	63,0 *2.480*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-37-111-C6	03080997	37,0 *1.457*	111,0 *4.370*	116,0 *4.567*	159,0 *6.260*	63,0 *2.480*	SPGX11T3	SCGX11T308	0,09 *0.004*	0,5 *0.020*
SD523-38-114-C6	03080998	38,0 *1.496*	114,0 *4.488*	119,0 *4.685*	162,0 *6.378*	63,0 *2.480*	SPGX12T3	SCGX11T308	0,5 *0.020*	0,5 *0.020*
SD523-39-117-C6	03080999	39,0 *1.535*	117,0 *4.606*	122,0 *4.803*	165,0 *6.496*	63,0 *2.480*	SPGX12T3	SCGX11T308	0,39 *0.015*	0,5 *0.020*
SD523-40-120-C6	03081000	40,0 *1.575*	120,0 *4.724*	125,0 *4.921*	168,0 *6.614*	63,0 *2.480*	SPGX12T3	SCGX11T308	0,19 *0.007*	0,5 *0.020*

Ersatzteile, im Lieferumfang enthalten

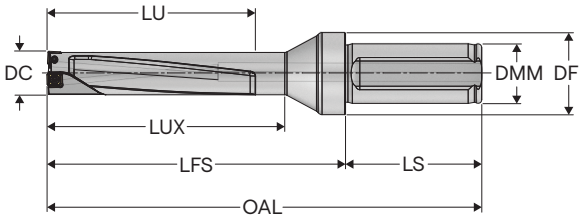
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
15,50-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
15,50-17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,00	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD524

Bohrtiefe ca. 4 x D – Metrisch/Zoll



– Schaft ISO 9766, -7
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 309, 310
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-17-68-25R7	03080330	17,0 *0.669*	68,0 *2.677*	154,0 *6.063*	73,0 *2.874*	98,0 *3.858*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0502	SCGX050204
SD524-17.5-70-25R7	03080326	17,5 *0.689*	70,0 *2.756*	156,0 *6.142*	75,0 *2.953*	100,0 *3.937*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204
SD524-18-72-25R7	03080333	18,0 *0.709*	72,0 *2.835*	158,0 *6.220*	77,0 *3.031*	102,0 *4.016*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204
SD524-18.5-74-25R7	03080331	18,5 *0.728*	74,0 *2.913*	160,0 *6.299*	79,0 *3.110*	104,0 *4.094*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204
SD524-19-76-25R7	03080336	19,0 *0.748*	76,0 *2.992*	162,0 *6.378*	81,0 *3.189*	106,0 *4.173*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204
SD524-20-80-25R7	03080340	20,0 *0.787*	80,0 *3.150*	166,0 *6.535*	85,0 *3.346*	110,0 *4.331*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204
SD524-21-84-25R7	03080344	21,0 *0.827*	84,0 *3.307*	170,0 *6.693*	89,0 *3.504*	114,0 *4.488*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204
SD524-22-88-25R7	03080348	22,0 *0.866*	88,0 *3.465*	174,0 *6.850*	93,0 *3.661*	118,0 *4.646*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX060204
SD524-23-92-25R7	03080351	23,0 *0.906*	92,0 *3.622*	178,0 *7.008*	97,0 *3.819*	122,0 *4.803*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308
SD524-24-96-25R7	03080352	24,0 *0.945*	96,0 *3.780*	182,0 *7.165*	101,0 *3.976*	126,0 *4.961*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308
SD524-25-100-32R7	03080353	25,0 *0.984*	100,0 *3.937*	190,0 *7.480*	105,0 *4.134*	130,0 *5.118*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0703	SCGX070308
SD524-26-104-32R7	03080354	26,0 *1.024*	104,0 *4.094*	194,0 *7.638*	109,0 *4.291*	134,0 *5.276*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308
SD524-27-108-32R7	03080355	27,0 *1.063*	108,0 *4.252*	198,0 *7.795*	113,0 *4.449*	138,0 *5.433*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308
SD524-28-112-32R7	03080356	28,0 *1.102*	112,0 *4.409*	202,0 *7.953*	117,0 *4.606*	142,0 *5.591*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308
SD524-29-116-32R7	03080357	29,0 *1.142*	116,0 *4.567*	206,0 *8.110*	121,0 *4.764*	146,0 *5.748*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308
SD524-30-120-32R7	03080358	30,0 *1.181*	120,0 *4.724*	210,0 *8.268*	125,0 *4.921*	150,0 *5.906*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308
SD524-31-124-32R7	03080360	31,0 *1.220*	124,0 *4.882*	214,0 *8.425*	129,0 *5.079*	154,0 *6.063*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308
SD524-32-128-40R7	03080361	32,0 *1.260*	128,0 *5.039*	226,0 *8.898*	133,0 *5.236*	158,0 *6.220*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-33-132-40R7	03080362	33,0 *1.299*	132,0 *5.197*	230,0 *9.055*	137,0 *5.394*	162,0 *6.378*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-34-136-40R7	03080363	34,0 *1.339*	136,0 *5.354*	234,0 *9.213*	141,0 *5.551*	166,0 *6.535*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-35-140-40R7	03080364	35,0 *1.378*	140,0 *5.512*	238,0 *9.370*	145,0 *5.709*	170,0 *6.693*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-36-144-40R7	03080365	36,0 *1.417*	144,0 *5.669*	242,0 *9.528*	149,0 *5.866*	174,0 *6.850*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-37-148-40R7	03080366	37,0 *1.457*	148,0 *5.827*	246,0 *9.685*	153,0 *6.024*	178,0 *7.008*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-38-152-40R7	03080367	38,0 *1.496*	152,0 *5.984*	250,0 *9.843*	157,0 *6.181*	182,0 *7.165*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-39-156-40R7	03080368	39,0 *1.535*	156,0 *6.142*	254,0 *10.000*	161,0 *6.339*	186,0 *7.323*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-40-160-40R7	03080369	40,0 *1.575*	160,0 *6.299*	258,0 *10.157*	165,0 *6.496*	190,0 *7.480*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-41-164-40R7	03080370	41,0 *1.614*	164,0 *6.457*	262,0 *10.315*	169,0 *6.654*	194,0 *7.638*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408
SD524-42-168-40R7	03080371	42,0 *1.654*	168,0 *6.614*	266,0 *10.472*	173,0 *6.811*	198,0 *7.795*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408
SD524-43-172-40R7	03080372	43,0 *1.693*	172,0 *6.772*	270,0 *10.630*	177,0 *6.969*	202,0 *7.953*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408
SD524-44-176-40R7	03080373	44,0 *1.732*	176,0 *6.929*	274,0 *10.787*	181,0 *7.126*	206,0 *8.110*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX120408
SD524-45-180-40R7	03080374	45,0 *1.772*	180,0 *7.087*	278,0 *10.945*	185,0 *7.283*	210,0 *8.268*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512
SD524-46-184-40R7	03080375	46,0 *1.811*	184,0 *7.244*	282,0 *11.102*	189,0 *7.441*	214,0 *8.425*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512
SD524-47-188-40R7	03080376	47,0 *1.850*	188,0 *7.402*	286,0 *11.260*	193,0 *7.598*	218,0 *8.583*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512
SD524-48-192-40R7	03080377	48,0 *1.890*	192,0 *7.559*	290,0 *11.417*	197,0 *7.756*	222,0 *8.740*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512
SD524-49-196-40R7	03080378	49,0 *1.929*	196,0 *7.717*	294,0 *11.575*	201,0 *7.913*	226,0 *8.898*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512
SD524-50-200-40R7	03080379	50,0 *1.969*	200,0 *7.874*	298,0 *11.732*	205,0 *8.071*	230,0 *9.055*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512
SD524-51-204-40R7	03080380	51,0 *2.008*	204,0 *8.031*	302,0 *11.890*	209,0 *8.228*	234,0 *9.213*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1504	SCGX150512
SD524-52-208-40R7	03080381	52,0 *2.047*	208,0 *8.189*	306,0 *12.047*	213,0 *8.386*	238,0 *9.370*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512
SD524-53-212-40R7	03080382	53,0 *2.087*	212,0 *8.346*	310,0 *12.205*	217,0 *8.543*	242,0 *9.528*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512
SD524-54-216-40R7	03080383	54,0 *2.126*	216,0 *8.504*	314,0 *12.362*	221,0 *8.701*	246,0 *9.685*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512
SD524-55-220-40R7	03080384	55,0 *2.165*	220,0 *8.661*	318,0 *12.520*	225,0 *8.858*	250,0 *9.843*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512
SD524-56-224-40R7	03080385	56,0 *2.205*	224,0 *8.819*	322,0 *12.677*	229,0 *9.016*	254,0 *10.000*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512
SD524-57-228-40R7	03080386	57,0 *2.244*	228,0 *8.976*	326,0 *12.835*	233,0 *9.173*	258,0 *10.157*	68,0 *2.677*	40,0 *1.575*	59,35 *2.337*	SPGX1904	SCGX150512
SD524-58-232-40R7	03080387	58,0 *2.283*	232,0 *9.134*	330,0 *12.992*	237,0 *9.331*	262,0 *10.315*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX1904	SCGX150512
SD524-59-236-40R7	03080388	59,0 *2.323*	236,0 *9.291*	334,0 *13.150*	241,0 *9.488*	266,0 *10.472*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX1904	SCGX150512

Ersatzteile, im Lieferumfang enthalten

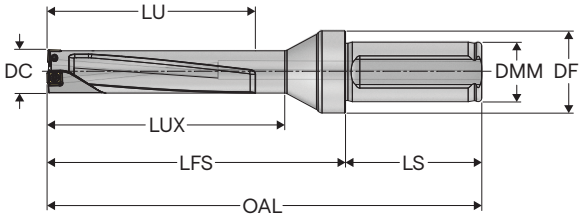
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,76	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
29,00-31,00	C03007-T09P	C03009-T09P	T09P-2
32,00-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,00-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Drehmomentschlüssel
T00-07P09
T00-07P09
T00-07P09
T00-08P12
T00-08P12
T00-09P20
T00-09P20
T00-15P30
T00-15P30
T00-15P35

SD524

Bohrtiefe ca. 4 x D – Zoll



- Schaft ISO 9766, R7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 309, 310
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-0594-238-1000R7	03080280	0.594	2.380	5.811	2.577	3.561	2.250	1.000	1.378	SPGX0502	SCGX050204
SD524-0625-250-1000R7	03080281	0.625	2.500	5.931	2.697	3.681	2.250	1.000	1.378	SPGX0502	SCGX050204
SD524-0656-262-1000R7	03080283	0.656	2.620	6.051	2.817	3.801	2.250	1.000	1.378	SPGX0502	SCGX050204
SD524-0687-275-1000R7	03080285	0.687	2.750	6.181	2.947	3.931	2.250	1.000	1.378	SPGX0502	SCGX050204
SD524-0709-284-1000R7	03080286	0.709	2.840	6.271	3.037	4.021	2.250	1.000	1.378	SPGX0602	SCGX050204
SD524-0750-300-1000R7	03080288	0.750	3.000	6.431	3.197	4.181	2.250	1.000	1.378	SPGX0602	SCGX050204
SD524-0766-306-1000R7	03080289	0.766	3.060	6.491	3.257	4.241	2.250	1.000	1.378	SPGX0602	SCGX050204
SD524-0787-315-1000R7	03080290	0.787	3.150	6.581	3.347	4.331	2.250	1.000	1.378	SPGX0602	SCGX060204
SD524-0812-325-1000R7	03080292	0.812	3.250	6.681	3.447	4.431	2.250	1.000	1.378	SPGX0602	SCGX060204
SD524-0827-331-1000R7	03080294	0.827	3.310	6.741	3.507	4.491	2.250	1.000	1.378	SPGX0602	SCGX060204
SD524-0875-350-1000R7	03080295	0.875	3.500	6.931	3.697	4.681	2.250	1.000	1.378	SPGX0703	SCGX060204
SD524-0906-362-1000R7	03080297	0.906	3.620	7.051	3.817	4.801	2.250	1.000	1.378	SPGX0703	SCGX070308
SD524-0922-369-1000R7	03080298	0.922	3.690	7.121	3.887	4.871	2.250	1.000	1.378	SPGX0703	SCGX070308
SD524-0937-375-1000R7	03080299	0.937	3.750	7.181	3.947	4.931	2.250	1.000	1.378	SPGX0703	SCGX070308
SD524-0984-394-1250R7	03080301	0.984	3.940	7.496	4.137	5.121	2.375	1.250	1.654	SPGX0703	SCGX070308
SD524-1000-400-1250R7	03080302	1.000	4.000	7.556	4.197	5.181	2.375	1.250	1.654	SPGX0703	SCGX070308
SD524-1032-413-1250R7	03080304	1.032	4.130	7.686	4.327	5.311	2.375	1.250	1.654	SPGX0903	SCGX070308
SD524-1062-425-1250R7	03080305	1.062	4.250	7.806	4.447	5.431	2.375	1.250	1.654	SPGX0903	SCGX070308
SD524-1109-443-1250R7	03080307	1.109	4.430	7.986	4.627	5.611	2.375	1.250	1.654	SPGX0903	SCGX070308
SD524-1125-450-1250R7	03080308	1.125	4.500	8.056	4.697	5.681	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD524-1172-469-1250R7	03080310	1.172	4.690	8.246	4.887	5.871	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD524-1187-475-1250R7	03080311	1.187	4.750	8.306	4.947	5.931	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD524-1250-500-1500R7	03080314	1.250	5.000	8.806	5.197	6.181	2.625	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1312-525-1500R7	03080315	1.312	5.250	9.056	5.447	6.431	2.625	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1344-538-1500R7	03080317	1.344	5.380	9.186	5.577	6.561	2.625	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1375-550-1500R7	03080318	1.375	5.500	9.306	5.697	6.681	2.625	1.500	1.969	SPGX11T3	SCGX11T308
SD524-1437-575-1500R7	03080320	1.437	5.750	9.556	5.947	6.931	2.625	1.500	1.969	SPGX11T3	SCGX11T308
SD524-1500-600-1500R7	03080322	1.500	6.000	9.806	6.197	7.181	2.625	1.500	1.969	SPGX12T3	SCGX11T308
SD524-1562-625-1500R7	03080323	1.562	6.250	10.056	6.447	7.431	2.625	1.500	1.969	SPGX12T3	SCGX11T308
SD524-1625-650-1500R7	03080324	1.625	6.500	10.306	6.697	7.681	2.625	1.500	1.969	SPGX12T3	SCGX120408
SD524-1687-675-1500R7	03080325	1.687	6.750	10.556	6.947	7.931	2.625	1.500	1.969	SPGX12T3	SCGX120408
SD524-1750-700-1500R7	03080328	1.750	7.000	10.806	7.197	8.181	2.625	1.500	1.969	SPGX1504	SCGX120408
SD524-1812-725-1500R7	03080332	1.812	7.250	11.056	7.447	8.431	2.625	1.500	1.969	SPGX1504	SCGX150512
SD524-1875-750-1500R7	03080334	1.875	7.500	11.306	7.697	8.681	2.625	1.500	1.969	SPGX1504	SCGX150512
SD524-1937-775-1500R7	03080335	1.937	7.750	11.556	7.947	8.931	2.625	1.500	2.337	SPGX1504	SCGX150512
SD524-2000-800-1500R7	03080337	2.000	8.000	11.806	8.197	9.181	2.625	1.500	2.337	SPGX1504	SCGX150512
SD524-2062-825-1500R7	03080339	2.062	8.250	12.056	8.447	9.431	2.625	1.500	2.337	SPGX1904	SCGX150512
SD524-2125-850-1500R7	03080342	2.125	8.500	12.306	8.697	9.681	2.625	1.500	2.337	SPGX1904	SCGX150512

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-2250-900-1500R7	03080346	2.250	9.000	12.806	9.197	10.181	2.625	1.500	2.337	SPGX1904	SCGX150512
SD524-2375-950-1500R7	03080349	2.375	9.500	13.306	9.697	10.681	2.625	1.500	2.480	SPGX1904	SCGX150512

Ersatzteile, im Lieferumfang enthalten

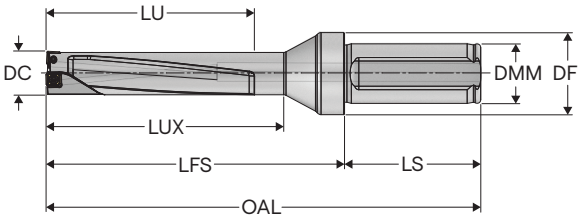
Bohrerdurchmesser (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787-0.827	C02205-T07P	C02205-T07P	T07P-2
0.875-0.905	C02506-T08P	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.109	C03007-T09P	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.562	C03508-T15P	C03508-T15P	T15P-2D
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrerdurchmesser (Zoll)	Drehmomentschlüssel
0.594-0.687	T00-07P09
0.709-0.766	T00-07P09
0.787-0.827	T00-07P09
0.875-0.905	T00-08P12
0.906-1.000	T00-08P12
1.032-1.109	T00-09P20
1.125-1.187	T00-09P20
1.250-1.562	T00-15P30
1.625-1.687	T00-15P30
1.750-2.375	T00-15P35

SD524

Bohrtiefe ca. 4 x D – Zoll



- Schaft ISO 9766, R7-C
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 309, 310
- Zwischendurchmesser siehe MyDesign-Software
- Für statische Anwendungen

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-0625-250-1000R7-C	03080282	0.625	2.500	6.628	2.697	3.878	2.750	1.000	1.378	SPGX0502	SCGX050204
SD524-0687-275-1000R7-C	03080284	0.687	2.750	6.878	2.947	4.128	2.750	1.000	1.378	SCGX0502	SCGX050204
SD524-0750-300-1000R7-C	03080287	0.750	3.000	7.128	3.197	4.378	2.750	1.000	1.378	SPGX0602	SCGX050204
SD524-0812-325-1000R7-C	03080293	0.812	3.250	7.378	3.447	4.628	2.750	1.000	1.378	SPGX0602	SCGX060204
SD524-0875-350-1000R7-C	03080296	0.875	3.500	7.628	3.697	4.878	2.750	1.000	1.378	SPGX0703	SCGX060204
SD524-0937-375-1000R7-C	03080300	0.937	3.750	7.878	3.947	5.128	2.750	1.000	1.378	SPGX0703	SCGX070308
SD524-1000-400-1250R7-C	03080303	1.000	4.000	8.128	4.197	5.378	2.750	1.250	1.654	SPGX0703	SCGX070308
SD524-1062-425-1250R7-C	03080306	1.062	4.250	8.378	4.447	5.628	2.750	1.250	1.654	SPGX0903	SCGX070308
SD524-1125-450-1250R7-C	03080309	1.125	4.500	8.628	4.697	5.878	2.750	1.250	1.654	SPGX0903	SCGX09T308
SD524-1187-475-1250R7-C	03080312	1.187	4.750	8.878	4.947	6.128	2.750	1.250	1.654	SPGX0903	SCGX09T308
SD524-1250-500-1500R7-C	03080313	1.250	5.000	9.128	5.197	6.378	2.750	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1312-525-1500R7-C	03080316	1.312	5.250	9.378	5.447	6.628	2.750	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1375-550-1500R7-C	03080319	1.375	5.500	9.628	5.697	6.878	2.750	1.500	1.969	SPGX11T3	SCGX11T308
SD524-1500-600-1500R7-C	03080321	1.500	6.000	10.128	6.197	7.378	2.750	1.500	1.969	SPGX12T3	SCGX11T308
SD524-1750-700-1500R7-C	03080329	1.750	7.000	11.128	7.197	8.378	2.750	1.500	1.969	SPGX1504	SCGX120408
SD524-2000-800-1500R7-C	03080338	2.000	8.000	12.128	8.197	9.378	2.750	1.500	2.337	SPGX1504	SCGX150512
SD524-2125-850-1500R7-C	03080343	2.125	8.500	12.628	8.697	9.878	2.750	1.500	2.337	SPGX1904	SCGX150512
SD524-2250-900-1500R7-C	03080347	2.250	9.000	13.128	9.197	10.378	2.750	1.500	2.337	SPGX1904	SCGX150512
SD524-2375-950-1500R7-C	03080350	2.375	9.500	13.628	9.697	10.878	2.750	1.500	2.480	SPGX1904	SCGX150512

Ersatzteile, im Lieferumfang enthalten

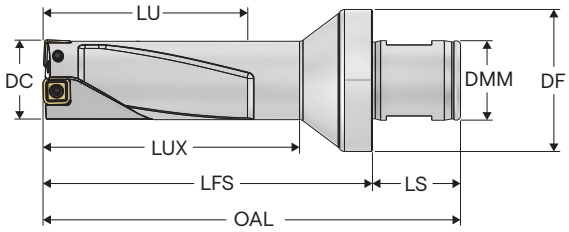
Bohrerdurch-messer (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Dichtschraube
0.625-0.687	C02245-T07P	C02245-T07P	T07P-2	R1/4
0.750	C02205-T07P	C02245-T07P	T07P-2	R1/4
0.812	C02205-T07P	C02205-T07P	T07P-2	R1/4
0.875	C02506-T08P	C02506-T08P	T08P-2	R1/4
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.062	C03007-T09P	C03007-T09P	T09P-2	R1/4
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2	R1/4
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D	R1/4
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D	R1/4

Zubehör

Schlauchadapter	Drehmomentschlüssel
1310	T00-07P09
1310	T00-07P09
1310	T00-07P09
1310	T00-08P12
1310	T00-08P12
1310	T00-09P20
1310	T00-09P20
1310	T00-15P30
1310	T00-15P35

SD524

Bohrtiefe ca. 4 x D – Metrisch/Zoll



- Mit ABS 50 kompatibler Schaft, -2
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 309, 310
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-17-68-50R2	03080208	17,0 *0.669*	68,0 *2.677*	129,0 *5.079*	73,0 *2.874*	98,0 *3.858*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0502	SCGX050204
SD524-17.5-70-50R2	03080327	17,5 *0.689*	70,0 *2.756*	131,0 *5.157*	75,0 *2.953*	100,0 *3.937*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-18-72-50R2	03080209	18,0 *0.709*	72,0 *2.835*	133,0 *5.236*	77,0 *3.031*	102,0 *4.016*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-18.5-74-50R2	03080210	18,5 *0.728*	74,0 *2.913*	135,0 *5.315*	79,0 *3.110*	104,0 *4.094*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-19-76-50R2	03080422	19,0 *0.748*	76,0 *2.992*	137,0 *5.394*	81,0 *3.189*	106,0 *4.173*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-20-80-50R2	03080341	20,0 *0.787*	80,0 *3.150*	141,0 *5.551*	85,0 *3.346*	110,0 *4.331*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204
SD524-20.62-83-50R2	03080215	20,62 *0.812*	83,0 *3.268*	144,0 *5.669*	88,0 *3.465*	113,0 *4.449*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204
SD524-21-84-50R2	03080345	21,0 *0.827*	84,0 *3.307*	145,0 *5.709*	89,0 *3.504*	114,0 *4.488*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0602	SCGX060204
SD524-22-88-50R2	03080193	22,0 *0.866*	88,0 *3.465*	149,0 *5.866*	93,0 *3.661*	118,0 *4.646*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX060204
SD524-22.23-89-50R2	03080216	22,23 *0.875*	89,0 *3.504*	150,0 *5.906*	94,0 *3.701*	119,0 *4.685*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX060204
SD524-23-92-50R2	03080194	23,0 *0.906*	92,0 *3.622*	153,0 *6.024*	97,0 *3.819*	122,0 *4.803*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-24-96-50R2	03080195	24,0 *0.945*	96,0 *3.780*	157,0 *6.181*	101,0 *3.976*	126,0 *4.961*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-25-100-50R2	03080196	25,0 *0.984*	100,0 *3.937*	161,0 *6.339*	105,0 *4.134*	130,0 *5.118*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-25.4-102-50R2	03080217	25,4 *1.000*	102,0 *4.016*	163,0 *6.417*	107,0 *4.213*	132,0 *5.197*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-26-104-50R2	03080423	26,0 *1.024*	104,0 *4.094*	165,0 *6.496*	109,0 *4.291*	134,0 *5.276*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-27-108-50R2	03080197	27,0 *1.063*	108,0 *4.252*	169,0 *6.654*	113,0 *4.449*	138,0 *5.433*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-28-112-50R2	03080424	28,0 *1.102*	112,0 *4.409*	173,0 *6.811*	117,0 *4.606*	142,0 *5.591*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-28.59-115-50R2	03080218	28,59 *1.126*	115,0 *4.528*	176,0 *6.929*	120,0 *4.724*	145,0 *5.709*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-29-116-50R2	03080198	29,0 *1.142*	116,0 *4.567*	177,0 *6.969*	121,0 *4.764*	146,0 *5.748*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308
SD524-30-120-50R2	03080199	30,0 *1.181*	120,0 *4.724*	181,0 *7.126*	125,0 *4.921*	150,0 *5.906*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308
SD524-31-124-50R2	03080200	31,0 *1.220*	124,0 *4.882*	185,0 *7.283*	129,0 *5.079*	154,0 *6.063*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX0903	SCGX09T308
SD524-32-128-50R2	03080425	32,0 *1.260*	128,0 *5.039*	189,0 *7.441*	133,0 *5.236*	158,0 *6.220*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-33-132-50R2	03080201	33,0 *1.299*	132,0 *5.197*	193,0 *7.598*	137,0 *5.394*	162,0 *6.378*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-34-136-50R2	03080207	34,0 *1.339*	136,0 *5.354*	197,0 *7.756*	141,0 *5.551*	166,0 *6.535*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-35-140-50R2	03080202	35,0 *1.378*	140,0 *5.512*	201,0 *7.913*	145,0 *5.709*	170,0 *6.693*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-36-144-50R2	03080203	36,0 *1.417*	144,0 *5.669*	205,0 *8.071*	149,0 *5.866*	174,0 *6.850*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-37-148-50R2	03080204	37,0 *1.457*	148,0 *5.827*	209,0 *8.228*	153,0 *6.024*	178,0 *7.008*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-38-152-50R2	03080426	38,0 *1.496*	152,0 *5.984*	213,0 *8.386*	157,0 *6.181*	182,0 *7.165*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-39-156-50R2	03080205	39,0 *1.535*	156,0 *6.142*	217,0 *8.543*	161,0 *6.339*	186,0 *7.323*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-40-160-50R2	03080206	40,0 *1.575*	160,0 *6.299*	221,0 *8.701*	165,0 *6.496*	190,0 *7.480*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308

Ersatzteile, im Lieferumfang enthalten

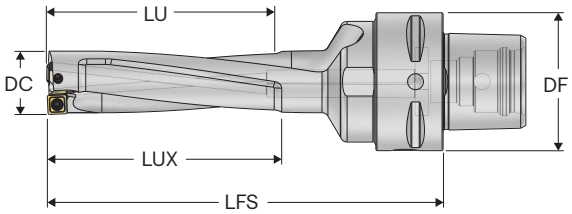
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD524

Bohrtiefe ca. 4 x D – Metrisch/Zoll



–Seco Capto™ C4-Schaft
–Kühlmittelzufuhr
–Informationen zu Wendeplatten siehe Seite(n) 301-304
–Schnittdaten siehe Seite(n) 309, 310
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-17-68-C4	03080219	17,0 *0.669*	68,0 *2.677*	73,0 *2.874*	106,0 *4.173*	40,0 *1.575*	SPGX0502	SCGX050204
SD524-17.5-70-C4	03080220	17,5 *0.689*	70,0 *2.756*	75,0 *2.953*	109,0 *4.291*	40,0 *1.575*	SPGX0602	SCGX050204
SD524-18-72-C4	03080221	18,0 *0.709*	72,0 *2.835*	77,0 *3.031*	111,0 *4.370*	40,0 *1.575*	SPGX0602	SCGX050204
SD524-18.5-74-C4	03080222	18,5 *0.728*	74,0 *2.913*	79,0 *3.110*	113,0 *4.449*	40,0 *1.575*	SPGX0602	SCGX050204
SD524-19-76-C4	03080223	19,0 *0.748*	76,0 *2.992*	81,0 *3.189*	115,0 *4.528*	40,0 *1.575*	SPGX0602	SCGX050204
SD524-20-80-C4	03080224	20,0 *0.787*	80,0 *3.150*	85,0 *3.346*	121,0 *4.764*	40,0 *1.575*	SPGX0602	SCGX060204
SD524-20.62-83-C4	03080413	20,62 *0.812*	83,0 *3.268*	88,0 *3.465*	124,0 *4.882*	40,0 *1.575*	SPGX0602	SCGX060204
SD524-21-84-C4	03080225	21,0 *0.827*	84,0 *3.307*	89,0 *3.504*	125,0 *4.921*	40,0 *1.575*	SPGX0602	SCGX060204
SD524-22-88-C4	03080226	22,0 *0.866*	88,0 *3.465*	93,0 *3.661*	129,0 *5.079*	40,0 *1.575*	SPGX0703	SCGX060204
SD524-22.23-89-C4	03080414	22,23 *0.875*	89,0 *3.504*	94,0 *3.701*	130,0 *5.118*	40,0 *1.575*	SPGX0703	SCGX060204
SD524-23-92-C4	03080227	23,0 *0.906*	92,0 *3.622*	97,0 *3.819*	134,0 *5.276*	40,0 *1.575*	SPGX0703	SCGX070308
SD524-24-96-C4	03080228	24,0 *0.945*	96,0 *3.780*	101,0 *3.976*	139,0 *5.472*	40,0 *1.575*	SPGX0703	SCGX070308
SD524-25-100-C4	03080229	25,0 *0.984*	100,0 *3.937*	105,0 *4.134*	144,0 *5.669*	40,0 *1.575*	SPGX0703	SCGX070308
SD524-25.4-102-C4	03080415	25,4 *1.000*	102,0 *4.016*	107,0 *4.213*	146,0 *5.748*	40,0 *1.575*	SPGX0703	SCGX070308
SD524-26-104-C4	03080230	26,0 *1.024*	104,0 *4.094*	109,0 *4.291*	148,0 *5.827*	40,0 *1.575*	SPGX0903	SCGX070308
SD524-27-108-C4	03080231	27,0 *1.063*	108,0 *4.252*	113,0 *4.449*	152,0 *5.984*	40,0 *1.575*	SPGX0903	SCGX070308
SD524-28-112-C4	03080232	28,0 *1.102*	112,0 *4.409*	117,0 *4.606*	157,0 *6.181*	40,0 *1.575*	SPGX0903	SCGX070308
SD524-28.59-115-C4	03080416	28,59 *1.126*	115,0 *4.528*	120,0 *4.724*	160,0 *6.299*	40,0 *1.575*	SPGX0903	SCGX070308
SD524-29-116-C4	03080233	29,0 *1.142*	116,0 *4.567*	121,0 *4.764*	161,0 *6.339*	40,0 *1.575*	SPGX0903	SCGX09T308
SD524-30-120-C4	03080234	30,0 *1.181*	120,0 *4.724*	125,0 *4.921*	165,0 *6.496*	40,0 *1.575*	SPGX0903	SCGX09T308

Ersatzteile, im Lieferumfang enthalten

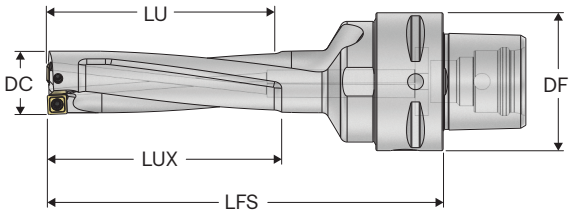
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-30,00	C03007-T09P	C03009-T09P	T09P-2

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-30,00	T00-09P20

SD524

Bohrtiefe ca. 4 x D – Metrisch/Zoll



– Seco Capto™ C5-Schaft
– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301-304
– Schnittdaten siehe Seite(n) 309, 310
– Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-17-68-C5	03080235	17,0 *0.669*	68,0 *2.677*	73,0 *2.874*	106,0 *4.173*	50,0 *1.969*	SPGX0502	SCGX050204
SD524-17.5-70-C5	03080237	17,5 *0.689*	70,0 *2.756*	75,0 *2.953*	109,0 *4.291*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-18-72-C5	03080238	18,0 *0.709*	72,0 *2.835*	77,0 *3.031*	111,0 *4.370*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-18.5-74-C5	03080239	18,5 *0.728*	74,0 *2.913*	79,0 *3.110*	113,0 *4.449*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-19-76-C5	03080240	19,0 *0.748*	76,0 *2.992*	81,0 *3.189*	115,0 *4.528*	50,0 *1.969*	SPGX0602	SCGX050204
SD524-20-80-C5	03080241	20,0 *0.787*	80,0 *3.150*	85,0 *3.346*	121,0 *4.764*	50,0 *1.969*	SPGX0602	SCGX060204
SD524-20.62-83-C5	03080408	20,62 *0.812*	83,0 *3.268*	88,0 *3.465*	124,0 *4.882*	50,0 *1.969*	SPGX0602	SCGX060204
SD524-21-84-C5	03080242	21,0 *0.827*	84,0 *3.307*	89,0 *3.504*	125,0 *4.921*	50,0 *1.969*	SPGX0602	SCGX060204
SD524-22-88-C5	03080243	22,0 *0.866*	88,0 *3.465*	93,0 *3.661*	129,0 *5.079*	50,0 *1.969*	SPGX0703	SCGX060204
SD524-22.23-89-C5	03080409	22,23 *0.875*	89,0 *3.504*	94,0 *3.701*	130,0 *5.118*	50,0 *1.969*	SPGX0703	SCGX060204
SD524-23-92-C5	03080244	23,0 *0.906*	92,0 *3.622*	97,0 *3.819*	134,0 *5.276*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-24-96-C5	03080245	24,0 *0.945*	96,0 *3.780*	101,0 *3.976*	139,0 *5.472*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-25-100-C5	03080246	25,0 *0.984*	100,0 *3.937*	105,0 *4.134*	144,0 *5.669*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-25.4-102-C5	03080410	25,4 *1.000*	102,0 *4.016*	107,0 *4.213*	146,0 *5.748*	50,0 *1.969*	SPGX0703	SCGX070308
SD524-26-104-C5	03080247	26,0 *1.024*	104,0 *4.094*	109,0 *4.291*	148,0 *5.827*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-27-108-C5	03080248	27,0 *1.063*	108,0 *4.252*	113,0 *4.449*	152,0 *5.984*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-28-112-C5	03080249	28,0 *1.102*	112,0 *4.409*	117,0 *4.606*	157,0 *6.181*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-28.59-115-C5	03080411	28,59 *1.126*	115,0 *4.528*	120,0 *4.724*	160,0 *6.299*	50,0 *1.969*	SPGX0903	SCGX070308
SD524-29-116-C5	03080250	29,0 *1.142*	116,0 *4.567*	121,0 *4.764*	161,0 *6.339*	50,0 *1.969*	SPGX0903	SCGX09T308
SD524-30-120-C5	03080251	30,0 *1.181*	120,0 *4.724*	125,0 *4.921*	165,0 *6.496*	50,0 *1.969*	SPGX0903	SCGX09T308
SD524-31-124-C5	03080252	31,0 *1.220*	124,0 *4.882*	129,0 *5.079*	169,0 *6.654*	50,0 *1.969*	SPGX0903	SCGX09T308
SD524-31.75-127-C5	03080412	31,75 *1.250*	127,0 *5.000*	132,0 *5.197*	173,0 *6.811*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-32-128-C5	03080253	32,0 *1.260*	128,0 *5.039*	133,0 *5.236*	174,0 *6.850*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-33-132-C5	03080254	33,0 *1.299*	132,0 *5.197*	137,0 *5.394*	178,0 *7.008*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD524-34-136-C5	03080255	34,0 *1.339*	136,0 *5.354*	141,0 *5.551*	182,0 *7.165*	50,0 *1.969*	SPGX11T3	SCGX09T308

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-35-140-C5	03080256	35,0 *1.378*	140,0 *5.512*	145,0 *5.709*	186,0 *7.323*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-36-144-C5	03080257	36,0 *1.417*	144,0 *5.669*	149,0 *5.866*	190,0 *7.480*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-37-148-C5	03080258	37,0 *1.457*	148,0 *5.827*	153,0 *6.024*	194,0 *7.638*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-38-152-C5	03080259	38,0 *1.496*	152,0 *5.984*	157,0 *6.181*	198,0 *7.795*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-39-156-C5	03080260	39,0 *1.535*	156,0 *6.142*	161,0 *6.339*	202,0 *7.953*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-40-160-C5	03080261	40,0 *1.575*	160,0 *6.299*	165,0 *6.496*	206,0 *8.110*	50,0 *1.969*	SPGX12T3	SCGX11T308

Ersatzteile, im Lieferumfang enthalten

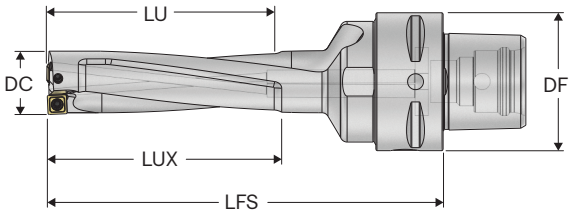
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD524

Bohrtiefe ca. 4 x D – Metrisch/Zoll



–Seco Capto™ C6-Schaft
–Kühlmittelzufuhr
–Informationen zu Wendeplatten siehe Seite(n) 301-304
–Schnittdaten siehe Seite(n) 309, 310
–Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-17-68-C6	03080262	17,0 *0.669*	68,0 *2.677*	73,0 *2.874*	108,0 *4.252*	63,0 *2.480*	SPGX0502	SCGX050204
SD524-17.5-70-C6	03080263	17,5 *0.689*	70,0 *2.756*	75,0 *2.953*	111,0 *4.370*	63,0 *2.480*	SPGX0602	SCGX050204
SD524-18-72-C6	03080265	18,0 *0.709*	72,0 *2.835*	77,0 *3.031*	113,0 *4.449*	63,0 *2.480*	SPGX0602	SCGX050204
SD524-18.5-74-C6	03080266	18,5 *0.728*	74,0 *2.913*	79,0 *3.110*	115,0 *4.528*	63,0 *2.480*	SPGX0602	SCGX050204
SD524-19-76-C6	03080267	19,0 *0.748*	76,0 *2.992*	81,0 *3.189*	117,0 *4.606*	63,0 *2.480*	SPGX0602	SCGX050204
SD524-20-80-C6	03080268	20,0 *0.787*	80,0 *3.150*	85,0 *3.346*	123,0 *4.843*	63,0 *2.480*	SPGX0602	SCGX060204
SD524-20.62-83-C6	03080417	20,62 *0.812*	83,0 *3.268*	88,0 *3.465*	126,0 *4.961*	63,0 *2.480*	SPGX0602	SCGX060204
SD524-21-84-C6	03080269	21,0 *0.827*	84,0 *3.307*	89,0 *3.504*	127,0 *5.000*	63,0 *2.480*	SPGX0602	SCGX060204
SD524-22-88-C6	03080270	22,0 *0.866*	88,0 *3.465*	93,0 *3.661*	131,0 *5.157*	63,0 *2.480*	SPGX0703	SCGX060204
SD524-22.23-89-C6	03080418	22,23 *0.875*	89,0 *3.504*	94,0 *3.701*	132,0 *5.197*	63,0 *2.480*	SPGX0703	SCGX060204
SD524-23-92-C6	03080271	23,0 *0.906*	92,0 *3.622*	97,0 *3.819*	136,0 *5.354*	63,0 *2.480*	SPGX0703	SCGX070308
SD524-24-96-C6	03080272	24,0 *0.945*	96,0 *3.780*	101,0 *3.976*	141,0 *5.551*	63,0 *2.480*	SPGX0703	SCGX070308
SD524-25-100-C6	03080392	25,0 *0.984*	100,0 *3.937*	105,0 *4.134*	146,0 *5.748*	63,0 *2.480*	SPGX0703	SCGX070308
SD524-25.4-102-C6	03080419	25,4 *1.000*	102,0 *4.016*	107,0 *4.213*	148,0 *5.827*	63,0 *2.480*	SPGX0703	SCGX070308
SD524-26-104-C6	03080393	26,0 *1.024*	104,0 *4.094*	109,0 *4.291*	150,0 *5.906*	63,0 *2.480*	SPGX0903	SCGX070308
SD524-27-108-C6	03080394	27,0 *1.063*	108,0 *4.252*	113,0 *4.449*	154,0 *6.063*	63,0 *2.480*	SPGX0903	SCGX070308
SD524-28-112-C6	03080395	28,0 *1.102*	112,0 *4.409*	117,0 *4.606*	159,0 *6.260*	63,0 *2.480*	SPGX0903	SCGX070308
SD524-28.59-115-C6	03080420	28,59 *1.126*	115,0 *4.528*	120,0 *4.724*	162,0 *6.378*	63,0 *2.480*	SPGX0903	SCGX070308
SD524-29-116-C6	03080396	29,0 *1.142*	116,0 *4.567*	121,0 *4.764*	163,0 *6.417*	63,0 *2.480*	SPGX0903	SCGX09T308
SD524-30-120-C6	03080397	30,0 *1.181*	120,0 *4.724*	125,0 *4.921*	167,0 *6.575*	63,0 *2.480*	SPGX0903	SCGX09T308
SD524-31-124-C6	03080398	31,0 *1.220*	124,0 *4.882*	129,0 *5.079*	171,0 *6.732*	63,0 *2.480*	SPGX0903	SCGX09T308
SD524-31.75-127-C6	03080421	31,75 *1.250*	127,0 *5.000*	132,0 *5.197*	175,0 *6.890*	63,0 *2.480*	SPGX0903	SCGX09T308
SD524-32-128-C6	03080399	32,0 *1.260*	128,0 *5.039*	133,0 *5.236*	176,0 *6.929*	63,0 *2.480*	SPGX11T3	SCGX09T308
SD524-33-132-C6	03080400	33,0 *1.299*	132,0 *5.197*	137,0 *5.394*	180,0 *7.087*	63,0 *2.480*	SPGX11T3	SCGX09T308
SD524-34-136-C6	03080401	34,0 *1.339*	136,0 *5.354*	141,0 *5.551*	184,0 *7.244*	63,0 *2.480*	SPGX11T3	SCGX09T308

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-35-140-C6	03080402	35,0 *1.378*	140,0 *5.512*	145,0 *5.709*	188,0 *7.402*	63,0 *2.480*	SPGX11T3	SCGX11T308
SD524-36-144-C6	03080403	36,0 *1.417*	144,0 *5.669*	149,0 *5.866*	192,0 *7.559*	63,0 *2.480*	SPGX11T3	SCGX11T308
SD524-37-148-C6	03080404	37,0 *1.457*	148,0 *5.827*	153,0 *6.024*	196,0 *7.717*	63,0 *2.480*	SPGX11T3	SCGX11T308
SD524-38-152-C6	03080405	38,0 *1.496*	152,0 *5.984*	157,0 *6.181*	200,0 *7.874*	63,0 *2.480*	SPGX12T3	SCGX11T308
SD524-39-156-C6	03080406	39,0 *1.535*	156,0 *6.142*	161,0 *6.339*	204,0 *8.031*	63,0 *2.480*	SPGX12T3	SCGX11T308
SD524-40-160-C6	03080407	40,0 *1.575*	160,0 *6.299*	165,0 *6.496*	208,0 *8.189*	63,0 *2.480*	SPGX12T3	SCGX11T308

Ersatzteile, im Lieferumfang enthalten

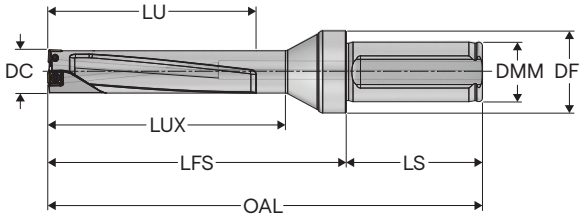
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD525

Bohrtiefe ca. 5 x D – Metrisch/Zoll



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 311, 312
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD525-19-95-25R7	03079580	19,0 *0.748*	95,0 *3.740*	181,0 *7.126*	100,0 *3.937*	125,0 *4.921*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX050204
SD525-20-100-25R7	03079582	20,0 *0.787*	100,0 *3.937*	186,0 *7.323*	105,0 *4.134*	130,0 *5.118*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204
SD525-21-105-25R7	03079583	21,0 *0.827*	105,0 *4.134*	191,0 *7.520*	110,0 *4.331*	135,0 *5.315*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0602	SCGX060204
SD525-22-110-25R7	03079584	22,0 *0.866*	110,0 *4.331*	196,0 *7.717*	115,0 *4.528*	140,0 *5.512*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX060204
SD525-23-115-25R7	03079585	23,0 *0.906*	115,0 *4.528*	201,0 *7.913*	120,0 *4.724*	145,0 *5.709*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308
SD525-24-120-25R7	03079586	24,0 *0.945*	120,0 *4.724*	206,0 *8.110*	125,0 *4.921*	150,0 *5.906*	56,0 *2.205*	25,0 *0.984*	35,0 *1.378*	SPGX0703	SCGX070308
SD525-25-125-32R7	03079587	25,0 *0.984*	125,0 *4.921*	215,0 *8.465*	130,0 *5.118*	155,0 *6.102*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0703	SCGX070308
SD525-26-130-32R7	03079588	26,0 *1.024*	130,0 *5.118*	220,0 *8.661*	135,0 *5.315*	160,0 *6.299*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308
SD525-27-135-32R7	03079589	27,0 *1.063*	135,0 *5.315*	225,0 *8.858*	140,0 *5.512*	165,0 *6.496*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308
SD525-28-140-32R7	03079590	28,0 *1.102*	140,0 *5.512*	230,0 *9.055*	145,0 *5.709*	170,0 *6.693*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX070308
SD525-29-145-32R7	03079591	29,0 *1.142*	145,0 *5.709*	235,0 *9.252*	150,0 *5.906*	175,0 *6.890*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308
SD525-30-150-32R7	03079592	30,0 *1.181*	150,0 *5.906*	240,0 *9.449*	155,0 *6.102*	180,0 *7.087*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308
SD525-31-155-32R7	03079593	31,0 *1.220*	155,0 *6.102*	245,0 *9.646*	160,0 *6.299*	185,0 *7.283*	60,0 *2.362*	32,0 *1.260*	42,0 *1.654*	SPGX0903	SCGX09T308
SD525-32-160-40R7	03079595	32,0 *1.260*	160,0 *6.299*	258,0 *10.157*	165,0 *6.496*	190,0 *7.480*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD525-33-165-40R7	03079596	33,0 *1.299*	165,0 *6.496*	263,0 *10.354*	170,0 *6.693*	195,0 *7.677*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD525-34-170-40R7	03079597	34,0 *1.339*	170,0 *6.693*	268,0 *10.551*	175,0 *6.890*	200,0 *7.874*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX09T308
SD525-35-175-40R7	03079598	35,0 *1.378*	175,0 *6.890*	273,0 *10.748*	180,0 *7.087*	205,0 *8.071*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD525-36-180-40R7	03079599	36,0 *1.417*	180,0 *7.087*	278,0 *10.945*	185,0 *7.283*	210,0 *8.268*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD525-37-185-40R7	03079600	37,0 *1.457*	185,0 *7.283*	283,0 *11.142*	190,0 *7.480*	215,0 *8.465*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD525-38-190-40R7	03079601	38,0 *1.496*	190,0 *7.480*	288,0 *11.339*	195,0 *7.677*	220,0 *8.661*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD525-39-195-40R7	03079602	39,0 *1.535*	195,0 *7.677*	293,0 *11.535*	200,0 *7.874*	225,0 *8.858*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD525-40-200-40R7	03079603	40,0 *1.575*	200,0 *7.874*	298,0 *11.732*	205,0 *8.071*	230,0 *9.055*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD525-41-205-40R7	03079604	41,0 *1.614*	205,0 *8.071*	303,0 *11.929*	210,0 *8.268*	235,0 *9.252*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408
SD525-42-210-40R7	03079605	42,0 *1.654*	210,0 *8.268*	308,0 *12.126*	215,0 *8.465*	240,0 *9.449*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408
SD525-43-215-40R7	03079606	43,0 *1.693*	215,0 *8.465*	313,0 *12.323*	220,0 *8.661*	245,0 *9.646*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX12T3	SCGX120408

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD525-44-220-40R7	03079607	44,0 *1.732*	220,0 *8.661*	318,0 *12.520*	225,0 *8.858*	250,0 *9.843*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX120408
SD525-45-225-40R7	03079608	45,0 *1.772*	225,0 *8.858*	323,0 *12.717*	230,0 *9.055*	255,0 *10.039*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512

Ersatzteile, im Lieferumfang enthalten

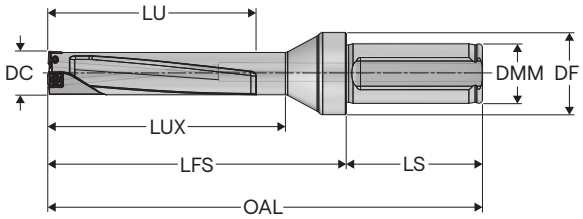
Bohrer-durchmesser (mm)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
29,00-31,00	C03007-T09P	C03009-T09P	T09P-2
32,00-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-42,00	C03508-T15P	C05012-T15P	T15P-2D
43,00-45,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrer-durchmesser (mm)	Drehmomentschlüssel
19,00	T00-07P09
20,00-21,00	T00-07P09
22,00	T00-08P12
23,00-25,00	T00-08P12
26,00-28,00	T00-09P20
29,00-31,00	T00-09P20
32,00-40,00	T00-15P30
41,00-42,00	T00-15P30
43,00-45,00	T00-15P35

SD525

Bohrtiefe ca. 5 x D – Zoll



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 311, 312
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD525-0750-375-1000R7	03079565	0.750	3.750	7.181	3.947	4.931	2.250	1.000	1.378	SPGX0602	SCGX050204
SD525-0812-406-1000R7	03079566	0.812	4.060	7.491	4.257	5.241	2.250	1.000	1.378	SPGX0602	SCGX060204
SD525-0875-438-1000R7	03079567	0.875	4.380	7.811	4.577	5.561	2.250	1.000	1.378	SPGX0703	SCGX060204
SD525-0937-469-1000R7	03079568	0.937	4.690	8.121	4.887	5.871	2.250	1.000	1.378	SPGX0703	SCGX070308
SD525-1000-500-1250R7	03079569	1.000	5.000	8.556	5.197	6.181	2.375	1.250	1.654	SPGX0703	SCGX070308
SD525-1062-531-1250R7	03079570	1.062	5.310	8.866	5.507	6.491	2.375	1.250	1.654	SPGX0903	SCGX070308
SD525-1125-563-1250R7	03079571	1.125	5.630	9.186	5.827	6.811	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD525-1187-594-1250R7	03079572	1.187	5.940	9.496	6.137	7.121	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD525-1250-625-1500R7	03079573	1.250	6.250	10.056	6.447	7.431	2.625	1.500	1.969	SPGX11T3	SCGX09T308
SD525-1375-687-1500R7	03079574	1.375	6.870	10.676	7.067	8.051	2.625	1.500	1.969	SPGX11T3	SCGX11T308
SD525-1500-750-1500R7	03079575	1.500	7.500	11.306	7.697	8.681	2.625	1.500	1.969	SPGX12T3	SCGX11T308
SD525-1625-812-1500R7	03079576	1.625	8.120	11.926	8.317	9.301	2.625	1.500	1.969	SPGX12T3	SCGX120408
SD525-1750-875-1500R7	03079577	1.750	8.750	12.556	8.947	9.931	2.625	1.500	1.969	SPGX1504	SCGX120408
SD525-1875-937-1500R7	03079578	1.875	9.370	13.176	9.567	10.551	2.625	1.500	1.969	SPGX1504	SCGX150512
SD525-1937-968-1500R7	03079579	1.937	9.680	13.486	9.877	10.861	2.625	1.500	2.337	SPGX1504	SCGX150512
SD525-2000-1000-1500R7	03079581	2.000	10.000	13.806	10.197	11.181	2.625	1.500	2.337	SPGX1504	SCGX150512

Ersatzteile, im Lieferumfang enthalten

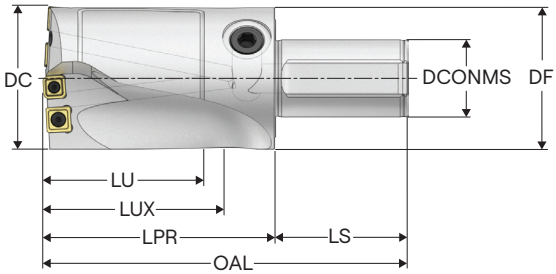
Bohrerdurch-messer (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
0.750	C02205-T07P	C02245-T07P	T07P-2
0.812	C02205-T07P	C02205-T07P	T07P-2
0.875	C02506-T08P	C02506-T08P	T08P-2
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2
1.062	C03007-T09P	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D
1.625	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.000	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Drehmomentschlüssel
T00-07P09
T00-07P09
T00-08P12
T00-08P12
T00-09P20
T00-09P20
T00-15P30
T00-15P30
T00-15P35

SD5301

Bohrtiefe = 84 mm (3.307") – Metrisch/Zoll



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 313, 314
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LPR	OAL	LS	DCONMS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD5301-64-84-40R7	10137541	64,0 *2.520*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX 0903-CI	SCGX09T308...
SD5301-69-84-40R7	10137542	69,0 *2.717*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	68,0 *2.677*	SPGX 11T3-C1	SCGX120408...
SD5301-74-84-40R7	10137543	74,0 *2.913*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	73,0 *2.874*	SPGX 11T3-C1	SCGX 120408...
SD5301-79-84-40R7	10137544	79,0 *3.110*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	78,0 *3.071*	SPGX 12T3-C1	SCGX 120408...
SD5301-84-84-40R7	10137545	84,0 *3.307*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	83,0 *3.268*	SPGX 12T3-C1	SCGX 120408...

Ersatzteile, im Lieferumfang enthalten

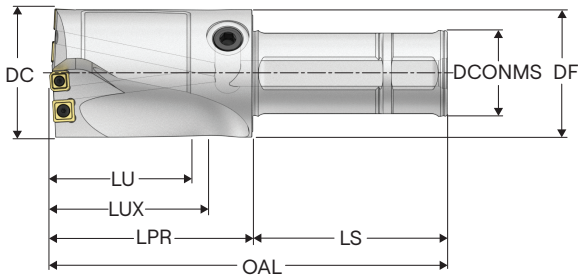
Bohrer-durchmesser (mm)	Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Dichtschraube
64,0	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
69,0-84,0	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8

Zubehör

Bohrer-durchmesser (mm)	Drehmoment-schlüssel
64,0	T00-09P20
69,0-84,0	T00-15P30

SD5301

Bohrtiefe = 84 mm (3.307") – Metrisch/Zoll



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 313, 314
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer									Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD5301-2500-330-2000R7	10137546	2.500	3.307	3.406	4.724	9.224	4.500	2.000	2.461	SPGX 0903-CI	SCGX09T308...
SD5301-2750-330-2000R7	10137547	2.750	3.307	3.406	4.724	9.224	4.500	2.000	2.711	SPGX 11T3-C1	SCGX120408...
SD5301-3000-330-2000R7	10137548	3.000	3.307	3.406	4.724	9.224	4.500	2.000	2.961	SPGX 11T3-C1	SCGX 120408...
SD5301-3250-330-2000R7	10137549	3.250	3.307	3.406	4.724	9.224	4.500	2.000	3.211	SPGX 12T3-C1	SCGX 120408...
SD5301-3500-330-2000R7	10137550	3.500	3.307	3.406	4.724	9.224	4.500	2.000	3.461	SPGX 1504-C1	SCGX 120408...

Ersatzteile, im Lieferumfang enthalten

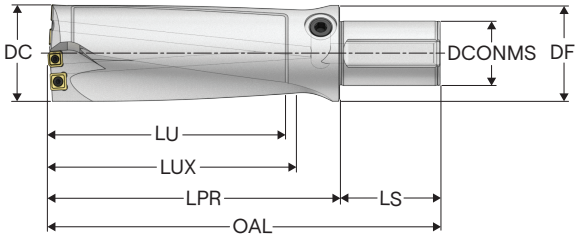
Bohrer-durchmesser (mm)	Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Dichtschraube
63,5	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
69,85-82,55	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8
88,9	R3/8-HA	T15P-2D	C04011-T15P	C05012-T15P	R3/8

Zubehör

Bohrer-durchmesser (mm)	Drehmoment-schlüssel
63,5	T00-09P20
69,85-82,55	T00-15P30
88,9	T00-15P30

SD5402

Bohrtiefe ca. 2.5 X D



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 313, 314
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	DC	LU	LUX	LPR	OAL	LS	DCONMS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD5402-60-150-40R7	10137529	60,0 *2.362*	150 *5.906*	156,0 *6.142*	189,5 *7.461*	257,5 *10.138*	68,0 *2.677*	40,0 *1.575*	59,0 *2.323*	SPGX 0903-C1	SCGX 09T308...
SD5402-65-162.5-40R7	10137530	65,0 *2.559*	162,5 *6.398*	168,5 *6.634*	202,0 *7.953*	270,0 *10.630*	68,0 *2.677*	40,0 *1.575*	64,0 *2.520*	SPGX 0903-C1	SCGX 09T308...
SD5402-70-175-40R7	10137531	70,0 *2.756*	175 *6.890*	181,0 *7.126*	214,5 *8.445*	282,5 *11.122*	68,0 *2.677*	40,0 *1.575*	69,0 *2.717*	SPGX 11T3-C1	SCGX 120408...
SD5402-75-187.5-50R7	10137532	75,0 *2.953*	187,5 *7.382*	193,5 *7.618*	227,0 *8.937*	305,0 *12.008*	78,0 *3.071*	50,0 *1.969*	74,0 *2.913*	SPGX 11T3-C1	SCGX 120408...
SD5402-80-200-50R7	10137533	80,0 *3.150*	200 *7.874*	206,0 *8.110*	239,5 *9.429*	317,5 *12.500*	78,0 *3.071*	50,0 *1.969*	79,0 *3.110*	SPGX 12T3-C1	SCGX 120408...
SD5402-85-212.5-50R7	10137534	85,0 *3.346*	212,5 *8.366*	218,5 *8.602*	252,0 *9.921*	330,0 *12.992*	78,0 *3.071*	50,0 *1.969*	84,0 *3.307*	SPGX 1504-C1	SCGX 120408...

Ersatzteile, im Lieferumfang enthalten

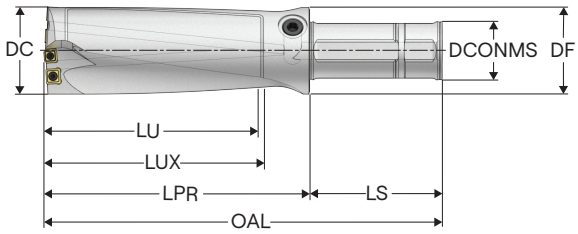
Bohrer-durchmesser (mm)	Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Dichtschraube
60,0	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
65,0	R3/8-HA	T15P-2D	CO3508-T15P	C03508-T15P	R3/8
70,0-85,0	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8

Zubehör

Bohrer-durchmesser (mm)	Drehmoment-schlüssel
60,0	T00-09P20
65,0	T00-15P30
70,0-85,0	T00-15P30

SD5402

Bohrtiefe ca. 2.5 X D



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 313, 314
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer								Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD5402-2250-563-1500R7	10137535	2.250	5.630	5.866	7.185	11.685	4.500	1.500	2.211	SPGX 0903-C1	SCGX 09T308...
SD5402-2500-625-1500R7	10137536	2.500	6.250	6.486	7.805	12.305	4.500	1.500	2.461	SPGX 0903-C1	SCGX 09T308...
SD5402-2750-688-1500R7	10137537	2.750	6.880	7.116	8.435	12.935	4.500	1.500	2.711	SPGX 11T3-C1	SCGX 120408...
SD5402-3000-750-2000R7	10137538	3.000	7.500	7.736	9.055	13.555	4.500	2.000	2.961	SPGX 11T3-C1	SCGX 120408...
SD5402-3250-813-2500R7	10137539	3.250	8.130	8.366	9.685	14.185	4.500	2.500	3.211	SPGX 12T3-C1	SCGX 120408...
SD5402-3500-875-2500R7	10137540	3.500	8.750	8.986	10.305	14.805	4.500	2.500	3.461	SPGX 1504-C1	SCGX 120408...

Ersatzteile, im Lieferumfang enthalten

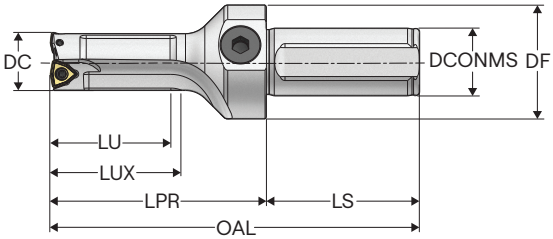
Bohrer-durchmesser (mm)	Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Dichtschraube
57,15-63,5	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
69,85-82,55	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8
88,9	R3/8-HA	T15P-2D	C04011-T15P	C05012-T15P	R3/8

Zubehör

Bohrer-durchmesser (mm)	Drehmoment-schlüssel
57,15-63,5	T00-09P20
69,85-82,55	T00-15P30
88,9	T00-15P30

SD5702

Bohrtiefe ca. 2 x D



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 315-316
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	Bohrungs-durchmesser min-max		DC	LU	LUX	LPR	OAL	LS	DCONMS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD5702-15-30-25R7	10337950	14,8 *0.583*	18,0 *0.709*	15,0 *0.591*	30,0 *1.181*	35,0 *1.378*	65,0 *2.559*	121,0 *4.764*	56,0 *2.205*	25,0 *0.984*	42,0 *1.654*	WCMX030208-86	WCMX030208...
SD5702-16-32-25R7	10337951	15,8 *0.622*	18,0 *0.709*	16,0 *0.630*	32,0 *1.260*	37,0 *1.457*	67,0 *2.638*	123,0 *4.843*	56,0 *2.205*	25,0 *0.984*	42,0 *1.654*	WCMX030208-86	WCMX030208...
SD5702-17-34-25R7	10337952	16,8 *0.661*	19,0 *0.748*	17,0 *0.669*	34,0 *1.339*	39,0 *1.535*	69,0 *2.717*	125,0 *4.921*	56,0 *2.205*	25,0 *0.984*	42,0 *1.654*	WCMX030208-86	WCMX030208...
SD5702-19-38-25R7	10337953	18,8 *0.740*	22,0 *0.866*	19,0 *0.748*	38,0 *1.496*	43,0 *1.693*	73,0 *2.874*	129,0 *5.079*	56,0 *2.205*	25,0 *0.984*	42,0 *1.654*	WCMX040208-86	WCMX030208...
SD5702-22-44-25R7	10337954	21,8 *0.858*	27,0 *1.063*	22,0 *0.866*	44,0 *1.732*	49,0 *1.929*	79,0 *3.110*	135,0 *5.315*	56,0 *2.205*	25,0 *0.984*	42,0 *1.654*	WCMX050308-86	WCMX040208...
SD5702-27-54-32R7	10337955	26,8 *1.055*	33,0 *1.299*	27,0 *1.063*	54,0 *2.126*	59,0 *2.323*	89,0 *3.504*	149,0 *5.866*	60,0 *2.362*	32,0 *1.260*	50,0 *1.969*	WCMX06T308-86	WCMX050308...
SD5702-33-66-40R7	10337956	32,8 *1.291*	41,0 *1.614*	33,0 *1.299*	66,0 *2.598*	71,0 *2.795*	101,0 *3.976*	169,0 *6.654*	68,0 *2.677*	40,0 *1.575*	59,0 *2.323*	WCMX080412-86	WCMX06T308...
SD5702-41-82-40R7	10337957	40,8 *1.606*	47,0 *1.850*	41,0 *1.614*	82,0 *3.228*	87,0 *3.425*	117,0 *4.606*	185,0 *7.283*	68,0 *2.677*	40,0 *1.575*	59,0 *2.323*	WCMX080412-86	WCMX080412...
SD5702-47-94-40R7	10337958	46,8 *1.843*	52,0 *2.047*	47,0 *1.850*	94,0 *3.701*	99,0 *3.898*	129,0 *5.079*	197,0 *7.756*	68,0 *2.677*	40,0 *1.575*	59,0 *2.323*	WCMX080412-86	WCMX080412...

Ersatzteile, im Lieferumfang enthalten

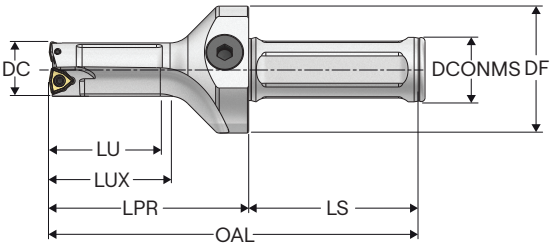
Bohrer-durchmesser (mm)		Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schraube
15.00-20.59	C02205-T07P	1310	T07P-2	C02205-T07P	C02205-T07P	R1/4
20.60-24.59	T08P-2	1310	T09P-2	C03007-T09P	C02506-T08P	R1/4
24.60-32.59	T09P-2	1310	T15P-2D	C03508-T15P	C03007-T09P	R1/4
32.60-36.59	C03508-T15P	1310	T15P-2D	C03508-T15P	C03508-T15P	R1/4
36.60-59.00	C04011-T15P	1310	T15P-2D	C04011-T15P	C04011-T15P	R1/4

Zubehör

Bohrer-durchmesser (mm)	Drehmoment	Drehmoment 2	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel	Drehmoment-schlüssel 2
15.00-20.59	0,9 Nm		T00-07P	–	T00-07P09	–
20.60-24.59	1,2 Nm		T00-09P	T00-08P	T00-09P12	T00-08P12
24.60-32.59	3,0 Nm		T00-15P	T00-09P	T00-15P30	T00-09P20
32.60-36.59	3,0 Nm		T00-15P	–	T00-15P30	–
36.60-59.00	3,0 Nm		T00-15P	–	T00-15P30	–

SD5702

Bohrtiefe ca. 2 x D – Zoll



- Schaft ISO 9766, -7
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301-304
- Schnittdaten siehe Seite(n) 315-316
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produktnummer	Bohrungsdurchmesser min-max		DC	LU	LUX	LPR	OAL	LS	DCONMS	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrumsschneide	Peripherieschneide
SD5702-0591-118-1000R7-C	10337968	*0.583*	*0.709*	*0.591*	*1.182*	*1.379*	*2.560*	*5.599*	*0.118*	*0.039*	*1,775*	WCMX030208-86	WCMX030208...
SD5702-0669-134-1000R7-C	10337969	*0.661*	*0.748*	*0.669*	*1.338*	*1.535*	*2.716*	*5.755*	*0.118*	*0.039*	*1,775*	WCMX030208-86	WCMX030208...
SD5702-0748-150-1000R7-C	10337970	*0.740*	*0.866*	*0.748*	*1.496*	*1.690*	*2.874*	*5.913*	*0.118*	*0.039*	*1,775*	WCMX040208-86	WCMX030208...
SD5702-0866-173-1000R7-C	10337971	*0.858*	*1.063*	*0.866*	*1.732*	*1.929*	*3.110*	*6.149*	*0.118*	*0.039*	*1,775*	WCMX050308-86	WCMX040208...
SD5702-1062-212-1250R7-C	10337972	*1.054*	*1.298*	*1.062*	*2.124*	*2.321*	*3.502*	*6.600*	*0.118*	*0.049*	*2,165*	WCMX06T308-86	WCMX050308...
SD5702-1299-260-1500R7-C	10337973	*1.291*	*1.614*	*1.299*	*2.598*	*2.795*	*3.976*	*6.917*	*0.118*	*0.059*	*2,303*	WCMX080412-86	WCMX06T308...
SD5702-1614-322-1500R7-C	10337974	*1.606*	*1.850*	*1.614*	*3.228*	*3.425*	*4.606*	*7.547*	*0.118*	*0.059*	*2,303*	WCMX080412-86	WCMX080412...
SD5702-1850-370-1500R7-C	10337975	*1.842*	*2.047*	*1.850*	*3.700*	*3.700*	*5.078*	*8.019*	*0.118*	*0.059*	*2,303*	WCMX080412-86	WCMX080412...

Ersatzteile, im Lieferumfang enthalten

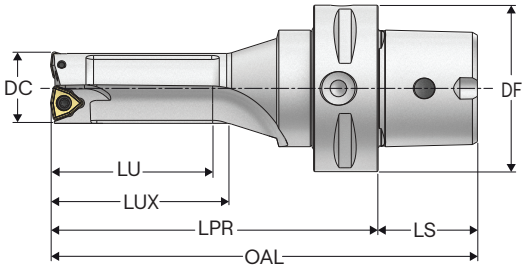
Bohrerdurchmesser (Zoll)		Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schraube
0.591-0.811	C02205-T07P	1310	T07P-2	C02205-T07P	C02205-T07P	R1/4
0.812-0.968	T08P-2	1310	T09P-2	C03007-T09P	C02506-T08P	R1/4
0.969-1.283	T09P-2	1310	T15P-2D	C03508-T15P	C03007-T09P	R1/4
1.283-1.440	C03508-T15P	1310	T15P-2D	C03508-T15P	C03508-T15P	R1/4
1.441-2.323	C04011-T15P	1310	T15P-2D	C04011-T15P	C04011-T15P	R1/4

Zubehör

Bohrerdurchmesser (mm)	Drehmoment	Drehmoment 2	Ersatzklinge	Ersatzklinge 1	Drehmomentschlüssel	Drehmomentschlüssel 2
0.591-0.811	0,9 Nm		T00-07P	–	T00-07P09	–
0.812-0.968	1,2 Nm		T00-09P	T00-08P	T00-09P12	T00-08P12
0.969-1.283	0,9 Nm		T00-15P	T00-09P	T00-15P30	T00-09P20
1.283-1.440	3,0 Nm		T00-15P	–	T00-15P30	–
1.441-2.323	3,0 Nm		T00-15P	–	T00-15P30	–

SD5702

Bohrtiefe ca. 2 x D



- Seco Capto™ C5-Schaft
- Kühlmittelzufuhr
- Informationen zu Wendeplatten siehe Seite(n) 301–304
- Schnittdaten siehe Seite(n) 315–316
- Zwischendurchmesser siehe MyDesign-Software

Bezeichnung	Produkt-nummer	Bohrungsdurchmesser min-max		DC	LU	LUX	LPR	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
SD5702-15-30-C5	10337959	14,8 *0.583*	18,0 *0.709*	15,0 *0.591*	30,0 *1.181*	35,0 *1.378*	85,0 *3.346*	50,0 *1.969*	WCMX030208-86	WCMX030208...
SD5702-16-32-C5	10337960	15,8 *0.622*	18,0 *0.709*	16,0 *0.630*	32,0 *1.260*	37,0 *1.457*	87,0 *3.425*	50,0 *1.969*	WCMX030208-86	WCMX030208...
SD5702-17-34-C5	10337961	16,8 *0.661*	19,0 *0.748*	17,0 *0.669*	34,0 *1.339*	39,0 *1.535*	89,0 *3.504*	50,0 *1.969*	WCMX030208-86	WCMX030208...
SD5702-19-38-C5	10337962	18,8 *0.740*	22,0 *0.866*	19,0 *0.748*	38,0 *1.496*	43,0 *1.693*	93,0 *3.661*	50,0 *1.969*	WCMX040208-86	WCMX030208...
SD5702-22-44-C5	10337963	21,8 *0.858*	27,0 *1.063*	22,0 *0.866*	44,0 *1.732*	49,0 *1.929*	99,0 *3.898*	50,0 *1.969*	WCMX050308-86	WCMX040208...
SD5702-27-54-C5	10337964	26,8 *1.055*	33,0 *1.299*	27,0 *1.063*	54,0 *2.126*	59,0 *2.323*	109,0 *4.291*	50,0 *1.969*	WCMX06T308-86	WCMX050308...
SD5702-33-66-C5	10337965	32,8 *1.291*	41,0 *1.614*	33,0 *1.299*	66,0 *2.598*	71,0 *2.795*	121,0 *4.764*	50,0 *1.969*	WCMX080412-86	WCMX06T308...
SD5702-41-82-C5	10337966	40,8 *1.606*	47,0 *1.850*	41,0 *1.614*	82,0 *3.228*	87,0 *3.425*	157,0 *6.181*	50,0 *1.969*	WCMX080412-86	WCMX080412...
SD5702-47-94-C5	10337967	46,8 *1.843*	52,0 *2.047*	47,0 *1.850*	94,0 *3.701*	99,0 *3.898*	169,0 *6.654*	50,0 *1.969*	WCMX080412-86	WCMX080412...

Ersatzteile, im Lieferumfang enthalten

Bohrer-durchmesser (mm)		Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP
15.00-20.59	C02205-T07P	T07P-2	C02205-T07P	C02205-T07P
20.60-24.59	T08P-2	T09P-2	C03007-T09P	C02506-T08P
24.60-32.59	T09P-2	T15P-2D	C03508-T15P	C03007-T09P
32.60-36.59	C03508-T15P	T15P-2D	C03508-T15P	C03508-T15P
36.60-59.00	C04011-T15P	T15P-2D	C04011-T15P	C04011-T15P

Zubehör

Bohrer-durchmesser (mm)	Drehmoment	Drehmoment 2	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel	Drehmoment-schlüssel 2
15.00-20.59	0,9 Nm		T00-07P	–	T00-07P09	–
20.60-24.59	1,2 Nm		T00-09P	T00-08P	T00-09P12	T00-08P12
24.60-32.59	3,0 Nm		T00-15P	T00-09P	T00-15P30	T00-09P20
32.60-36.59	3,0 Nm		T00-15P	–	T00-15P30	–
36.60-59.00	3,0 Nm		T00-15P	–	T00-15P30	–

Perfomax® SD602

Der Seco Perfomax® SD602 ist ein modulares Bohrsystem speziell für sichere und effiziente Tieflochbohrungen mit großen Durchmessern.

— Wendeschneidplatten der Sorte DP2501 bieten die nötige Zähigkeit für den optimierten Perfomax® SD602.
— Die Sorte ermöglicht hohe Vorschübe und Geschwindigkeiten.
— Hohe Flexibilität durch den Einsatz von Verlängerungen, um die erforderliche Bohrtiefe zu erreichen.

Code-Schlüssel

Bohrerkörper

SD602	–	89/90	–	50	RG
1		2		3	4

1.
Bohrertyp
SD602: Zentrierbohrer und EInsatz

2.
Möglicher Bohrerdurchmesser
89 - Untermaßdurchmesser
90 - Übermaßdurchmesser

3.
Flanschdurchmesser

4.
Schafttyp

Zoll

SD602	–	3500	RG

Zentrierbohrer

SD601	1	–	10	–	R
	2		3		4

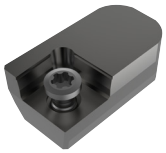
(Der Zentrierbohrer muss separat erworben werden.)

2.
0 = Vollhartmetall
1 = HSS

3.
Bohrerdurchmesser

4.
Rechtsdrehend

Kassette



-N

-U

SD600	C	–	07	–	N
	2		3		4

2.
C = Zentrum
*P = Peripherie

3.
WSP-Größe:
SCGX07
SCGX09
SCGX12
SCGX15

***4.**
N – Nenndurchmesser
U – Untermaßdurchmesser

Kit

-N

-U

SD602	1	–	P	–	07	–	N
	2		3		4		5

2.
0 = einschließlich 2 Führungsleisten (Durchmesser < 135 mm)
1 = einschließlich 4 Führungsleisten (Durchmesser > 135 mm)

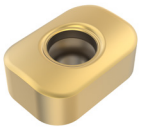
3.
Peripherie

4.
WSP-Größe:
SCGX07
SCGX09
SCGX12
SCGX15

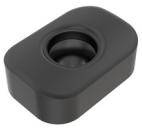
5.
N – Nenndurchmesser
U – Untermaßdurchmesser

Hinweis: Ersatzteil-Kits “D” für nominalen (-N) oder Untermaßdurchmesser (-U) auf Seite 295 wählen, um den Bohrerkörper zu vervollständigen. Kit “D” ist separat zu erwerben.

Führungsleiste



-N



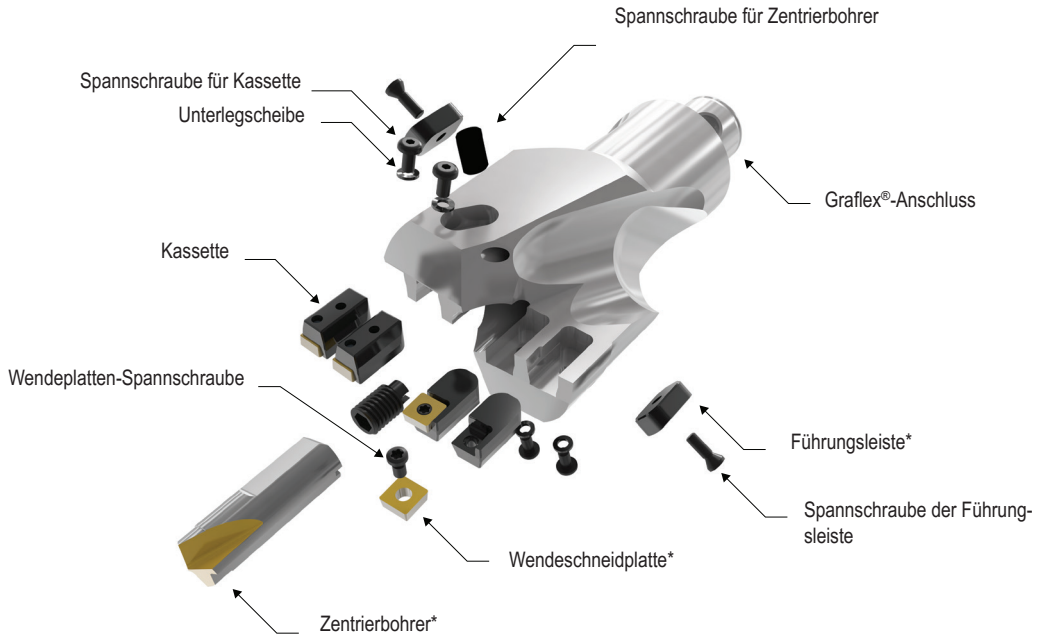
-U

PAD	–	L20R25	-N
			3

***3.**
*N - Nenndurchmesser
U - Untermaß-Durchmesser

Modularer Bohrkopf

SD602-59/60-40RG



Beispiel: Durchmesser 59; SD602-59-40RG
Folgendes Kit verwenden: SD6020-P07*

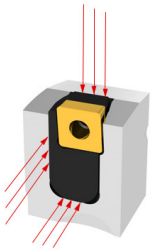
Beispiel: Durchmesser 60; SD602-60-40RG
Folgendes Kit verwenden: SD6020-P07-N*

Montagehinweise

- Die Spannschraube für die Kassette anziehen
- Die Wendeschneidplatten einsetzen
- Den Zentrierbohrer bis auf den Bohrungsgrund einsetzen und bei Bedarf mit der Einstellschraube verlängern
- Erweiterungen anbringen

Montieren der Kassette und der Führungsleiste

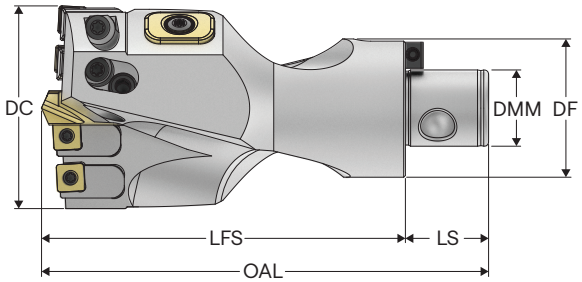
- Kassette montieren
- Auf bündigen Einsatz der Kassette achten
- Klemmschraube für Kassette anziehen mit dem Drehmomentschlüssel:
  SD600-x-07: 3 Nm
  SD600-x-09: 3 Nm
  SD600-x-12: 8 Nm
  SD600-x-15: 8 Nm
- Führungsleiste anbringen
- Spannschraube der Führungsleiste festziehen



*** Nicht im Lieferumfang enthalten.** Peripherie-Kit, Zentrierbohrer und Wendeschneidplatten müssen separat bestellt werden.

SD602

Modularer Bohrkopf – Metrisch/Zoll



– Kühlmittelzufuhr
– Informationen zu Wendeplatten siehe Seite(n) 301–304
– Schnittdaten siehe Seite(n) 317–318
– Zentrierbohrer mit Längeneinstellung

Bezeichnung	Produkt-nummer	Graflex Größe	Bereich DCN	Bereich DCX	OAL	LFS	LS	DF	DMM	Gewicht	WSP
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
SD602-59/60-40RG	02846688	G4	59,0 *2.323*	60,0 *2.362*	129,0 *5.079*	105,0 *4.134*	24,0 *0.945*	40,0 *1.575*	22,0 *0.866*	1,0 *2.200*	SCGX07
SD602-69/70-40RG	02846689	G4	69,0 *2.717*	70,0 *2.756*	129,0 *5.079*	105,0 *4.134*	24,0 *0.945*	40,0 *1.575*	22,0 *0.866*	1,2 *2.650*	SCGX09
SD602-79/80-50RG	02846690	G5	79,0 *3.110*	80,0 *3.150*	160,0 *6.299*	130,0 *5.118*	30,0 *1.181*	50,0 *1.969*	28,0 *1.102*	1,9 *4.190*	SCGX09
SD602-89/90-50RG	02846691	G5	89,0 *3.504*	90,0 *3.543*	160,0 *6.299*	130,0 *5.118*	30,0 *1.181*	50,0 *1.969*	28,0 *1.102*	2,1 *4.630*	SCGX09/12
SD602-99/100-63RG	02846692	G6	99,0 *3.898*	100,0 *3.937*	185,0 *7.283*	145,0 *5.709*	40,0 *1.575*	63,0 *2.480*	36,0 *1.417*	3,3 *7.280*	SCGX12
SD602-119/120-63RG	02846693	G6	119,0 *4.685*	120,0 *4.724*	185,0 *7.283*	145,0 *5.709*	40,0 *1.575*	63,0 *2.480*	36,0 *1.417*	3,5 *7.720*	SCGX15
SD602-139/140-90RG	02846694	G7	139,0 *5.472*	140,0 *5.512*	210,0 *8.268*	160,0 *6.299*	50,0 *1.969*	90,0 *3.543*	46,0 *1.811*	6,1 *13.450*	SCGX12
SD602-159/160-90RG	02846695	G7	159,0 *6.260*	160,0 *6.299*	210,0 *8.268*	160,0 *6.299*	50,0 *1.969*	90,0 *3.543*	46,0 *1.811*	7,0 *15.430*	SCGX12/15
SD602-2500-40RG	02846698	G4	62,5 *2.461*	63,5 *2.500*	129,0 *5.079*	105,0 *4.134*	24,0 *0.945*	40,0 *1.575*	22,0 *0.866*	1,0 *2.200*	SCGX07
SD602-2750-40RG	02846699	G4	68,85 *2.711*	69,85 *2.750*	129,0 *5.079*	105,0 *4.134*	24,0 *0.945*	40,0 *1.575*	22,0 *0.866*	1,1 *2.430*	SCGX07/09
SD602-3000-40RG	02846700	G4	75,2 *2.961*	76,2 *3.000*	129,0 *5.079*	105,0 *4.134*	24,0 *0.945*	40,0 *1.575*	22,0 *0.866*	1,2 *2.650*	SCGX09
SD602-3250-50RG	02846701	G5	81,55 *3.211*	82,55 *3.250*	160,0 *6.299*	130,0 *5.118*	30,0 *1.181*	50,0 *1.969*	28,0 *1.102*	2,0 *4.410*	SCGX09/12
SD602-3500-50RG	02846702	G5	87,9 *3.461*	88,9 *3.500*	160,0 *6.299*	130,0 *5.118*	30,0 *1.181*	50,0 *1.969*	28,0 *1.102*	2,1 *4.630*	SCGX09/12
SD602-4000-63RG	02846703	G6	100,6 *3.961*	101,6 *4.000*	185,0 *7.283*	145,0 *5.709*	40,0 *1.575*	63,0 *2.480*	36,0 *1.417*	3,4 *7.500*	SCGX12

Ersatzteile, im Lieferumfang enthalten

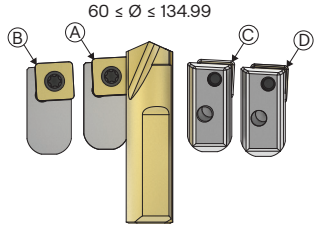
Kassette	Kassette	Kassettenschraube	Unterlegscheibe	Schraube für WSP	Wendeplatten-Schlüssel	Führungsleiste*	Führungsleiste*	Padschraube
SD600-C-07	SD600-P-07-N	K6S4x8	LW0408	C03007-T09P	T09P-2, T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-09	SD600-P-09-N	K6S4x8	LW0408	C03508-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-12	SD600-P-12-N	K6S6x10	LW0611	C05012-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-15	SD600-P-15-N	K6S6x12	LW0611	C05012-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P

*Nicht im Lieferumfang enthalten

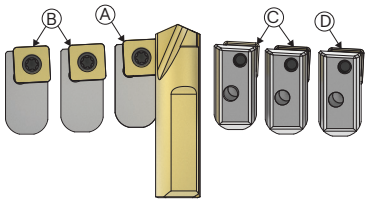
SD602

Modularer Bohrkopf

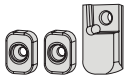
60 ≤ Ø ≤ 134.99



135 ≤ Ø ≤ 160



Ersatzteile, im Lieferumfang enthalten

Bezeichnung	Bohrerdurch-messer (mm)	Bohrerdurch-messer (Zoll)	Zentrierschraube	Einstellschraube	Kassette (A)	Kassette (B)	Kassette (C)	Peripheriekit* (D)	Zentrierbohrer* x=0 Vollhartmetall x=1 HSS
									
SD602-59/60-40RG	59	2.323	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-U	SD601x-10-R
SD602-59/60-40RG	60	2.362	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-N	SD601x-10-R
SD602-2500-40RG	62,5	2.461	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-U	SD601x-10-R
SD602-2500-40RG	63,5	2.500	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-N	SD601x-10-R
SD602-2750-40RG	68,85	2.711	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-07	SD600-P-07	SD6020-P-07-U	SD601x-10-R
SD602-2750-40RG	69,85	2.750	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-07	SD600-P-07	SD6020-P-07-N	SD601x-10-R
SD602-69/70-40RG	69	2.717	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-10-R
SD602-69/70-40RG	70	2.756	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-10-R
SD602-3000-40RG	75,2	2.961	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-15-R
SD602-3000-40RG	76,2	3.000	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-15-R
SD602-79/80-50RG	79	3.110	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-15-R
SD602-79/80-50RG	80	3.150	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-15-R
SD602-3250-50RG	81,55	3.211	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-15-R
SD602-3250-50RG	82,55	3.250	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-15-R
SD602-3500-50RG	87,9	3.461	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-U	SD601x-15-R
SD602-3500-50RG	88,9	3.500	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-N	SD601x-15-R
SD602-89/90-50RG	89	3.504	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-U	SD601x-15-R
SD602-89/90-50RG	90	3.543	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-N	SD601x-15-R
SD602-99/100-63RG	99	3.898	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-U	SD601x-15-R
SD602-99/100-63RG	100	3.937	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-N	SD601x-15-R
SD602-4000-63RG	100,6	3.961	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-U	SD601x-15-R
SD602-4000-63RG	101,6	4.000	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-N	SD601x-15-R
SD602-119/120-63RG	119	4.685	P6SS 10X10	19TLR1016	SD600-C-15	SD600-C-15	SD600-P-15	SD6020-P-15-U	SD601x-15-R
SD602-119/120-63RG	120	4.724	P6SS 10X10	19TLR1016	SD600-C-15	SD600-C-15	SD600-P-15	SD6020-P-15-N	SD601x-15-R
SD602-139/140-90RG	139	5.472	P6SS 12X12	19TLR1216	SD600-C-12	SD600-C-12	SD600-P-12	SD6021-P-12-U	SD601x-25-R
SD602-139/140-90RG	140	5.512	P6SS 12X12	19TLR1216	SD600-C-12	SD600-C-12	SD600-P-12	SD6021-P-12-N	SD601x-25-R
SD602-159/160-90RG	159	6.260	P6SS 12X12	19TLR1216	SD600-C-15	SD600-C-12	SD600-P-12	SD6021-P-15-U	SD601x-25-R
SD602-159/160-90RG	160	6.299	P6SS 12X12	19TLR1216	SD600-C-15	SD600-C-12	SD600-P-12	SD6021-P-15-N	SD601x-25-R

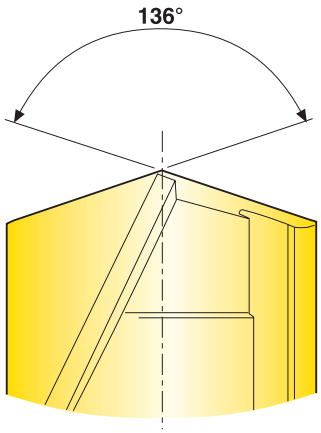
*Nicht im Lieferumfang enthalten. Peripheriekit, U-Untermaß, N-Nenngröße.
Wendeplattengröße siehe Seite 301-304

Nachschleifanweisungen für SD602

Spezifikationen:
Spezifikation der Diamant-Schleifscheibe
Abb. 1: Diamant-Schleifscheibenform 12A2 Korngröße D54
Abb. 3: Diamant-Schleifscheibenform 1A1 oder 1V1 Korngröße D64-D46
Abb. 2: Eckenfase Diamant-Schleifscheibenform 1A1 oder 12A2
Negative Primärfase:
Abb. 2: Fase schleifen oder bürsten.

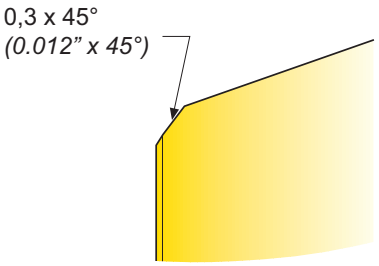
Wichtig:
- Beide Schneidkanten müssen einheitlich und mit der gleichen Größe der Schneidkantenpräparation ausgeführt sein.
- Die Schneidkantenpräparation muss auf die gesamte Länge der Schneidkanten angewendet werden.

1. Spitzenwinkel

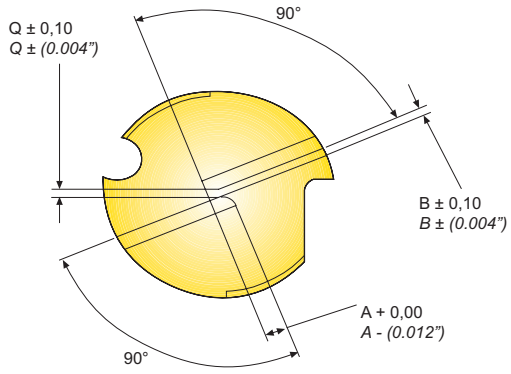


Schneidkantenausführung 0-0,1 mm *(0-.004")* x 20°. Bohrerspitze konischer Anschliff 10°

2. Eckenfase



3.

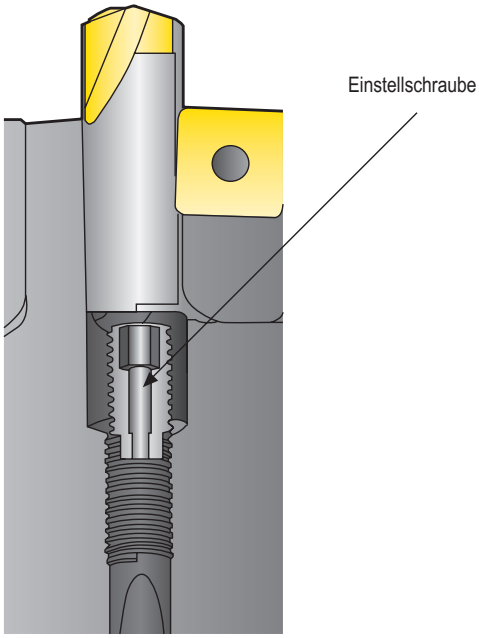


4.

	Abmessungen in mm (*Zoll*)			
Durchmesser	**A**	**B**	**C**	**Mindestlänge**
10 mm	1,5 *(0.059)*	0,5 *(0.020)*	0,57 *(0.022)*	38 *(1.496)*
15 mm	1,5 *(0.059)*	0,6 *(0.024)*	0,68 *(0.027)*	45 *(1.772)*
25 mm	1,5 *(0.059)*	1,4 *(0.055)*	1,6 *(0.063)*	57 *(2.244)*

Modularer Bohrkopf

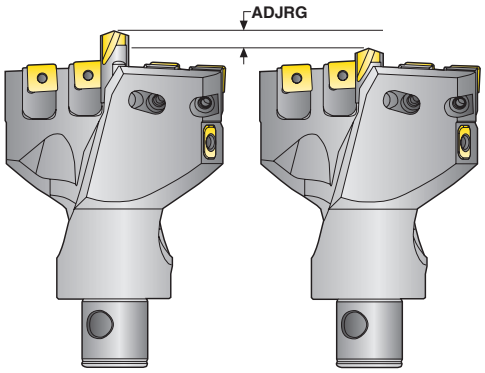
Merkmal: Einstellbarer Zentrierbohrer



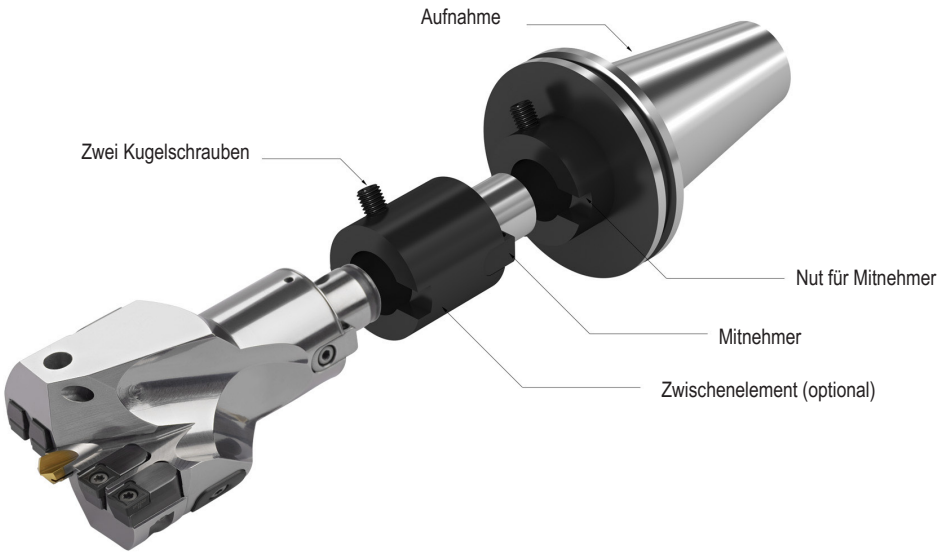
Bohrer	Einstellbarer Längenabstand ADJRG mm	*Zoll*
SD602-59/60-40RG	3,0	*0.118*
SD602-69/70-40RG	3,0	*0.118*
SD602-79/80-50RG	5,0	*0.197*
SD602-89/90-50RG	5,0	*0.197*
SD602-99/100-63RG	5,0	*0.197*
SD602-119/120-63RG	5,0	*0.197*
SD602-139/140-90RG	5,0	*0.197*
SD602-159/160-90RG	5,0	*0.197*
SD602-2500-40RG	3,0	*0.118*
SD602-2750-40RG	3,0	*0.118*
SD602-3000-40RG	5,0	*0.197*
SD602-3250-50RG	5,0	*0.197*
SD602-3500-50RG	5,0	*0.197*
SD602-4000-63RG	5,0	*0.197*

Merkmal: Einstellbarer Längenabstand

Vorteile: Gleiche Einstelllänge nach dem Nachschliff des Zentrierbohrers
Einstellbare Auskraglänge des Zentrierbohrers
Bei einer Bohrtiefe von > 5 x D empfehlen wir eine um 5 mm (*0.197"*) erweiterte Einstellung.
Empfehlung: Im Falle des erneuten Eintritts des Zentrierbohrers in die Bohrung, die Einstellung um 3 mm (*0.118"*) zur ursprünglichen Position versetzen, um eine bessere Konzentrizität zu gewährleisten.

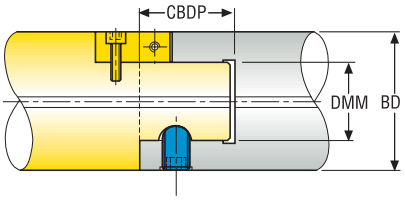


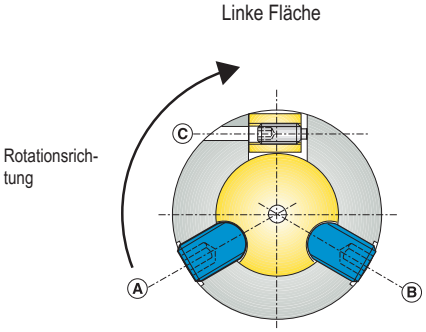
Modularer Bohrkopf



Montagehinweise

1. Zuerst Elemente reinigen und mit einem dünnen Korrosionsschutzfilm überziehen.
2. Zwischen der linken Anlagefläche des Mitnehmers und der linken Anlagefläche der Nut muss Kontakt bestehen.
3. Schraube (A) leicht anziehen (der Bohrerkopf muss vor- und zurückbewegt werden, um den niedrigsten Punkt für Schraube A zu finden).
4. Schraube B leicht anziehen.
5. Drehmoment der Klemmschraube C einstellen.
6. Drehmoment der Schraube A einstellen.
7. Drehmoment der Schraube B einstellen.
8. Festen Sitz der Klemmschraube überprüfen.





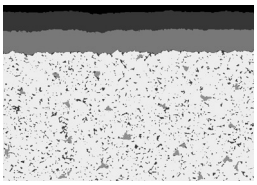
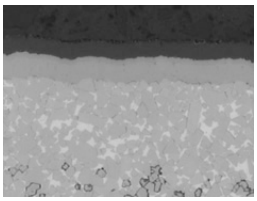
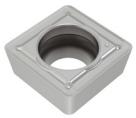
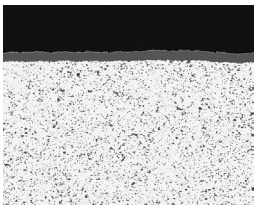
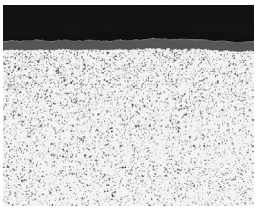
Graflex-Schaft	DMM mm (*Zoll*)	BD mm (*Zoll*)	CBDP mm (*Zoll*)	Empfohlene Anzugsmomente für Graflex-Verbindungen: Kugelkopfschrauben (A) & (B)	Klemmschraube des Mitnehmers (C)
4	22 *(0,866)*	40 *(1,575)*	24 *(0,945)*	20 Nm *(14.7 ft/lbs)*	0,7 Nm *(0.5 ft/lbs)*
5	28 *(1,102)*	50 *(1,969)*	30 *(1,181)*	25 Nm *(18.4 ft/lbs)*	2 Nm *(1.5 ft/lbs)*
6	36 *(1,417)*	63 *(2,480)*	40 *(1,575)*	35 Nm *(25.8 ft/lbs)*	4 Nm *(2.9 ft/lbs)*
7	46 *(1,811)*	90 *(3,543)*	50 *(1,969)*	60 Nm *(44.2 ft/lbs)*	8 Nm *(5.9 ft/lbs)*

Wendeplattensorte

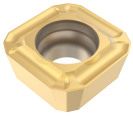
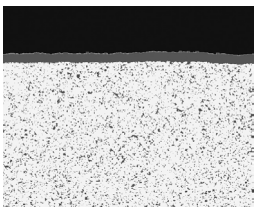
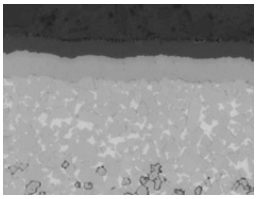
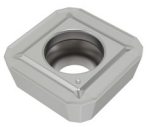
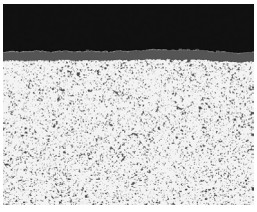
Merkmale:
- 4 Schneiden pro Wendeschneidplatte
- Stabile quadratische Wendeschneidplatten

Ihre Vorteile:
- Wirtschaftlichkeit
- Zuverlässigkeit
- Hochleistung
- Geringe Kosten pro Bohrung

Peripherieschneide

DP2000			DURATOMIC®-Beschichtungstechnologie Optimierte Sorte für die Bearbeitung von Stahl und Guss Für sehr hohe Schnittgeschwindigkeiten Einzigartige Kombination überragender Schneidenzähigkeit und verschleißfester Beschichtung Ti(C,N) + Al_2O_3 DURATOMIC®
DP2501			DURATOMIC®-Technologie Universalsorte Überragende Verschleißfestigkeit und Kantenzähigkeit Zähe Sorte für maximale Anwendungssicherheit Ti(C,N) + Al_2O_3 DURATOMIC® Gradientensubstrat
DS2050			Optimierte Sorte für Titan, Superlegierungen und schwierig zerspanbares Rostfrei PVD beschichtet TiAlN + NbN
T250D			Erste Wahl aus gehärtetem Stahl und Aluminium mit hohem Si-Anteil; scharfe Schneidkante durch Mikrokornsubstrat und PVD-Beschichtung (Ti,Al)N + TiN

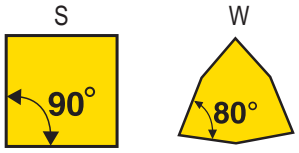
Zentrums-schneide

T400D			Erste Wahl Zähe Sorte für Zentrumsschneide mit maximaler Anwendungssicherheit PVD-beschichtet (Ti, Al)N + TiN
DP2501			DURATOMIC®-Technologie Überragende Verschleißfestigkeit und Kantenzähigkeit Ti(C,N) + Al_2O_3 DURATOMIC® Gradientensubstrat
DS4050			Optimierte Sorte für Titan, Superlegierungen und schwierig zerspanbares Rostfrei PVD beschichtet TiAlN + NbN

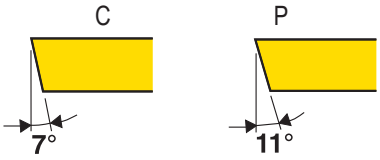
Geometrien

S	C	G	X	06	02	04	–	P1
1	2	3	4	5	6	7		10

1. Wendeplattenform



2. Seitlicher Freiwinkel der Wendeschneidplatte



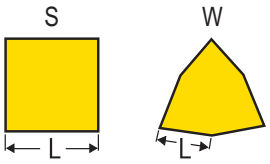
4. Typ

X = Spezial

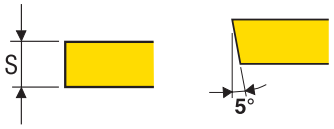
3. Toleranzen

Tol. -Klasse	Toleranz +/- mm (*Zoll*)			Für Durchflusskühlmittelzufuhr, Abmessungen in mm (*Zoll*)								
		S		5,556 (0,2187)	6,35 (0,2500)	7,937 (0,3125)	7,94 (0,3126)	9,525 (0,3750)	11,509 (0,4531)	12,7 (0,5000)	15,875 (0,6250)	19,05 (0,7500)
	m	S	IC									
G	0,025 (0.001)	0,13 (0.005)	0,025 (0.001)	•	•	•		•	•	•	•	•
M	0,013 (0.005)	0,13 (0.005)	0,05 (0.002)	•	•		•	•	•	•	•	•
M	0,013 (0.005)	0,13 (0.005)	0,08 (0.003)							•		

5. Schneidkantenlänge



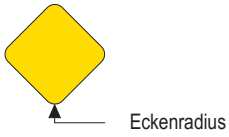
6. Dicke



02 = 2,38 mm *(0.094")*
03 = 3,18 mm *(0.125")*
T3 = 3,97 mm *(0.156")*

04 = 4,76 mm *(0.187")*
05 = 5,56 mm *(0.219")*

7. Wendeplatten mit Eckenfase/Spitzenradius



04 = 0,4 mm *(0.016")*
08 = 0,8 mm *(0.031")*
12 = 1,2 mm *(0.047")*
usw.

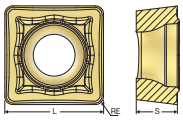
10. Interne Bezeichnung

z. B. Spanbrecher-Bezeichnung

P1 = xx
P2 = xx
85 = xx
86 = xx

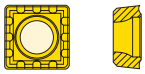
Wendeschneidplatten – Peripherie Wendeplatte Typ P1*

für SD522, SD523, SD524, SD525, SD542, SD602



Toleranzen:
L = ±0,025 (0.001")
S = ±0,13 (0.005")
RE = ±0,1 (0.004")

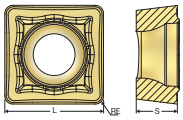
*Spanbrecher für niedrige Vorschubraten und große Oberflächengüte in allen Werkstoffen



Bezeichnung	Wendeschneidplatten	L	S	RE	Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	T250D	DP2000	DP2501
SCGX060204-P1	SCGX-P1	6,35 *0,25*	2,381 *0,094*	0,4 *0,016*	00059712	02590849	10299511
SCGX070308-P1	SCGX-P1	7,938 *0,313*	3,18 *0,125*	0,8 *0,031*	00059713	02590850	10299512
SCGX09T308-P1	SCGX-P1	9,525 *0,375*	3,969 *0,156*	0,8 *0,031*	00059714	02590851	10299509
SCGX11T308-P1	SCGX-P1	11,509 *0,453*	3,97 *0,156*	0,8 *0,031*	03136962	03136963	10299513
SCGX120408-P1	SCGX-P1	12,7 *0,5*	4,762 *0,187*	0,8 *0,031*	00059715	02590852	10299510
SCGX150512-P1	SCGX-P1	15,875 *0,625*	5,556 *0,219*	1,2 *0,047*	00059716	02590853	10299514

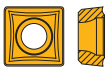
Wendeschneidplatten – Peripherie Wendeplatte Typ P2**

für SD522, SD523, SD524, SD525, SD542, SD602



Toleranzen:
L = ±0,025 (0.001")
S = ±0,13 (0.005")
RE = ±0,1 (0.004")

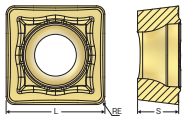
**Spanbrecher für hohe Vorschubweiten in Stahl, Rostfrei und Guss



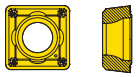
Bezeichnung	Wendeschneidplatten	L	S	RE	Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	T250D	DP2000	DP2501
SCGX050204-P2	SCGX-P2	5,556 *0,219*	2,38 *0,094*	0,4 *0,016*	00059711	02590854	10299502
SCGX060204-P2	SCGX-P2	6,35 *0,25*	2,38 *0,094*	0,4 *0,016*	02526803	02590855	10299503
SCGX070308-P2	SCGX-P2	7,937 *0,312*	3,18 *0,125*	0,8 *0,031*	02526787	02590856	10299504
SCGX09T308-P2	SCGX-P2	9,525 *0,375*	3,97 *0,156*	0,8 *0,031*	02794476	02590857	10299505
SCGX11T308-P2	SCGX-P2	11,509 *0,453*	3,97 *0,156*	0,8 *0,031*	03097760	03097761	10299506
SCGX120408-P2	SCGX-P2	12,7 *0,5*	4,76 *0,187*	0,8 *0,031*	02794477	02590858	10299507
SCGX150512-P2	SCGX-P2	15,875 *0,625*	5,56 *0,219*	1,2 *0,047*	02794478	02590859	10299508

Wendeschneidplatten – Peripherie Wendeplatte, für Typ MP

für SD522, SD523, SD524, SD525, SD542



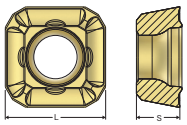
Toleranzen:
L = ±0,025 (0.001")
S = ±0,13 (0.005")
RE = ±0,1 (0.004")



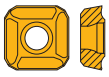
Bezeichnung	Wendeschneidplatten	L	S	RE	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	DS2050
SCGX050204-MP	SCGX-MP	5,56 *0,219*	2,38 *0,094*	0,4 *0,016*	03134312
SCGX060204-MP	SCGX-MP	6,35 *0,25*	6,35 *0,25*	0,4 *0,016*	03134313
SCGX070308-MP	SCGX-MP	7,94 *0,313*	3,18 *0,125*	0,8 *0,031*	03134314
SCGX09T308-MP	SCGX-MP	9,525 *0,375*	3,97 *0,156*	0,8 *0,031*	03134315
SCGX11T308-MP	SCGX-MP	11,509 *0,453*	3,97 *0,156*	0,8 *0,031*	03134316
SCGX120408-MP	SCGX-MP	12,7 *0,5*	4,76 *0,187*	0,8 *0,031*	03134317
SCGX150512-MP	SCGX-MP	15,875 *0,625*	5,56 *0,219*	1,2 *0,047*	03134318

Wendeschneidplatten – Zentrum – Wendeplatte Typ C1

für SD522, SD523, SD524, SD525, SD542, SD602



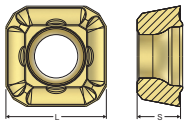
Toleranzen:
L = ±0,025 (0.001")
S = ±0,13 (0.005")



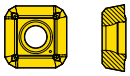
Bezeichnung	Wendeschneidplatten	L	S	Beschichtung	
		mm *Zoll*	mm *Zoll*	T400D	DP2501
SPGX0502-C1	SPGX-C1	5,556 *0,219*	2,38 *0,094*	74077370	10299515
SPGX0602-C1	SPGX-C1	6,35 *0,25*	2,38 *0,094*	74077371	10299516
SPGX0703-C1	SPGX-C1	7,937 *0,312*	3,18 *0,125*	74077372	10299517
SPGX0903-C1	SPGX-C1	9,525 *0,375*	3,18 *0,125*	74077373	10299518
SPGX11T3-C1	SPGX-C1	11,509 *0,453*	3,97 *0,156*	74077374	10299519
SPGX12T3-C1	SPGX-C1	12,7 *0,5*	3,97 *0,156*	74077375	10299520
SPGX1504-C1	SPGX-C1	15,875 *0,625*	4,76 *0,187*	74077376	10299521
SPGX1904-C1	SPGX-C1	19,05 *0,75*	4,76 *0,187*	74077377	10299522

Wendeschneidplatten – Zentrum - Wendeplatte Typ MC

für SD522, SD523, SD524, SD525, SD542



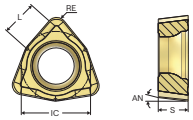
Toleranzen:
L = ±0,025 (0.001")
S = ±0,13 (0.005")



Bezeichnung	Wendeschneidplatten	L	S	Beschichtung
		mm *Zoll*	mm *Zoll*	**DS4050**
SPGX0502-MC	SPGX-MC	5,56 *0,219*	2,38 *0,094*	03134319
SPGX0602-MC	SPGX-MC	6,35 *0,25*	2,38 *0,094*	03134320
SPGX0703-MC	SPGX-MC	7,94 *0,313*	3,18 *0,125*	03134321
SPGX0903-MC	SPGX-MC	9,525 *0,375*	3,18 *0,125*	03134322
SPGX11T3-MC	SPGX-MC	11,509 *0,453*	3,97 *0,156*	03134323
SPGX12T3-MC	SPGX-MC	12,7 *0,5*	3,97 *0,156*	03134324
SPGX1504-MC	SPGX-MC	15,875 *0,625*	4,76 *0,187*	03134325
SPGX1904-MC	SPGX-MC	19,05 *0,75*	4,76 *0,187*	03134326

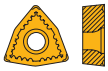
Wendeschneidplatten – Peripherie Wendeplatte Typ 85*

für SD572



Toleranzen:
S = ±0,13 (0.005")
RE = ±0,1 (0.004")

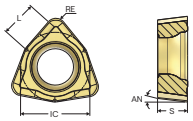
*Spanbrecher für niedrige Vorschubraten und große Oberflächengüte in allen Werkstoffen



Bezeichnung	Wendeschneidplatten	IC	L	S	RE	Beschichtung
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	**DP2501**
WCMX040208-85	WCMX-85	6,35 *0,25*	3,99 *0,157*	2,38 *0,094*	0,8 *0,031*	10299523
WCMX050308-85	WCMX-85	7,94 *0,313*	5,07 *0,2*	3,18 *0,125*	0,8 *0,031*	10299524
WCMX06T308-85	WCMX-85	9,525 *0,375*	6,14 *0,242*	3,97 *0,156*	0,8 *0,031*	10299525
WCMX080412-85	WCMX-85	12,7 *0,5*	8,14 *0,32*	4,76 *0,187*	1,2 *0,047*	10299526

Zentrumsschneide, Peripherieschneide, Typ 86**

für SD572



Toleranzen:
S = ±0,13 (0.005")
RE = ±0,1 (0.004")

**Spanbrecher für hohe Vorschubweiten in Stahl, Rostfrei und Guss

Bezeichnung	Wendeschneidplatten	IC	L	S	RE	Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	T400D	DP2000	DP2501
WCMX030208-86	WCMX-86	5,556 *0,219*	3,46 *0,136*	2,38 *0,094*	0,8 *0,031*	02506629	02899808	10299527
WCMX040208-86	WCMX-86	6,35 *0,25*	3,99 *0,157*	2,38 *0,094*	0,8 *0,031*	02506638	02899809	10299528
WCMX050308-86	WCMX-86	7,94 *0,313*	5,07 *0,2*	3,18 *0,125*	0,8 *0,031*	02506640	02899810	10299529
WCMX06T308-86	WCMX-86	9,525 *0,375*	6,14 *0,242*	3,97 *0,156*	0,8 *0,031*	02506645	02899811	10299530
WCMX080412-86	WCMX-86	12,7 *0,5*	8,14 *0,32*	4,76 *0,187*	1,2 *0,047*	02506646	02899812	10299531

SD522 ∅ **15-60 mm** / *0.590-2.375 Zoll*

SMG		f							v_c
		Ø 15,00-19,49 *Ø 0.590-0.767*	Ø 19,50-22,49 *Ø 0.768-0.885*	Ø 22,50-28,49 *Ø 0.886-1.121*	Ø 28,50-34,49 *Ø 1.122-1.357*	Ø 34,50-40,49 *Ø1.358-1.593*	Ø 40,49-44,49 *Ø 1.594-1.751*	Ø 44,50-59,99 *Ø 1.752-2.375*	
P1	P1 DP2000	0,060	0,070	0,085	0,095	0,11	0,12	0,13	460
	P1 DP2000	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*1500*
P2	P1 DP2000	0,060	0,070	0,085	0,10	0,11	0,12	0,13	450
	P1 DP2000	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0048*	*0.0050*	*1475*
P3	P2 DP2501	0,12	0,14	0,17	0,19	0,22	0,22	0,26	345
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*1125*
P4	P2 DP2501	0,12	0,13	0,16	0,19	0,22	0,22	0,25	230
	P2 DP2501	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*750*
P5	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	220
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*720*
P6	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	250
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*820*
P7	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	235
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*770*
P8	P2 DP2501	0,12	0,14	0,17	0,19	0,22	0,22	0,26	220
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*720*
P11	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	230
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*750*
P12	P2 DP2501	0,075	0,090	0,11	0,12	0,14	0,15	0,17	135
	P2 DP2501	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*445*
M1	P2 DP2501	0,085	0,10	0,12	0,14	0,16	0,17	0,19	240
	P2 DP2501	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*790*
M2	P2 DP2501	0,080	0,090	0,11	0,13	0,14	0,15	0,17	195
	P2 DP2501	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*640*
M3	MP DS2050	0,065	0,075	0,090	0,10	0,12	0,13	0,14	160
	MP DS2050	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*520*
M4	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	140
	MP DS2050	*0.0022*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0048*	*460*
M5	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	115
	MP DS2050	*0.0022*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0048*	*375*
K1	P2 DP2000	0,12	0,14	0,17	0,20	0,22	0,24	0,26	250
	P2 DP2000	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*820*
K2	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	215
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*710*
K3	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	185
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*610*
K4	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	175
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*570*
K5	P2 DP2000	0,10	0,11	0,14	0,16	0,18	0,19	0,22	105
	P2 DP2000	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0085*	*345*
N1	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	365
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*1200*
N2	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	235
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*770*
N3	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	155
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*510*
N11	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	310
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*1025*
S1	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	60
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*195*
S2	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	48
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*155*
S3	MP DS2050	0,085	0,10	0,12	0,14	0,16	0,17	0,19	41
	MP DS2050	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*135*
S11	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	85
	MP DS2050	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0095*	*280*
S12	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	65
	MP DS2050	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0095*	*215*
S13	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	50
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*165*
H3	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	70
	P1 T250D	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0044*	*230*
H5	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	130
	P1 T250D	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*425*
H7	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	70
	P1 T250D	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0044*	*230*
H8	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	130
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*425*
H11	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	165
	P1 T250D	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*540*
H12	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	150
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*490*
H21	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	130
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*425*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD522 Schnittgeschwindigkeit

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	460 *1500*	415 *1350*	415 *1350*	315 *1025*	415 *1350*
P2	450 *1475*	405 *1325*	405 *1325*	305 *1000*	405 *1325*
P3	385 *1275*	345 *1125*	345 *1125*	265 *870*	345 *1125*
P4	285 *940*	230 *750*	220 *720*	140 *460*	— —
P5	270 *890*	220 *720*	210 *690*	135 *445*	— —
P6	305 *1000*	250 *820*	240 *790*	150 *490*	— —
P7	285 *940*	235 *770*	225 *740*	140 *460*	— —
P8	270 *890*	220 *720*	210 *690*	135 *445*	— —
P11	280 *920*	230 *750*	220 *720*	140 *460*	— —
P12	165 *540*	135 *445*	130 *425*	80 *260*	— —
M1	— —	240 *790*	260 *850*	160 *520*	— —
M2	— —	195 *640*	210 *690*	130 *425*	— —
M3	— —	160 *520*	160 *520*	100 *330*	160 *520*
M4	— —	120 *395*	120 *395*	75 *245*	140 *460*
M5	— —	100 *330*	100 *330*	60 *195*	115 *375*
K1	250 *820*	235 *770*	235 *770*	— —	— —
K2	215 *710*	205 *670*	205 *670*	— —	— —
K3	185 *610*	175 *570*	175 *570*	— —	— —
K4	175 *570*	165 *540*	165 *540*	— —	— —
K5	105 *345*	100 *330*	100 *330*	— —	— —
N1	— —	420 *1375*	420 *1375*	365 *1200*	365 *1200*
N2	— —	270 *890*	270 *890*	235 *770*	235 *770*
N3	— —	180 *590*	180 *590*	155 *510*	155 *510*
N11	— —	350 *1150*	350 *1150*	310 *1025*	310 *1025*
S1	— —	— —	— —	40 *130*	60 *195*
S2	— —	— —	— —	30 *100*	48 *155*
S3	— —	— —	— —	30 *100*	41 *135*
S11	— —	— —	— —	80 *260*	85 *280*
S12	— —	— —	— —	60 *195*	65 *215*
S13	— —	— —	— —	46 *150*	50 *165*
H3	— —	33 *110*	70 *230*	70 *230*	— —
H5	— —	60 *195*	130 *425*	130 *425*	— —
H7	— —	33 *110*	70 *230*	70 *230*	— —
H8	— —	60 *195*	130 *425*	130 *425*	— —
H11	— —	80 *260*	165 *540*	165 *540*	— —
H12	— —	70 *230*	75 *245*	150 *490*	— —
H21	— —	130 *425*	130 *425*	130 *425*	— —

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD523 ∅ **15-60 mm** / *0.590-2.375 Zoll*

SMG		f							v_c
		Ø 15,00-19,49 *Ø 0.590-0.767*	Ø 19,50-22,49 *Ø 0.768-0.885*	Ø 22,50-28,49 *Ø 0.886-1.121*	Ø 28,50-34,49 *Ø 1.122-1.357*	Ø 34,50-40,49 *Ø1.358-1.593*	Ø 40,49-44,49 *Ø 1.594-1.751*	Ø 44,50-59,99 *Ø 1.752-2.375*	
P1	P1 DP2000	0,060	0,070	0,085	0,095	0,11	0,12	0,13	415
	P1 DP2000	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*1350*
P2	P1 DP2000	0,060	0,070	0,085	0,10	0,11	0,12	0,13	405
	P1 DP2000	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0048*	*0.0050*	*1325*
P3	P2 DP2501	0,12	0,14	0,17	0,19	0,22	0,22	0,26	310
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*1025*
P4	P2 DP2501	0,12	0,13	0,16	0,19	0,22	0,22	0,25	210
	P2 DP2501	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*690*
P5	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	200
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*660*
P6	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	225
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*740*
P7	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	210
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*690*
P8	P2 DP2501	0,12	0,14	0,17	0,19	0,22	0,22	0,26	200
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*660*
P11	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	205
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*670*
P12	P2 DP2501	0,075	0,090	0,11	0,12	0,14	0,15	0,17	120
	P2 DP2501	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*395*
M1	P2 DP2501	0,085	0,10	0,12	0,14	0,16	0,17	0,19	225
	P2 DP2501	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*740*
M2	P2 DP2501	0,080	0,090	0,11	0,13	0,14	0,15	0,17	185
	P2 DP2501	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*610*
M3	MP DS2050	0,065	0,075	0,090	0,10	0,12	0,13	0,14	150
	MP DS2050	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*490*
M4	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	120
	MP DS2050	*0.0022*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0048*	*395*
M5	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	100
	MP DS2050	*0.0022*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0048*	*330*
K1	P2 DP2000	0,12	0,14	0,17	0,20	0,22	0,24	0,26	225
	P2 DP2000	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*740*
K2	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	195
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*640*
K3	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	165
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*540*
K4	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	160
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*520*
K5	P2 DP2000	0,10	0,11	0,14	0,16	0,18	0,19	0,22	95
	P2 DP2000	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0085*	*310*
N1	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	310
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*1025*
N2	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	200
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*660*
N3	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	135
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*445*
N11	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	260
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*850*
S1	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	55
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*180*
S2	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	43
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*140*
S3	MP DS2050	0,085	0,10	0,12	0,14	0,16	0,17	0,19	37
	MP DS2050	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*120*
S11	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	75
	MP DS2050	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0095*	*245*
S12	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	60
	MP DS2050	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0095*	*195*
S13	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	45
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*150*
H3	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	60
	P1 T250D	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0044*	*195*
H5	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	110
	P1 T250D	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*360*
H7	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	60
	P1 T250D	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0044*	*195*
H8	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	110
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*360*
H11	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	140
	P1 T250D	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*460*
H12	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	130
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*425*
H21	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	110
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*360*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD523 Schnittgeschwindigkeit

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	415 *1350*	370 *1225*	370 *1225*	265 *870*	370 *1225*
P2	405 *1325*	360 *1175*	360 *1175*	260 *850*	360 *1175*
P3	345 *1125*	310 *1025*	310 *1025*	225 *740*	310 *1025*
P4	230 *750*	210 *690*	200 *660*	120 *395*	— —
P5	220 *720*	200 *660*	190 *620*	115 *375*	— —
P6	250 *820*	225 *740*	215 *710*	130 *425*	— —
P7	235 *770*	210 *690*	200 *660*	120 *395*	— —
P8	220 *720*	200 *660*	190 *620*	115 *375*	— —
P11	225 *740*	205 *670*	195 *640*	115 *375*	— —
P12	135 *445*	120 *395*	115 *375*	70 *230*	— —
M1	— —	225 *740*	245 *800*	135 *445*	— —
M2	— —	185 *610*	195 *640*	110 *360*	— —
M3	— —	150 *490*	150 *490*	85 *280*	150 *490*
M4	— —	115 *375*	115 *375*	65 *215*	120 *395*
M5	— —	95 *310*	95 *310*	55 *180*	100 *330*
K1	225 *740*	215 *710*	215 *710*	— —	— —
K2	195 *640*	185 *610*	185 *610*	— —	— —
K3	165 *540*	160 *520*	160 *520*	— —	— —
K4	160 *520*	150 *490*	150 *490*	— —	— —
K5	95 *310*	90 *295*	90 *295*	— —	— —
N1	— —	360 *1175*	360 *1175*	310 *1025*	310 *1025*
N2	— —	230 *750*	230 *750*	200 *660*	200 *660*
N3	— —	155 *510*	155 *510*	135 *445*	135 *445*
N11	— —	300 *980*	300 *980*	260 *850*	260 *850*
S1	— —	— —	— —	34 *110*	55 *180*
S2	— —	— —	— —	25 *80*	43 *140*
S3	— —	— —	— —	25 *80*	37 *120*
S11	— —	— —	— —	65 *215*	75 *245*
S12	— —	— —	— —	50 *165*	60 *195*
S13	— —	— —	— —	39 *130*	45 *150*
H3	— —	29 *95*	60 *195*	60 *195*	— —
H5	— —	55 *180*	115 *375*	110 *360*	— —
H7	— —	29 *95*	60 *195*	60 *195*	— —
H8	— —	55 *180*	115 *375*	110 *360*	— —
H11	— —	70 *230*	145 *475*	140 *460*	— —
H12	— —	65 *215*	70 *230*	130 *425*	— —
H21	— —	115 *375*	115 *375*	110 *360*	— —

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD524 ∅ **15-60 mm** / *0.590-2.375 Zoll*

SMG		f							v_c
		Ø 15,00-19,49 *Ø 0.590-0.767*	Ø 19,50-22,49 *Ø 0.768-0.885*	Ø 22,50-28,49 *Ø 0.886-1.121*	Ø 28,50-34,49 *Ø 1.122-1.357*	Ø 34,50-40,49 *Ø1.358-1.593*	Ø 40,49-44,49 *Ø 1.594-1.751*	Ø 44,50-59,99 *Ø 1.752-2.375*	
P1	P1 DP2000	0,060	0,070	0,085	0,095	0,11	0,12	0,13	380
	P1 DP2000	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*1250*
P2	P1 DP2000	0,060	0,070	0,085	0,10	0,11	0,12	0,13	370
	P1 DP2000	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0048*	*0.0050*	*1225*
P3	P2 DP2501	0,12	0,14	0,17	0,19	0,22	0,22	0,26	285
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*940*
P4	P2 DP2501	0,12	0,13	0,16	0,19	0,22	0,22	0,25	190
	P2 DP2501	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*620*
P5	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	185
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*610*
P6	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	205
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*670*
P7	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	195
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*640*
P8	P2 DP2501	0,12	0,14	0,17	0,19	0,22	0,22	0,26	185
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*610*
P11	P2 DP2501	0,11	0,13	0,16	0,18	0,20	0,22	0,25	190
	P2 DP2501	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*620*
P12	P2 DP2501	0,075	0,090	0,11	0,12	0,14	0,15	0,17	110
	P2 DP2501	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*360*
M1	P2 DP2501	0,085	0,10	0,12	0,14	0,16	0,17	0,19	215
	P2 DP2501	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*710*
M2	P2 DP2501	0,080	0,090	0,11	0,13	0,14	0,15	0,17	175
	P2 DP2501	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*570*
M3	MP DS2050	0,065	0,075	0,090	0,10	0,12	0,13	0,14	145
	MP DS2050	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*475*
M4	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	105
	MP DS2050	*0.0022*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0048*	*345*
M5	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	90
	MP DS2050	*0.0022*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*0.0048*	*295*
K1	P2 DP2000	0,12	0,14	0,17	0,20	0,22	0,24	0,26	210
	P2 DP2000	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*690*
K2	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	180
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*590*
K3	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	155
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*510*
K4	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	145
	P2 DP2000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.0095*	*475*
K5	P2 DP2000	0,10	0,11	0,14	0,16	0,18	0,19	0,22	85
	P2 DP2000	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0075*	*0.0085*	*280*
N1	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	270
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*890*
N2	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	175
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*570*
N3	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	115
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*375*
N11	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	230
	P1 T250D	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*0.010*	*750*
S1	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	48
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*155*
S2	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	39
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*130*
S3	MP DS2050	0,085	0,10	0,12	0,14	0,16	0,17	0,19	33
	MP DS2050	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*110*
S11	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	70
	MP DS2050	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0095*	*230*
S12	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	55
	MP DS2050	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0075*	*0.0080*	*0.0095*	*180*
S13	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	41
	MP DS2050	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0080*	*135*
H3	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	50
	P1 T250D	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0044*	*165*
H5	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	95
	P1 T250D	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*310*
H7	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	50
	P1 T250D	*0.0020*	*0.0024*	*0.0028*	*0.0032*	*0.0038*	*0.0040*	*0.0044*	*165*
H8	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	95
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*310*
H11	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	125
	P1 T250D	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*410*
H12	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	110
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*360*
H21	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	95
	P1 T250D	*0.0024*	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0044*	*0.0050*	*310*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD524 Schnittgeschwindigkeit

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	380 *1250*	340 *1125*	340 *1125*	230 *750*	340 *1125*
P2	370 *1225*	330 *1075*	330 *1075*	225 *740*	330 *1075*
P3	320 *1050*	285 *940*	285 *940*	195 *640*	285 *940*
P4	195 *640*	190 *620*	185 *610*	105 *345*	— —
P5	185 *610*	185 *610*	175 *570*	100 *330*	— —
P6	210 *690*	205 *670*	195 *640*	110 *360*	— —
P7	195 *640*	195 *640*	185 *610*	105 *345*	— —
P8	185 *610*	185 *610*	175 *570*	100 *330*	— —
P11	190 *620*	190 *620*	180 *590*	100 *330*	— —
P12	110 *360*	110 *360*	105 *345*	60 *195*	— —
M1	— —	215 *710*	235 *770*	120 *395*	— —
M2	— —	175 *570*	190 *620*	95 *310*	— —
M3	— —	145 *475*	145 *475*	75 *245*	145 *475*
M4	— —	110 *360*	110 *360*	55 *180*	105 *345*
M5	— —	90 *295*	90 *295*	46 *150*	90 *295*
K1	210 *690*	200 *660*	200 *660*	— —	— —
K2	180 *590*	170 *560*	170 *560*	— —	— —
K3	155 *510*	145 *475*	145 *475*	— —	— —
K4	145 *475*	140 *460*	140 *460*	— —	— —
K5	85 *280*	85 *280*	85 *280*	— —	— —
N1	— —	315 *1025*	315 *1025*	270 *890*	270 *890*
N2	— —	205 *670*	205 *670*	175 *570*	175 *570*
N3	— —	135 *445*	135 *445*	115 *375*	115 *375*
N11	— —	265 *870*	265 *870*	230 *750*	230 *750*
S1	— —	— —	— —	29 *95*	48 *155*
S2	— —	— —	— —	22 *70*	39 *130*
S3	— —	— —	— —	22 *70*	33 *110*
S11	— —	— —	— —	55 *180*	70 *230*
S12	— —	— —	— —	44 *145*	55 *180*
S13	— —	— —	— —	34 *110*	41 *135*
H3	— —	27 *90*	55 *180*	50 *165*	— —
H5	— —	50 *165*	100 *330*	95 *310*	— —
H7	— —	27 *90*	55 *180*	50 *165*	— —
H8	— —	50 *165*	100 *330*	95 *310*	— —
H11	— —	65 *215*	125 *410*	125 *410*	— —
H12	— —	60 *195*	65 *215*	110 *360*	— —
H21	— —	100 *330*	100 *330*	95 *310*	— —

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD525 ∅ **19-45 mm** / *0.768-2.000 Zoll*

SMG		f					v_c
		Ø 19,50-22,49 *Ø 0.768-0.885*	Ø 22,50-28,49 *Ø 0.886-1.121*	Ø 28,50-34,49 *Ø 1.122-1.357*	Ø 34,50-40,49 *Ø1.358-1.593*	Ø 40,49-45,00 *Ø 1.594-2.000*	
P1	P2 DP2501 *P2 DP2501*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	320 *1050*
P2	P2 DP2501 *P2 DP2501*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	310 *1025*
P3	P2 DP2501 *P2 DP2501*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,22 *0.0085*	265 *870*
P4	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,22 *0.0085*	180 *590*
P5	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	170 *560*
P6	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	190 *620*
P7	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	180 *590*
P8	P2 DP2501 *P2 DP2501*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,22 *0.0085*	170 *560*
P11	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	175 *570*
P12	P2 DP2501 *P2 DP2501*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	105 *345*
M1	P2 DP2501 *P2 DP2501*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,17 *0.0065*	210 *690*
M2	P2 DP2501 *P2 DP2501*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	0,15 *0.0060*	170 *560*
M3	MP DS2050 *MP DS2050*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 *460*
M4	MP DS2050 *MP DS2050*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	95 *310*
M5	MP DS2050 *MP DS2050*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 *260*
K1	P2 DP2501 *P2 DP2501*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	185 *610*
K2	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	160 *520*
K3	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	135 *445*
K4	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	130 *425*
K5	P2 DP2501 *P2 DP2501*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	80 *260*
N1	P1 T250D *P1 T250D*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	240 *790*
N2	P1 T250D *P1 T250D*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	155 *510*
N3	P1 T250D *P1 T250D*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	100 *330*
N11	P1 T250D *P1 T250D*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	200 *660*
S1	MP DS2050 *MP DS2050*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	44 *145*
S2	MP DS2050 *MP DS2050*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	36 *120*
S3	MP DS2050 *MP DS2050*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,17 *0.0065*	31 *100*
S11	MP DS2050 *MP DS2050*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	0,20 *0.0080*	65 *215*
S12	MP DS2050 *MP DS2050*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	0,20 *0.0080*	49 *160*
S13	MP DS2050 *MP DS2050*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,18 *0.0070*	38 *125*
H3	P1 T250D *P1 T250D*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,10 *0.0040*	46 *150*
H5	P1 T250D *P1 T250D*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	85 *280*
H7	P1 T250D *P1 T250D*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,10 *0.0040*	46 *150*
H8	P1 T250D *P1 T250D*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,11 *0.0044*	85 *280*
H11	P1 T250D *P1 T250D*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	110 *360*
H12	P1 T250D *P1 T250D*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,11 *0.0044*	100 *330*
H21	P1 T250D *P1 T250D*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,11 *0.0044*	85 *280*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD525 Schnittgeschwindigkeit

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	355 *1175*	320 *1050*	320 *1050*	205 *670*	320 *1050*
P2	345 *1125*	310 *1025*	310 *1025*	200 *660*	310 *1025*
P3	295 *970*	265 *870*	265 *870*	170 *560*	265 *870*
P4	165 *540*	180 *590*	170 *560*	90 *295*	— —
P5	155 *510*	170 *560*	165 *540*	90 *295*	— —
P6	175 *570*	190 *620*	180 *590*	100 *330*	— —
P7	165 *540*	180 *590*	170 *560*	95 *310*	— —
P8	155 *510*	170 *560*	165 *540*	90 *295*	— —
P11	160 *520*	175 *570*	165 *540*	90 *295*	— —
P12	95 *310*	105 *345*	100 *330*	55 *180*	— —
M1	— —	210 *690*	225 *740*	105 *345*	— —
M2	— —	170 *560*	180 *590*	85 *280*	— —
M3	— —	140 *460*	140 *460*	65 *215*	140 *460*
M4	— —	105 *345*	105 *345*	49 *160*	95 *310*
M5	— —	85 *280*	85 *280*	41 *135*	80 *260*
K1	195 *640*	185 *610*	185 *610*	— —	— —
K2	170 *560*	160 *520*	160 *520*	— —	— —
K3	145 *475*	135 *445*	135 *445*	— —	— —
K4	140 *460*	130 *425*	130 *425*	— —	— —
K5	80 *260*	80 *260*	80 *260*	— —	— —
N1	— —	285 *940*	285 *940*	240 *790*	240 *790*
N2	— —	185 *610*	185 *610*	155 *510*	155 *510*
N3	— —	120 *395*	120 *395*	100 *330*	100 *330*
N11	— —	235 *770*	235 *770*	200 *660*	200 *660*
S1	— —	— —	— —	26 *85*	44 *145*
S2	— —	— —	— —	20 *65*	36 *120*
S3	— —	— —	— —	20 *65*	31 *100*
S11	— —	— —	— —	50 *165*	65 *215*
S12	— —	— —	— —	39 *130*	49 *160*
S13	— —	— —	— —	30 *100*	38 *125*
H3	— —	25 *80*	48 *155*	46 *150*	— —
H5	— —	47 *155*	90 *295*	85 *280*	— —
H7	— —	25 *80*	48 *155*	46 *150*	— —
H8	— —	47 *155*	90 *295*	85 *280*	— —
H11	— —	60 *195*	115 *375*	110 *360*	— —
H12	— —	55 *180*	60 *195*	100 *330*	— —
H21	— —	90 *295*	90 *295*	85 *280*	— —

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD5301 & SD5402 ∅ 60-85 mm / *2.250-3.500 Zoll*

SMG		f		v_c
		Ø60,00-65,00 *Ø 2.250-2.559*	Ø70,00-85,00 *Ø 2.750-3.500*	
P1	P2 DP2501 *P2 DP2501*	0,095 *0.0038*	0,12 *0.0048*	390 *1275*
P2	P2 DP2501 *P2 DP2501*	0,10 *0.0040*	0,12 *0.0048*	380 *1250*
P3	P2 DP2501 *P2 DP2501*	0,19 *0.0075*	0,22 *0.0085*	325 *1075*
P4	P2 DP2501 *P2 DP2501*	0,19 *0.0075*	0,22 *0.0085*	220 *720*
P5	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	210 *690*
P6	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	235 *770*
P7	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	220 *720*
P8	P2 DP2501 *P2 DP2501*	0,19 *0.0075*	0,22 *0.0085*	210 *690*
P11	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	215 *710*
P12	P2 DP2501 *P2 DP2501*	0,12 *0.0048*	0,15 *0.0060*	125 *410*
M1	P2 DP2501 *P2 DP2501*	0,14 *0.0055*	0,17 *0.0065*	235 *770*
M2	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,15 *0.0060*	190 *620*
M3	P1 T250D *P1 T250D*	0,10 *0.0040*	0,12 *0.0048*	90 *295*
M4	P1 T250D *P1 T250D*	0,090 *0.0036*	0,11 *0.0044*	70 *230*
M5	P1 T250D *P1 T250D*	0,090 *0.0036*	0,11 *0.0044*	55 *180*
K1	P2 DP2501 *P2 DP2501*	0,20 *0.0080*	0,24 *0.0095*	225 *740*
K2	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	195 *640*
K3	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	165 *540*
K4	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	160 *520*
K5	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,19 *0.0075*	95 *310*
N1	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	335 *1100*
N2	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	215 *710*
N3	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	145 *475*
N11	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	285 *940*
S1	MP DS2050 *MP DS2050*	0,15 *0.0060*	0,18 *0.0070*	55 *180*
S2	MP DS2050 *MP DS2050*	0,15 *0.0060*	0,18 *0.0070*	45 *150*
S3	MP DS2050 *MP DS2050*	0,14 *0.0055*	0,17 *0.0065*	39 *130*
S11	MP DS2050 *MP DS2050*	0,17 *0.0065*	0,20 *0.0080*	80 *260*
S12	MP DS2050 *MP DS2050*	0,17 *0.0065*	0,20 *0.0080*	60 *195*
S13	MP DS2050 *MP DS2050*	0,15 *0.0060*	0,18 *0.0070*	48 *155*
H3	P1 T250D *P1 T250D*	0,080 *0.0032*	0,10 *0.0040*	65 *215*
H5	P1 T250D *P1 T250D*	0,12 *0.0048*	0,15 *0.0060*	120 *395*
H7	P1 T250D *P1 T250D*	0,080 *0.0032*	0,10 *0.0040*	65 *215*
H8	P1 T250D *P1 T250D*	0,095 *0.0038*	0,11 *0.0044*	120 *395*
H11	P1 T250D *P1 T250D*	0,12 *0.0048*	0,15 *0.0060*	155 *510*
H12	P1 T250D *P1 T250D*	0,095 *0.0038*	0,11 *0.0044*	140 *460*
H21	P1 T250D *P1 T250D*	0,095 *0.0038*	0,11 *0.0044*	120 *395*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD5301 & SD5402 Schnittgeschwindigkeit

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	435 *1425*	390 *1275*	390 *1275*	290 *950*	390 *1275*
P2	425 *1400*	380 *1250*	380 *1250*	280 *920*	380 *1250*
P3	365 *1200*	325 *1075*	325 *1075*	240 *790*	325 *1075*
P4	255 *840*	220 *720*	210 *690*	130 *425*	— —
P5	245 *800*	210 *690*	200 *660*	125 *410*	— —
P6	275 *900*	235 *770*	225 *740*	140 *460*	— —
P7	260 *850*	220 *720*	210 *690*	130 *425*	— —
P8	245 *800*	210 *690*	200 *660*	125 *410*	— —
P11	250 *820*	215 *710*	205 *670*	125 *410*	— —
P12	150 *490*	125 *410*	120 *395*	75 *245*	— —
M1	— —	235 *770*	250 *820*	150 *490*	— —
M2	— —	190 *620*	205 *670*	120 *395*	— —
M3	— —	155 *510*	155 *510*	90 *295*	155 *510*
M4	— —	115 *375*	115 *375*	70 *230*	130 *425*
M5	— —	95 *310*	95 *310*	55 *180*	105 *345*
K1	235 *770*	225 *740*	225 *740*	— —	— —
K2	205 *670*	195 *640*	195 *640*	— —	— —
K3	175 *570*	165 *540*	165 *540*	— —	— —
K4	165 *540*	160 *520*	160 *520*	— —	— —
K5	100 *330*	95 *310*	95 *310*	— —	— —
N1	— —	390 *1275*	390 *1275*	335 *1100*	335 *1100*
N2	— —	250 *820*	250 *820*	215 *710*	215 *710*
N3	— —	165 *540*	165 *540*	145 *475*	145 *475*
N11	— —	325 *1075*	325 *1075*	285 *940*	285 *940*
S1	— —	— —	— —	37 *120*	55 *180*
S2	— —	— —	— —	27 *90*	45 *150*
S3	— —	— —	— —	27 *90*	39 *130*
S11	— —	— —	— —	70 *230*	80 *260*
S12	— —	— —	— —	55 *180*	60 *195*
S13	— —	— —	— —	43 *140*	48 *155*
H3	— —	31 *100*	65 *215*	65 *215*	— —
H5	— —	60 *195*	120 *395*	120 *395*	— —
H7	— —	31 *100*	65 *215*	65 *215*	— —
H8	— —	60 *195*	120 *395*	120 *395*	— —
H11	— —	75 *245*	155 *510*	155 *510*	— —
H12	— —	65 *215*	70 *230*	140 *460*	— —
H21	— —	120 *395*	120 *395*	120 *395*	— —

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD5702 ∅ 15-52 mm / *0.590-2.0472 Zoll*

SMG		f						v_c
		Ø15,00-17,00 *Ø 0.590-0.669*	Ø18,00-20,00 *Ø 0.670-0.787*	Ø21,00-24,00 *Ø 0.788-0.944*	Ø25,00-32,00 *Ø 0.945-1.259*	Ø33,00-36,00 *Ø 1.260-1.417*	Ø37,00-52,00 *Ø 1.418-1.850*	
P1	85 DP2501	0,042	0,042	0,048	0,060	0,070	0,085	325
	85 DP2501	*0.0017*	*0.0017*	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*1075*
P2	85 DP2501	0,042	0,042	0,050	0,060	0,070	0,085	320
	85 DP2501	*0.0017*	*0.0017*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*1050*
P3	86 DP2501	0,080	0,080	0,090	0,11	0,13	0,16	275
	86 DP2501	*0.0032*	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*900*
P4	86 DP2501	0,080	0,080	0,090	0,11	0,13	0,16	240
	86 DP2501	*0.0032*	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*790*
P5	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	230
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*750*
P6	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	260
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*850*
P7	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	245
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*800*
P8	86 DP2501	0,080	0,080	0,090	0,11	0,13	0,16	230
	86 DP2501	*0.0032*	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*750*
P11	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	235
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*770*
P12	86 DP2501	0,050	0,050	0,060	0,075	0,085	0,10	140
	86 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*460*
M1	86 DP2501	0,048	0,048	0,055	0,065	0,080	0,095	235
	86 DP2501	*0.0019*	*0.0019*	*0.0022*	*0.0026*	*0.0032*	*0.0038*	*770*
M2	86 DP2501	0,042	0,042	0,050	0,060	0,070	0,085	190
	86 DP2501	*0.0017*	*0.0017*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*620*
M3	85 DP2501	0,034	0,034	0,040	0,048	0,055	0,070	145
	85 DP2501	*0.0013*	*0.0013*	*0.0016*	*0.0019*	*0.0022*	*0.0028*	*475*
M4	85 DP2501	0,030	0,030	0,034	0,042	0,050	0,060	110
	85 DP2501	*0.0012*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0024*	*360*
M5	85 DP2501	0,030	0,030	0,034	0,042	0,050	0,060	90
	85 DP2501	*0.0012*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0024*	*295*
K1	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	180
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*590*
K2	86 DP2501	0,070	0,070	0,080	0,10	0,12	0,14	155
	86 DP2501	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*510*
K3	86 DP2501	0,070	0,070	0,080	0,10	0,12	0,14	130
	86 DP2501	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*425*
K4	86 DP2501	0,070	0,070	0,080	0,10	0,12	0,14	125
	86 DP2501	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*410*
K5	86 DP2501	0,065	0,065	0,075	0,090	0,10	0,12	75
	86 DP2501	*0.0026*	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0048*	*245*
S1	85 DP2501	0,055	0,055	0,060	0,075	0,090	0,11	40
	85 DP2501	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*130*
S2	85 DP2501	0,055	0,055	0,060	0,075	0,090	0,11	30
	85 DP2501	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*100*
S3	85 DP2501	0,050	0,050	0,060	0,070	0,085	0,10	30
	85 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*100*
S11	85 DP2501	0,060	0,060	0,070	0,090	0,10	0,12	80
	85 DP2501	*0.0024*	*0.0024*	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*260*
S12	85 DP2501	0,060	0,060	0,070	0,090	0,10	0,12	60
	85 DP2501	*0.0024*	*0.0024*	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*195*
S13	85 DP2501	0,055	0,055	0,060	0,075	0,090	0,11	47
	85 DP2501	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*155*
H3	86 DP2501	0,034	0,034	0,040	0,050	0,055	0,070	80
	86 DP2501	*0.0013*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*0.0028*	*260*
H5	86 DP2501	0,050	0,050	0,060	0,075	0,085	0,10	150
	86 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*490*
H7	86 DP2501	0,034	0,034	0,040	0,050	0,055	0,070	80
	86 DP2501	*0.0013*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*0.0028*	*260*
H8	86 DP2501	0,040	0,040	0,046	0,055	0,065	0,080	150
	86 DP2501	*0.0016*	*0.0016*	*0.0018*	*0.0022*	*0.0026*	*0.0032*	*490*
H11	86 DP2501	0,050	0,050	0,060	0,075	0,085	0,10	195
	86 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*640*
H12	86 DP2501	0,040	0,040	0,046	0,055	0,065	0,080	85
	86 DP2501	*0.0016*	*0.0016*	*0.0018*	*0.0022*	*0.0026*	*0.0032*	*280*
H21	86 DP2501	0,040	0,040	0,046	0,055	0,065	0,080	150
	86 DP2501	*0.0016*	*0.0016*	*0.0018*	*0.0022*	*0.0026*	*0.0032*	*490*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD5702 Schnittgeschwindigkeit

SMG	v_c		
	DP2000	DP2501	DP3000
P1	375 *1225*	325 *1075*	310 *1025*
P2	365 *1200*	320 *1050*	305 *1000*
P3	315 *1025*	275 *900*	260 *850*
P4	280 *920*	240 *790*	230 *750*
P5	265 *870*	230 *750*	220 *720*
P6	300 *980*	260 *850*	245 *800*
P7	280 *920*	245 *800*	235 *770*
P8	265 *870*	230 *750*	220 *720*
P11	275 *900*	235 *770*	225 *740*
P12	160 *520*	140 *460*	135 *445*
M1	285 *940*	235 *770*	235 *770*
M2	230 *750*	190 *620*	190 *620*
M3	175 *570*	145 *475*	145 *475*
M4	130 *425*	110 *360*	110 *360*
M5	110 *360*	90 *295*	90 *295*
K1	215 *710*	180 *590*	180 *590*
K2	185 *610*	155 *510*	155 *510*
K3	160 *520*	130 *425*	130 *425*
K4	150 *490*	125 *410*	125 *410*
K5	90 *295*	75 *245*	75 *245*
S1	— —	40 *130*	40 *130*
S2	— —	30 *100*	30 *100*
S3	— —	30 *100*	30 *100*
S11	— —	80 *260*	80 *260*
S12	— —	60 *195*	60 *195*
S13	— —	47 *155*	47 *155*
H3	80 *260*	80 *260*	80 *260*
H5	150 *490*	150 *490*	150 *490*
H7	80 *260*	80 *260*	80 *260*
H8	150 *490*	150 *490*	150 *490*
H11	195 *640*	195 *640*	195 *640*
H12	95 *310*	85 *280*	80 *260*
H21	150 *490*	150 *490*	150 *490*

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD602 ∅ 60-160 mm / *2.362-6.300 Zoll*

SMG		f					v_c
		Ø60,00-69,99 *Ø 2.362-2.755*	Ø70,00-91,99 *Ø 2.756-3.621*	Ø92,00-110,99 *Ø 3.622-4.369*	Ø111,00-134,99 *Ø 4.370-4.314*	Ø135,00-160,00 *Ø 4.315-6.300*	
P1	P2 DP2501	0,085	0,095	0,12	0,13	0,12	295
	P2 DP2501	*0.0034*	*0.0038*	*0.0048*	*0.0050*	*0.0048*	*970*
P2	P2 DP2501	0,085	0,10	0,12	0,13	0,12	285
	P2 DP2501	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0048*	*940*
P3	P2 DP2501	0,17	0,19	0,22	0,26	0,22	245
	P2 DP2501	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.0085*	*800*
P4	P2 DP2501	0,16	0,19	0,22	0,25	0,22	165
	P2 DP2501	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.0085*	*540*
P5	P2 DP2501	0,16	0,18	0,22	0,25	0,22	160
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*520*
P6	P2 DP2501	0,16	0,18	0,22	0,25	0,22	175
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*570*
P7	P2 DP2501	0,16	0,18	0,22	0,25	0,22	165
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*540*
P8	P2 DP2501	0,17	0,19	0,22	0,26	0,22	160
	P2 DP2501	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.0085*	*520*
P11	P2 DP2501	0,16	0,18	0,22	0,25	0,22	160
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*520*
P12	P2 DP2501	0,11	0,12	0,15	0,17	0,15	95
	P2 DP2501	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0060*	*310*
M1	P2 DP2501	0,12	0,14	0,17	0,19	0,17	200
	P2 DP2501	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0065*	*660*
M2	P2 DP2501	0,11	0,13	0,15	0,17	0,15	160
	P2 DP2501	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0060*	*520*
M3	P1 DP2501	0,090	0,10	0,12	0,14	0,12	135
	P1 DP2501	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*0.0048*	*445*
M4	P1 DP2501	0,075	0,090	0,11	0,12	0,11	100
	P1 DP2501	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0044*	*330*
M5	P1 DP2501	0,075	0,090	0,11	0,12	0,11	85
	P1 DP2501	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0044*	*280*
K1	P2 DP2501	0,17	0,20	0,24	0,26	0,24	175
	P2 DP2501	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.0095*	*570*
K2	P2 DP2501	0,16	0,18	0,22	0,24	0,22	150
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.0085*	*490*
K3	P2 DP2501	0,16	0,18	0,22	0,24	0,22	130
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.0085*	*425*
K4	P2 DP2501	0,16	0,18	0,22	0,24	0,22	120
	P2 DP2501	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.0085*	*395*
K5	P2 DP2501	0,14	0,16	0,19	0,22	0,19	75
	P2 DP2501	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0075*	*245*
H3	P2 DP2501	0,070	0,080	0,10	0,11	0,10	23
	P2 DP2501	*0.0028*	*0.0032*	*0.0040*	*0.0044*	*0.0040*	*75*
H5	P2 DP2501	0,11	0,12	0,15	0,17	0,15	43
	P2 DP2501	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0060*	*140*
H7	P2 DP2501	0,070	0,080	0,10	0,11	0,10	23
	P2 DP2501	*0.0028*	*0.0032*	*0.0040*	*0.0044*	*0.0040*	*75*
H8	P2 DP2501	0,085	0,095	0,11	0,13	0,11	43
	P2 DP2501	*0.0034*	*0.0038*	*0.0044*	*0.0050*	*0.0044*	*140*
H11	P2 DP2501	0,11	0,12	0,15	0,17	0,15	55
	P2 DP2501	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0060*	*180*
H12	P2 DP2501	0,085	0,095	0,11	0,13	0,11	50
	P2 DP2501	*0.0034*	*0.0038*	*0.0044*	*0.0050*	*0.0044*	*165*
H21	P2 DP2501	0,085	0,095	0,11	0,13	0,11	80
	P2 DP2501	*0.0034*	*0.0038*	*0.0044*	*0.0050*	*0.0044*	*260*

SMG = Seco Werkstoff-Gruppe f = mm/U (ipr) v_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

SD602 Schnittgeschwindigkeit

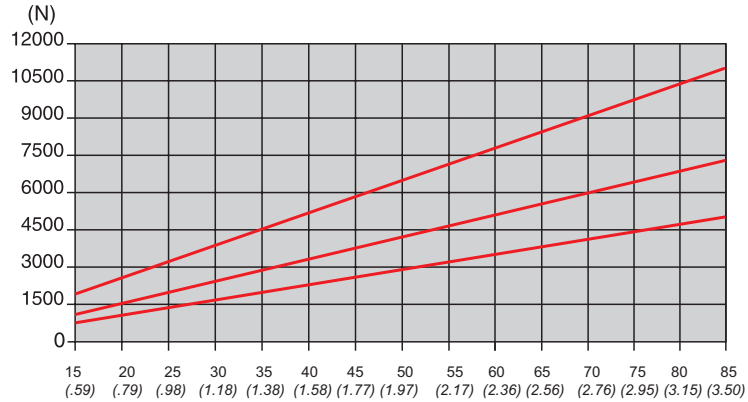
SMG	v_c			
	DP2501	DP3000	T250D	DS2050
P1	295 *970*	295 *970*	180 *590*	295 *970*
P2	285 *940*	285 *940*	175 *570*	285 *940*
P3	245 *800*	245 *800*	150 *490*	245 *800*
P4	165 *540*	160 *520*	80 *260*	— —
P5	160 *520*	150 *490*	75 *245*	— —
P6	175 *570*	170 *560*	85 *280*	— —
P7	165 *540*	160 *520*	80 *260*	— —
P8	160 *520*	150 *490*	75 *245*	— —
P11	160 *520*	155 *510*	80 *260*	— —
P12	95 *310*	90 *295*	46 *150*	— —
M1	200 *660*	215 *710*	90 *295*	— —
M2	160 *520*	175 *570*	75 *245*	— —
M3	135 *445*	135 *445*	55 *180*	135 *445*
M4	100 *330*	100 *330*	43 *140*	85 *280*
M5	85 *280*	85 *280*	36 *120*	70 *230*
K1	175 *570*	175 *570*	— —	— —
K2	150 *490*	150 *490*	— —	— —
K3	130 *425*	130 *425*	— —	— —
K4	120 *395*	120 *395*	— —	— —
K5	75 *245*	75 *245*	— —	— —
H3	23 *75*	42 *140*	40 *130*	— —
H5	43 *140*	80 *260*	75 *245*	— —
H7	23 *75*	42 *140*	40 *130*	— —
H8	43 *140*	80 *260*	75 *245*	— —
H11	55 *180*	100 *330*	95 *310*	— —
H12	50 *165*	55 *180*	85 *280*	— —
H21	80 *260*	80 *260*	75 *245*	— —

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Bearbeitungsparameter SD522, SD523, SD524, SD525, SD5301, SD5402 und SD5702 – Leistungsbedarf, Kühlschmierstoffmenge und Vorschubkraft

Die Grafiken zeigen Basiswerte, die, abhängig von Werkstoff und Schnittdaten sowie den individuellen Bearbeitungsbedingungen, angepasst werden müssen. Die Werte in den Tabellen sind gültig für die Seco Werkstoff-Gruppe (SMG) P5-P6 und Schnittgeschwindigkeiten von 200 m/min (*655 sf/min*).

Vorschubkraft

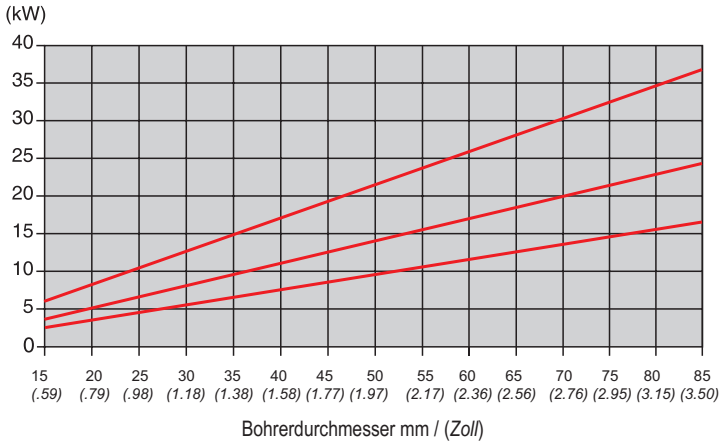


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Leistungsbedarf

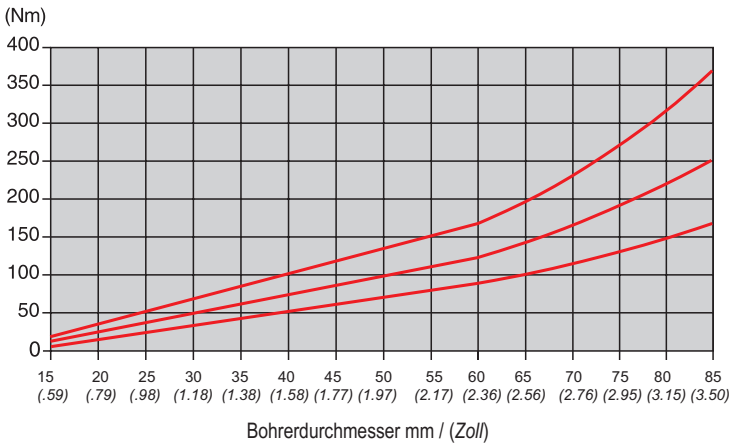


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Drehmoment



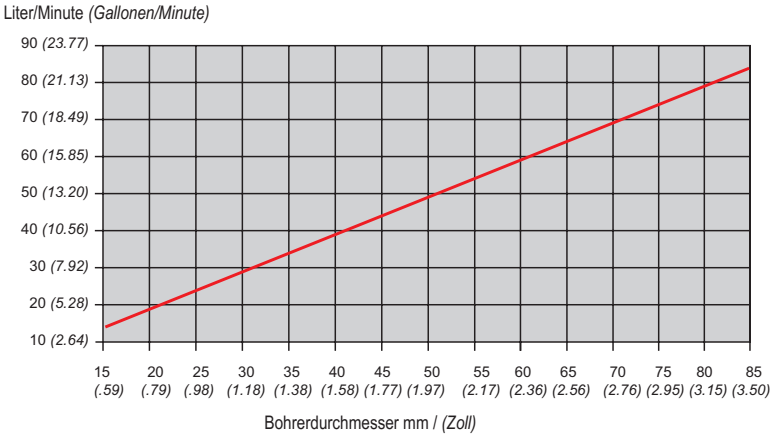
f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Bearbeitungsparameter

Kühlschmierstoffmenge

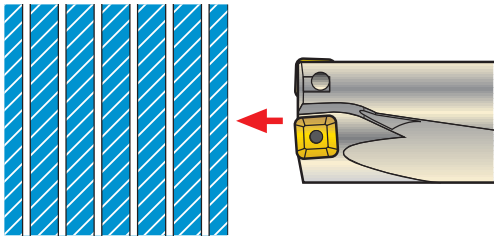


Kühlschmierstoffdruck

Empfohlener Druck bar *(PSI)*

	Bohrerdurchmesser mm (*Zoll*)		
Bohrtiefe	**15–25** *(0.591-0.984)*	**> 25–40** *> 0.984-1.575*	**> 40** *> 1.575*
< 3 x D	6 *(87)*	4,5 *(65)*	3 *(44)*
≥ 3 x D	12 *(174)*	9 *(130)*	6 *(87)*

Bohren von Plattenpaketen



Bohren von Plattenpaketen ohne Zwischenräume, max. 0,2 mm *(0.008")*, möglich mit Bohrer SD522 2 x D, SD523 3 x D und SD542 2,5 x D. Hierfür ist eine sehr stabile Aufspannung erforderlich.

Schnittdaten und Wendeschneidplatten-Empfehlungen zum Bohren von Plattenpaketen

WSP-Geometrie:	**Wendeschneidplatten-Geometrie:**	**Hartmetallsorte**
Zentrum - Wendeplatte	SPGX-C1	T400D
Peripherie Wendeplatte	SCGX-P2	DP2501

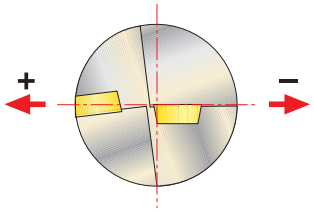
Schnittgeschwindigkeit: Siehe Empfehlung für die Hartmetallsorte DP2501
Vorschub/U: Siehe Empfehlung für Geometrie P2

Wenn der Bohrer die einzelnen Plattenpakete durchbricht und hierbei Probleme auftreten, den Vorschub/U um 30-50% senken.

Achtung!
Bei Austritt des Bohrers aus dem Werkstück (statischer Einsatz, rotierendes Werkstück) wird eine Scheibe mit hoher Geschwindigkeit herausgeschleudert. Nur Drehmaschinen mit entsprechenden Schutzvorrichtungen einsetzen, wenn Plattenpakete gebohrt werden.

Einstellung

Mittenversatz und Bohrereinsatz
Durch Mittenversatz der Wendeplatten-Bohrer können kleinere oder größere Bohrungen als der Bohrerdurchmesser erzielt werden.
Den maximalen und minimalen Mittenversatz finden Sie auf den Katalogseiten.



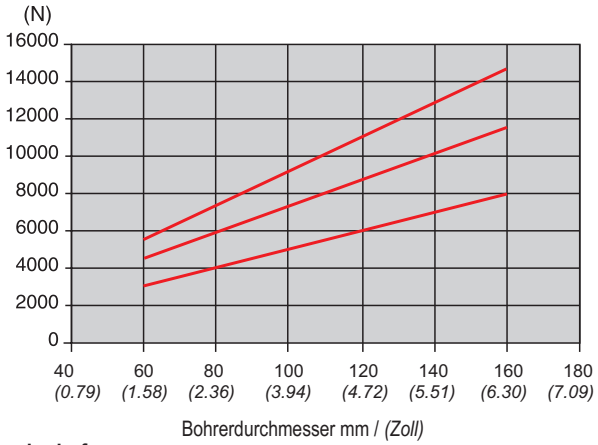
Rotierender Einsatz
Mit der einstellbaren Aufnahme von Seco werden präzise Bohrungen erzielt. Bohrungstoleranz IT10 mit SD522 und SD523, 3 x D bei rotierendem Einsatz.

Statischer Einsatz
Achten Sie bei Aufspannung des Bohrers darauf, dass die Schneidkanten parallel zum Maschinenbett liegen und Bohrermitte und Werkstückmitte auf einer Linie sind. Ein größerer Bohrungsdurchmesser wird durch Mittenversatz des Bohrers in Richtung Peripherieschneide erzielt.

Bearbeitungsparameter SD602 – Leistungsbedarf, Kühlschmierstoff und Vorschubkraft

Die Grafiken zeigen Basiswerte, die, abhängig von Werkstoff und Schnittdaten sowie den individuellen Bearbeitungsbedingungen, angepasst werden müssen. Die Werte in den Tabellen sind gültig für die SMG P5-P6 und Schnittgeschwindigkeiten von 200 m/min (*655 sf/min*).

Vorschubkraft

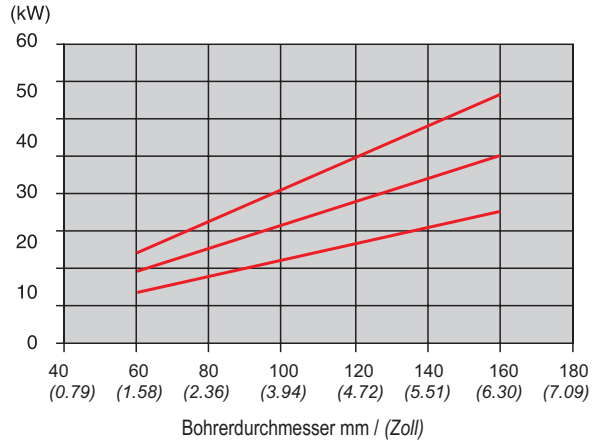


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Leistungsbedarf

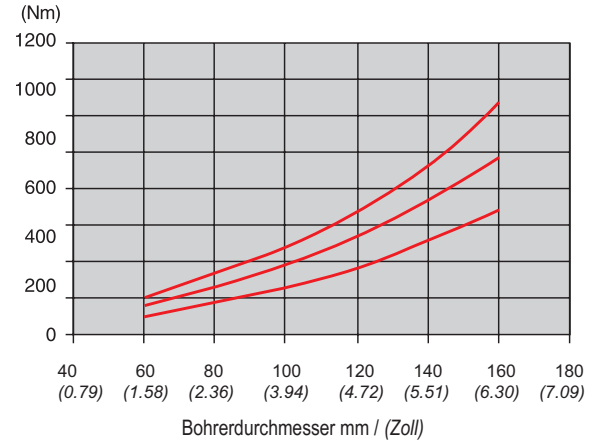


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Drehmoment



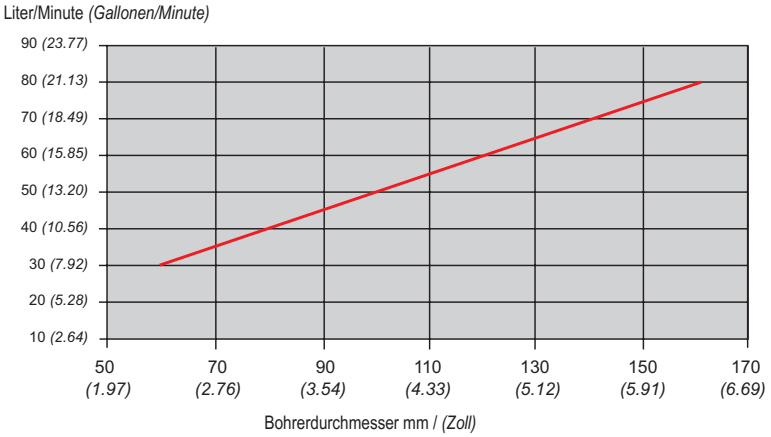
f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

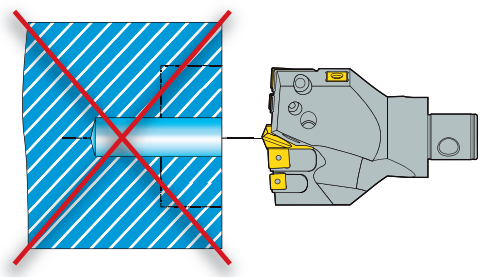
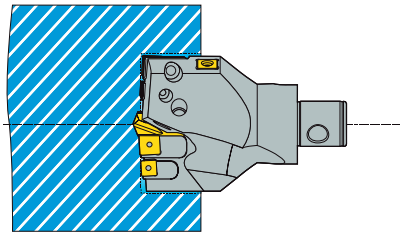
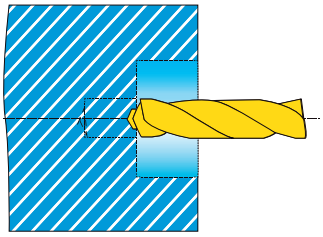
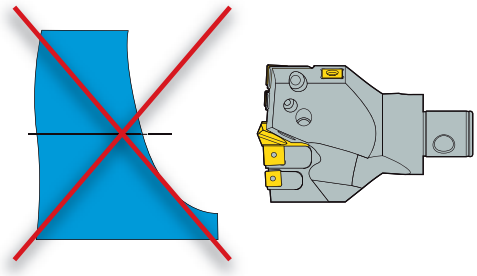
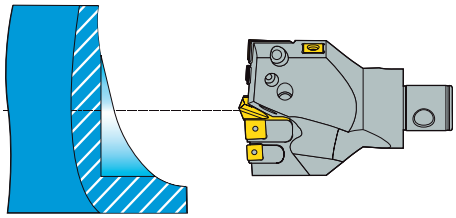
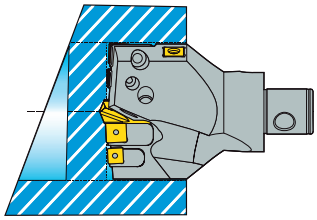
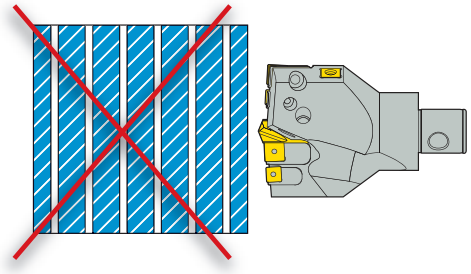
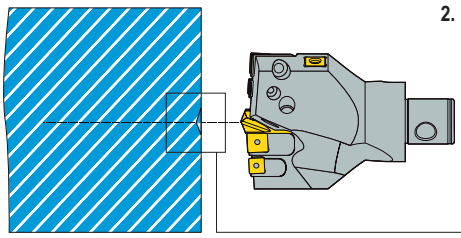
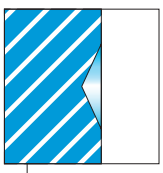
f = 0,08 mm/U
(f = 0.003 "/U)

Bearbeitungsparameter SD602

Kühlschmierstoffmenge



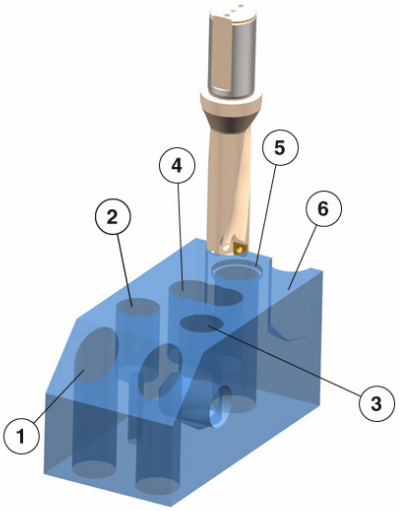
Einsatzbereiche

nicht empfehlenswert	Lösung
	1.  2. 
	1.  2. 
	1.  2.  > 5xD

Vielseitigkeit

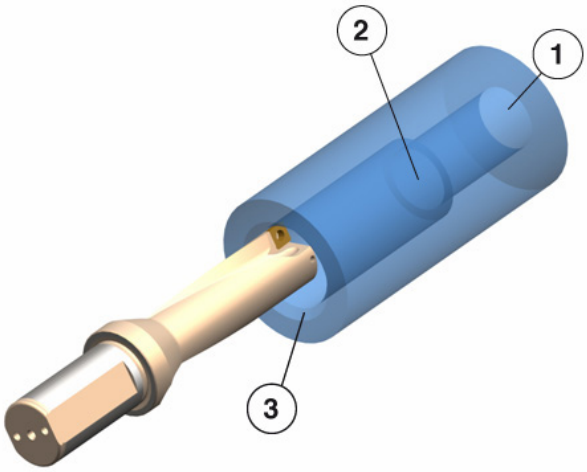
Anwendungsbereiche

1. Bohrungen mit abgewinkeltem Eintritt
2. Ausdrehen
3. Bohrungen durch ein vorhandenes Bohrloch
4. Bohren und Eintauchen
5. Bohren und Ansenken durch Bohrzirkularbearbeitung
6. Tauchfräsen



Mehrfachauswahl bei nichtrotierenden Bearbeitungen

1. Bohren
2. Ausspindeln / Konische Bohrungen
3. Anfasen



Empfehlungen

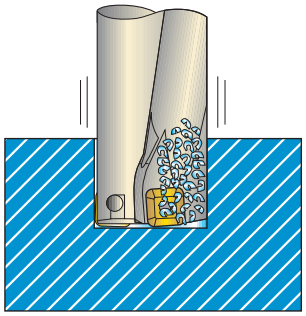
- 2 x D und 3 x D-Bohrer (SD522, SD523)
- Vorschub um ~ 50% reduzieren, wenn der Bohrer nicht im vollen Eingriff ist
- Sorte DP2501 einsetzen
- Spanbrecher -P2 einsetzen

Fehlerbehebung

Vibrationen

Anwendungsbereiche

- Aufspannung des Bohrers prüfen
- Aufspannung des Werkstücks prüfen
- Vorschub erhöhen Bei sehr weichen Werkstoffen Vorschub reduzieren und Geschwindigkeit erhöhen
- Schnittgeschwindigkeit reduzieren



Drehmoment zu gering

- Vorschub reduzieren
- Geometrie für kleinere Vorschübe wählen

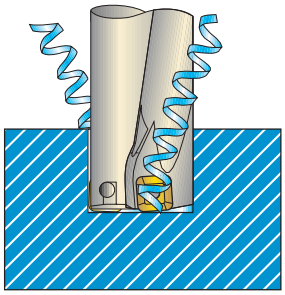
Maschinenleistung zu gering

- Schnittgeschwindigkeit reduzieren
- Vorschub reduzieren
- Geometrie für kleinere Vorschübe einsetzen (SCGX-P1)

Spänestauprobleme

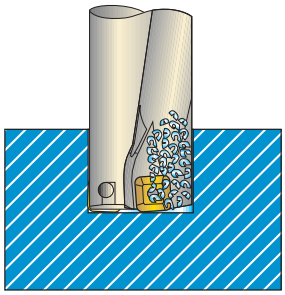
Spänestau durch lange Späne

- Vorschub erhöhen Bei langspanenden Werkstoffen Vorschub reduzieren und Schnittgeschwindigkeit erhöhen
- Geometrie für kleinere Vorschübe einsetzen (SCGX-P1)



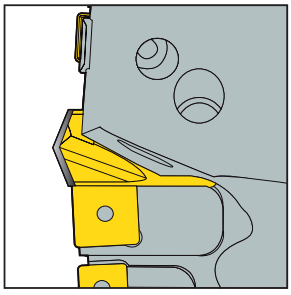
Spänestau durch kurze Späne

- Kühlmitteldruck/-menge erhöhen
- Schnittgeschwindigkeit reduzieren



Schneller Freiflächenverschleiß beim Zentrierbohrer

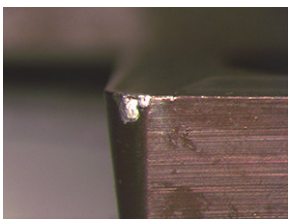
- Schnittgeschwindigkeit reduzieren
- Kühlmittelkonzentration erhöhen



Probleme mit der Werkzeugstandzeit

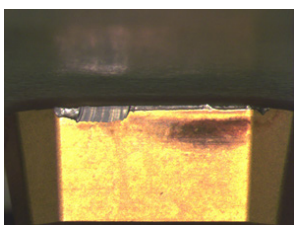
Ausbrüche an der äußeren Wendeplatte

- Eintrittsvorschub reduzieren
- Zähere Sorte wählen
- Stabilere Wendeplatte einsetzen (SCGX-P2)
- Vorschub reduzieren
- Schnittgeschwindigkeit reduzieren



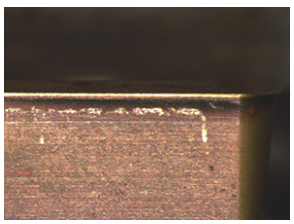
Ausbrüche an der Zentrumsschneide

- Aufspannung des Bohrers prüfen
- Aufspannung des Werkstücks prüfen
- Eintrittsvorschub reduzieren
- Vorschub erhöhen
- Schnittgeschwindigkeit reduzieren

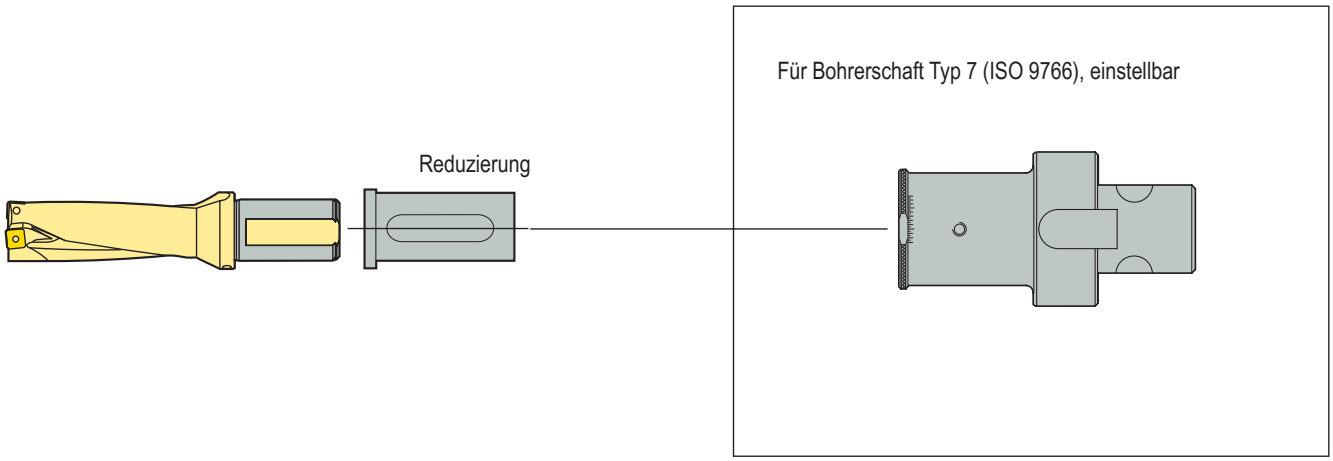


Schneller Verschleiß der Peripherieschneide

- Schnittgeschwindigkeit reduzieren
- Kühlmitteldruck erhöhen
- Verschleißfestere Sorte wählen

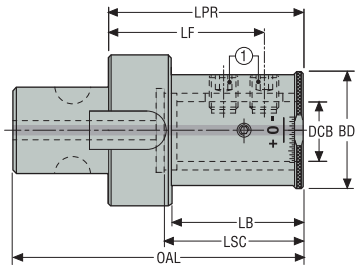


Einstellbare Aufnahmen für Bohrer



ADH 6101 – Verstellbare Bohrerhalter, für den Bohrerschafttyp 7

Graflex®



1. Spannschraube

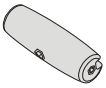
—Für Perfomax®-Bohrer
—Einstellbar von -0,3 bis +0,8 mm

		Maschinenseite	Werkstückseite									
Bezeichnung	Produktnummer	Graflex-Schaftgröße	Für Bohrer	DCB	OAL	LPR	BD	LF	LB	LSC	Gewicht	Auswuchtung
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BM061610025	02422113	G6	R7	25,0 *0.984*	110,0 *4.331*	70,0 *2.756*	49,0 *1.929*	55,0 *2.165*	54,0 *2.126*	54,0 *2.126*	1,12 *2.470*	PB
BM061610125	02422116	G6	R7	25,4 *1.000*	110,0 *4.331*	70,0 *2.756*	49,0 *1.929*	55,0 *2.165*	54,0 *2.126*	54,5 *2.146*	1,11 *2.450*	PB
BM061610032	02422114	G6	R7	32,0 *1.260*	125,0 *4.921*	85,0 *3.346*	71,0 *2.795*	70,0 *2.756*	66,0 *2.598*	60,5 *2.382*	2,1 *4.630*	PB
BM061610138	02422118	G6	R7	38,1 *1.500*	125,0 *4.921*	85,0 *3.346*	81,0 *3.189*	70,0 *2.756*	66,0 *2.598*	60,5 *2.382*	2,45 *5.400*	PB
BM061610040	02422115	G6	R7	40,0 *1.575*	125,0 *4.921*	85,0 *3.346*	81,0 *3.189*	70,0 *2.756*	66,0 *2.598*	60,5 *2.382*	2,4 *5.290*	PB

Ersatzteile, im Lieferumfang enthalten

Für DCB	Befestigungsschraube	Mitnehmer
25,4/1.000	950AF1210014	90M61
25/0.984	950AF1210014	90M61
32/1.260	–	90M61
38,1/1.500	–	90M61
40/1.575	–	90M61

Zubehör

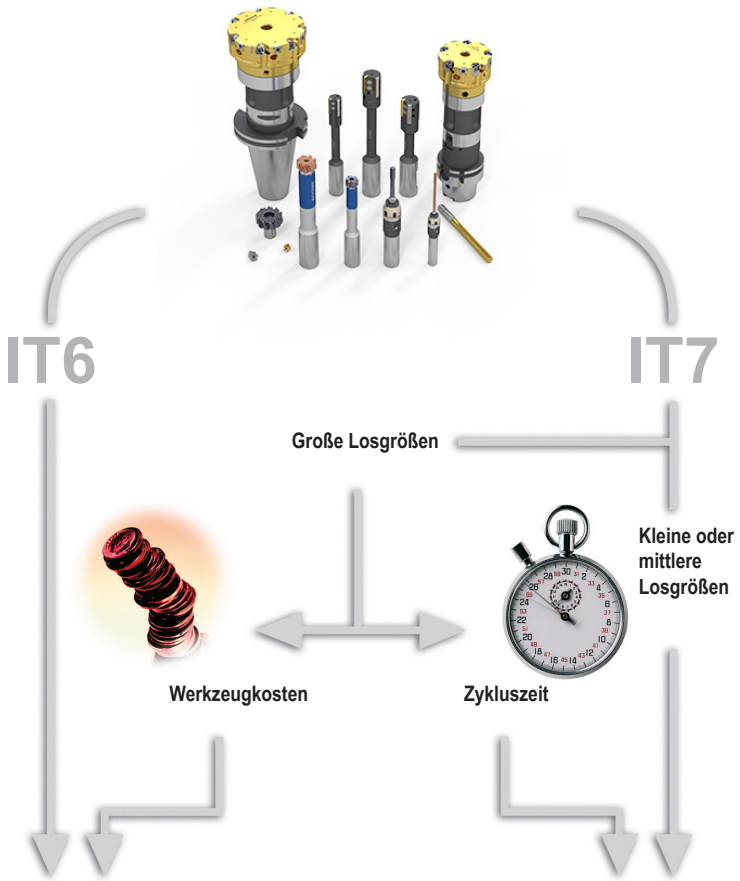
Für DCB	Schlüssel (Quergriff)	Schlüssel
		
25,4/1.000	DOUBLE-T	H6B-H6.0L
25/0.984	DOUBLE-T	H6B-H6.0L
32/1.260	DOUBLE-T	H6B-H6.0L
38,1/1.500	–	H06-4
40/1.575	DOUBLE-T	H6B-H6.0L

PB = vorausgeglichen konstruiert (weitere Informationen auf der Seite „Auswucht-Guide" im Katalog Werkzeugsysteme)

Mehrschneidige Reibahle oder einstellbare Reibahle – Wahl der besten Lösung

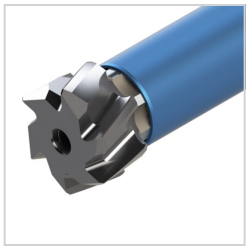
Erreichen Sie Qualität, Leistung und geringe Werkzeugkosten. Die Wahl eines Reibwerkzeuges richtet sich nach Bohrungstoleranz, Produktionsmenge und Zykluszeit. Die Seco Systeme für die Bohrungsbearbeitung erfüllen diese Anforderungen.
Mit Precimaster, Bifix, Xfix und Nanojet Reibahlen bietet Seco die richtige Lösung für Ihre Reibbearbeitung.

Wählen Sie anhand der nachstehenden Tabelle das ideale Werkzeug für Ihre Reibbearbeitung.



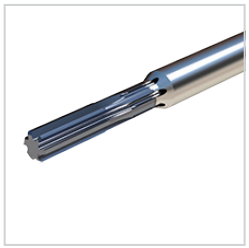
Bifix®

Precimaster™ Plus



Xfix™

Nanojet



Programmübersicht

	Seite(n)	Durchmesser-bereich	Reibtiefe	Bohrungsdurch-messertoleranz	Zwischendurchmesser	Oberflächengüte
Precimaster™ Plus	Seite(n) 329-366	∅ 7,75-60,500 mm *(0.3051-2.3818")*	~ 2-10 x D	IT 6-7-8	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Nanojet	Seite(n) 367-392	∅ 1,461-9,960 mm *(0.057-0.392")*	~ 4-15 x D	IT 7	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Bifix®	Seite(n) 393-419	∅ 5,900-60,500 mm *(0.2323-2.3819")*	~ 2-7 x D	IT 6-7	Ja, auch über MyDesign verfügbar	R_a 0,2-0,8 µm *(R_a 7.87-31.5 µin)*
Xfix™	Seite(n) 420-459	∅ 39,500-154,500 mm *(1.5551-6.0827")*	~ 2,5-6,5 x D	IT 6	Ja, auch über MyDesign verfügbar	R_a 0,8-1,6 µm *(R_a 31-63 µin)*

Precimaster™ Plus

Precimaster™ Plus ist ein modulares Reibsystem für höhere Schnittgeschwindigkeiten, mehr Stabilität und Vielseitigkeit für präzisere und kosteneffizientere Bohrungsbearbeitung.

— Das System bietet einen innovativen hochpräzisen Anschluss, Vollhartmetall-Wechselköpfe und Aufnahmen für Grundloch- und Durchgangsbohrung.
— Toleranzen zwischen 15 und 25 µm und Oberflächengüten mit R_a 0,4 bis 0,8 µm (RMS 15 bis 35 µ/Zoll) sind möglich.

Precimaster™ Plus – Programmübersicht

	Durchmesser-bereich	Reibtiefe	Bohrungsdurchmesser-toleranz	Zwischendurchmesser	Oberflächengüte
PMX5 / PMX6 / PMX8	7,75-60 mm *(0.3051-2.3622")*	~ 2-3 x D	IT 6-7-8	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
PMX5 / PMX6 / PMX8	7,75-60 mm *(0.3051-2.3622")*	~ 4-5 x D	IT 6-7-8	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
PMX5 / PMX6 / PMX8	7,75-60 mm *(0.3051-2.3622")*	~ 8-10 x D	IT 6-7-8	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*

Code-Schlüssel

Precimaster-Plus-Aufnahmen sind sowohl für Grundlochbohrungen als auch für Durchgangsbohrungen geeignet.

Werkzeugschaft

PMX08	–	08200	–	20	–	N	1
1		2		3		4	5

1. Werkzeugkörpergröße Reibahle

2. Max. Reibtiefe

3. Zylindrischer Schaft-durchmesser

4. Neutral

5. Schaftart
1. Zylindrisch DIN1835

Schneidkopf

PMX6	–	18H7	–	EB45	–	RX2000
1		2		3		4

PMX6

1. Schneidkopftyp

2. Bohrungsdurchmesser und Bohrungstoleranz in mm/Zoll

3. Eintrittsgeometrie

4. Hartmetallsorte

Zwischendurchmesser Schneidkopf

PMX5	–	15.515 P7	–	EB845	–	RX2000
1		2		3		4

0.6108”/0.6115”
2

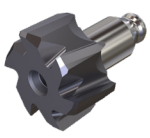
1. Schneidkopftyp

2. Bohrungsdurchmesser und Bohrungstoleranz in mm/Zoll

3. Eintrittsgeometrie

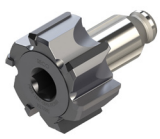
4. Hartmetallsorte

PMX4: Rechtsgedrallte Spannuten, nur für Grundlochbohrungen.
PMX5: Gerade Spannuten für Grundloch- und Durchgangsbohrungen.
PMX6: Linksgedrallte Spannuten, nur für Durchgangsbohrungen.
PMX8: Gerade Spannuten, dehnbar, für Grundloch- und Durchgangsbohrungen
Technische Details:
Der Linksdrall sorgt dafür, dass die Späne nach vorne abgeführt werden.
Der Rechtsdrall sorgt dafür, dass die Späne nach hinten abgeführt werden.
Siehe Auswahlseite für Precimaster-Schneidköpfe 338.



PMX4

PMX5



PMX8

Code-Schlüssel

Precimaster-Plus-Aufnahmen sind sowohl für Grundlochbohrungen als auch für Durchgangsbohrungen geeignet.

PMX08 B HM	–	14500	–	20	–	N	1
1 2 3		4		5		6	7

1.	2.	3.	4	5	6.	7.
Werkzeugkörper-größe Reibahle	Kühldüse für Grund-lochbohrungen	Hartmetallkörper	Max. Reibtiefe	Zylindrischer Schaft-durchmesser	Neutral	Schaftart 1. Zylindrisch DIN1835

PMX08 T	–	AD	–	08200	–	20	–	N	1
1 2		3		4		5		6	7

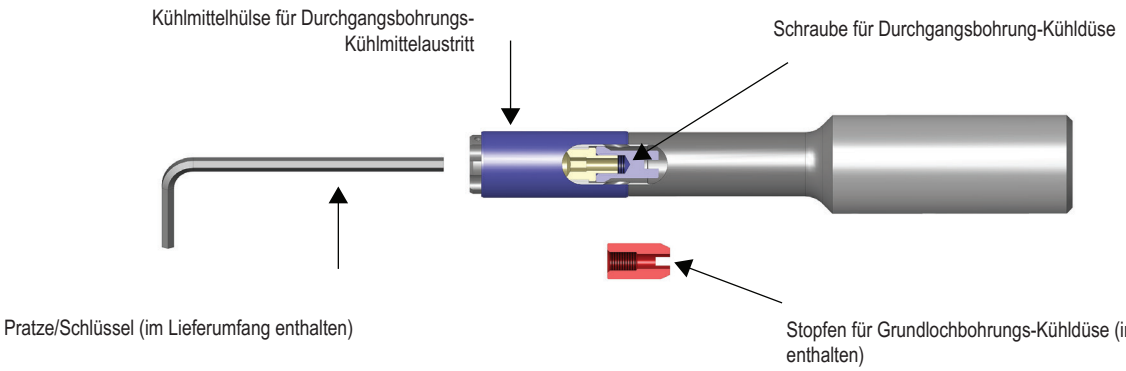
1.	2.	3.	4	5	6.	7.
Werkzeugkörper-größe Reibahle	Kühlmittelbohrung für Durchgangsbohrun-gen	Einstellbare Aufnahme	Max. Reibtiefe	Zylindrischer Schaft-durchmesser	Neutral	Schaftart 1. Zylindrisch DIN1835

PMX08 T	–	FL	–	08200	–	20	–	N	1
1 2		3		4		5		6	7

1.	2.	3.	4	5	6.	7.
Werkzeugkörper-größe Reibahle	Kühlmittelbohrung für Durchgangsbohrun-gen	Pendelhalter	Max. Reibtiefe	Zylindrischer Schaft-durchmesser	Neutral	Schaftart 1. Zylindrisch DIN1835

Einstellen der Kühlmittelzufuhr

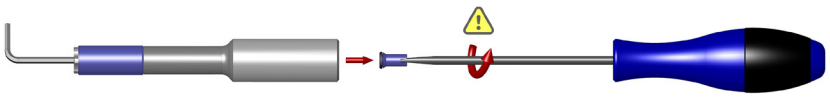
Kühlmittelaustritt einstellen: Beschreibung der Ersatzteile



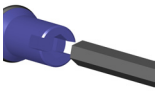
Kühlmittelaustritt einstellen: Einstellen der Kühldüse für Grundlochbohrungen

1.

Verschlussschraube für Durchgangbohrungs-Kühldüse entnehmen (blau)
Hinweis: Verschlussschrauben sind linksdrehend



Einen Schraubendreher mit flacher Klinge oder einen Innensechskant-Schlüssel verwenden, wie in der Tabelle empfohlen.

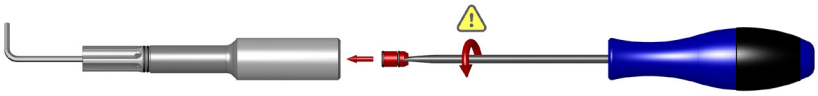
Körpergröße	Schraubendreher mit flacher Klinge (mm)	Schraubendreher mit flacher Klinge *Zoll*	Schlüsselweite mm	Schlüsselweite *Zoll*
				
PMX05	1,2 x 4 x 120	*0.05 x 0.16 x 4.72*	2 x 120	*0.08 x 4.72*
PMX06	1,0 x 5,5 x 150	*0.04 x 0.22 x 5.9*	2.5 x 150	*0.10 x 5.9*
PMX08	1,2 x 6,5 x 200	*0.05 x 0.26 x 7.87*	3 x 200	*0.12 x 7.87*
PMX12	1,2 x 8 x 200	*0.05 x 0.31 x 6.89*	5 x 200	*0.2 x 6.89*

2.

Kühlmittelhülse abnehmen

3.

Schraube für Grundlochbohrungs-Kühldüse einsetzen (rot)
Anmerkung: Dichtschrauben sind linksdrehend



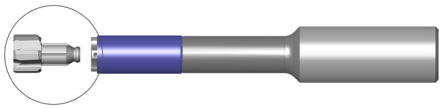
Einsetzen des Kopfes

1.

Darauf achten, dass die Kopfgeometrie für die Kühlung geeignet ist.

PMX5/PMX8

PMX6

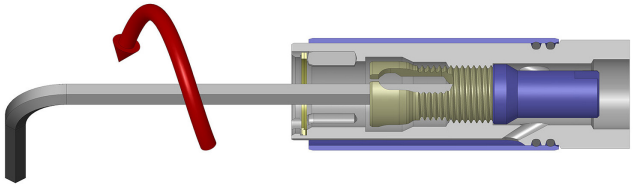

Durchgangsbohrung

PMX5/PMX8

Grundlochbohrung

2.

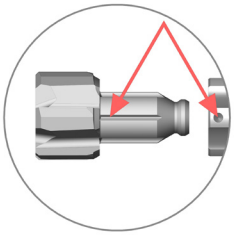
Pratze vor der Montage des Kopfes positionieren

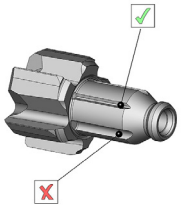


3.

Die Indexnut zum Markierungspunkt der Aufnahme ausrichten.

Kleine Nut

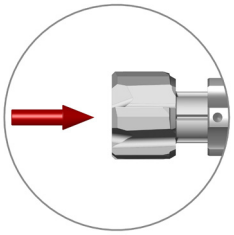




Große Nuten

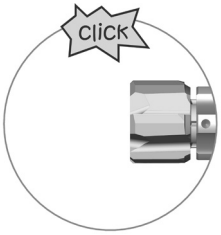
4.

Kopf in den Körper einsetzen



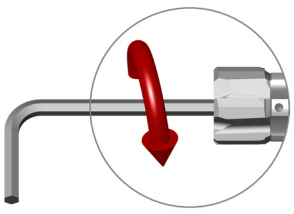
5.

Kopf in den Körper drücken, bis ein Klicken zu hören ist.



6.

Pratze mit einem Innensechskant-Schlüssel anziehen.

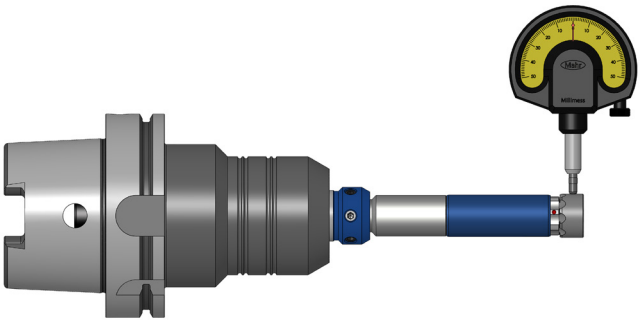


PMX Schaftgröße	Empfohlenes Klemmmoment
PMX05	0,5 Nm
PMX06	0,9 Nm
PMX08	1,2 Nm
PMX12	2,0 Nm
PMX16	5,0 Nm

Aufspannung – Rundlaufabweichung

Rotierendes Werkzeug

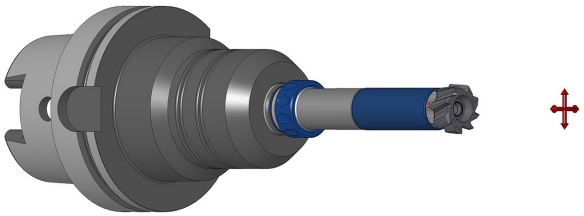
Die maximale empfohlene Rundlaufabweichung beträgt: 10-15 µm *(393.7008-590.5512 µin)*.
Empfehlung: Hydro-Dehnspannfutter, Präzisionsspannzange oder Schrumpffutter.
Für beste Rundlaufkontrolle empfehlen wir einstellbare Precimaster-Plus-Adapter PMX-AD, siehe Seite 350-351.



Statisches Werkzeug

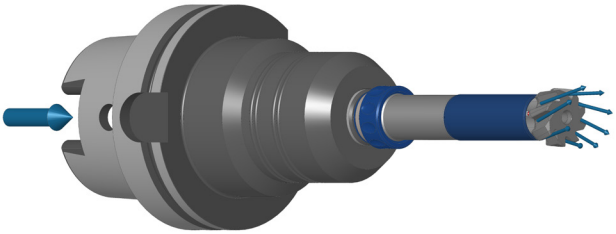
Verwenden Sie Precimaster-Plus-Pendelhalter PMX-FL, siehe Seite(n) 352-353.

Mit Pendelhaltern erzielen Sie eine Selbstzentrierung in der Vorbohrung.



Kühlschmierstoffzufuhr

Zur Erreichung maximaler Standzeit und Bohrungsqualität sind die nachfolgenden Kühlschmierstoffanforderungen zu beachten.
Für das Werkzeug wird interne Kühlschmierstoffzufuhr empfohlen.
Bei einer Reibtiefe < 2 x D kann externe Kühlschmierstoffzufuhr erfolgen.
Wir empfehlen hierfür eine Qualitäts-Emulsion mit mindestens 40% reinem Mineralöl.
Für Rostfrei empfehlen wir reines Öl.
- Mindest-Konzentration 6 bis 8 %
Filtrierung 30-50 µm *(1200-2000 µin)*.
Volumen min. 0,5 l/min/mm *(3.35 gal/min/Zoll)* für Werkzeugdurchmesser
(Beispiel: Reibahle Durchmesser 10, Mindestvolumen beträgt 5 l/min *(1.3 gal/min)*.

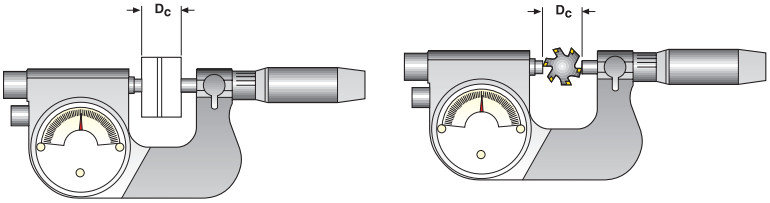


Messung des Durchmessers

Messung des Durchmessers mit Mikrometer-Uhr.

Wichtig
Precimaster Reibahlen haben eine ungleichmäßige Teilung der Schneiden. Die Messung des Durchmessers erfolgt über zwei Schneiden, die um 180° versetzt sind.

Messung des Durchmessers mit Mikrometer und Messblock zum Kalibrieren.

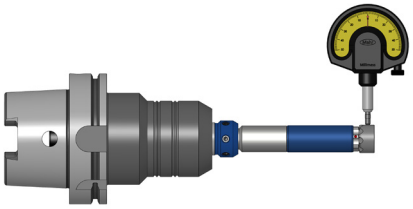


Aufnahme ausrichten:

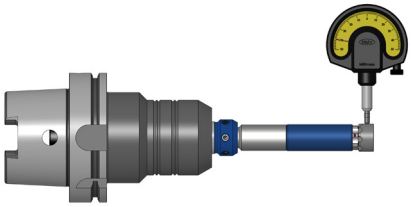
1.
Kontrolldorn-Kopf in die Aufnahme spannen.

Werkzeug in Spindel einsetzen.

2.
Uhr wie gezeigt einstellen.

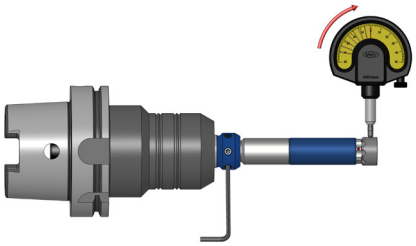


3.
Werkzeug manuell auf tiefste Position einstellen.

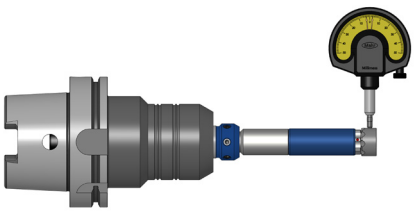


4.
Rundlaufausgleich mit Einstellschrauben vornehmen. Wie gezeigt an den Pfeilen ausrichten.

5.
Rundlaufabweichung prüfen und Kompensierung wiederholen, wenn nötig.

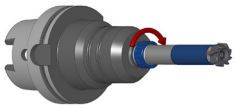


6.
Wenn die maximale Rundlaufabweichung geringer als 5 µm *(197 µin)* ist, die Einstellschrauben anziehen, um zu verhindern, dass sich die Einstellung löst.

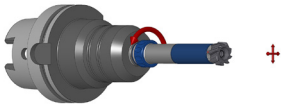


Pendelhalter einstellen:

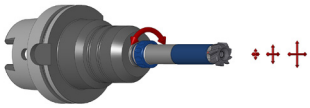
1.
Den Pendelschaft fest anziehen, indem Sie den Einstellring im Uhrzeigersinn drehen.



2.
Den Pendelhalter durch zwei oder drei Umdrehungen des Einstellringes gegen den Uhrzeigersinn lösen.

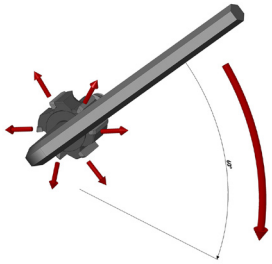


3.
Weitere Einstellungen vornehmen, wenn nötig. Ein zu großer Pendelwert kann zu instabilen Bedingungen beim Eintritt führen. Ein zu geringer Pendelwert kann Vibrationen und unrunde Bohrungen verursachen.

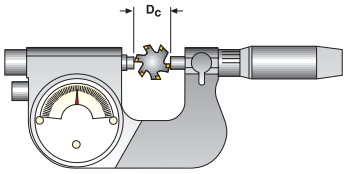


Dehnbare Reibahle mit Verschleißkompensierung

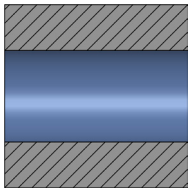
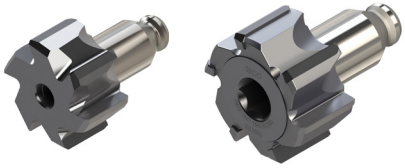
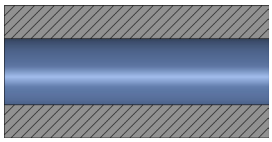
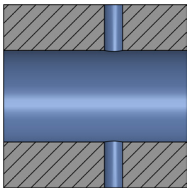
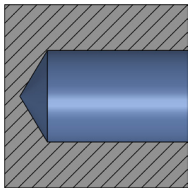
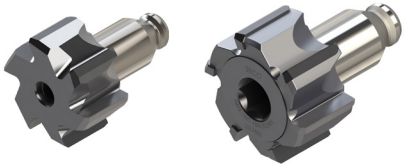
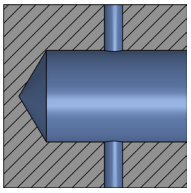
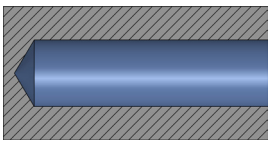
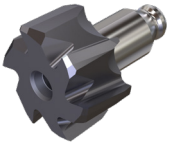
1.
Einen Sechskant-Schlüssel verwenden, um den Durchmesser neu einzustellen (60° Erhöhung = ca. 0,005 mm *(0.197µ")* Kompensierung auf den Durchmesser)



2.
Den Durchmesser nach jeder Einstellung mithilfe einer Messuhr prüfen.



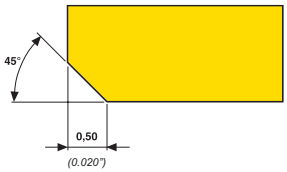
Auswahl Schneidköpfe

Werkstück	**Bearbeitungsdurchmesser 8–60 mm** *(0,3150–2,3622")*	
Kurze Durchgangsbohrung < 3 x D 	**PMX5/PMX8** 	
Lange Durchgangsbohrung > 3 x D 	**PMX6** Für Durchgangsbohrungen muss die Kühldüse der Aufnahme entsprechend eingestellt werden: siehe Seiten zur Kühlmitteleinstellung.	
Querbohrung 		
Grundlochbohrung 	**PMX5/PMX8** Für Grundlochbohrungen muss die Kühldüse der Aufnahme entsprechend eingestellt werden: siehe Seiten zur Kühlmitteleinstellung. 	
Grundloch- und Querbohrung 		
Grundlochbohrungen > 3x D 	**PMX4** Für tiefe Grundlochbohrungen muss die Kühldüse der Aufnahme entsprechend eingestellt werden: siehe Seiten zur Kühlmitteleinstellung. 	

Auswahl der Geometrie – Anwendung

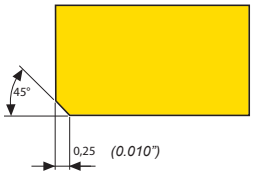
Anschnittgeometrie – EB45

Sehr gute Spankontrolle
Hervorragende Oberflächengüte R_a 0,8 - 1,2 µm
(Hervorragende Oberflächengüte R_a 31 - 47 µin)
Vielseitig



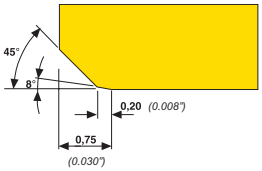
Anschnittgeometrie – EBS45

Sehr gute Spankontrolle
Gute Oberflächengüte R_a 0,8- 1,2 µm
(Gute Oberflächengüte R_a 31- 47 µin)
EB45 kurz



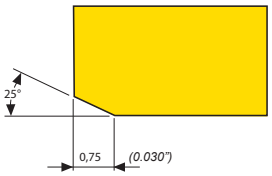
Anschnittgeometrie – EB845

Sehr gute Spankontrolle
Hervorragende Oberflächengüte R_a 0,2 - 0,8 µm
(Hervorragende Oberflächengüte R_a 8 - 31 µin)



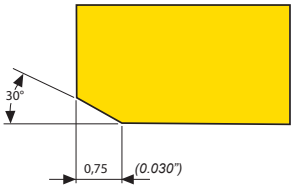
Anschnittgeometrie – EB25

Exzellente Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle

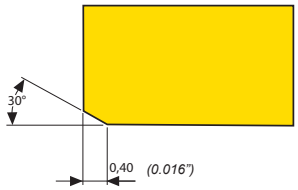
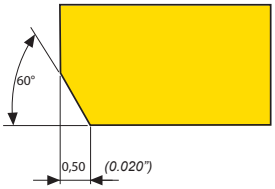
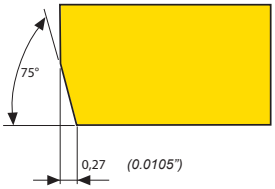


Anschnittgeometrie – EB30

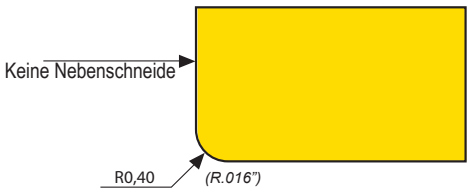
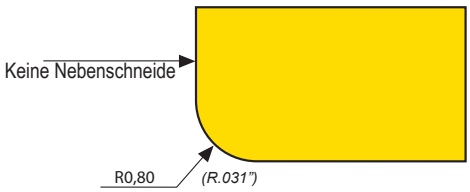
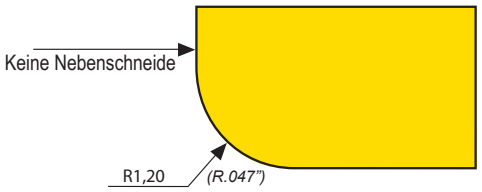
Vorschubleistung +++
Oberflächengüte ++ R_a 0,4 - 0,8 µm
(Oberflächengüte ++ R_a 16 - 31 µin)
Spankontrolle +



Auswahl der Geometrie – Anwendung

Anschnittgeometrie – EBS30 Vorschubleistung +++ Oberflächengüte ++ R_a 0,4 - 0,8 µm *(Oberflächengüte ++ R_a 16 - 31 µin)* Spankontrolle + EB30 kurz	
Anschnittgeometrie – EB60 Vorschubleistung + Oberflächengüte ++ R_a 0,8 - 1,2 µm *(Oberflächengüte ++ R_a 31 - 47 µin)* Spankontrolle ++	
Anschnittgeometrie – EB75 Vorschubleistung + Oberflächengüte ++ R_a 0,8 - 1,2 µm *(Oberflächengüte ++ R_a 31 - 47 µin)* Spankontrolle ++	

Auswahl der Geometrie – Anwendung

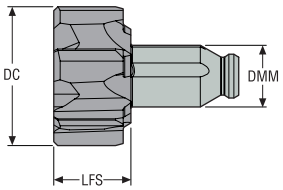
Anschnittgeometrie – RE040 Vorschubleistung ++ Oberflächengüte ++ R_a 0,4 - 0,8 µm *(Oberflächengüte ++ R_a 16 - 31 µin)* Spankontrolle +	
Anschnittgeometrie – RE080 Vorschubleistung ++ Oberflächengüte ++ R_a 0,4 - 0,8 µm *(Oberflächengüte ++ R_a 16 - 31 µin)* Spankontrolle +	
Anschnittgeometrie – RE120 Vorschubleistung ++ Oberflächengüte ++ R_a 0,4 - 0,8 µm *(Oberflächengüte ++ R_a 16 - 31 µin)* Spankontrolle + Verfügbar ab einem Durchmesser von 14 mm *(0,551 Zoll)*	

Sorten

	RX2000	**Beschichtet** Beschichtete Hochleistungssorte für alle Werkstoffe.
	CP20	**Beschichtet** Eine vielseitige beschichtete Sorte, die für die meisten Werkstoffe außer Aluminium geeignet ist. TiN
	H15	**Unbeschichtet** Zähe Sorte mit scharfer Schneidkante für alle Werkstoffe. Dank der hervorragenden Kantenstabilität zum Feinreiben geeignet.
	CF	**Cermet** Hochverschleißfeste Sorte zur Optimierung bei Stahl.
	RX1500	**Beschichtetes Cermet** Verschleißfeste beschichtete Sorte zur Leistungsoptimierung bei Stahl und Guss.
	RN2010	**Unbeschichtet** Feinstkörnige, unbeschichtete Sorte mit optimierten Geometrien für NE-Metalle
	RM2020	**Beschichtet** Zähe, beschichtete Sorte für Feinreibbearbeitungen mit optimierten Geometrien für M-Werkstoffe.
	RM2090	**Beschichtet** Verschleißfeste, beschichtete Sorte mit spezifischen Geometrien für M-Werkstoffe. Optimierung bei M-Werkstoffen.
	RK2050	**Beschichtet** Zähe, beschichtete Sorte für Feinreibbearbeitungen mit optimierten Geometrien für K-Werkstoffe.
	RK1550	**Beschichtetes Cermet** Verschleißfeste, beschichtete Sorte mit spezifischen Geometrien für K-Werkstoffe. Optimierung bei K-Werkstoffen.
	RS2090	**Beschichtet** Verschleißfeste, beschichtete Sorte mit spezifischen Geometrien für S-Werkstoffe. Optimierung bei S-Werkstoffen.

Köpfe für Durchgangs- und Grundlochbohrungen

∅ 8-32 mm / 0.315-1.260"



–Auswahl der Geometrie siehe Seite(n) 339-341
–Schnittdaten siehe Seite(n) 360-366

Bezeichnung	Produkt-nummer	DC	Bohrergröße*		LFS	DMM	Körpergröße	Geometrie			Beschichtung				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX5-8H7-EB45	03123158	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX5-9H7-EB45	03123159	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX5-10H7-EB30	10020602	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-11H7-EB45	02925754	11,0	10,8/10,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-12H7-EB30	10019482	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-12H7-EB45	02925755	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-13H7-EB30	10019483	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-13H7-EB45	02925756	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-14H7-EB30	10019484	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-14H7-EB45	02925757	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-15H7-EB30	10019485	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-15H7-EB45	02925758	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-16H7-EB30	10019486	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-16H7-EB45	02925759	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-17H7-EB30	10019487	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-17H7-EB45	02925760	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-18H7-EB30	10019488	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-18H7-EB45	02925761	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-19H7-EB30	10019489	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-19H7-EB45	02925762	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-20H7-EB30	10020603	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-20H7-EB45	02925763	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-21H7-EB45	02925764	21,0	20,8/20,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-22H7-EB30	10020604	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-22H7-EB45	02925765	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-23H7-EB30	10019490	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-23H7-EB45	02925766	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-24H7-EB30	10019491	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-24H7-EB45	02925767	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-25H7-EB30	10019492	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-25H7-EB45	02925768	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-26H7-EB30	10019493	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-26H7-EB45	02925769	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-27H7-EB45	02925770	27,0	26,8/26,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-28H7-EB30	10019494	28,0	26,8/26,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-28H7-EB45	02925771	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-29H7-EB45	02925772	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-30H7-EB30	10019495	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-30H7-EB45	02925773	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

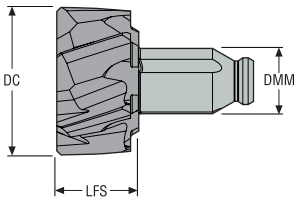
Bezeichnung	Produkt-nummer	DC	Bohrergröße*		LFS	DMM	Körpergröße	Geometrie			Beschichtung				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX5-32H7-EB30	10019496	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-32H7-EB45	02925775	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

*Weitere Informationen darüber, welcher Bohrer zu verwenden ist und auf welche Weise, siehe Seite(n) 11
■ **Lagerstandard.** □ **nicht standardmäßig auf Lager.**

<STEPTABLE O="A4 test PMX5 annan tabell" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

Köpfe für Durchgangsbohrungen

∅ 8-32 mm / 0.315-1.260"



–Auswahl der Geometrie siehe Seite(n) 339-341
–Schnittdaten siehe Seite(n) 360-366

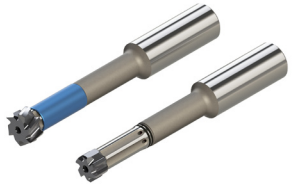
Bezeichnung	Produkt-nummer	DC	Bohrergröße*		LFS	DMM	Körpergröße	Geometrie			Beschichtung				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX6-8H7-EB45	03123161	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX6-9H7-EB45	03123162	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX6-10H7-EB45	02965863	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-11H7-EB45	02925776	11,0	10,8/10,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-12H7-EB45	02925777	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-13H7-EB45	02925778	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-14H7-EB45	02925779	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-15H7-EB45	02925780	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-16H7-EB45	02925781	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-17H7-EB45	02925782	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-18H7-EB45	02925783	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-19H7-EB45	02925784	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-20H7-EB45	02925785	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-21H7-EB45	02925786	21,0	20,8/20,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-22H7-EB45	02925030	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-23H7-EB45	02925031	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-24H7-EB45	02925032	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-25H7-EB45	02925033	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-26H7-EB45	02925034	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-27H7-EB45	02925035	27,0	26,8/26,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-28H7-EB45	02925036	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-29H7-EB45	02925037	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-30H7-EB45	02925038	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-31H7-EB45	02925039	31,0	30,8/30,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-32H7-EB45	02925040	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

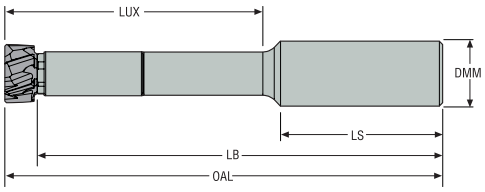
*Weitere Informationen darüber, welcher Bohrer zu verwenden ist und auf welche Weise, siehe Seite(n) 11
■ **Lagerstandard.** □ **nicht standardmäßig auf Lager.**

<STEPTABLE O="New A4_Precimaster_PMX6" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

Aufnahmen für Durchgangs- und Grundlochbohrungen

∅ 7,75–60,500 mm / 0.305–2.381"

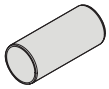
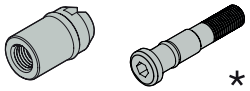
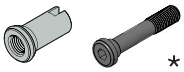




–Auswahl der Geometrie siehe Seite(n) 339–341
–Schnittdaten siehe Seite(n) 360–366

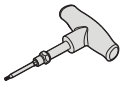
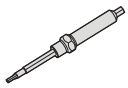
Bezeichnung	Produkt-nummer	Material der Aufnahme	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05-02800-10N1	03123012	Stahl	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05-04100-10N1	02929923	Stahl	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05-10000-10N1	03123013	Stahl	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06-03700-12N1	02925828	Stahl	9,901 - 14,499	84,0	77,0	45,0	37,0	12,0
PMX06-05700-12N1	02925829	Stahl	9,901 - 14,499	104,0	97,0	45,0	57,0	12,0
PMX06-12000-12N1	02925830	Stahl	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX06HM-12000-12N1	02925831	Hartmetall	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX08-04600-20N1	02925832	Stahl	14,5 - 21,499	99,0	89,0	50,0	46,0	20,0
PMX08-08200-20N1	02925833	Stahl	14,5 - 21,499	135,0	125,0	50,0	82,0	20,0
PMX08-14500-20N1	02925834	Stahl	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX08HM-14500-20N1	02925835	Hartmetall	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX12-06800-25N1	02925836	Stahl	21,5 - 32,499	127,0	115,0	56,0	68,0	25,0
PMX12-10400-25N1	02925837	Stahl	21,5 - 32,499	163,0	151,0	56,0	104,0	25,0
PMX12-17000-25N1	02925838	Stahl	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX12HM-17000-25N1	02925839	Hartmetall	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX16-06300-32N1	02925840	Stahl	32,5 - 60,5	124,0	110,0	60,0	63,0	32,0
PMX16-12700-32N1	02925841	Stahl	32,5 - 60,5	188,0	174,0	60,0	127,0	32,0
PMX16-17000-32N1	02925842	Stahl	32,5 - 60,5	231,0	217,0	60,0	170,0	32,0
PMX16HM-17000-32N1	02925843	Hartmetall	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

Ersatzteile, im Lieferumfang enthalten

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Klemmkit	Kühlkit	Stopfen für Grundloch-bohrung	Stopfen für Durchgangs-bohrung
			*		 *	 *
PMX05	7,75-9,900	1.5SMS795	PMX05-CLKI	RT05-KI	SB05	ST05
PMX06	9,901-14,499	2SMS795	PMX06-CLKI	RT06-KI	SB06	ST06
PMX08	14,5-21,499	2.5SMS795	PMX08-CLKI	RT08-KI	SB08	ST08
PMX12	21,5-32,499	4SMS795	PMX12-CLKI	RT12-KI	SB12	ST12
PMX16	32,5-60	5SMS795	PMX16-CLKI	–	SB16	ST16

* Ersatzteile nur für PMX16-Körper. Bei PMX16 werden auch Schrauben zur Klemmung verwendet.

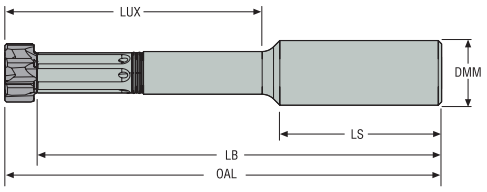
Zubehör

Für Durchmesser (mm)	Schaftgröße	Produktnummer	Drehmomentschlüssel	Produktnummer	Klinge	Produktnummer	Drehmomentschlüssel	Produktnummer	Klinge	Drehmoment
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

Für Durchmesser (mm)	Schaftgröße	Produktnummer	Auswerfer in Einheitsgröße	Produktnummer	Extraktionsring	Produktnummer	Extraktorkörper	Produktnummer	Extraktorkit
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Aufnahmen für Grundlochbohrungen

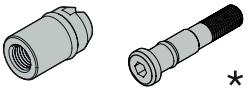
∅ 7,75–60,500 mm / 0.305–2.381"



—Auswahl der Geometrie siehe Seite(n) 339–341
—Schnittdaten siehe Seite(n) 360–366

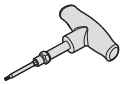
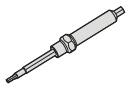
Bezeichnung	Produkt-nummer	Material der Aufnahme	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05B-02800-10N1	03144322	Stahl	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05B-04100-10N1	03144323	Stahl	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05B-10000-10N1	03144324	Stahl	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06B-03700-12N1	03075433	Stahl	9,901 - 14,499	84,0	77,0	45,0	37,0	12,0
PMX06B-05700-12N1	03075434	Stahl	9,901 - 14,499	104,0	97,0	45,0	57,0	12,0
PMX06B-12000-12N1	03075435	Stahl	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX06BHM-12000-12N1	03075436	Hartmetall	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX08B-04600-20N1	03075437	Stahl	14,5 - 21,499	99,0	89,0	50,0	46,0	20,0
PMX08B-08200-20N1	03075438	Stahl	14,5 - 21,499	135,0	125,0	50,0	82,0	20,0
PMX08B-14500-20N1	03075439	Stahl	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX08BHM-14500-20N1	03075440	Hartmetall	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX12B-06800-25N1	03075441	Stahl	21,5 - 32,499	127,0	115,0	56,0	68,0	25,0
PMX12B-10400-25N1	03075442	Stahl	21,5 - 32,499	163,0	151,0	56,0	104,0	25,0
PMX12B-17000-25N1	03075443	Stahl	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX12BHM-17000-25N1	03075444	Hartmetall	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX16B-06300-32N1	03075445	Stahl	32,5 - 60,5	124,0	110,0	61,0	63,0	32,0
PMX16B-12700-32N1	03075446	Stahl	32,5 - 60,5	188,0	174,0	61,0	127,0	32,0
PMX16B-17000-32N1	03075447	Stahl	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0
PMX16BHM-17000-32N1	03075448	Hartmetall	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

Ersatzteile, im Lieferumfang enthalten

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Klemmkit	Stopfen für Grundlochbohrung
				
PMX05B	7,75-9,900	1.5SMS795	PMX05-CLKI	SB05
PMX06B	9,901-14,499	2SMS795	PMX06-CLKI	SB06
PMX08B	14,500-21,499	2.5SMS795	PMX08-CLKI	SB08
PMX12B	21,500-32,499	4SMS795	PMX12-CLKI	SB12
PMX16B	32,500-60,000	5SMS795	PMX16-CLKI	SB16

* Ersatzteile nur für PMX16-Körper. Bei PMX16 werden auch Schrauben zur Klemmung verwendet.

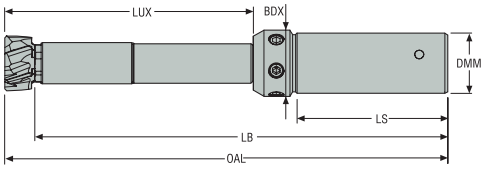
Zubehör

Für Durchmesser (mm)	Schaftgröße	Produktnummer	Drehmomentschlüssel	Produktnummer	Klinge	Produktnummer	Drehmomentschlüssel	Produktnummer	Klinge	Drehmoment
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

Für Durchmesser (mm)	Schaftgröße	Produktnummer	Auswerfer in Einheitsgröße	Produktnummer	Extraktionsring	Produktnummer	Extraktorkörper	Produktnummer	Extraktorkit
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Einstellbare Aufnahmen für Durchgangsbohrungen

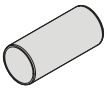
∅ 7,75–60,500 mm / 0.305–2.381"



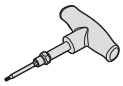
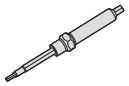
–Auswahl der Geometrie siehe Seite(n) 339–341
–Schnittdaten siehe Seite(n) 360–366

Bezeichnung	Produkt-nummer	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05T-AD-04100-16N1	03271918	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06T-AD-05700-16N1	03002833	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08T-AD-08200-20N1	03002835	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12T-AD-10400-25N1	03002837	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16T-AD-12700-32N1	03002839	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

Ersatzteile, im Lieferumfang enthalten

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Kühlring	Einstell-schlüssel	Kontrolldorn-Kopf	Einstellschraube
						
PMX05T	7,750-9,900	1.5SMS795	RT05-KI	2SMS795	PMX05-MSTR	HCM4X4X0.5/ISO4026
PMX06T	9,901-14,499	–	RT06-KI	2SMS795	PMX06-MSTR	HCM4X4X0.5/ISO4026
PMX08T	14,50-21,499	–	RT08-KI	2.5SMS795	PMX08-MSTR	HCM5X5X0.5/ISO4026
PMX12T	21,50-32,499	4SMS795	RT12-KI	3SMS795	PMX12-MSTR	HCM6X6X0.75/ISO4026
PMX16T	32,50-60,000	5SMS795	–	3SMS795	–	HCM6X6X0.75/ISO4026

Zubehör

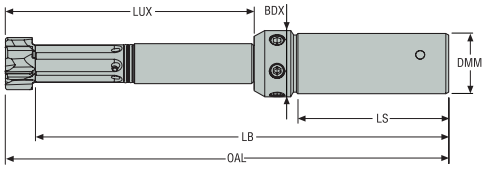
Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Drehmo-mentschlüssel	Produkt-nummer	Klinge	Produkt-nummer	Drehmo-mentschlüssel	Produkt-nummer	Klinge	Drehmo-ment
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Auswerfer in Einheitsgröße	Produkt-nummer	Extraktionsring	Produkt-nummer	Extraktorkörper	Produkt-nummer	Extraktorkit
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Hinweis: Das Reparaturpratzenkit PMxx-CLKI ist nicht geeignet für Typen PMX FL und AD

Einstellbare Aufnahmen für Grundlochbohrungen

∅ 7,75-60,500 mm / 0.305-2.381”



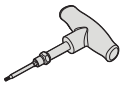
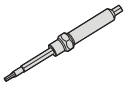
—Auswahl der Geometrie siehe Seite(n) 339-341
—Schnittdaten siehe Seite(n) 360-366

Bezeichnung	Produkt-nummer	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05B-AD-04100-16N1	03271919	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06B-AD-05700-16N1	03002834	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08B-AD-08200-20N1	03002836	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12B-AD-10400-25N1	03002838	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16B-AD-12700-32N1	03002840	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

Ersatzteile, im Lieferumfang enthalten

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Einstell-schlüssel	Kontrolldorn-Kopf	Einstellschraube
PMX05B	7,750-9,900	1.5SMS795	2SMS795	PMX05-MSTR	HCM4X4X0.5/ISO4026
PMX06B	9,901-14,499	2SMS795	–	PMX06-MSTR	HCM4X4X0.5/ISO4026
PMX08B	14,50-21,499	–	2.5SMS795	PMX08-MSTR	HCM5X5X0.5/ISO4026
PMX12B	21,50-32,499	4SMS795	3SMS795	PMX12-MSTR	HCM6X6X0.75/ISO4026
PMX16B	32,50-60,000	5SMS795	3SMS795	–	HCM6X6X0.75/ISO4026

Zubehör

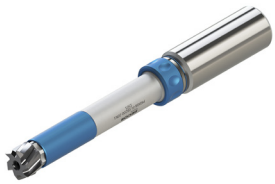
Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Drehmomentschlüssel	Produkt-nummer	Klinge	Produkt-nummer	Drehmomentschlüssel	Produkt-nummer	Klinge	Drehmoment
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

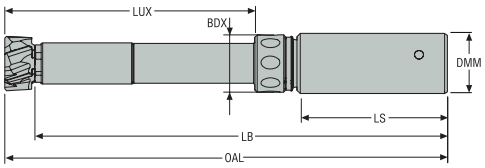
Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Auswerfer in Einheitsgröße	Produkt-nummer	Extraktionsring	Produkt-nummer	Extraktorkörper	Produkt-nummer	Extraktorkit
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Hinweis: Das Reparaturpratzenkit PMxx-CLKI ist nicht geeignet für Typen PMX FL und AD

Pendelhalter Aufnahme für Durchgangsbohrungen

∅ 7,75–60,500 mm / 0.305–2.381"

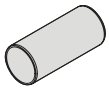




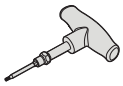
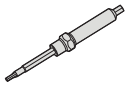
–Auswahl der Geometrie siehe Seite(n) 339–341
–Schnittdaten siehe Seite(n) 360–366

Bezeichnung	Produkt-nummer	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05T-FL-04100-16N1	03197751	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06T-FL-05700-16N1	03002825	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08T-FL-08200-20N1	03002827	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12T-FL-10400-25N1	03002829	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16T-FL-12700-32N1	03002831	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

Ersatzteile, im Lieferumfang enthalten

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Kühlring	Einstell-schlüssel
				
PMX05T	7,750-9,900	1.5SMS795	RT05-KI	–
PMX06T	9,901-14,499	–	RT06-KI	2SMS795
PMX08T	14,50-21,499	–	RT08-KI	2.5SMS795
PMX12T	21,50-32,499	4SMS795	RT12-KI	–
PMX16T	32,50-60,000	5SMS795	–	–

Zubehör

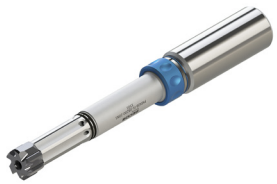
Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Drehmo-mentschlüssel	Produkt-nummer	Klinge	Produkt-nummer	Drehmo-mentschlüssel	Produkt-nummer	Klinge	Drehmo-ment
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

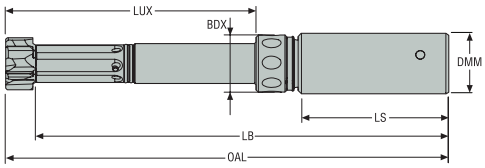
Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Auswerfer in Einheitsgröße	Produkt-nummer	Extraktionsring	Produkt-nummer	Extraktorkörper	Produkt-nummer	Extraktorkit
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Hinweis: Das Reparaturpratzenkit PMxx-CLKI ist nicht geeignet für Typen PMX FL und AD

Pendelhalter Aufnahme für Grundlochbohrungen

∅ 7,75-60,500 mm / 0.305-2.381”





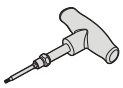
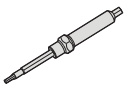
—Auswahl der Geometrie siehe Seite(n) 339-341
—Schnittdaten siehe Seite(n) 360-366

Bezeichnung	Produkt-nummer	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05B-FL-04100-16N1	03271916	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06B-FL-05700-16N1	03002826	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08B-FL-08200-20N1	03002828	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12B-FL-10400-25N1	03002830	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16B-FL-12700-32N1	03002832	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

Ersatzteile, im Lieferumfang enthalten

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze
PMX05B	7,750-9,900	1.5SMS795
PMX06B	9,901-14,499	2SMS795
PMX08B	14,50-21,499	2.5SMS795
PMX12B	21,50-32,499	4SMS795
PMX16B	32,50-60,500	5SMS795

Zubehör

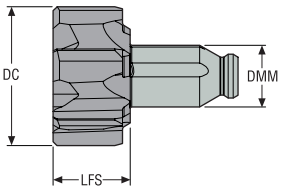
Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Drehmomentschlüssel	Produkt-nummer	Klinge	Produkt-nummer	Drehmomentschlüssel	Produkt-nummer	Klinge	Drehmoment
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

Für Durchmesser (mm)	Schaftgröße	Produkt-nummer	Auswerfer in Einheitsgröße	Produkt-nummer	Extraktionsring	Produkt-nummer	Extraktorkörper	Produkt-nummer	Extraktorkit
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Hinweis: Das Reparaturpratzenkit PMxx-CLKI ist nicht geeignet für Typen PMX FL und AD

Köpfe für Durchgangs- und Grundlochbohrungen, Werkzeuge nach Kundenwunsch

∅ 7,75–60,500 mm / 0.305–2.381"



–Auswahl der Geometrie siehe Seite(n) 339–341
–Schnittdaten siehe Seite(n) 360–366

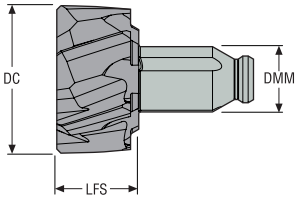
Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Beschichtung										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX5-7.75-XX-XXXX	7,75 *0.305*	9,9 *0.390*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB845 EB30	□	□	□	□	□	–	–	□	□	□	□
PMX5-10.0-XX-XXXX	9,901 *0.390*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX5-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX5-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-XX	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX5-32.5-XX-XXXX	32,5 *1.280*	60,5 *2.382*	14,0 *0.551*	16,0 *0.630*	10	PMX16-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□

□ **= nicht standardmäßig auf Lager.**
Hinweis: Bei der Bestellung von Precimaster Plus Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: PMX5-16.515 P7-EB45 RM2020.

<STEPTABLE O="A4_Precimaster_custom_1" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

Köpfe für Durchgangsbohrungen, Werkzeuge nach Kundenwunsch

∅ 7,75-60,500 mm / 0.305-2.381”



—Auswahl der Geometrie siehe Seite(n) 339-341
—Schnittdaten siehe Seite(n) 360-366

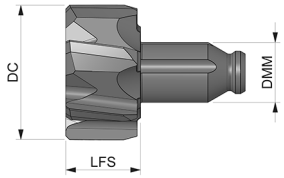
Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Beschichtung										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX6-7.75-XX-XXXX	7,75 *0.305*	9,9 *0.390*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB845 EB30	□	□	□	□	□	–	–	□	□	□	□
PMX6-10.0-XX-XXXX	9,901 *0.390*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX6-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX6-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-XX	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX6-32.5-XX-XXXX	32,5 *1.280*	60,5 *2.382*	14,0 *0.551*	16,0 *0.630*	10	PMX16-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□

□ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Precimaster Plus Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: PMX6-16.515 P7-EB45 RM2020.

<STEPTABLE O=”A4_ Precimaster custom PMX6” OT=”Product” TT=”stibo.91791239” VC=”DEde” VO=”6710816” W=”Main” />

Köpfe für Grundlochbohrungen, Werkzeuge nach Kundenwunsch

∅ 7,75–60,500 mm / 0.305–2.381"



–Auswahl der Geometrie siehe Seite(n) 339–341
–Schnittdaten siehe Seite(n) 360–366

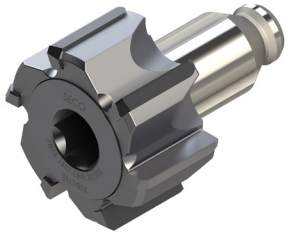
Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Beschichtung										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX4-7.75-XX-XXXX	7,75 *0.305*	9,9 *0.390*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB84 EB30	□	□	□	□	□	–	–	□	□	□	□
PMX4-10.0-XX-XXXX	9,901 *0.390*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX4-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX4-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX4-32.5-XX-XXXX	32,5 *1.280*	60,5 *2.382*	14,0 *0.551*	16,0 *0.630*	10	PMX16-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□

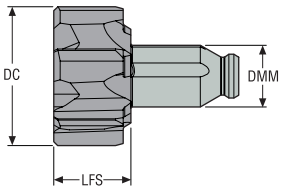
□ **= nicht standardmäßig auf Lager.**
Hinweis: Bei der Bestellung von Precimaster Plus Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: PMX4-16.515 P7-EB45 RM2020.

<STEPTABLE O="A4 PMX4 right hand helical" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

Spreizköpfe für Durchgangsbohrungen und Grundlochbohrungen

∅ 10,00-32,500 mm / 0.393-1.279"





—Auswahl der Geometrie siehe Seite(n) 339-341
—Schnittdaten siehe Seite(n) 360-366

Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Beschichtung										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX8-10.0-XX-XXXX	10,0 *0.394*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX8-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX8-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□

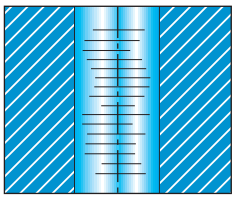
□ **= nicht standardmäßig auf Lager.**
Hinweis: Bei der Bestellung von Precimaster Plus Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: PMX8-16.515 P7-EB45 RM2020.

<STEPTABLE O="A4_Precimaster_custom_3" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

Fehlerbehebung

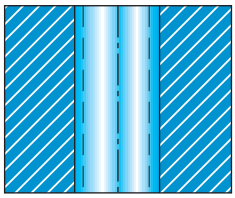
Mangelhafte Oberflächengüte

– Aufmaß prüfen
– Kühlmittelzustand verbessern (Anschlussart, Druck, Qualität)
– Vorschubrate reduzieren



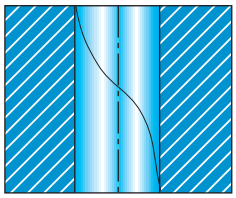
Durchmesser zu groß

– Konzentrizität verbessern (Teil/Werkzeug)



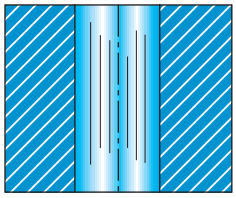
Rückzugsriefen

– Kühlmittelzustand verbessern (Anschluss, Druck, Qualität)
– Konzentrizität prüfen (Werkstück/Werkzeug)
– Ausgangsvorschub reduzieren



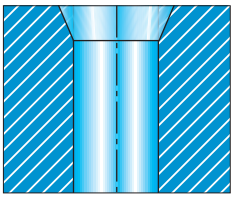
Rattermarken

– Konzentrizität prüfen (Werkstück/Werkzeug)
– Aufmaß prüfen



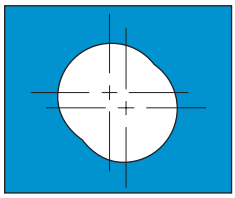
Konischer Eintritt

– Vorschubrate reduzieren
– Konzentrizität verbessern (Teil/Werkzeug)
– Rundlaufabweichung reduzieren



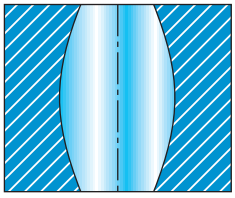
Exzentrische Bohrung

– Werkstückklemmung prüfen
– Aufmaß prüfen
– Konzentrizität prüfen (Werkstück/Werkzeug)



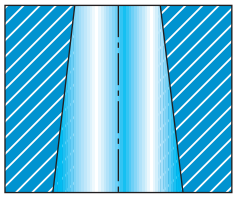
Deformierte Bohrung

– Werkstückklemmung (Verformung des Werkstückes) prüfen



Konische Bohrung

– Konzentrizität verbessern (Teil/Werkzeug)



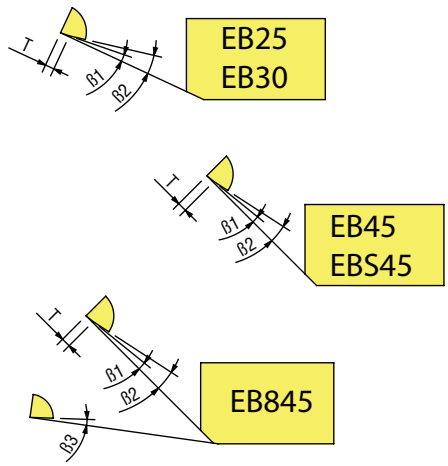
Hinweise zum Nachschleifen

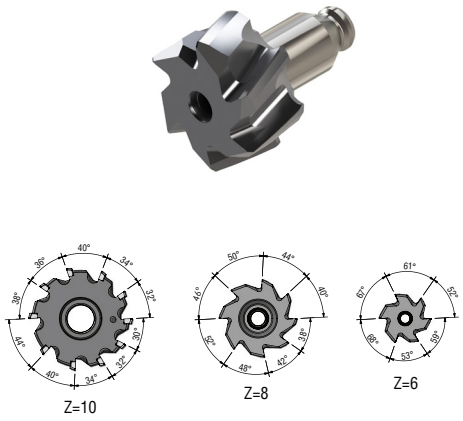
Einzelheiten

Diamant-Schleifscheibe
Korngröße:
D6 – Erster Freiwinkel (β1–β3)
D64 – Zweiter Freiwinkel (β2)

Wichtig:

Durch einen Nachschliff reduziert sich der Reib-Durchmesser. Bei einer Neubeschichtung können sich Abweichungen im Durchmesser ergeben.
Die maximale Rundlaufabweichung, gemessen an der Führungsfase, beträgt 10 µm *(394 µin)*





∅ **Precimaster Plus mm** *(Zoll)*	β_1	β_2	β_3	**T mm** *(Zoll)*
7,75–9,999 *(0.3151–0.3937)*	8°	18°	8°	0,20 *(0.008)*
10,00–14,499 *(0.3937–0.5708)*	8°	18°	8°	0,20 *(0.008)*
14,500–21,499 *(0.5709–0.8464)*	8°	18°	8°	0,20 *(0.008)*
21,500–32,499 *(0.8465–1.2795)*	8°	18°	8°	0,25 *(0.010)*
32,500–60,499 *(1.2795–2.3819)*	8°	15°	8°	0,30 *(0.012)*

Schnittdaten – PM Plus... -EB45 Metrisch

SMG		a_p (∅)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
P1	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–	–
P2	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–	–
P3	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–	–
P4	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P5	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P6	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P7	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P8	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–	–
P11	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–	–
P12	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	12 (8-15)	25 (15-45)	30 (15-65)	–	65 (45-95)	95 (65-145)	–	–	–	–	–
M1	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	12 (9-15)	25 (15-45)	35 (20-70)	–	–	–	–	–	25 (15-40)	40 (25-80)	–
M2	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	–	25 (15-40)	40 (25-80)	–
M3	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	–	25 (15-40)	40 (25-80)	–
M4	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	–	20 (10-30)	30 (20-60)	–
M5	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	–	20 (10-30)	30 (20-60)	–
K1	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
K2	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	25 (20-40)	40 (30-70)	45 (35-80)	–	80 (50-100)	90 (55-110)	–	–	–	–
K3	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
K4	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–	–
K5	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–	–
K6	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
K7	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
N1	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
N2	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
N3	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
N11	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
S1	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	-	–	–	25 (12-30)
S2	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	-	–	–	25 (12-30)
S3	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	-	–	–	25 (12-30)
S11	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	–	50 (25-65)
S12	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	–	50 (25-65)
S13	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	–	50 (25-65)

Die Tabelle wird auf der nächsten Seite fortgesetzt.

Schnittdaten – PM Plus... -EB45 Metrisch

SMG		a_p (∅)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
H3	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H5	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H7	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H8	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H11	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H12	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H21	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H31	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB45	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–	–
PM2	PMXxx ..6 ..8 -EB45	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–	–
PM3	PMXxx ..6 ..8 -EB45	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–	–
TS1	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	–
TS2	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	–
TS3	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	–
TS4	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	25 (12-30)
TP1	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	25 (12-30)
TP2	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	25 (12-30)
TP3	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	50 (25-65)
TP4	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	50 (25-65)
GR1	PMXxx ..6 ..8 -EB45	0,10 -0,30	0,10 -0,40	0,30 -0,90	0,40 -1,20	0,50 -1,50	40 (80-20)	–	60 (30-120)	–	–	–	–	–	–	–	50 (25-65)

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – PM Plus...-EB45 *Zoll*

SMG		a_p (∅)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
P1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–	–
P2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–	–
P3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–	–
P4	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P5	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P6	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P7	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P8	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–	–
P11	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–	–
P12	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.008	.008 -.028	.012 -.039	.016 -.047	40 (25-50)	80 (50-130)	100 (50-215)	–	215 (150-315)	315 (215-480)	–	–	–	–	–
M1	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	40 (30-50)	80 (50-130)	115 (65-230)	–	–	–	–	–	80 (50-130)	130 (80-260)	–
M2	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	–	80 (50-130)	130 (80-260)	–
M3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	–	80 (50-130)	130 (80-260)	–
M4	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	–	65 (35-100)	100 (65-195)	–
M5	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	–	65 (35-100)	100 (65-195)	–
K1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
K2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	80 (65-130)	130 (100-230)	145 (110-260)	–	260 (165-330)	290 (185-370)	–	–	–	–
K3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
K4	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–	–
K5	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–	–
K6	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
K7	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
N1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N11	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
S1	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S2	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S11	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	–	165 (80-215)
S12	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	–	165 (80-215)
S13	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	–	165 (80-215)

Die Tabelle wird auf der nächsten Seite fortgesetzt.

Schnittdaten – PM Plus...-EB45 *Zoll*

SMG		a_p (∅)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
H5	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H7	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H8	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H11	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H12	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H21	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H31	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
PM1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .012	.012- .035	.016- .047	.020- .059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–	–
PM2	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .012	.012- .035	.016- .047	.020- .059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–	–
PM3	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .012	.012- .035	.016- .047	.020- .059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–	–
TS1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TS2	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TS3	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TS4	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP2	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP3	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP4	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
GR1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .016	.012- .035	.016- .047	.020- .059	130 (260-65)	–	195 (100-395)	–	–	–	–	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c = sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – PM Plus...-EB845 Metrisch

SMG		a_p (∅)		f			v_c									
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RM2020	RM2090	RS2090
P3	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–
P4	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P5	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P6	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P7	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P8	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–
P11	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–
P12	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	12 (8-15)	25 (15-45)	30 (15-65)	–	65 (45-95)	95 (65-145)	–	–	–	–
M1	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	12 (9-15)	25 (15-45)	35 (20-70)	–	–	–	–	25 (15-40)	35 (20-70)	–
M2	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	25 (15-40)	35 (20-70)	–
M3	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	25 (15-40)	35 (20-70)	–
M4	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	20 (10-30)	25 (15-50)	–
M5	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	20 (10-30)	25 (15-50)	–
K1	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
K2	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	25 (20-40)	40 (30-70)	45 (35-80)	–	80 (50-100)	90 (55-110)	–	–	–
K3	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
K4	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–
K5	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–
K6	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
K7	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
S1	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	–	–	25 (12-30)
S2	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	–	–	25 (12-30)
S3	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	–	–	25 (12-30)
S11	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	50 (25-65)
S12	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	50 (25-65)
S13	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	50 (25-65)
H3	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H5	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H7	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H8	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H11	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H12	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H21	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H31	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB845	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–
PM2	PMXxx ..6 ..8 -EB845	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–
PM3	PMXxx ..6 ..8 -EB845	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – PM Plus...-EB845 *Zoll*

SMG		a_p (∅)		f			v_c									
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RM2020	RM2090	RS2090
P3	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–
P4	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P5	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P6	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P7	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P8	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–
P11	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–
P12	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	40 (25-50)	80 (50-130)	100 (50-215)	–	215 (150-315)	315 (215-480)	–	–		
M1	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	40 (30-50)	80 (50-130)	115 (65-230)	–	–	–	–	80 (50-130)	115 (65-230)	–
M2	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	80 (50-130)	115 (65-230)	–
M3	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	80 (50-130)	115 (65-230)	–
M4	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	65 (35-100)	80 (50-165)	–
M5	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	65 (35-100)	80 (50-165)	–
K1	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–
K2	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	80 (65-130)	130 (100-230)	145 (110-260)	–	260 (165-330)	290 (185-370)	–	–	–
K3	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–
K4	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–
K5	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–
K6	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–
K7	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	-
S1	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S2	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S3	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S11	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	165 (80-215)
S12	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	165 (80-215)
S13	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	165 (80-215)
H3	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H5	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H7	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H8	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H11	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H12	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H21	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H31	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
PM1	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–
PM2	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–
PM3	*PMXxx ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Plus... -EB25/EB30 Metrisch

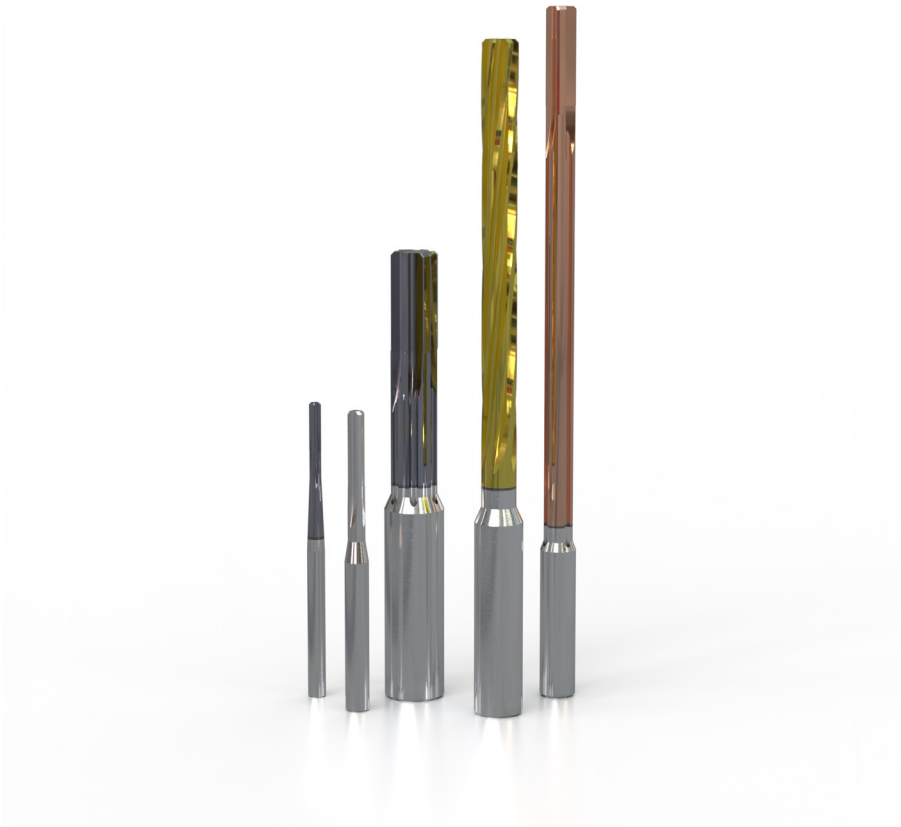
SMG		a_p (∅)		f			v_c						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–
P2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–
P3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–
P4	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
P5	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
P6	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
P7	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
M1	PMXxx ..6 ..8 -EB25/EB30	0,08-0,15	0,10-0,20	0,80-1,20	1,00-2,00	1,20-2,50	–	25 (15-40)	35 (20-70)	–	–	–	–
K1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
K2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	–	25 (20-40)	40 (30-70)	45 (35-80)	–	80 (50-100)	90 (55-110)
K3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
K4	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)
K5	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)
K6	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
K7	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
N1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
N2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
N3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
N11	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	–	50 (30-80)	70 (40-100)	–	–	–	–

SMG = Seco Werkstoff-Gruppe. a_p = mm. f = mm/U. v_c= m/min. Alle Schnittdaten sind Startwerte

Schnittdaten – PM Plus... -EB25/EB30 *Zoll*

SMG		a_p (∅)		f			v_c						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–	*590 (295-655)*	*720 (395-985)*	–
P2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–	*590 (295-655)*	*720 (395-985)*	–
P3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–	*590 (295-655)*	*720 (395-985)*	–
P4	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
P5	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
P6	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
P7	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .071*	*.039 – .094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
M1	*PMXxx ..6 ..8 -EB25/EB30*	*.003 – .006*	*.004 – .008*	*.031 – .047*	*.039 – .079*	*.039-.098*	–	*80 (50-130)*	*115 (65-230)*	–	–	–	–
K1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .087*	*.039 – .110*	*.047-.138*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
K2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .071*	*.039 – .094*	*.047-.118*	–	*80 (65-130)*	*130 (100-230)*	*145 (110-260)*	–	*260 (165-330)*	*290 (185-370)*
K3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .087*	*.039 – .110*	*.047-.138*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
K4	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .087*	*.039 – .110*	*.047-.138*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*	*330 (230-490)*	*490 (260-655)*	*550 (290-735)*
K5	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .087*	*.039 – .110*	*.047-.138*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*	*330 (230-490)*	*490 (260-655)*	*550 (290-735)*
K6	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .071*	*.039 – .094*	*.047-.118*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
K7	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .010*	*.031 – .071*	*.039 – .094*	*.047-.118*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
N1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .087*	*.039 – .110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .087*	*.039 – .110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .087*	*.039 – .110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N11	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.031 – .087*	*.039 – .110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
PM1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.020 – .071*	*.031 – .079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–
PM2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.020 – .071*	*.031 – .079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–
PM3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 – .008*	*.004 – .012*	*.020 – .071*	*.031 – .079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–

SMG = Seco Werkstoff-Gruppe. a_p = *Zoll*. f = in/U. v_c= sf/min. Alle Schnittdaten sind Startwerte

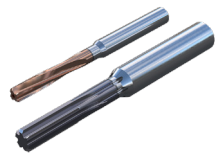
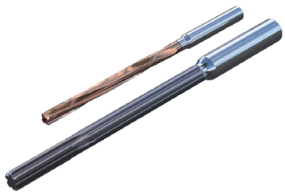
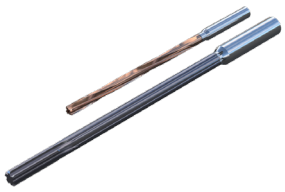


Nanojet

Nanojet Vollhartmetall-Reibahlen eignen sich für kleine Durchmesser von 1,461 bis 11,960mm (0,057'' - 0470").

- Leistungsstarke und innovative Kühlmitteldüse
- Ermöglicht die Herstellung von Durchmessertoleranz zwischen 10 und 15 µm (0,0004'' – 0,0006'')
- Acht verfügbare Geometrien: EB45, EBS45, EB845, EB25, EB30, EBS30, EB60 und EB75
- Drei verschiedene Längen: Kurz, mittel und lang

Programmübersicht

Nanojet	Durchmesser-bereich	Reibtiefe	Bohrungsdurchmesser-toleranz	Zwischendurchmesser	Oberflächengüte
Kurz 	1,461- 11,960 mm *(0.057-0.470")*	~ 4-7 x D	IT 7	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Mittleres 	1,461- 11,960 mm *(0.057-0.470")*	~ 7-12 x D	IT 7	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Lang 	1,461- 11,960 mm *(0.057-0.470")*	~ 12-15 x D	IT 7	Ja, auch über MyDesign verfügbar	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*

Nanojet ist eine Vollhartmetall-Reibahle für kleine Durchmesser von 1,461 bis 9,960 mm (0,057'' - 0,392'').
Das Design umfasst eine innovative periphere Kühlmitteldüse, die das Kühlmittel optimiert und leistungsstark direkt in die Spannuten leitet.

Code-Schlüssel

Reibahlen

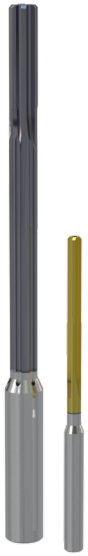
N5TS	–	4H7	–	EB45	–	RX2000
1		2		3		4

1.	2.	3.	4
Reibahlentyp	Bohrungsdurchmesser und Toleranz	Anschnittgeometrie	Sorte

Reibahlen mit Zwischendurchmesser

N4BM	–	2.5 P7	–	EB30	–	RK2050
1		2		3		4

0.0984”–0.0989”
2



1.	2.	3.	4
Reibahlentyp	Bohrungsdurchmesser und Toleranz	Anschnittgeometrie	Sorte

Reibahlen mit Zwischendurchmesser

N5TL	–	9.525 H7	–	EB60	–	RN2010
1		2		3		4

0.3750”–0.3751”
2

1.	2.	3.	4
Reibahlentyp	Bohrungsdurchmesser und Toleranz	Anschnittgeometrie	Sorte

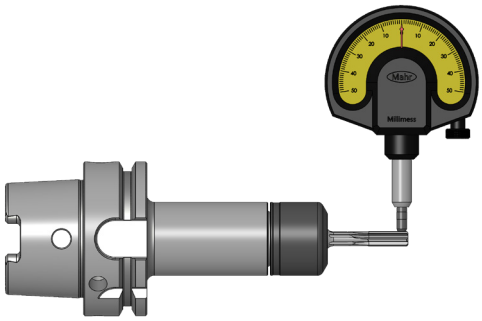
N5TS / N5TM / N5TL: Gerade Spannutform. Geeignet für Durchgangsbohrungen, kurze, mittlere und lange Ausführung.
N5BS / N5BM / N5BL: Gerade Spannutform. Geeignet für Grundlochbohrungen, kurze, mittlere und lange Ausführung.
N4BS / N4BM / N4BTL: Rechtsschneidiges Schneidendesign. Geeignet für Grundlochbohrungen, kurze, mittlere und lange Ausführung.
Die rechtsschneidige Ausführung verbessert die Spanabfuhr, empfohlen für tiefe Grundlochbohrungen.

Siehe Auswahl der Nanojet-Spannutgeometrien auf den Seite(n) 371.

Rundlaufabweichung

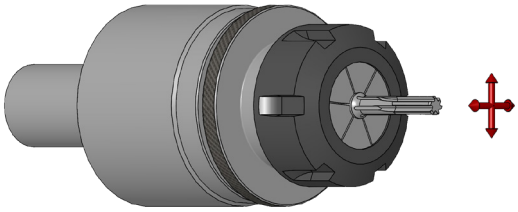
Rotierendes Werkzeug

Die empfohlene maximale Rundlaufabweichung beträgt: 5 µm *(197 µin)*.
Präzisionsaufnahmen werden empfohlen: Hydrodehnspannfutter, ERHP-Hochpräzisions-Spannzangenfutter oder Schrumpfhalter



Statisches Werkzeug

Pendelhalter ermöglichen eine Selbstzentrierung der Reibahle in der Vorbohrung.



Kühlschmierstoffzufuhr

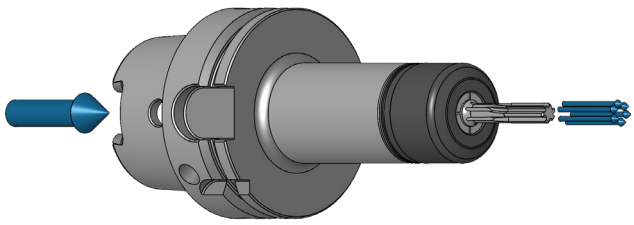
Zur Erreichung maximaler Standzeit und Bohrungsqualität sind die nachfolgenden Kühlschmierstoffanforderungen zu beachten.

Für das Werkzeug wird interne Kühlschmierstoffzufuhr empfohlen. Äußere Kühlmittelzufuhr kann verwendet werden, wenn die Zerspanungsbedingungen um 75 % reduziert werden.

Lösliches Öl mit mindestens 40 % Mineralöl verwenden.
Für Rostfrei empfehlen wir reines Öl.

Mindest-Konzentration 6 bis 8%. Filtrierung 30–50 µm *(1181-1969 µin)*.
Volumen min. 0,5 l/min/mm *(0.13 gal/min/Zoll)* für Werkzeugdurchmesser (Beispiel: Reibahle Durchmesser 10, Mindestvolumen beträgt 5 l/min *(1.3 gal/min)*.

Empfohlener Kühlschmiermitteldruck: min. 8-10 bar, max. 30 bar

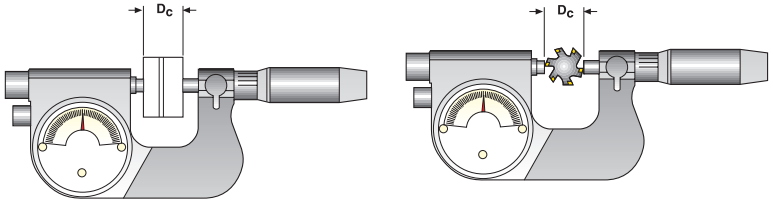


Messung des Durchmessers

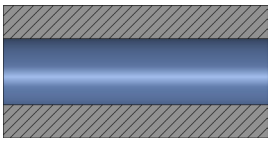
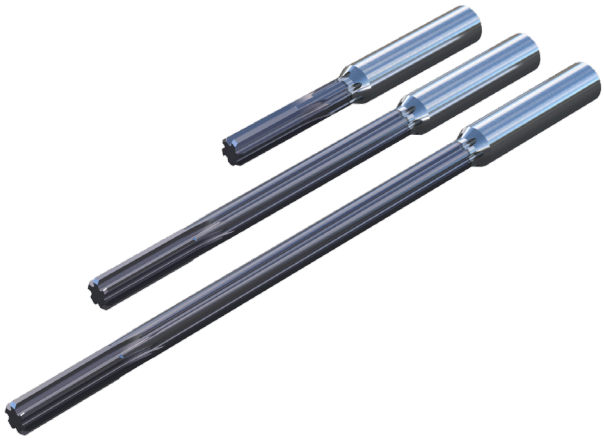
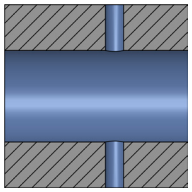
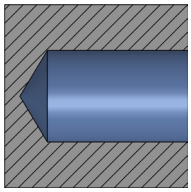
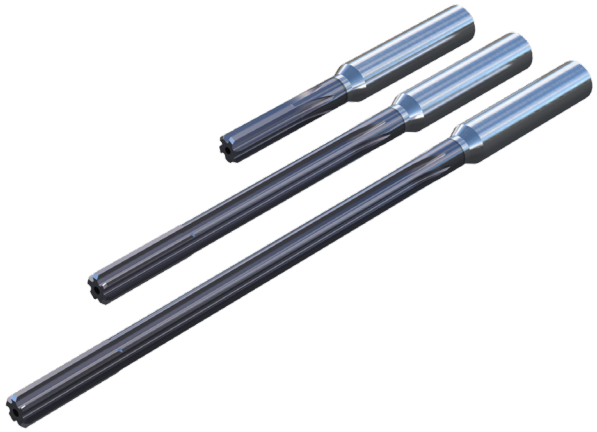
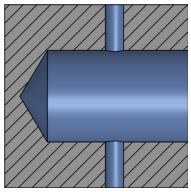
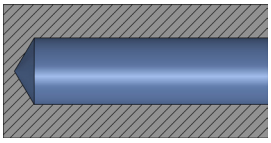
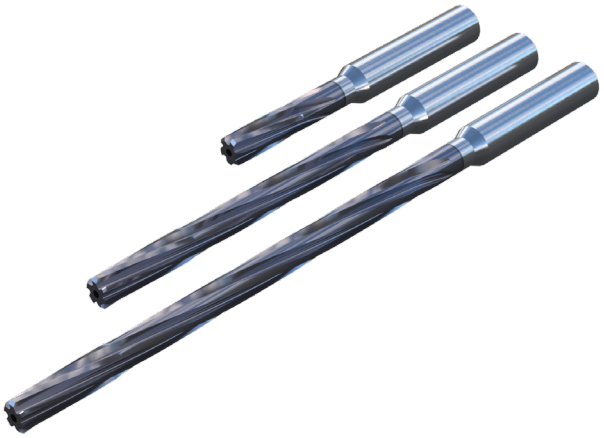
Messung des Durchmessers mit Mikrometer-Uhr.

Wichtig:
Nanojet-Reibahlen haben eine ungleiche Zahnteilung.
Die Messung des Durchmessers erfolgt über zwei Schneiden, die um 180° versetzt sind.

Messung des Durchmessers mit Mikrometer und Messblock zum Kalibrieren.



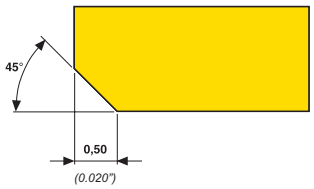
Auswahl der Spannutgeometrie

Werkstück	Bearbeitungsdurchmesser ∅ 1.461–11.960 mm *(0,057–0,470")*	
Durchgangsbohrungen 	**Gerade Spannuten** N5T	
Durchgangs- und Querbohrungen 		
Grundlochbohrung 	**Gerade Spannuten** N5B	
Grundloch- und Querbohrung 		
Grundlochbohrungen > 3 x D 	**Rechtsgedrallte Spannuten** N4B	

Auswahl der Geometrie – Anwendung

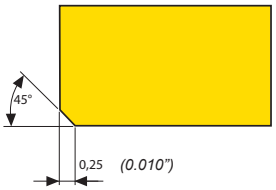
Anschnittgeometrie – EB45

Sehr gute Spankontrolle
Hervorragende Oberflächengüte R_a 0,8 - 1,2 µm
(Hervorragende Oberflächengüte R_a 31 - 47 µin)
Vielseitig



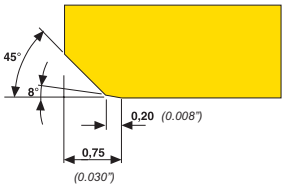
Anschnittgeometrie – EBS45

Sehr gute Spankontrolle
Gute Oberflächengüte R_a 0,8- 1,2 µm
(Gute Oberflächengüte R_a 31- 47 µin)
EB45 kurz



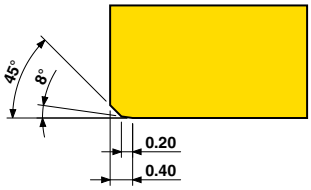
Anschnittgeometrie – EB845

Sehr gute Spankontrolle
Hervorragende Oberflächengüte R_a 0,2 - 0,8 µm
(Hervorragende Oberflächengüte R_a 8 - 31 µin)



Anschnittgeometrie – EBS845

Sehr gute Spankontrolle
Hervorragende Oberflächengüte R_a 0,2 - 0,8 µm
(Hervorragende Oberflächengüte R_a 8 - 31 µin)

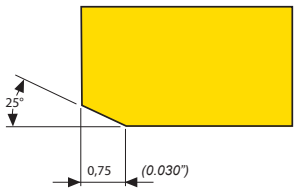


Hinweis: Für kleine Anschnittgeometrien können Längenmaße etwas kleiner als oben angegeben sein.

Auswahl der Geometrie – Anwendung

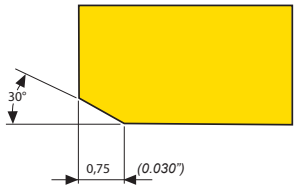
Anschnittgeometrie – EB25

Exzellente Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle



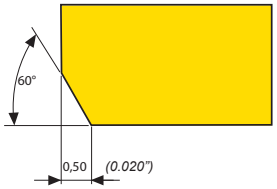
Anschnittgeometrie – EB30

Vorschubleistung +++
Oberflächengüte ++ R_a 0,4 - 0,8 µm
(Oberflächengüte ++ R_a 16 - 31 µin)
Spankontrolle +



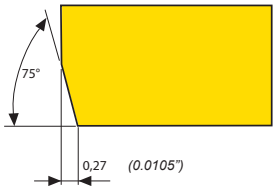
Anschnittgeometrie – EB60

Sehr gute Oberflächengüte R_a 0,8- 1,2 µm
(Sehr gute Oberflächengüte R_a 31 - 47 µin)
Sehr gute Spankontrolle



Anschnittgeometrie – EB75

Oberflächengüte ++ R_a 0,8 - 1,2 µm
(Oberflächengüte ++ R_a 31 - 47 µin)
Spankontrolle ++



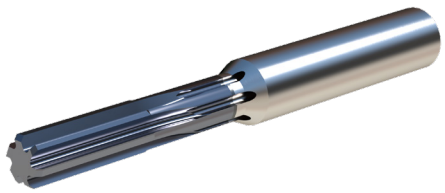
Hinweis: Für kleine Anschnittgeometrien können Längenmaße etwas kleiner als oben angegeben sein.

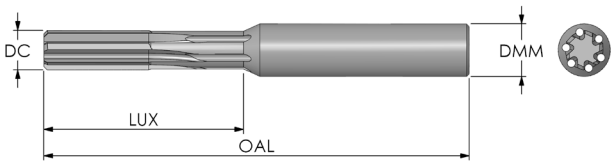
Sorten

	RX2000	**Beschichtet** Beschichtete Hochleistungssorte für alle Werkstoffe.
	CP20	**Beschichtet** Eine vielseitige beschichtete Sorte, die für die meisten Werkstoffe außer Aluminium geeignet ist. TiN
	H15	**Unbeschichtet** Zähe Sorte mit scharfer Schneidkante für alle Werkstoffe. Dank der hervorragenden Kantenstabilität zum Feinreiben geeignet.
	RN2010	**Unbeschichtet** Feinstkörnige, unbeschichtete Sorte mit optimierten Geometrien für NE-Metalle
	RM2020	**Beschichtet** Zähe, beschichtete Sorte für Feinreibbearbeitungen mit optimierten Geometrien für M-Werkstoffe.
	RM2090	**Beschichtet** Verschleißfeste, beschichtete Sorte mit spezifischen Geometrien für M-Werkstoffe. Optimierung bei M-Werkstoffen.
	RK2050	**Beschichtet** Zähe, beschichtete Sorte für Feinreibbearbeitungen mit optimierten Geometrien für K-Werkstoffe.
	RS2090	**Beschichtet** Verschleißfeste, beschichtete Sorte mit spezifischen Geometrien für S-Werkstoffe. Optimierung bei S-Werkstoffen.

Reibahle für Durchgangsbohrungen

∅ 1,98–11,113 mm / 0.0779–0.4375”





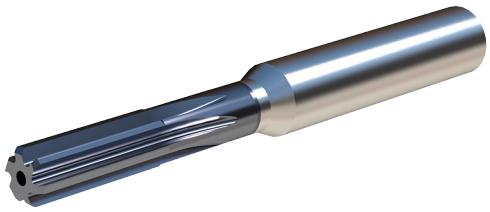
Bezeichnung	Produktnummer	DC	Bohrungsdurchmesser min-max		LUX	OAL	DMM		Geometrie			Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	H15	H15
N5TS-1.98H7-EB45	10289732	1,98 *0.0780*	1,98 *0.0780*	1,99 *0.0783*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-1.99H7-EB45	10289733	1,99 *0.0783*	1,99 *0.0783*	2,0 *0.0787*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2H7-EB45	10238500	2,0 *0.0787*	2,0 *0.0787*	2,01 *0.0791*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2.01H7-EB45	10289734	2,01 *0.0791*	2,01 *0.0791*	2,02 *0.0795*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2.02H7-EB45	10289735	2,02 *0.0795*	2,02 *0.0795*	2,03 *0.0799*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2.98H7-EB45	10289736	2,98 *0.1173*	2,98 *0.1173*	2,99 *0.1177*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-2.99H7-EB45	10289737	2,99 *0.1177*	2,99 *0.1177*	3,0 *0.1181*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3H7-EB45	10238501	3,0 *0.1181*	3,0 *0.1181*	3,01 *0.1185*	21,0 *0.8270*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.01H7-EB45	10289738	3,01 *0.1185*	3,01 *0.1185*	3,022 *0.1190*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.02H7-EB45	10289739	3,02 *0.1189*	3,02 *0.1189*	3,032 *0.1194*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.175H7-EB45	10289740	3,175 *0.1250*	3,175 *0.1250*	3,187 *0.1255*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.98H7-EB45	10289741	3,98 *0.1567*	3,98 *0.1567*	3,992 *0.1572*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-3.99H7-EB45	10289742	3,99 *0.1571*	3,99 *0.1571*	4,002 *0.1576*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4H7-EB45	10238502	4,0 *0.1575*	4,0 *0.1575*	4,012 *0.1580*	28,0 *1.1020*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4.01H7-EB45	10289743	4,01 *0.1579*	4,01 *0.1579*	4,022 *0.1583*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4.02H7-EB45	10289744	4,02 *0.1583*	4,02 *0.1583*	4,032 *0.1587*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4.98H7-EB45	10289745	4,98 *0.1961*	4,98 *0.1961*	4,992 *0.1965*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-4.99H7-EB45	10289746	4,99 *0.1965*	4,99 *0.1965*	5,002 *0.1969*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5H7-EB45	10238503	5,0 *0.1969*	5,0 *0.1969*	5,012 *0.1973*	28,0 *1.1020*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5.01H7-EB45	10289747	5,01 *0.1972*	5,01 *0.1972*	5,022 *0.1977*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5.02H7-EB45	10290135	5,02 *0.1976*	5,02 *0.1976*	5,032 *0.1981*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5.98H7-EB45	10289748	5,98 *0.2354*	5,98 *0.2354*	5,992 *0.2359*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-5.99H7-EB45	10289749	5,99 *0.2358*	5,99 *0.2358*	6,002 *0.2363*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-6H7-EB45	10238504	6,0 *0.2362*	6,0 *0.2362*	6,015 *0.2368*	30,0 *1.1810*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-6.01H7-EB45	10290075	6,01 *0.2366*	6,01 *0.2366*	6,025 *0.2372*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-6.02H7-EB45	10289750	6,02 *0.2370*	6,02 *0.2370*	6,035 *0.2376*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□

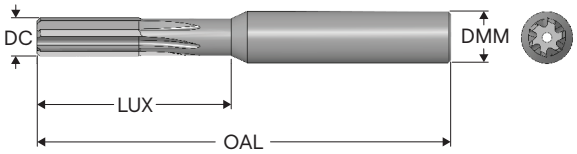
Bezeichnung	Produktnummer	DC	Bohrungsdurchmesser min-max		LUX	OAL	DMM		Geometrie			Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	H15	H15
N5TS-6.35H7-EB45	10238506	6,35 *0.2500*	6,35 *0.2500*	6,365 *0.2506*	30,0 *1.1810*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-7H7-EB45	10289625	7,0 *0.2756*	7,0 *0.2756*	7,015 *0.2762*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-7.937H7-EB45	10289626	7,937 *0.3125*	7,937 *0.3125*	7,952 *0.3131*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-7.98H7-EB45	10289751	7,98 *0.3142*	7,98 *0.3142*	7,995 *0.3148*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-7.99H7-EB45	10289752	7,99 *0.3146*	7,99 *0.3146*	8,005 *0.3152*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-8H7-EB45	10238505	8,0 *0.3150*	8,0 *0.3150*	8,015 *0.3156*	40,0 *1.5750*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-8.01H7-EB45	10289753	8,01 *0.3154*	8,01 *0.3154*	8,025 *0.3159*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-8.02H7-EB45	10289754	8,02 *0.3157*	8,02 *0.3157*	8,035 *0.3163*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-9.525H7-EB45	10289627	9,525 *0.3750*	9,525 *0.3750*	9,54 *0.3756*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□

■ Lagerstandard. □ nicht standardmäßig auf Lager.

Reibahle für Grundlochbohrungen

∅ 1,98–11,113 mm / 0.0779–0.4375”





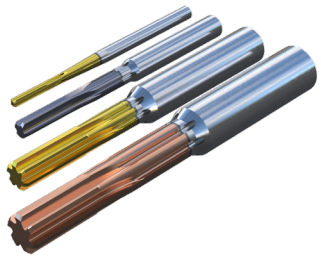
Bezeichnung	Produktnummer	DC	Bohrungsdurchmesser min-max		LUX	OAL	DMM		Geometrie			Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	H15	H15
N5BS-1.98H7-EB45	10289755	1,98 *0.0780*	1,98 *0.0780*	1,99 *0.0783*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-1.99H7-EB45	10289756	1,99 *0.0783*	1,99 *0.0783*	2,0 *0.0787*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-2.01H7-EB45	10289757	2,01 *0.0791*	2,01 *0.0791*	2,02 *0.0795*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-2.02H7-EB45	10289758	2,02 *0.0795*	2,02 *0.0795*	2,03 *0.0799*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-2.98H7-EB45	10289759	2,98 *0.1173*	2,98 *0.1173*	2,99 *0.1177*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-2.99H7-EB45	10289760	2,99 *0.1177*	2,99 *0.1177*	3,0 *0.1181*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-2H7-EB45	10284828	2,0 *0.0787*	2,0 *0.0787*	2,01 *0.0791*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-3.01H7-EB45	10289761	3,01 *0.1185*	3,01 *0.1185*	3,022 *0.1190*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-3.02H7-EB45	10289762	3,02 *0.1189*	3,02 *0.1189*	3,032 *0.1194*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-3.175H7-EB45	10289628	3,175 *0.1250*	3,175 *0.1250*	3,187 *0.1255*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-3.98H7-EB45	10289764	3,98 *0.1567*	3,98 *0.1567*	3,992 *0.1572*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-3.99H7-EB45	10289765	3,99 *0.1571*	3,99 *0.1571*	4,002 *0.1576*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-3H7-EB45	10284829	3,0 *0.1181*	3,0 *0.1181*	3,01 *0.1185*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-4.01H7-EB45	10289766	4,01 *0.1579*	4,01 *0.1579*	4,022 *0.1583*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-4.02H7-EB45	10289767	4,02 *0.1583*	4,02 *0.1583*	4,032 *0.1587*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-4.98H7-EB45	10289768	4,98 *0.1961*	4,98 *0.1961*	4,992 *0.1965*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-4.99H7-EB45	10289769	4,99 *0.1965*	4,99 *0.1965*	5,002 *0.1969*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-4H7-EB45	10284830	4,0 *0.1575*	4,0 *0.1575*	4,012 *0.1580*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-5.01H7-EB45	10289770	5,01 *0.1972*	5,01 *0.1972*	5,022 *0.1977*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-5.02H7-EB45	10290138	5,02 *0.1976*	5,02 *0.1976*	5,032 *0.1981*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-5.98H7-EB45	10289771	5,98 *0.2354*	5,98 *0.2354*	5,992 *0.2359*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-5.99H7-EB45	10289772	5,99 *0.2358*	5,99 *0.2358*	6,002 *0.2363*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-5H7-EB45	10284831	5,0 *0.1969*	5,0 *0.1969*	5,012 *0.1973*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-6.01H7-EB45	10289773	6,01 *0.2366*	6,01 *0.2366*	6,025 *0.2372*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-6.02H7-EB45	10289774	6,02 *0.2370*	6,02 *0.2370*	6,035 *0.2376*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-6.35H7-EB45	10284836	6,35 *0.2500*	6,35 *0.2500*	6,365 *0.2506*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□

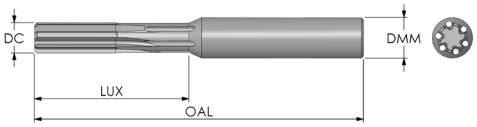
Bezeichnung	Produktnummer	DC	Bohrungsdurchmesser min-max		LUX	OAL	DMM		Geometrie			Beschichtung		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	H15	H15
N5BS-6H7-EB45	10284832	6,0 *0.2362*	6,0 *0.2362*	6,015 *0.2368*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-7.937H7-EB45	10289630	7,937 *0.3125*	7,937 *0.3125*	7,952 *0.3131*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-7.98H7-EB45	10289775	7,98 *0.3142*	7,98 *0.3142*	7,995 *0.3148*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-7.99H7-EB45	10289776	7,99 *0.3146*	7,99 *0.3146*	8,005 *0.3152*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-7H7-EB45	10289629	7,0 *0.2756*	7,0 *0.2756*	7,015 *0.2762*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-8.01H7-EB45	10289777	8,01 *0.3154*	8,01 *0.3154*	8,025 *0.3159*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-8.02H7-EB45	10289778	8,02 *0.3157*	8,02 *0.3157*	8,035 *0.3163*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-8H7-EB45	10284833	8,0 *0.3150*	8,0 *0.3150*	8,015 *0.3156*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-9.525H7-EB45	10289631	9,525 *0.3750*	9,525 *0.3750*	9,54 *0.3756*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□

■ Lagerstandard. □ nicht standardmäßig auf Lager.

Reibahle für Durchgangsbohrungen – Zwischendurchmesser

Gerade Schneide, kurze Version – ∅ 1,461-11,960 mm / 0.057- 0.470"





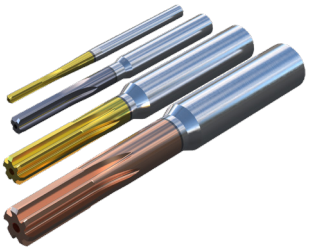
—Auswahl der Geometrie siehe Seite(n) 372-373
—Schnittdaten siehe Seite(n) 385-391

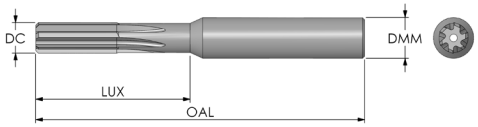
Bezeichnung	DCN	DCX	LUX	DMM	OAL		Geometrie	Beschichtung						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5TS-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	12,0 *0.472*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	17,0 *0.669*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	21,0 *0.827*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	23,0 *0.906*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	28,0 *1.102*	5,0 *0.197*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	28,0 *1.102*	6,0 *0.236*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	30,0 *1.181*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	31,0 *1.220*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	40,0 *1.575*	10,0 *0.394*	75,0 *2.953*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	50,0 *1.969*	12,0 *0.472*	100,0 *3.937*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Nanojet-Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: N5TS-2,5 R7-EBS45, RS2090

Reibahle für Grundlochbohrungen – Zwischendurchmesser

Gerade Schneide, kurze Version – ∅ 1,461-11,960 mm / 0.057- 0.470"





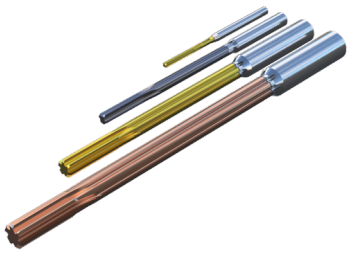
—Auswahl der Geometrie siehe Seite(n) 372-373
—Schnittdaten siehe Seite(n) 385-391

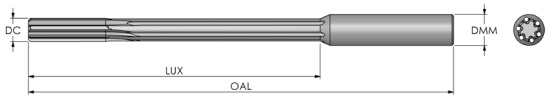
Bezeichnung	DCN	DCX	LUX	DMM	OAL		Geometrie	Beschichtung						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5BS-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	12,0 *0.472*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	17,0 *0.669*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	21,0 *0.827*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	23,0 *0.906*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	28,0 *1.102*	5,0 *0.197*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	28,0 *1.102*	6,0 *0.236*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	30,0 *1.181*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	31,0 *1.220*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	40,0 *1.575*	10,0 *0.394*	75,0 *2.953*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BS-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	50,0 *1.969*	12,0 *0.472*	100,0 *3.937*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐

☐ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Nanojet-Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: N5BS-8,084/8, 100-EB30, RK2050

Reibahle für Durchgangsbohrungen – Zwischendurchmesser

Gerade Schneide, mittlere Ausführung – ∅ 1,461-11,960 mm / 0.057- 0.470"





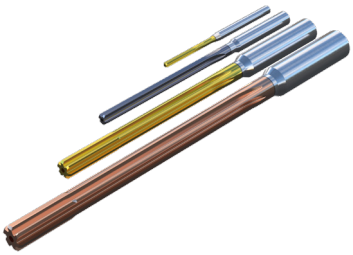
—Auswahl der Geometrie siehe Seite(n) 372-373
—Schnittdaten siehe Seite(n) 385-391

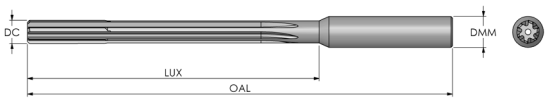
Bezeichnung	DCN	DCX	LUX	DMM	OAL		Geometrie	Beschichtung						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5TM-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	21,5 *0.846*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	32,5 *1.280*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	38,5 *1.516*	4,0 *0.157*	65,0 *2.559*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	48,5 *1.909*	4,0 *0.157*	75,0 *2.953*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	58,5 *2.303*	5,0 *0.197*	85,0 *3.346*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	68,5 *2.697*	6,0 *0.236*	95,0 *3.740*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	75,5 *2.972*	8,0 *0.315*	110,0 *4.331*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	86,5 *3.406*	8,0 *0.315*	120,0 *4.724*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	105,5 *4.154*	10,0 *0.394*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	117,0 *4.606*	12,0 *0.472*	165,0 *6.496*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Nanojet-Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: N5TM-2,5 R7-EBS45, RS2090

Reibahle für Grundlochbohrungen – Zwischendurchmesser

Gerade Schneide, mittlere Ausführung – ∅ 1,461-11,960 mm / 0.057- 0.470"





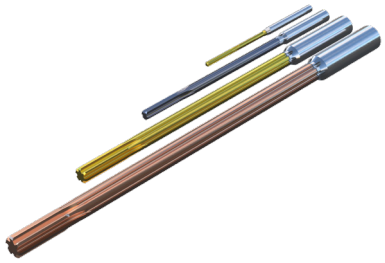
—Auswahl der Geometrie siehe Seite(n) 372-373
—Schnittdaten siehe Seite(n) 385-391

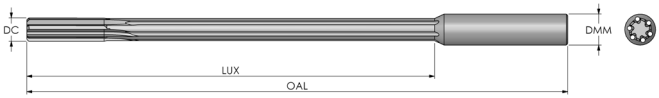
Bezeichnung	DCN	DCX	LUX	DMM	OAL		Geometrie	Beschichtung						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5BM-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	21,5 *0.846*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	32,5 *1.280*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	38,5 *1.516*	4,0 *0.157*	65,0 *2.559*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	48,5 *1.909*	4,0 *0.157*	75,0 *2.953*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	58,5 *2.303*	5,0 *0.197*	85,0 *3.346*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TBM-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	68,5 *2.697*	6,0 *0.236*	95,0 *3.740*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	75,5 *2.972*	8,0 *0.315*	110,0 *4.331*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	86,5 *3.406*	8,0 *0.315*	120,0 *4.724*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	105,5 *4.154*	10,0 *0.394*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	117,0 *4.606*	12,0 *0.472*	165,0 *6.496*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Nanojet-Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: N5BM-8,084/8, 100-EB30, RK2050

Reibahle für Durchgangsbohrungen – Zwischendurchmesser

Gerade Schneide, lange Version – ∅ 1,461-9,960 mm / 0.057- 0.392"





—Auswahl der Geometrie siehe Seite(n) 372-373
—Schnittdaten siehe Seite(n) 385-391

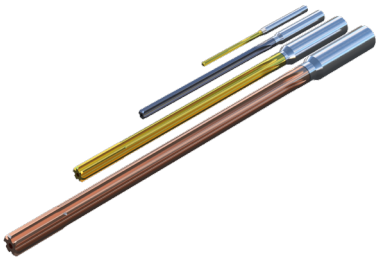
Bezeichnung	DCN	DCX	LUX	DMM	OAL		Geometrie	Beschichtung						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5TL-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	31,5 *1.240*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	42,5 *1.673*	3,0 *0.118*	70,0 *2.756*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	53,5 *2.106*	4,0 *0.157*	80,0 *3.150*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	61,5 *2.421*	4,0 *0.157*	88,0 *3.465*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	73,5 *2.894*	5,0 *0.197*	100,0 *3.937*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	88,5 *3.484*	6,0 *0.236*	115,0 *4.528*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	105,5 *4.154*	8,0 *0.315*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	121,5 *4.783*	8,0 *0.315*	155,0 *6.102*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5TL-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	145,5 *5.728*	10,0 *0.394*	180,0 *7.087*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐

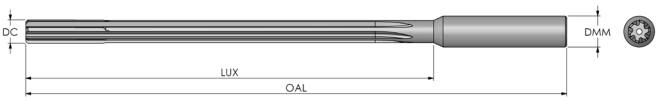
<STEPTABLE O="Nanojet N5TL thro-long" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

☐ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Nanojet-Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: N5TL-2,5 R7-EBS45, RS2090

Reibahle für Grundlochbohrungen – Zwischendurchmesser

Gerade Schneide, lange Version – ∅ 1,461-9,960 mm / 0.057- 0.392"





—Auswahl der Geometrie siehe Seite(n) 372-373
—Schnittdaten siehe Seite(n) 385-391

Bezeichnung	DCN	DCX	LUX	DMM	OAL		Geometrie	Beschichtung						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5BL-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	31,5 *1.240*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	42,5 *1.673*	3,0 *0.118*	70,0 *2.756*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	53,5 *2.106*	4,0 *0.157*	80,0 *3.150*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	61,5 *2.421*	4,0 *0.157*	88,0 *3.465*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	73,5 *2.894*	5,0 *0.197*	100,0 *3.937*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	88,5 *3.484*	6,0 *0.236*	115,0 *4.528*	4	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	105,5 *4.154*	8,0 *0.315*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	121,5 *4.783*	8,0 *0.315*	155,0 *6.102*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐
N5BL-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	145,5 *5.728*	10,0 *0.394*	180,0 *7.087*	6	EB45 EB845 EB30 EB60 …	☐	☐	☐	☐	☐	☐	☐

<STEPTABLE O="Nanojet N5BL blind-long" OT="Product" TT="stibo.91791239" VC="DEde" VO="6710816" W="Main" />

☐ = nicht standardmäßig auf Lager.
Hinweis: Bei der Bestellung von Nanojet-Reibahlen für Zwischendurchmesser bitte Durchmesser und Toleranz der zu reibenden Bohrung angeben.
Bestell-Beispiel: N5BL-8,084/8, 100-EB30, RK2050

Schnittdaten – Nanojet -EB45 Metrisch

SMG		a_p (∅)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
P1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	–	–	–	–
P2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	–	–	–	–
P3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	–	–	–	–
P4	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P5	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P6	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P7	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P8	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	–	–	–	–
P11	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	–	–	–	–
P12	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	12 (8-15)	25 (15-45)	30 (15-65)	-	–	–	–	–
M1	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	12 (9-15)	25 (15-40)	35 (20-60)	-	–	25 (15-40)	40 (20-60)	–
M2	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	25 (15-40)	35 (20-60)	-	–	25 (15-40)	40 (20-60)	–
M3	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	25 (15-40)	35 (20-60)	-	–	25 (15-40)	40 (20-60)	–
M4	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	20 (10-30)	25 (15-40)	-	–	25 (10-30)	30 (15-40)	–
M5	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	20 (10-30)	25 (15-40)	-	–	25 (10-30)	30 (15-40)	–
K1	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
K2	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	25 (20-40)	40 (30-70)	45 (35-80)	–	–	–	–
K3	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
K4	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	–	–	–	–
K5	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	–	–	–	–
K6	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
K7	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
N1	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
N2	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
N3	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
N4	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
S1	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	15 (8-20)	20 (10-25)	-	–	–	–	20 (10-25)
S2	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	15 (8-20)	20 (10-25)	-	–	–	–	20 (10-25)
S3	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	15 (8-20)	20 (10-25)	-	–	–	–	25 (10-25)
S11	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	–	–	–	30 (20-50)
S12	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	–	–	–	30 (20-50)
S13	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	–	–	–	30 (20-50)

Die Tabelle wird auf der nächsten Seite fortgesetzt.

Schnittdaten – Nanojet -EB45 Metrisch

SMG		a_p (∅)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
H3	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H5	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H7	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H8	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H11	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H12	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H21	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H31	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
PM1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	-	–	–	–	–
PM2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	-	–	–	–	–
PM3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	-	–	–	–	–
TS1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TS2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TS3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TS4	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP4	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
GR1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	40 (80-20)	–	60 (30-120)	-	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Nanojet -EB45 *Zoll*

SMG		a_p (∅)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
P1	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	–	–	–	–	–
P2	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	–	–	–	–	–
P3	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	–	–	–	–	–
P4	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P5	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P6	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P7	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P8	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–	–
P11	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–	–
P12	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	40 (25-50)	80 (50-150)	100 (50-215)	–	–	–	–	–
M1	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	40 (30-50)	80 (50-130)	115 (65-195)	–	–	80 (50-130)	130 (65-195)	–
M2	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	80 (50-130)	115 (65-195)	–	–	80 (50-130)	130 (65-195)	–
M3	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	80 (50-130)	115 (65-195)	–	–	80 (50-130)	130 (65-195)	–
M4	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	65 (35-100)	80 (50-130)	–	–	65 (35-100)	100 (50-130)	–
M5	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	65 (35-100)	80 (50-130)	–	–	65 (35-100)	100 (50-130)	–
K1	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
K2	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	80 (65-130)	130 (100-230)	145 (110-260)	–	–	–	–
K3	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
K4	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	–	–	–	–
K5	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	–	–	–	–
K6	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
K7	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
N1	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
N2	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
N3	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
N4	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
S1	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	–	50 (25-65)	65 (35-80)	–	–	–	–	65 (35-80)
S2	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	–	50 (25-65)	65 (35-80)	–	–	–	–	65 (35-80)
S3	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	–	50 (25-65)	65 (35-80)	–	–	–	–	80 (35-80)
S11	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	100 (65-165)
S12	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	100 (65-165)
S13	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	100 (65-165)

Die Tabelle wird auf der nächsten Seite fortgesetzt.

Schnittdaten – Nanojet -EB45 *Zoll*

SMG		a_p (∅)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
H3	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H5	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H7	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H8	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H11	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H12	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H21	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H31	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
PM1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–	–
PM2	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–	–
PM3	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–	–
TS1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TS2	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TS3	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TS4	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP2	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP3	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP4	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
GR1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*130 (65-260)*	–	*195 (100-395)*	–	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Nanojet -EB845 Metrisch

SMG		a_p (∅)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,30	0,20 -0,60	–	60 (30-100)	80 (30-150)	–	–	–	–
P4	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	60 (30-120)	–	–	–	–
P5	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	–	–	–	–
P6	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	–	–	–	–
P7	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	–	–	–	–
P8	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	15 (10-20)	35 (20-60)	40 (20-80)	–	–	–	–
P11	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	15 (10-20)	35 (20-60)	40 (20-80)	–	–	–	–
P12	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	12 (8-15)	25 (15-45)	30 (15-65)	–	–	–	–
M1	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	12 (9-15)	25 (15-45)	35 (20-60)	–	25 (15-40)	40 (20-60)	–
M2	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	25 (15-45)	35 (20-60)	–	25 (15-40)	40 (20-60)	–
M3	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	25 (15-45)	35 (20-60)	–	25 (15-40)	40 (20-60)	–
M4	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	20 (10-30)	25 (15-40)	–	25 (10-30)	30 (15-40)	–
M5	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	20 (10-30)	25 (15-40)	–	25 (10-30)	30 (15-40)	–
K1	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
K2	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	–	25 (20-40)	40 (30-70)	45 (35-80)	–	–	–
K3	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
K4	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (30-150)	–	–	–
K5	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	–	–	–
K6	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
K7	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
S1	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	15 (8-20)	20 (10-25)	–	–	–	20 (10-25)
S2	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	15 (8-20)	20 (10-25)	–	–	–	20 (10-25)
S3	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	15 (8-20)	20 (10-25)	–	–	–	25 (10-25)
S11	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	30 (20-50)
S12	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	30 (20-50)
S13	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	30 (20-50)
H3	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H5	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H7	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H8	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H11	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H12	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H21	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H31	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
PM1	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM2	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM3	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Nanojet -EB845 *Zoll*

SMG		a_p (∅)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.012	0.008 –0.024	–	195 (100-330)	260 (100-490)	–	–	–	–
P4	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	195 (100-395)	–	–	–	–
P5	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–
P6	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–
P7	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–
P8	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–
P11	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–
P12	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	40 (25-50)	80 (50-150)	100 (50-125)	–	–	–	–
M1	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	40 (30-50)	80 (50-150)	115 (65-200)	–	80 (50-130)	130 (65-195)	–
M2	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	80 (50-150)	115 (65-200)	–	80 (50-130)	130 (65-195)	–
M3	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	80 (50-150)	115 (65-200)	–	80 (50-130)	130 (65-195)	–
M4	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	65 (30-100)	80 (50-135)	–	80 (35-100)	100 (50-130)	–
M5	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	65 (30-100)	80 (50-135)	–	80 (35-100)	100 (50-130)	–
K1	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
K2	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	–	80 (65-130)	130 (100-230)	145 (110-260)	–	–	–
K3	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
K4	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	150 (100-330)	230 (130-395)	260 (145-440)	–	–	–
K5	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	150 (100-330)	230 (130-395)	260 (145-440)	–	–	–
K6	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
K7	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
S1	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	50 (25-65)	65 (35-80)	–	–	–	65 (35-80)
S2	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	50 (25-65)	65 (35-80)	–	–	–	65 (35-80)
S3	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	50 (25-65)	65 (35-80)	–	–	–	65 (35-80)
S11	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	100 (65-165)
S12	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	100 (65-165)
S13	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	100 (65-165)
H3	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H5	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H7	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H8	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H11	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H12	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H21	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H31	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
PM1	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	230 (130-350)	–	–	–	–
PM2	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	230 (130-350)	–	–	–	–
PM3	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	230 (130-350)	–	–	–	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Nanojet -EB25/EB30 Metrisch

SMG		a_p (∅)		f		v_c			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	–
P2	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	–
P3	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	–
P4	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
P5	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
P6	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
P7	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
M1	N5T/N5B-EB25/EB30	0,08-0,15	0,10-0,15	0,3-0,7	0,5-1	–	25 (15-40)	35 (20-60)	–
K1	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)
K2	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	–	25 (20-40)	40 (30-70)	45 (35-80)
K3	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)
K4	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)
K5	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)
K6	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	–	60 (40-100)	80 (30-150)	90 (35-170)
K7	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	–	60 (40-100)	80 (30-150)	90 (35-170)
N1	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N2	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N3	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N11	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
PM1	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	–	50 (30-80)	70 (40-100)	–
PM2	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	–	50 (30-80)	70 (40-100)	–
PM3	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	–	50 (30-80)	70 (40-100)	–

SMG = Seco Werkstoff-Gruppe. a_p = mm. f = mm/U. v_c= m/min. Alle Schnittdaten sind Startwerte

Schnittdaten – Nanojet -EB25/EB30 *Zoll*

SMG		a_p (∅)		f		v_c			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–
P2	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–
P3	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–
P4	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
P5	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
P6	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
P7	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
M1	*N5T/N5B-EB25/EB30*	*0.003–0.006*	*0.004–0.006*	*0.012–0.028*	*0.020–0.039*	–	*80 (50-130)*	*115 (65-195)*	–
K1	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
K2	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	–	*80 (65-130)*	*130 (100-230)*	*145 (110-260)*
K3	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
K4	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*
K5	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*
K6	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
K7	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
N1	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N2	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N3	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N11	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
PM1	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	–	*165 (100-265)*	*230 (130-330)*	–
PM2	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	–	*165 (100-265)*	*230 (130-330)*	–
PM3	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	–	*165 (100-265)*	*230 (130-330)*	–

SMG = Seco Werkstoff-Gruppe. a_p = *Zoll*. f = in/U. v_c= sf/min. Alle Schnittdaten sind Startwerte

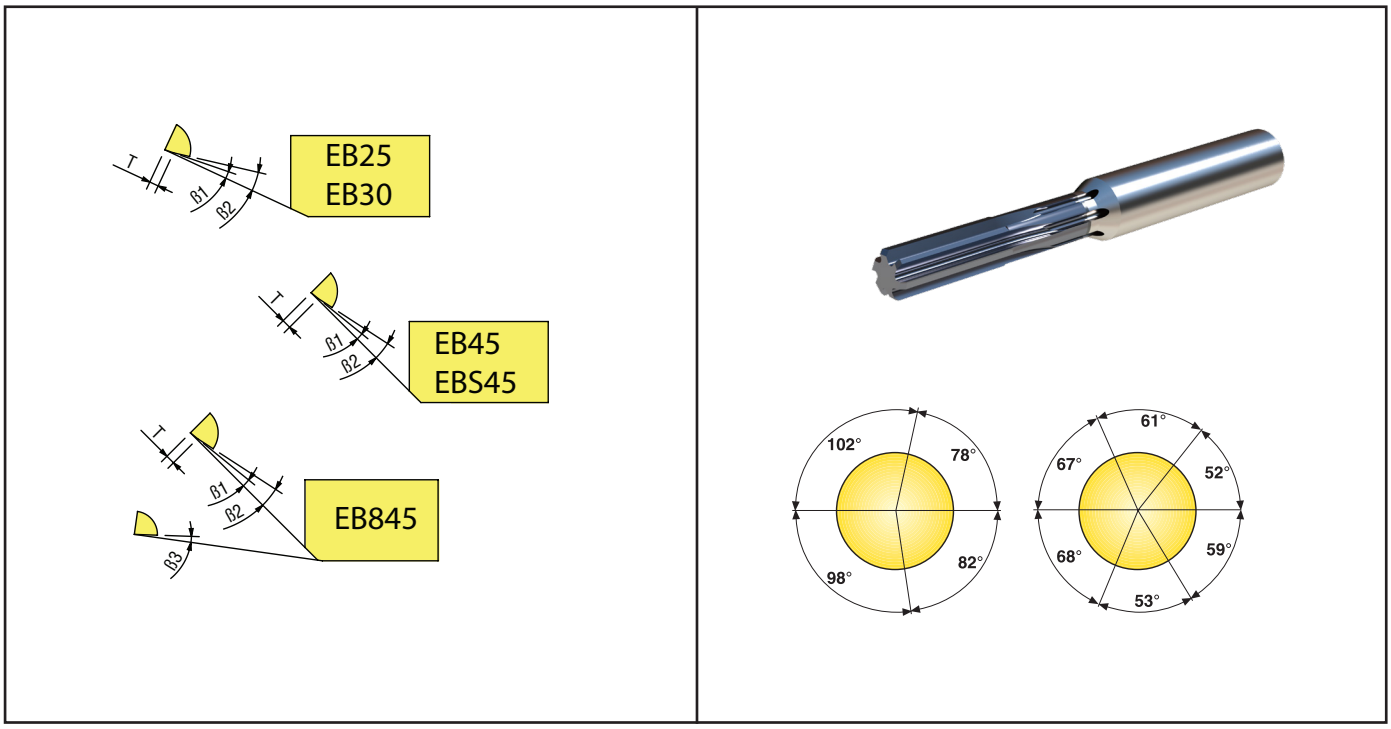
Hinweise zum Nachschleifen

Einzelheiten

Diamant-Schleifscheibe
Korngröße:
D6 für 1. Freiwinkel (β1 - β3)
D64 für 2. Freiwinkel (β2)

Wichtig

Durch einen Nachschliff reduziert sich der Reib-Durchmesser.
Bei einer Neubeschichtung können sich Abweichungen im Durchmesser ergeben.
Die maximale Rundlaufabweichung, gemessen an der Führungsfase, beträgt 10 µm *(394 µin)*.



Nanojet ∅ mm *(Zoll)*	β_1	β_2	β_3	T mm *(Zoll)*
1,461-2,460 *(0.0575-0.0968")*	8°	21°	8°	0,10 *(0.004")*
2,461-2,960 *(0.0969-0.1165")*	8°	18°	8°	0,10 *(0.004")*
2,961-9,960 *(0.1166-0.3921")*	8°	18°	8°	0,15 *(0.006")*
9,961-11,960 *(0.3922-0.470")*	8°	18°	8°	0,20 *(0.008")*

Bifix®

Die einstellbaren Bifix®-Reibahlen ermöglichen hohe Präzision in allen Werkstoff-Gruppen.

- Das System ermöglicht Toleranzen zwischen 8 und 16 µm und Oberflächengüten von Ra 0,25 (RMS 12 µ/Zoll).
- Mit zwei Schneidkanten pro Wendeplatte
- Drei Cermet-Führungsleisten und ein präzises Einstellsystem

Programmübersicht

	Durchmesser-bereich	Reibtiefe	Bohrungsdurchmesser-toleranz	Zwischendurchmesser	Oberflächengüte
SR80 Für Durchgangsbohrungen	6,875-60,500 mm *(0.2707-2.3819")*	5-7 x D	IT 6	Ja, auch über MyDesign verfügbar	R_a 0,2-0,8 µm *(R_a 8-31 µin)*
SR81 Für Grundlochbohrungen	7,875-60,500 mm *(0.3100-2.3819")*	5-7 x D	IT 6-7	Ja, auch über MyDesign verfügbar	R_a 0,2-0,8 µm *(R_a 8-31 µin)*
SR82 Für Grundlochbohrungen, kurze Ausführung	7,875-60,500 mm *(0.3100-2.3819")*	3-5 x D	IT 6-7	Ja, auch über MyDesign verfügbar	R_a 0,2-0,8 µm *(R_a 8-31 µin)*

Code-Schlüssel

Reibahlen

Wenn nicht anders gewünscht, sind die Reibahlen so ausgelegt, dass sie einen Durchmesser in der Mitte der geforderten Toleranz erzeugen.

SR80	–	16.85 P6	–	EN1	–	R	9
1		2		3		4	

0.6624”–0.6628”
2

1.
Reibahlen-Typ:
Typ 80: Durchgangsbohrung
Typ SR81: Grundlochbohrung
Typ SR82: Grundlochbohrung, kurze Ausführung

2.
Bohrungsdurchmesser und Toleranz

3.
Anschnittgeometrie:
EN1, EN2, EN3

4
Schafttyp: (angeben, wenn abweichend von Standard)
SR80 und SR81: R1 zylindrischer Schaft
SR82: R9 zylindrischer Schaft mit Spannfläche

Schneiden

Wichtig:
Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.

P2	–	EN1	–	06	–	CP20
1		2		3		4

1.
WSP-Größe:
P0, P1, P2, P4

2.
Anschnittgeometrie:
EN1, EN2, EN3

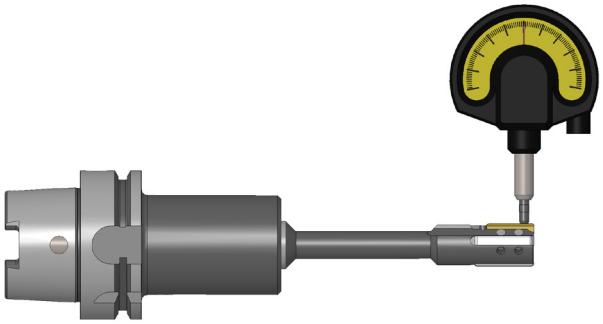
3.
Spanwinkel:
0°, 6°, 12°

4
Hartmetallsorte:
CP20, H15

Aufspannung und technische Informationen

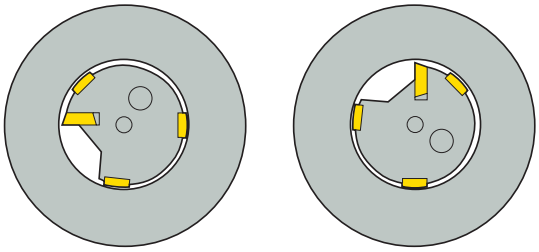
Rotierendes Werkzeug

Die empfohlene maximale Rundlaufabweichung beträgt: 0,02 mm *(0.0008")*.
Präzisionsaufnahmen werden empfohlen: Hydrodehnspannfutter, Präzisionsspannzange Typ 5672 oder Schrumpffutter.



Optimale Späneabfuhr

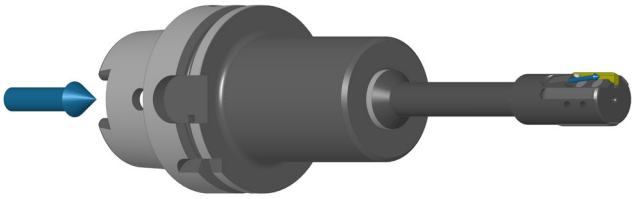
Die Schneidenausrichtung für den statischen Einsatz wird gemäß der Zeichnung empfohlen (Vorderansicht Werkzeuge).



Kühlschmierstoffzufuhr

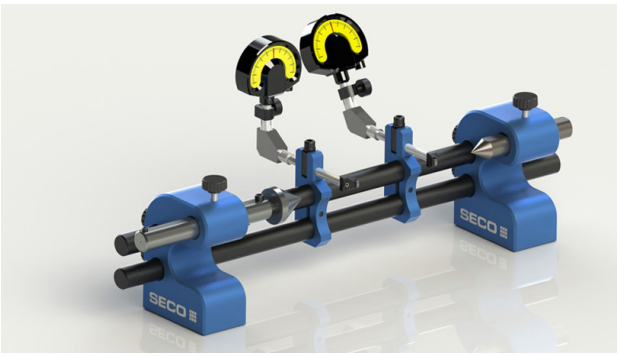
Zur Erreichung maximaler Standzeit und Bohrungsqualität sind die nachfolgenden Kühlschmierstoffanforderungen zu beachten.
Für das Werkzeug wird interne Kühlschmierstoffzufuhr empfohlen. Bei einer Reibtiefe < 2 x D kann externe Kühlschmierstoffzufuhr erfolgen. Wir empfehlen hierfür eine Qualitäts-Emulsion mit mindestens 40% reinem Mineralöl. Für Rostfrei empfehlen wir reines Öl.
Filtrierung 30-50 µm *(1200-2000 µin)*.
Volumen min. 0,5 l/min/mm *(3.35 gal/min/Zoll)* für Werkzeugdurchmesser
Beispiel: Reibahle Durchmesser 10, Mindestvolumen beträgt 5 l/min *(1.3 gal/min)*.

Empfohlener Kühlschmiermitteldruck: min. 8-10 bar, max. 30 bar



Einstellgerät und Zubehör

SF-60200-C160C190: Produktnummer 02885396
- Horizontales Gestell
- Erste Wahl für Durchmesser kleiner als 60 mm *(2,362 Zoll)*
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 60,5 mm *(2,382 Zoll)*
- Maximale Werkzeuglänge: 200 mm *(7.784")*



Auswahl der Geometrie – Schneiden

Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.

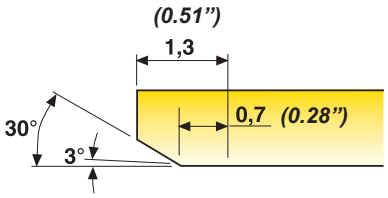
Schneidstoffe und Spanwinkel
Den zu bearbeitenden Werkstoff anhand der Seco Werkstoff-Gruppen auf Seite(n) 662-668 klassifizieren.

Die Schnittdatenempfehlungen entnehmen Sie den Tabellen auf Seite 408-416, um Schneidstoffe und Spanwinkel zu wählen.

Das Wendeschneidplatten-Programm finden Sie auf Seite(n) 406, 407.

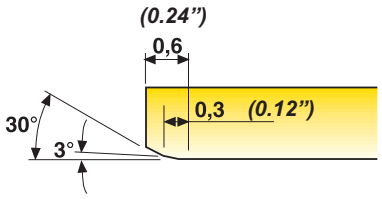
EN1 – Allgemein

Maximales Aufmaß Durchmesser 0,5 mm *(0.020")*
Gute Oberflächengüte R_a 0,3 - 0,8 µm
(Gute Oberflächengüte R_a 12 - 31 µin)



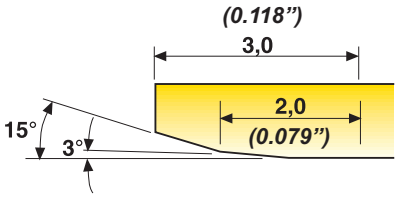
EN2 – Kurzer Anschnitt

Maximales Aufmaß Durchmesser 0,3 mm *(0.012")*
Gute Oberflächengüte R_a 0,4 - 1,2 µm
(Gute Oberflächengüte R_a 16 - 47 µin)
Maximaler Vorschub 0,2 mm/U *(0.008 Zoll/U)*
Für kurzen Anschnitt
Mit Hinterschnitt



EN3 – Höchste Oberflächengüte

Maximales Aufmaß Durchmesser 0,5 mm *(0.020")*
Gute Oberflächengüte R_a 0,2 - 0,6 µm
(Gute Oberflächengüte R_a 8 - 24 µin)
Geeignet für alle Werkstoffe außer Aluminium.
Zu verwenden für R_a < 0,3–0,4 µm *(12-16 µin)*



Optimierung / Sorten

Alternative Wendeplatten entweder für höhere Produktivität oder größere Sicherheit.

Auswahl an Grundhaltern

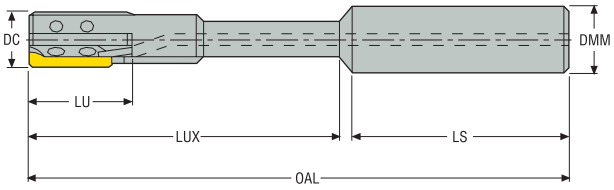
Schneidengröße	Stahl	Rostfrei	Guss	NE-Metalle	Aluminium	Verschleißfestigkeit ⟷ Zähigkeit			Bezeichnung	
						Produktivität	Vielseitigkeit	Sicherheit	Schneide	Sorte
P0, P1, P2, P4										
			•	•				X	Pxx-ENx-00	H15
	•		•		•			X	Pxx-ENx-06	H15
		•		•	•			X	Pxx-ENx-12	H15
	•					X			Pxx-ENx-00	CP20
	•		•				X		Pxx-ENx-06	CP20
	•	•					X		Pxx-ENx-12	CP20
	•		•			X			Pxx-ENx-00	CP15
	•		•			X			Pxx-ENx-06	CP15
	•	•		•	•	X			Pxx-ENx-12	CP15

Sorten

	CP15	**Beschichtet** Verschleißfeste beschichtete Sorte. Alternative zu CP20. Für die Optimierung in Guss und Stahl. Auch für Superlegierungen geeignet. Ti(C, N)
	CP20	**Beschichtet** Eine vielseitige beschichtete Sorte, die für die meisten Werkstoffe außer Aluminium geeignet ist. TiN
	H15	**Unbeschichtet** Zähe Sorte mit scharfer Schneidkante für alle Werkstoffe. Dank der hervorragenden Kantenstabilität zum Feinreiben geeignet.

Für Durchgangsbohrungen ∅ 7H6-26H6

Schafttyp R1, Zylindrisch ohne Fase, SR80



—Schneideninformationen auf Seite(n) 406, 407
—Innenkühlung
—Schnittdaten siehe Seite(n) 408-416

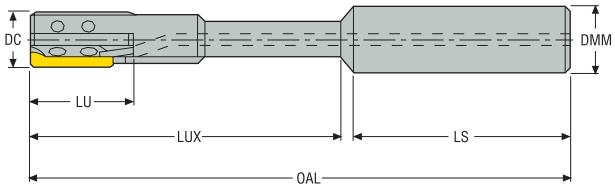
Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR80-7H6-EN1	7	105	40	63	25	10	P0-EN1-xx
SR80-8H6-EN1	8	115	40	73	25	10	P0-EN1-xx
SR80-9H6-EN1	9	115	40	73	25	10	P1-EN1-xx
SR80-10H6-EN1	10	115	40	74	25	10	P1-EN1-xx
SR80-11H6-EN1	11	133	48	81	25	16	P1-EN1-xx
SR80-12H6-EN1	12	133	48	81	25	16	P1-EN1-xx
SR80-13H6-EN1	13	133	48	81	25	16	P2-EN1-xx
SR80-14H6-EN1	14	133	48	81	25	16	P2-EN1-xx
SR80-15H6-EN1	15	133	48	82	25	16	P2-EN1-xx
SR80-16H6-EN1	16	133	48	82	25	16	P2-EN1-xx
SR80-17H6-EN1	17	155	50	100	25	20	P2-EN1-xx
SR80-18H6-EN1	18	155	50	100	25	20	P2-EN1-xx
SR80-19H6-EN1	19	155	50	100	25	20	P2-EN1-xx
SR80-20H6-EN1	20	155	50	100	30	20	P4-EN1-xx
SR80-21H6-EN1	21	191	56	128	30	25	P4-EN1-xx
SR80-22H6-EN1	22	191	56	129	30	25	P4-EN1-xx
SR80-23H6-EN1	23	191	56	129	30	25	P4-EN1-xx
SR80-24H6-EN1	24	191	56	129	30	25	P4-EN1-xx
SR80-25H6-EN1	25	191	56	129	30	25	P4-EN1-xx
SR80-26H6-EN1	26	191	56	129	30	25	P4-EN1-xx

Ersatzteile, im Lieferumfang enthalten

Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstellschlüssel	Auflagekugel	Drehmomentschlüssel	Drehmoment
7-8	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–	–
9	SH2025	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
10-12	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
13-19	SH2540	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509	0,9 Nm
20-60	SH3060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Für Durchgangsbohrungen ∅ 27H6–60H6

Schafttyp R1, Zylindrisch ohne Fase, SR80



–Schneideninformationen auf Seite(n) 406, 407
–Innenkühlung
–Schnittdaten siehe Seite(n) 408–416

Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR80-27H6-EN1	27	221	56	159	30	25	P4-EN1-xx
SR80-28H6-EN1	28	221	56	159	30	25	P4-EN1-xx
SR80-29H6-EN1	29	221	56	159	30	25	P4-EN1-xx
SR80-30H6-EN1	30	221	56	159	30	25	P4-EN1-xx
SR80-31H6-EN1	31	221	56	160	30	25	P4-EN1-xx
SR80-32H6-EN1	32	221	56	160	30	25	P4-EN1-xx
SR80-34H6-EN1	34	226	56	165	30	25	P4-EN1-xx
SR80-35H6-EN1	35	226	56	165	30	25	P4-EN1-xx
SR80-36H6-EN1	36	226	56	166	30	25	P4-EN1-xx
SR80-38H6-EN1	38	226	56	166	30	25	P4-EN1-xx
SR80-40H6-EN1	40	226	56	166	30	25	P4-EN1-xx
SR80-42H6-EN1	42	226	56	167	30	25	P4-EN1-xx
SR80-44H6-EN1	44	226	56	167	30	25	P4-EN1-xx
SR80-48H6-EN1	48	226	56	168	30	25	P4-EN1-xx
SR80-50H6-EN1	50	226	56	168	30	25	P4-EN1-xx
SR80-52H6-EN1	52	226	56	169	30	25	P4-EN1-xx
SR80-54H6-EN1	54	226	56	169	30	25	P4-EN1-xx
SR80-58H6-EN1	58	226	56	169	30	25	P4-EN1-xx
SR80-60H6-EN1	60	226	56	169	30	25	P4-EN1-xx

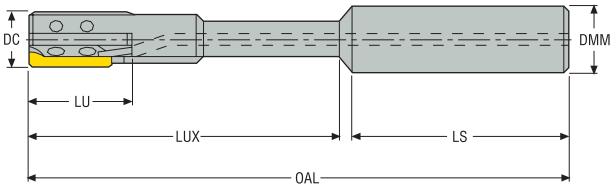
Ersatzteile, im Lieferumfang enthalten

Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstellschlüssel	Auflagekugel	Drehmomentschlüssel	Drehmoment
20-60	4060	SR-B5	LH4010	2SMS795	BB3.0	–	2,0 Nm

Der Drehmomentschlüssel wird mit Antriebsschneide geliefert

Für Durchgangsbohrungen – Zwischendurchmesser

Schafttyp R1, Zylindrisch ohne Fase, SR80



—Schneideninformationen auf Seite(n) 406, 407
—Wichtig: Reibahle und Schneide müssen die gleiche Anschnittgeometrie haben
—Zur Wahl der Anschnittgeometrie EN1, EN2 oder EN3 siehe Seite(n) 397
—Schnittdaten siehe Seite(n) 408–416

Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR80-6.875-XX-XXXX-EN	6,875 - 7,874	105,0	40,0	63,0	15,0	10,0	P0-EN-xx
SR80-7.875-XX-XXXX-EN	7,875 - 8,749	115,0	40,0	73,0	25,0	10,0	P0-EN-xx
SR80-8.750-XX-XXXX-EN	8,75 - 9,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR80-9.750-XX-XXXX-EN	9,75 - 10,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR80-10.750-XX-XXXX-EN	10,75 - 12,749	133,0	48,0	81,0	25,0	16,0	P1-EN-xx
SR80-12.750-XX-XXXX-EN	12,75 - 16,749	133,0	48,0	81,0	25,0	16,0	P2-EN-xx
SR80-16.750-XX-XXXX-EN	16,75 - 19,499	155,0	50,0	100,0	25,0	20,0	P2-EN-xx
SR80-19.500-XX-XXXX-EN	19,5 - 20,499	155,0	50,0	100,0	30,0	20,0	P4-EN-xx
SR80-20.500-XX-XXXX-EN	20,5 - 26,499	191,0	56,0	129,0	30,0	25,0	P4-EN-xx
SR80-26.500-XX-XXXX-EN	26,5 - 32,499	221,0	56,0	160,0	30,0	25,0	P4-EN-xx
SR80-32.500-XX-XXXX-EN	32,5 - 38,499	226,0	56,0	165,0	30,0	25,0	P4-EN-xx
SR80-38.500-XX-XXXX-EN	38,5 - 40,499	226,0	56,0	166,0	30,0	25,0	P4-EN-xx
SR80-40.500-XX-XXXX-EN	40,5 - 44,499	226,0	56,0	167,0	30,0	25,0	P4-EN-xx
SR80-44.500-XX-XXXX-EN	44,5 - 50,499	226,0	56,0	168,0	30,0	25,0	P4-EN-xx
SR80-50.500-XX-XXXX-EN	50,5 - 60,5	226,0	56,0	169,0	30,0	25,0	P4-EN-xx

Ersatzteile, im Lieferumfang enthalten

Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstell-schlüssel	Stützkugel
6,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5
8,750-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0
9,750-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0
12,750-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.0
19,500-60,500	SH4060	SR-B5	LH4010	2SMS795	BB3.0

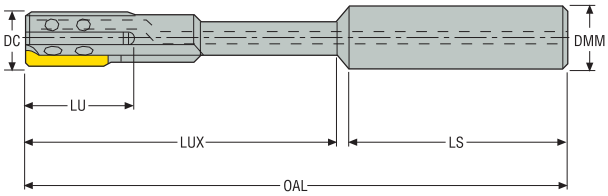
Zubehör

Drehmoment-schlüssel
–
H00-1305
H00-1305
H00-1509
H00-2020

Hinweis! Bei der Bestellung von Reibahlen mit Zwischendurchmesser bitte Folgendes angeben: ∅ und Toleranz der zu reibenden Bohrung, Anschnittgeometrie (EN1, EN2 oder EN3).
Bestell-Beispiel: SR80-11.50 H7-EN2, P1-EN2-06, CP20.

Für Grundlochbohrungen ∅ 8H6-26H6

Schafttyp R1, Zylindrisch ohne Fase, SR81



–Schneideninformationen auf Seite(n) 406, 407
–Innenkühlung
–Schnittdaten siehe Seite(n) 408-416

Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR81-8H6-EN1	8	115	40	73	25	10	P0-EN1-xx
SR81-9H6-EN1	9	115	40	73	25	10	P1-EN1-xx
SR81-11H6-EN1	11	133	48	81	25	16	P1-EN1-xx
SR81-13H6-EN1	13	133	48	81	25	16	P2-EN1-xx
SR81-14H6-EN1	14	133	48	81	25	16	P2-EN1-xx
SR81-15H6-EN1	15	133	48	82	25	16	P2-EN1-xx
SR81-16H6-EN1	16	133	48	82	25	16	P2-EN1-xx
SR81-17H6-EN1	17	155	50	100	25	20	P2-EN1-xx
SR81-18H6-EN1	18	155	50	100	25	20	P2-EN1-xx
SR81-19H6-EN1	19	155	50	100	25	20	P2-EN1-xx
SR81-20H6-EN1	20	155	50	100	30	20	P4-EN1-xx
SR81-21H6-EN1	21	191	56	128	30	25	P4-EN1-xx
SR81-22H6-EN1	22	191	56	129	30	25	P4-EN1-xx
SR81-23H6-EN1	23	191	56	129	30	25	P4-EN1-xx
SR81-25H6-EN1	25	191	56	129	30	25	P4-EN1-xx
SR81-26H6-EN1	26	191	56	129	30	25	P4-EN1-xx

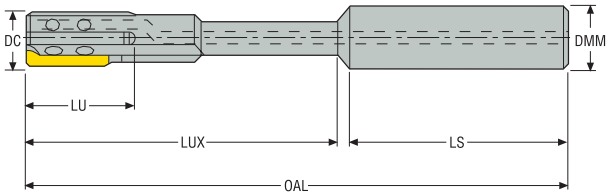
Ersatzteile, im Lieferumfang enthalten

Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstellschlüssel	Auflagekugel	Drehmomentschlüssel	Drehmoment
8	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–	–
9	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
10-12	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
13-19	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509	0,9 Nm
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Der Drehmomentschlüssel wird mit Antriebsschneide geliefert

Für Grundlochbohrungen ∅ 27H6–60H6

Schafttyp R1, Zylindrisch ohne Fase, SR81



—Schneideninformationen auf Seite(n) 406, 407
—Innenkühlung
—Schnittdaten siehe Seite(n) 408–416

Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR81-27H6-EN1	27	221	56	159	30	25	P4-EN1-xx
SR81-28H6-EN1	28	221	56	159	30	25	P4-EN1-xx
SR81-29H6-EN1	29	221	56	159	30	25	P4-EN1-xx
SR81-30H6-EN1	30	221	56	159	30	25	P4-EN1-xx
SR81-31H6-EN1	31	221	56	160	30	25	P4-EN1-xx
SR81-32H6-EN1	32	221	56	160	30	25	P4-EN1-xx
SR81-34H6-EN1	34	226	56	165	30	25	P4-EN1-xx
SR81-35H6-EN1	35	226	56	165	30	25	P4-EN1-xx
SR81-36H6-EN1	36	226	56	166	30	25	P4-EN1-xx
SR81-38H6-EN1	38	226	56	166	30	25	P4-EN1-xx
SR81-40H6-EN1	40	226	56	166	30	25	P4-EN1-xx
SR81-42H6-EN1	42	226	56	167	30	25	P4-EN1-xx
SR81-44H6-EN1	44	226	56	167	30	25	P4-EN1-xx
SR81-48H6-EN1	48	226	56	168	30	25	P4-EN1-xx
SR81-50H6-EN1	50	226	56	168	30	25	P4-EN1-xx
SR81-52H6-EN1	52	226	56	169	30	25	P4-EN1-xx
SR81-54H6-EN1	54	226	56	169	30	25	P4-EN1-xx
SR81-58H6-EN1	58	226	56	169	30	25	P4-EN1-xx
SR81-60H6-EN1	60	226	56	169	30	25	P4-EN1-xx

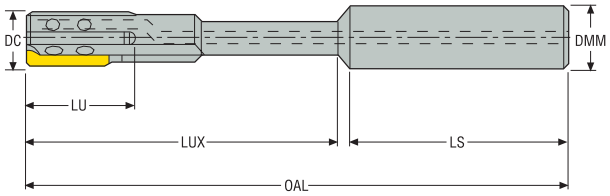
Ersatzteile, im Lieferumfang enthalten

Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstellschlüssel	Auflagekugel	Drehmomentschlüssel	Drehmoment
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Der Drehmomentschlüssel wird mit Antriebsschneide geliefert

Für Grundlochbohrungen – Zwischendurchmesser

Schafttyp R1, Zylindrisch ohne Fase, SR81



–Schneideninformationen auf Seite(n) 406, 407
–Wichtig: Reibahle und Schneide müssen die gleiche Anschnittgeometrie haben
–Zur Wahl der Anschnittgeometrie EN1, EN2 oder EN3 siehe Seite(n) 397
–Schnittdaten siehe Seite(n) 408–416

Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR81-7.875-XX-XXXX-EN	7,875 - 8,749	115,0	40,0	73,0	25,0	10,0	P0-EN-xx
SR81-8.750-XX-XXXX-EN	8,75 - 9,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR81-9.750-XX-XXXX-EN	9,75 - 10,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR81-10.750-XX-XXXX-EN	10,75 - 12,749	133,0	48,0	81,0	25,0	16,0	P1-EN-xx
SR81-12.750-XX-XXXX-EN	12,75 - 16,749	133,0	48,0	81,0	25,0	16,0	P2-EN-xx
SR81-16.750-XX-XXXX-EN	16,75 - 19,499	155,0	50,0	100,0	25,0	20,0	P2-EN-xx
SR81-19.500-XX-XXXX-EN	19,5 - 20,499	155,0	50,0	100,0	30,0	20,0	P4-EN-xx
SR81-20.500-XX-XXXX-EN	20,5 - 26,499	191,0	56,0	129,0	30,0	25,0	P4-EN-xx
SR81-26.500-XX-XXXX-EN	26,5 - 32,499	221,0	56,0	160,0	30,0	25,0	P4-EN-xx
SR81-32.500-XX-XXXX-EN	32,5 - 38,499	226,0	56,0	165,0	30,0	25,0	P4-EN-xx
SR81-38.500-XX-XXXX-EN	38,5 - 40,499	226,0	56,0	166,0	30,0	25,0	P4-EN-xx
SR81-40.500-XX-XXXX-EN	40,5 - 44,499	226,0	56,0	167,0	30,0	25,0	P4-EN-xx
SR81-44.500-XX-XXXX-EN	44,5 - 50,499	226,0	56,0	168,0	30,0	25,0	P4-EN-xx
SR81-50.500-XX-XXXX-EN	50,5 - 60,5	226,0	56,0	169,0	30,0	25,0	P4-EN-xx

Ersatzteile, im Lieferumfang enthalten

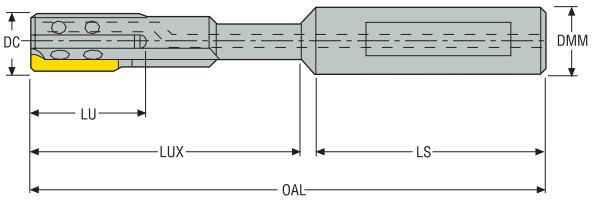
Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstell-schlüssel	Stützkugel
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0

Zubehör

Drehmoment-schlüssel
–
H00-1305
H00-1305
H00-1509
H00-2020

Für Grundlochbohrungen – Kurze Ausführung für Drehmaschinen

Schafttyp R9, Zylindrisch mit Fase, SR82



—Schneideninformationen auf Seite(n) 406, 407
—Wichtig: Reibahle und Schneide müssen die gleiche Anschnittgeometrie haben
—Zur Wahl der Anschnittgeometrie EN1, EN2 oder EN3 siehe Seite(n) 397
—Schnittdaten siehe Seite(n) 408-416

Bezeichnung	DC	OAL	LS	LUX	LU	DMM	WSP-Größe
	mm	mm	mm	mm	mm	mm	
SR82-7.875-XX-XXXX-EN	7,875 - 8,749	95,0	40,0	53,0	25,0	10,0	P0-EN-xx
SR82-8.750-XX-XXXX-EN	8,75 - 9,749	95,0	40,0	53,0	25,0	10,0	P1-EN-xx
SR82-9.750-XX-XXXX-EN	9,75 - 10,749	95,0	40,0	53,0	25,0	10,0	P1-EN-xx
SR82-10.750-XX-XXXX-EN	10,75 - 12,749	113,0	40,0	61,0	25,0	16,0	P1-EN-xx
SR82-12.750-XX-XXXX-EN	12,75 - 16,749	113,0	48,0	61,0	25,0	16,0	P2-EN-xx
SR82-16.750-XX-XXXX-EN	16,75 - 19,499	113,0	48,0	60,0	25,0	20,0	P2-EN-xx
SR82-19.500-XX-XXXX-EN	19,5 - 20,499	115,0	50,0	60,0	30,0	20,0	P4-EN-xx
SR82-20.500-XX-XXXX-EN	20,5 - 32,499	115,0	50,0	89,0	30,0	25,0	P4-EN-xx
SR82-32.500-XX-XXXX-EN	32,5 - 36,499	151,0	56,0	105,0	30,0	25,0	P4-EN-xx
SR82-36.500-XX-XXXX-EN	36,5 - 40,499	166,0	56,0	106,0	30,0	25,0	P4-EN-xx
SR82-40.500-XX-XXXX-EN	40,5 - 44,499	166,0	56,0	107,0	30,0	25,0	P4-EN-xx
SR82-44.500-XX-XXXX-EN	44,5 - 50,499	166,0	56,0	108,0	30,0	25,0	P4-EN-xx
SR82-50.500-XX-XXXX-EN	50,5 - 60,5	166,0	56,0	109,0	30,0	25,0	P4-EN-xx

Ersatzteile, im Lieferumfang enthalten

Für Durchmesser (mm)	Einstellschraube	Pratze	Spannschraube	Einstell-schlüssel	Stützkugel
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0

Zubehör

Drehmoment-schlüssel
–
H00-1305
H00-1305
H00-1509
H00-2020

P0-P4 Schneiden

Bezeichnung	Wendeschneidplatte	L	S	W1	Beschichtung	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	H15	CP20
P0-EN1-0	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098229	00098244
P0-EN1-06	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00091786	00091762
P0-EN1-12	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00097299	00091971
P0-EN2-0	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098234	00098249
P0-EN2-06	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098160	00098170
P0-EN2-12	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098165	00098175
P0-EN3-0	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098239	00098254
P0-EN3-06	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098185	00098195
P0-EN3-12	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098190	00098200
P1-EN1-0	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098230	00098245
P1-EN1-06	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00091787	00091764
P1-EN1-12	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00097300	00091972
P1-EN2-0	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098235	00098250
P1-EN2-06	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098161	00098171
P1-EN2-12	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098166	00098176
P1-EN3-0	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098240	00098255
P1-EN3-06	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098186	00094702
P1-EN3-12	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098191	00098201
P2-EN1-0	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098231	00098246
P2-EN1-06	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00091788	00091765
P2-EN1-12	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00097301	00091973
P2-EN2-0	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098236	00098251
P2-EN2-06	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098162	00098172
P2-EN2-12	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098167	00098177
P2-EN3-0	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098241	00098256
P2-EN3-06	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098187	00098197
P2-EN3-12	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098192	00098202
P4-EN1-0	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098232	00098247
P4-EN1-06	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00091789	00091766
P4-EN1-12	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098128	00091974

Bezeichnung	Wendeschneidplatte	L	S	W1	Beschichtung	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	H15	CP20
P4-EN2-0	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098237	00098252
P4-EN2-06	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098163	00098173
P4-EN2-12	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098168	00098178
P4-EN3-0	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098242	00098257
P4-EN3-06	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098188	00098198
P4-EN3-12	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098193	00098203

Schnittdaten – Pxx-EN1/EN2-00 Metrisch

SMG		a_p (∅)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	–
P6	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	–
P7	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	–
K1	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K2	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	35 (25-50)	50 (25-70)
K3	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K4	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K5	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K6	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K7	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
PM1	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	–
PM2	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	–
PM3	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	–

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN1/EN2-00 *Zoll*

SMG		a_p (∅)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	*Pxx-EN1/EN2-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P6	*Pxx-EN1/EN2-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P7	*Pxx-EN1/EN2-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
K1	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K2	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*115 (80-165)*	*165 (80-230)*
K3	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K4	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K5	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K6	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K7	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
PM1	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM2	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM3	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN1/EN2-06 Metrisch

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M4	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
M5	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
K1	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K2	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	35 (25-50)	50 (25-70)
K3	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K4	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K5	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K6	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K7	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
N11	Pxx-EN1/EN2-06	0,10-0,30	0,20-0,50	0,10-0,30	65 (50-150)	90 (70-150)	-
S1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
S2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
S3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
PM1	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c = m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN1/EN2-06 *Zoll*

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P3	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P4	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P5	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P6	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P7	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P8	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P11	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P12	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	*150 (100-180)*
M1	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M2	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M3	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M4	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
M5	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
K1	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	*395 (260-490)*
K2	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*115 (80-165)*	*165 (80-230)*
K3	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	*395 (260-490)*
K4	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	*295 (260-330)*
K5	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	*295 (260-330)*
K6	*Pxx-EN1/EN2-06*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-150)*	*295 (230-490)*	–
K7	*Pxx-EN1/EN2-06*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-150)*	*295 (230-490)*	–
N11	*Pxx-EN1/EN2-06*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-150)*	*295 (230-490)*	–
S1	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S2	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S3	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
PM1	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM2	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM3	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN1/EN2-12 Metrisch

SMG		a_p (∅)		f	v_c		
		– Ø < 9	– Ø ≥ 9		– H15	– CP20	– CP15
P1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M4	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
M5	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
K1	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	90 (80-100)	–
K3	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	90 (80-100)	–
K4	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	70 (60-80)	–
K5	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	70 (60-80)	–
N11	Pxx-EN1/EN2-12	0,10-0,30	0,20-0,50	0,10-0,30	65 (50-150)	90 (70-150)	–
S1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
S2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
S3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
PM1	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–
PM2	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–
PM3	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–

SMG = Seco Werkstoff-Gruppe. a_p = mm. f = mm/U. v_c= m/min. Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN1/EN2-12 *Zoll*

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P3	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P4	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P5	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P6	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P7	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P8	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P11	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P12	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	*150 (100-180)*
M1	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M2	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M3	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M4	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
M5	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
K1	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K3	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K4	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
K5	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
N11	*Pxx-EN1/EN2-12*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-490)*	*295 (230-490)*	–
S1	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S2	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S3	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
PM1	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM2	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM3	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–

SMG = Seco Werkstoff-Gruppe. a_p = *Zoll*. f = in/U. v_c= sf/min. Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN3-00 Metrisch

SMG		a_p (∅)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P6	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P7	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
K1	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K2	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	35 (25-50)	50 (25-70)
K3	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K4	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K5	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K6	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K7	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
PM1	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM2	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM3	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN3-00 *Zoll*

SMG		a_p (∅)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	*Pxx-EN3-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P6	*Pxx-EN3-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P7	*Pxx-EN3-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
K1	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K2	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*115 (80-165)*	*165 (80-230)*
K3	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K4	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K5	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K6	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K7	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
PM1	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM2	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM3	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN3-06 Metrisch

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M2	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M3	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M4	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	30 (25-40)
M5	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	30 (25-40)
K1	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K2	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	35 (25-50)	50 (25-70)
K3	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K4	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K5	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K6	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K7	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
PM1	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c = m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-E3-06 *Zoll*

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	**395 (295-490)**
P3	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	**395 (295-490)**
P4	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P5	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P6	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P7	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P8	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	**195 (130-230)**
P11	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	**195 (130-230)**
P12	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	**150 (100-180)**
M1	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**115 (80-130)**
M2	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**115 (80-130)**
M3	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**115 (80-130)**
M4	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**100 (80-130)**
M5	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**100 (80-130)**
K1	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
K2	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*115 (80-165)*	**165 (80-230)**
K3	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
K4	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	**295 (260-330)**
K5	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	**295 (260-330)**
K6	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
K7	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
PM1	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	**–**
PM2	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	**–**
PM3	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	**–**

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN3-12 Metrisch

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
K1	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	-
K3	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	-
K4	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	-
K5	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	-
PM1	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

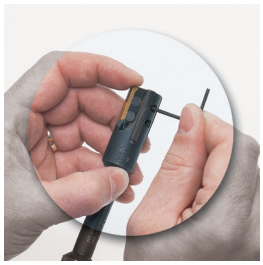
SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – Pxx-EN3-12 *Zoll*

SMG		a_p (∅)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P3	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P4	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P5	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P6	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P7	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P8	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P11	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P12	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	*150 (100-180)*
K1	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K3	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K4	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
K5	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
PM1	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM2	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM3	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–

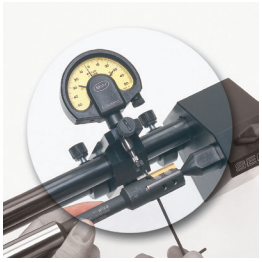
SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Einstellhinweise

1.		Die beiden Einstellschrauben (7) mit einer 1/4 Drehung gegen den Uhrzeigersinn lösen.
2.		Die zwei Klemmschrauben (5) lösen.
3.		Reinigen Sie Plattensitz und Wendeschneidplatte gründlich. Wenden Sie die Platte (2) oder setzen Sie eine neue ein.
4.		Drücken Sie die Wendeschneidplatte fest gegen den Axialanschlag und die Anlagekugeln (6).
5.		Klemmschrauben sorgfältig festziehen. Klemmschraube fest spannen, dabei den Schlüssel am kurzen Ende halten.
6.		Stellen Sie die Messuhr auf der unteren Führungsleiste auf Null (3).

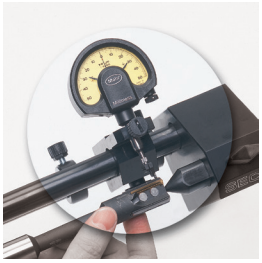
Einstellhinweise

7.



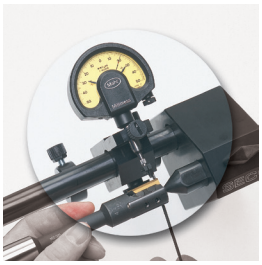
Die Wendeschneidplatte so einstellen, dass eine Verjüngung von 0,01 mm/10 mm *(0.0004"/0.394")* Schneidenlänge erreicht wird (Abb. 2, Messuhr B).

8.



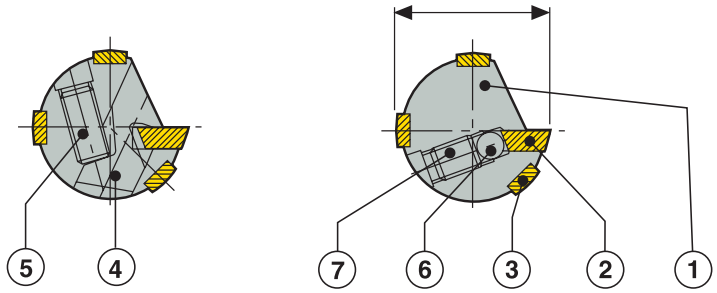
Nullen Sie die Führungsleiste mit der Messuhr ab (3).

9.



Schneidkante mit Uhr A auf 0,02 mm oder 0,015 mm *(0.0008" oder 0.0006")* Überstand zur Führungsleiste einstellen (3) Uhr A, siehe Abb. 1.
Verjüngung prüfen (Schritt 6 und 7), Uhr B.

10.



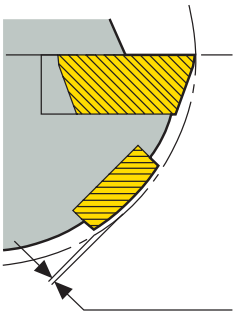


Abb. 1

0,015 mm (∅ ≤ 10 mm)
0,020 mm (∅ >10 mm)
Uhr A zur Durchmessereinstellung

0,0006" (∅ ≤ 0.394")
0,0008" (∅ > 0.394")
Uhr A zur Durchmessereinstellung

Hinweis: Wenn die geforderten Durchmesser während der Einstellung überschritten werden, noch einmal von neuem beginnen, um das Spiel der Einstellschrauben zu eliminieren.

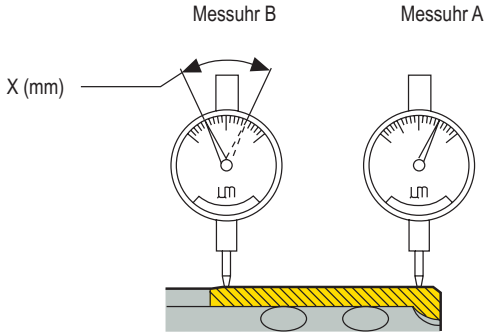


Abb. 2

Einstelltabelle

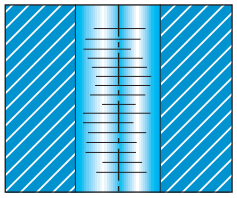
Durchmesserbereich (mm) *(Zoll)*	WSP-Größe	Vordere Messuhr A	Hintere Messuhr B
6,875-8,749 *(0.271-0.344")*	P0	+15	-5
8,750-10,000 *(0.344-0.394")*	P1	+15	-5
10,001-12,749 *(0.394-0.502")*	P1	+20	0
12,750-19,499 *(0.502-0.768")*	P2	+20	0
19,500-60,500 *(0.768-2.382")*	P4	+20	0

- Uhr Einheit = 1 µm *(39 µin)*
- Gültige Einstellmaße der Ebenen A & B bei Abnullen der vorderen und hinteren Messuhr auf der Leiste.
- Einstellmaße der Ebene B berechnet mit einer Verjüngung von 1 µm/mm *(0.00004")*.

Fehlerbehebung

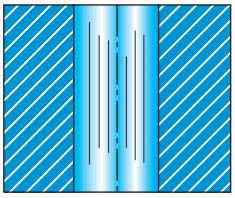
Mangelhafte Oberflächengüte

- Aufmaß prüfen
- Kühlung verbessern (Anschluss, Druck, Qualität)
- Vorschub reduzieren
- Eine andere Anschnittgeometrie wählen (Wendeschneidplatte/Reibahle)
- Axiale Lage der Wendeschneidplatte prüfen



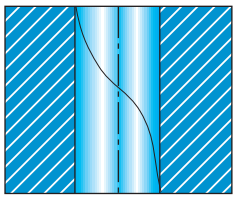
Rattermarken

- Konzentrizität prüfen (Werkstück/Werkzeug)
- Verjüngung vergrößern



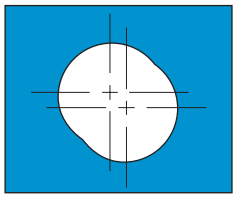
Rückzugsriefen

- Verbessern Sie die Kühlung (Anschluss, Druck, Qualität).
- Prüfen Sie die Konzentrizität (Werkstück/Werkzeug).
- Vergrößern Sie die Verjüngung.



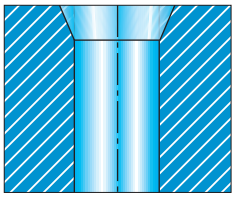
Exzentrische Bohrung

- Werkstückklemmung prüfen
- Aufmaß prüfen
- Konzentrizität prüfen (Werkstück/Werkzeug)
- Axiale Lage der Wendeschneidplatte prüfen



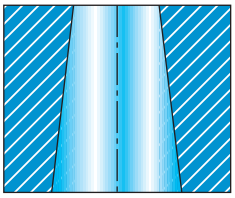
Konischer Eintritt

- Vorschub reduzieren
- Konzentrizität prüfen (Werkstück/Werkzeug)
- Verjüngung prüfen
- Rundlauf des Werkzeugs prüfen



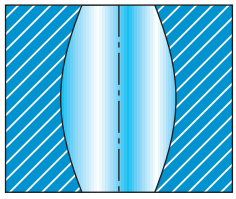
Konische Bohrung

- Konzentrizität prüfen (Werkstück/Werkzeug)
- Verjüngung prüfen



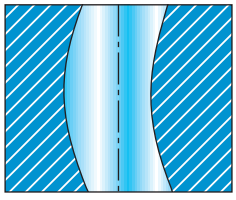
Deformierte Bohrung

- Einspannung verbessern (Verformung des Werkstücks)



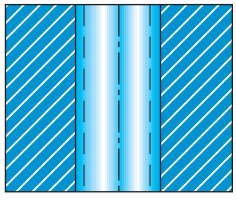
Verlaufende Bohrung

- Eine andere Anschnittgeometrie wählen (Wendeschneidplatte/Reibahle)
- Axiale Lage der Wendeschneidplatte prüfen



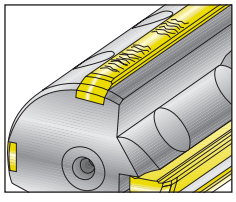
Durchmesser zu groß

- Konzentrizität prüfen (Werkstück/Werkzeug)
- Durchmesser prüfen



Aufbau auf Führungsleiste

- Kühlung verbessern (Anschluss, Druck, Qualität)
- Reibahle neu einstellen



Xfix™

Die mehrschneidigen Reibahlen Xfix™ für große Durchmesser bieten eine hohe Leistung und hohe Präzision für die Bohrungsbearbeitung.

- Bohrungstiefen bis zu 6,5 x D in einem Durchmesserbereich von 39.5 bis 154.5 mm (2.03”- 6.083”)
- Schnell und leicht einzustellen mit einer Schraube pro Schneide für den Durchmesser und einer Schraube für jede Schneide.
- Präzises Einstellsystem für enge Toleranzen zwischen 16 und 25 µm (.0006 - .0010”).
- Die Wendeschneidplatten sind entweder 4- oder 8-schneidig

Programmübersicht

	Durchmesser-bereich	Reibtiefe	Bohrungsdurchmesser-toleranz	Zwischendurchmesser	Oberflächengüte
Xfix™	39,500-154,500 mm *(1.5551-6.0827")*	2,5-6,5 x D	IT 6	Ja, auf Anfrage erhältlich	R_a 0,8-1,2 µm *(R_a 31-47 µin)*

Xfix™ ist ein speziell entwickeltes Seco-Reibprogramm für große Durchmesser von 39,5–154,5 mm *(1,555–6,083 Zoll)*.
Die Konstruktion umfasst einstellbare Wendeschneidplatten, um eine genaue Toleranz von IT6 zu erreichen, sowie einen integrierten einstellbaren Rundlaufadapter, um Werkstückqualität sicherzustellen.
Die mehrzahnige Konstruktion und die patentierten vorgespannten Führungsleisten bieten maximale Stabilität und Produktivität für Reibarbeiten mit großem Durchmesser.

Merkmale – Details

<table>
<tr>
<td>

– 4 oder 8 wirtschaftliche Schneidkanten
– Stabiles Klemmsystem
– Einfache Einstellung mit nur einer Einstellschraube
– Verschiedene Sorten und Geometrien für unterschiedliche Anwendungen

– Patentierte vorgespannte Führungsleisten für hohe Anwendungssicherheit
– Kühlung auf die Führungsleisten für mehr Leistung und Sicherheit

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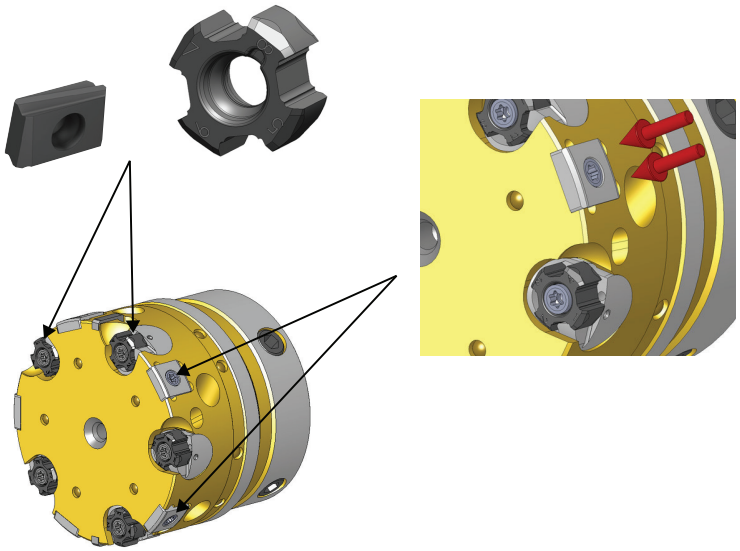

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– Perfekte Rundlaufkontrolle durch integrierten einstellbaren Adapter

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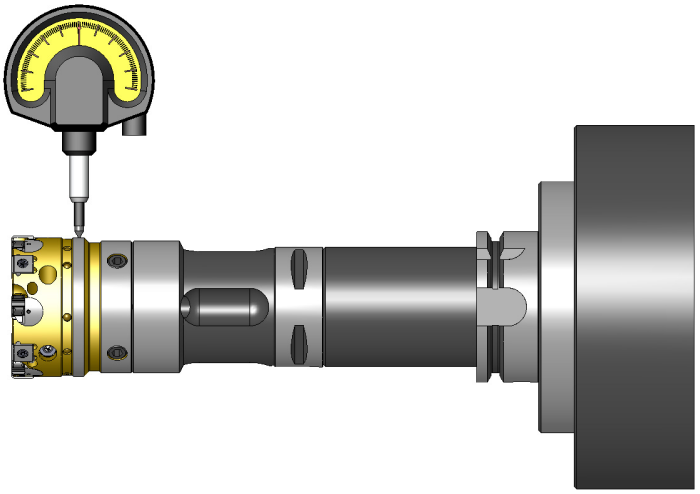

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– Umfangreiches Programm an Aufnahmen und Verlängerungen
– Weitere Informationen zum modularen System finden Sie im Katalog Werkzeug-Systeme

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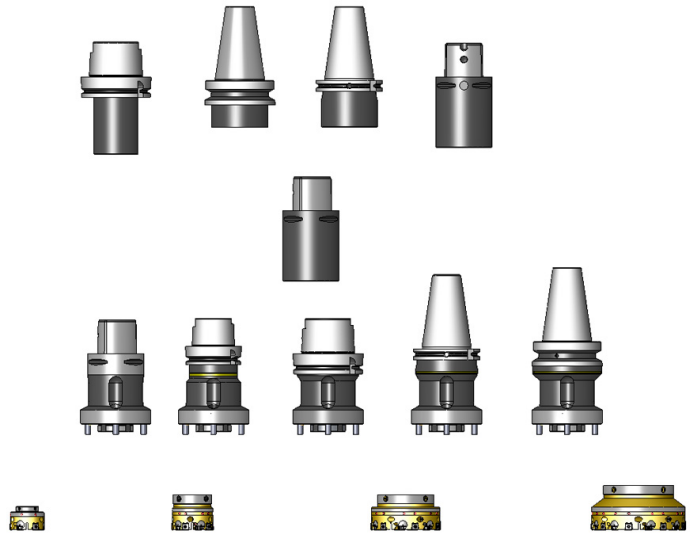

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Code-Schlüssel

Adapter

HF55	–	088	–	C5
1		2		3

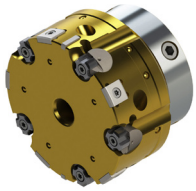
1. Flanschgröße

2. Länge

3. Schafttyp

Standardköpfe

HF85	–	60H6	–	05	–	55
1		2		3		4



1. Schneidkopftyp

2. Durchmesser und Toleranz

3. Zähnezahl

4. Flanschgröße D

Zwischenelemente Köpfe

HF85	–	65.2G7	–	05	–	55
1		2		3		4

1. Schneidkopftyp

2. Durchmesser und Toleranz

3. Zähnezahl

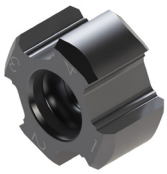
4. Flanschgröße D

Informationen zum Reibkopf:

- HF85, Durchgangsbohrung, kurz spanende Werkstoffe
- HF85B, Grundlochbohrung, kurz spanende Werkstoffe
- HF86, Durchgangsbohrung, alle Werkstoffe
- HF86B, Grundlochbohrung, alle Werkstoffe

Wendeschneidplatten

RNAX1005	–	EB45	–	03	–	RX2000
1		2		3		4



1. Wendeplattengröße

2. Anschnittgeometrie

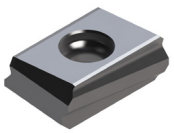
3. Spanwinkel

4. Sorte

RNAX-Wendeschneidplatten für HF85 und HF 85B Xfix-Köpfe

Wendeschneidplatten

LNEG	–	EB45	–	06	–	RX2000
1		2		3		4



1. Wendeplattengröße

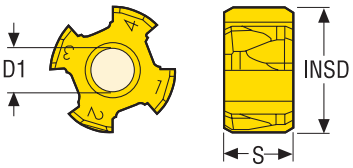
2. Anschnittgeometrie

3. Spanwinkel

4. Sorte

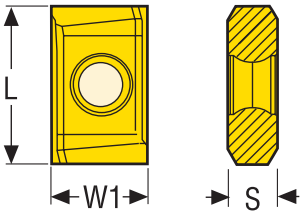
LNEG-Wendeschneidplatten für HF86 und HF86B Xfix-Köpfe

RNAX



Bezeichnung	Wendeschneidplatten	INSD	S	D1	Beschichtung		Spanwinkel
		mm *Zoll*	mm *Zoll*	mm *Zoll*	RX1500	RX2000	
RNAX1005-EB1570-03	RNAX	10,0 *0,394*	5,5 *0,217*	3,5 *0,138*	02687601	02687603	3 °
RNAX1005-EB45-03	RNAX	10,0 *0,394*	5,5 *0,217*	3,5 *0,138*	02687600	02688608	3 °
RNAX1005-EB845-03	RNAX	10,0 *0,394*	5,5 *0,217*	3,5 *0,138*	02687593	02688606	3 °

LNEG

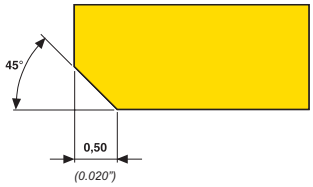


Bezeichnung	Wendeschneidplatten	L	S	W1	Beschichtung			Spanwinkel
		mm *Zoll*	mm *Zoll*	mm *Zoll*	RX1500	RX2000	CF	
LNEG1003-EB45-03	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*		02781311		3 °
LNEG1003-EB45-06	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*	02904277	02781313	02904276	6 °
LNEG1003-EB845-03	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*		02781314		3 °
LNEG1003-EB845-06	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*		02781315		6 °

Anschnittgeometrie

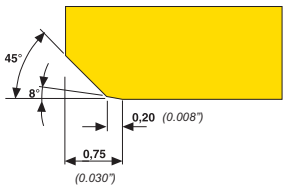
Anschnittgeometrie EB45 – Anwendung

Hervorragende Spankontrolle
Gute Oberflächengüte R_a 1,2–2 µm
(Gute Oberflächengüte R_a 0,047–0,0787 µin)
Geometrie der ersten Wahl



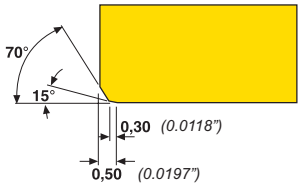
Anschnittgeometrie EB845 – Anwendung

Sehr gute Spankontrolle
Hervorragende Oberflächengüte R_a 0,4–1,2 µm
(Hervorragende Oberflächengüte R_a 0,0157–0.047 µin)



Anschnittgeometrie EB1570 – Anwendung

Sehr gute Spankontrolle
Sehr gute Oberflächengüte R_a 0,8–1,6 µm
(Sehr gute Oberflächengüte R_a 0,031–0,0630 µin)
Stabilität für große Auskragungen

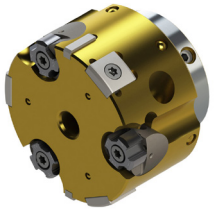


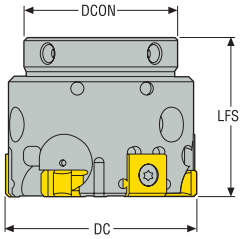
Sorten

	RX1500	**Beschichtetes Cermet** Verschleißfeste beschichtete Sorte zur Leistungsoptimierung bei Stahl und Guss.
	RX2000	**Beschichtet** Beschichtete Hochleistungssorte für alle Werkstoffe.
	CF	**Cermet** Hochverschleißfeste Sorte zur Optimierung bei Stahl.

HF85

Köpfe für RNAX Wendeplatten, Durchgangsbohrung ∅ 39,5–59,499 mm / 1.555-2.342”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
—Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	RNAX1005...
HF85-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	RNAX1005...
HF85-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	RNAX1005...
HF85-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85 03-32	SH4075S	CARTCYHF16	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

Zubehör

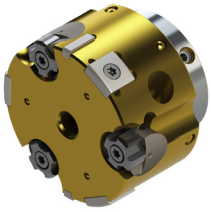
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85 03-32	H00-2020	T00-09P20

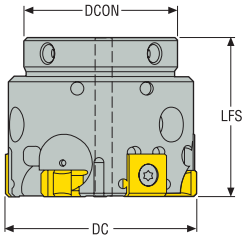
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Köpfe für RNAX Wendeplatten, Grundlochbohrung ∅ 39,5–59,499 mm / 1.555-2.342"





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
—Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85B-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	RNAX1005...
HF85B-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	RNAX1005...
HF85B-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	RNAX1005...
HF85B-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85B 03-32	SH4075S	CARTCYHF16B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

Zubehör

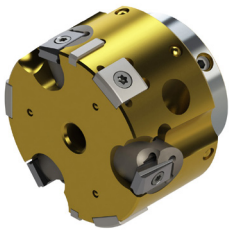
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85B 03-32	H00-2020	T00-09P20

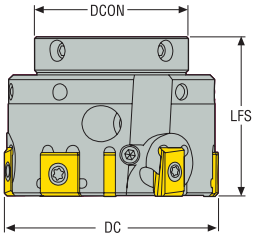
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Köpfe für LNEG Wendeplatten, Durchgangsbohrung ∅ 39,5–59,499 mm / 1.555–2.342"





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
—Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	LNEG1003...
HF86-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	LNEG1003...
HF86-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	LNEG1003...
HF86-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86 03-32	SH4075S	CARTCYLN16	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

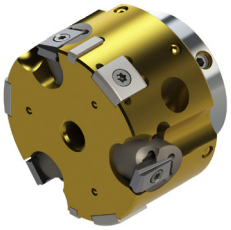
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86 03-32	H00-2020	T00-07P09

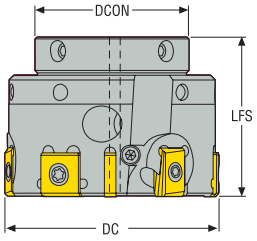
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Köpfe für LNEG Wendeplatten, Grundlochbohrung ∅ 39,5–59,499 mm / 1.555-2.342”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86B-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	LNEG1003...
HF86B-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	LNEG1003...
HF86B-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	LNEG1003...
HF86B-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86B 03-32	SH4075S	CARTCYLN16B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

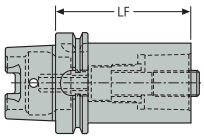
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86B 03-32	H00-2020	T00-07P09

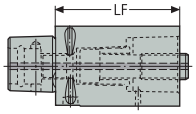
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

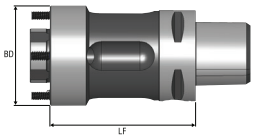
HF32

Seco Capto™ Schaft für ∅ 39,5–59,499 mm

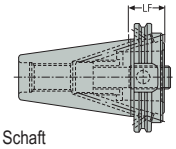




Verlängerung



Reibahlenhalter



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF32-050-C3	02688610	–	50	C3	32	0,3
HF32...HSKA63	–	65	245	HSK-A63	32	0,0
HF32...HSKA80	–	100	209	HSK-A80	32	0,0
HF32...HSKA100	–	70	245	HSK-A100	32	0,0
HF32...DIN40ADB	–	60	252	DIN40ADB	32	0,0
HF32...DIN50ADB	–	60	317	DIN50ADB	32	0,0
HF32...BT40ADB	–	65	252	BT40ADB	32	0,0
HF32...BT50ADB	–	75	317	BT50ADB	32	0,0

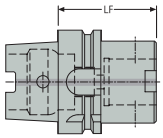
Schäfte und Verlängerungen für HF32-050-C3 (weitere Informationen siehe Seco Werkzeugsysteme).

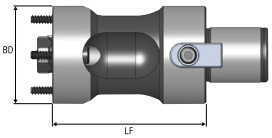
Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
HA10-C3-032-080	10197961	80	HSK-A100	C3	2,5
HA06-C4-040-080	10197964	80	HSK-A63	C4	1,1
C3-390B.140-40030	02924104	30	DIN40	C3	0,8
C3-390B.55-40030	02925959	30	BT40	C3	1,0
C3-390B.55-40060	02925960	60	BT40	C3	1,1
C3-390B.140-50030	02924106	30	DIN50	C3	2,6
C3-390B.140-50060	02924107	60	DIN50	C3	2,7
C3-390B.58-50040	02925961	40	BT50	C3	3,5
C3-390B.58-50070	02925962	70	BT50	C3	3,7

Bezeichnung Zug	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
C3-391.01-32060A	75039884	–	C3	C3	0,4
C3-391.01-32080A	00090847	–	C3	C3	0,5
C4-391.02-32055A	75039889	–	C4	C3	0,42
C4-391.02-32070A	02535687	–	C4	C3	0,56
C5-391.02-32060A	75039890	–	C5	C3	0,7
C6-391.02-32070A	75039892	–	C6	C3	1,1

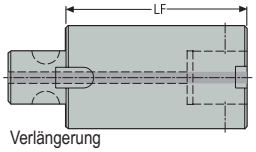
HF32

Graflex®-Schaft für ∅ 39,5–59,499 mm

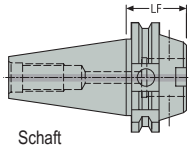




Reibahlenhalter



Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF32-050-G3	02698870	–	50	G3	32	0,4
HF32...HSKA63	–	65	245	HSK-A63	32	0,0
HF32...HSKA80	–	100	209	HSK-A80	32	0,0
HF32...HSKA100	–	70	245	HSK-A100	32	0,0
HF32...DIN40ADB	–	60	252	DIN40ADB	32	0,0
HF32...DIN50ADB	–	60	317	DIN50ADB	32	0,0
HF32...BT40ADB	–	65	252	BT40ADB	32	0,0
HF32...BT50ADB	–	75	317	BT50ADB	32	0,0

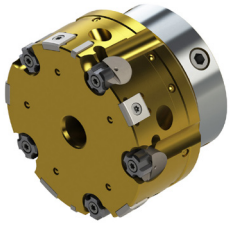
Schäfte und Verlängerungen für HF32-050-G3 (weitere Informationen siehe Seco Werkzeugsysteme).

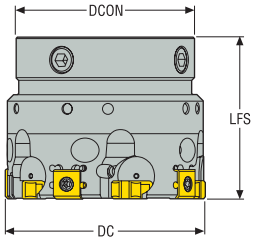
Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
EM93044011850	00086918	50	HSK-A63	G3	0,8
EM93064011855	00086925	55	HSK-A100	G3	2,2
EM34694011835	02420097	35	DIN40	G3	1,0
EM346940118100	02503298	100	DIN40	G3	1,3
EM34144011840	02503366	40	BT40	G3	1,07
EM341440118100	02503367	100	BT40	G3	1,31
EM34714011835	02503307	35	DIN50	G3	2,67
EM34164011845	02503376	45	BT50	G3	3,6
EM341640118120	02503377	120	BT50	G3	4,0

Bezeichnung Zug	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
M402330	00056758	–	G3	G3	0,3
M402331	75056759	–	G3	G3	0,4

HF85

Köpfe für RNAX Wendeplatten, Durchgangsbohrung ∅ 59,5–84,499 mm / 2.343–3.327”





–Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
–Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85-59.5/64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	RNAX1005...
HF85-64.5/69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	RNAX1005...
HF85-69.5/74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	RNAX1005...
HF85-74.5/79.499-05-55	74,5 *2.933*	79,499 *3.130*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	RNAX1005...
HF85-79.5/84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85 05-55	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

Zubehör

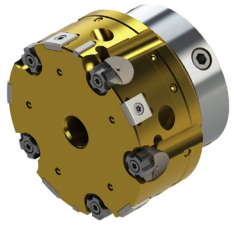
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85 05-55	H00-2020	T00-09P20

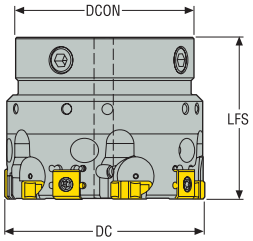
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Köpfe für RNAX Wendeplatten, Grundlochbohrung ∅ 59,5–84,499 mm / 2.343-3.327”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85B-59.5/64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	RNAX1005...
HF85B-64.5/69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	RNAX1005...
HF85B-69.5/74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	RNAX1005...
HF85B-74.5/79.499-05-55	74,5 *2.933*	79,499 *3.130*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	RNAX1005...
HF85B-79.5/84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85B 05-55	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

Zubehör

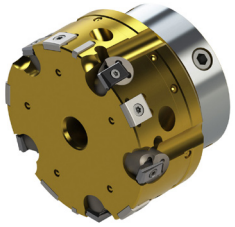
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85B 05-55	H00-2020	T00-09P20

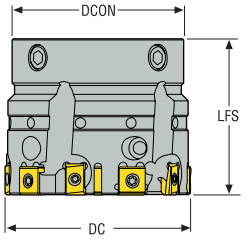
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Köpfe für LNEG Wendeplatten, Durchgangsbohrung ∅ 59,5–84,499 mm / 2.343-3.327”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86-59.5-64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	LNEG1003...
HF86-64.5-69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	LNEG1003...
HF86-69.5-74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	LNEG1003...
HF86-74.5-79.499-05-55	74,5 *2.933*	94,499 *3.720*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	LNEG1003...
HF86-79.5-84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86 05-55	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

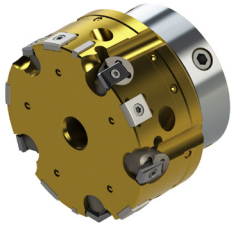
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86 05-55	H00-2020	T00-07P09

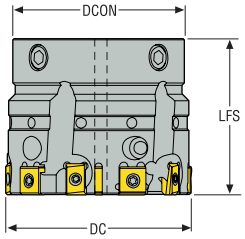
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Köpfe für LNEG Wendeplatten, Grundlochbohrung ∅ 59,5–84,499 mm / 2.343-3.327”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86B-59.5/64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	LNEG1003...
HF86B-64.5/69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	LNEG1003...
HF86B-69.5/74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	LNEG1003...
HF86B-74.5/79.499-05-55	74,5 *2.933*	79,499 *3.130*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	LNEG1003...
HF86B-79.5/84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86B 05-55	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

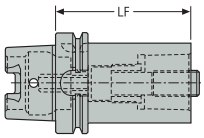
Für Kopf	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86B 05-55	H00-2020	T00-07P09

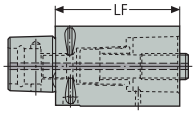
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

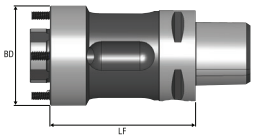
HF55

Seco Capto™ Schaft für ∅ 59,5–84,499 mm

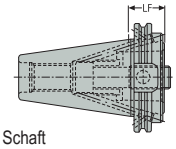




Verlängerung



Reibahlenhalter



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF55-080-C5	02688647	–	80	C5	55	1,3
HF55...HSKA63	–	80	239	HSK-A63	55	0,0
HF55...HSKA80	–	100	239	HSK-A80	55	0,0
HF55...HSKA100	–	100	239	HSK-A100	55	0,0
HF55...DIN40ADB	–	80	239	DIN40ADB	55	0,0
HF55...DIN50ADB	–	80	304	DIN50ADB	55	0,0
HF55...BT40ADB	–	80	239	BT40ADB	55	0,0
HF55...BT50ADB	–	80	304	BT50ADB	55	0,0

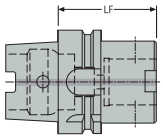
Schäfte und Verlängerungen für HF55-080-C5 (weitere Informationen siehe Seco Werkzeugsysteme).

Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
HA10-C4-040-090	10197963	90	HSK-A100	C4	2,5
HA06-C5-050-090	10197966	90	HSK-A63	C5	1,3
C5-390B.140-40040	02924112	40	DIN40	C5	0,9
C5-390B.140-40080	02924113	80	DIN40	C5	1,5
C5-390B.55-40050	02925967	50	BT40	C5	1,1
C5-390B.55-40090	02925968	90	BT40	C5	1,7
C5-390B.140-50030	02924114	30	DIN50	C5	2,6
C5-390B.140-50070	02924115	70	DIN50	C5	3,1
C5-390B.58-50040	02925969	40	BT50	C5	3,4
C5-390B.58-50080	02925970	80	BT50	C5	3,9

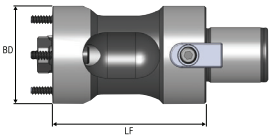
Bezeichnung Zug	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
C5-391.01-50080A	75039886	–	C5	C5	1,1
C5-391.01-50100A	00004773	–	C5	C5	1,4
C6-391.02-50080A	75039894	–	C6	C5	1,4
C6-391.02-50110A	02207400	–	C6	C5	2,2
C8-391.02-50080B	03080011	–	C8	C5	2,4

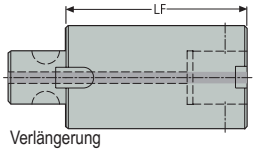
HF55

Graflex®-Schaft für ∅ 59,5–84,499 mm

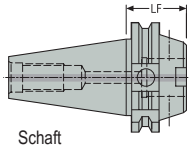


Reibahlenhalter





Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF55-080-G5	02698871	–	80	G5	55	1,3
HF55...HSKA63	–	80	239	HSK-A63	55	0,0
HF55...HSKA80	–	100	239	HSK-A80	55	0,0
HF55...HSKA100	–	100	239	HSK-A100	55	0,0
HF55...DIN40ADB	–	80	239	DIN40ADB	55	0,0
HF55...DIN50ADB	–	80	304	DIN50ADB	55	0,0
HF55...BT40ADB	–	80	239	BT40ADB	55	0,0
HF55...BT50ADB	–	80	304	BT50ADB	55	0,0

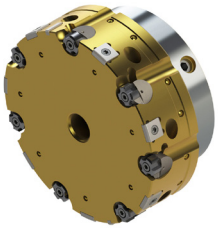
Schäfte und Verlängerungen für HF55-080-G5 (weitere Informationen siehe Seco Werkzeugsysteme).

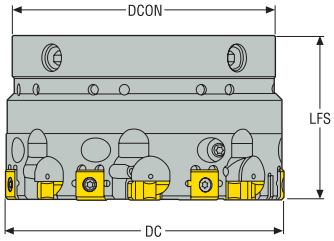
Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
EM93044012860	00086920	60	HSK-A63	G5	1,0
EM930440128100	00086921	100	HSK-A63	G5	1,6
EM930440128140	00086922	140	HSK-A63	G5	2,18
EM93064012865	00086927	65	HSK-A100	G5	2,4
EM930640128110	00086928	110	HSK-A100	G5	3,1
EM930640128150	00086929	150	HSK-A100	G5	3,7
EM34694012840	02458421	40	DIN40	G5	1,0
EM34694012880	02503301	80	DIN40	G5	1,5
EM346940128120	02503302	120	DIN40	G5	2,1
EM34144012845	02457989	45	BT40	G5	1,2
EM34144012880	02503371	80	BT40	G5	1,6
EM341440128120	02503372	120	BT40	G5	2,2
EM34714012840	02503312	40	DIN50	G5	2,75
EM341640128100	02503381	100	BT50	G5	4,3
EM34164012855	02503380	55	BT50	G5	4,0
EM341640128140	02503382	140	BT50	G5	4,9

Bezeichnung Zug	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
M402550	00056762	–	G5	G5	0,8
M402551	00056763	–	G5	G5	1,2
M402552	00056764	–	G5	G5	1,5

HF85

Köpfe für RNAX Wendeplatten, Durchgangsbohrung ∅ 84,5–119,499 mm / 3.327-4.705”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	RNAX1005...
HF85-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	RNAX1005...
HF85-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	RNAX1005...
HF85-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	RNAX1005...
HF85-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	RNAX1005...
HF85-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	RNAX1005...
HF85-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85 07-80	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

Zubehör

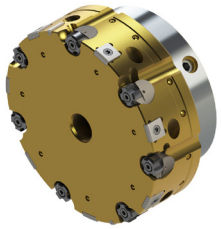
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85 07-80	H00-2020	T00-09P20

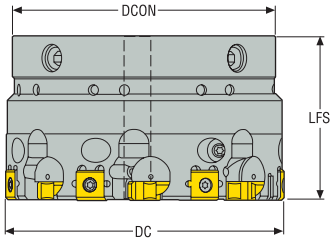
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Köpfe für RNAX Wendeplatten, Grundlochbohrung ∅ 84,5–119,499 mm / 3.327–4.705”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
—Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85B-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	RNAX1005...
HF85B-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	RNAX1005...
HF85B-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	RNAX1005...
HF85B-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	RNAX1005...
HF85B-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	RNAX1005...
HF85B-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	RNAX1005...
HF85B-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85B 07-80	SH4075S	CARTCYHF20B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

Zubehör

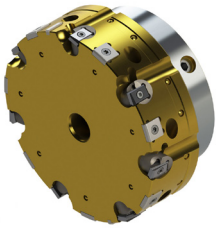
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85B 07-80	H00-2020	T00-09P20

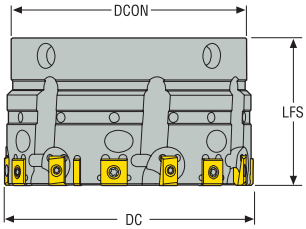
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Köpfe für LNEG Wendeplatten, Durchgangsbohrung ∅ 84,5–119,499 mm / 3.327-4.705”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	LNEG1003...
HF86-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	LNEG1003...
HF86-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	LNEG1003...
HF86-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	LNEG1003...
HF86-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	LNEG1003...
HF86-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	LNEG1003...
HF86-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86 07-80	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

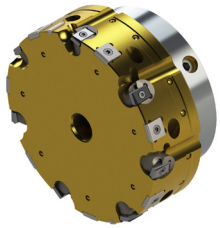
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86 07-80	H00-2020	T00-07P09

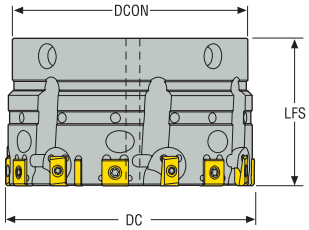
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Köpfe für LNEG Wendeplatten, Grundlochbohrung ∅ 84,5–119,499 mm / 3.327–4.705"





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
—Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86B-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	LNEG1003...
HF86B-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	LNEG1003...
HF86B-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	LNEG1003...
HF86B-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	LNEG1003...
HF86B-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	LNEG1003...
HF86B-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	LNEG1003...
HF86B-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86B	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

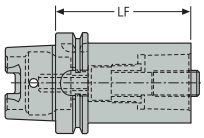
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86B	H00-2020	T00-07P09

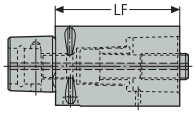
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

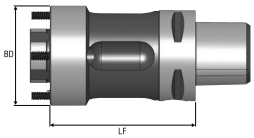
HF80

Seco Capto™ Schaft für ∅ 84,5–119,499 mm

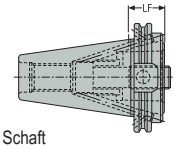




Verlängerung



Reibahlenhalter



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF80-080-C6	02688648	–	80	C6	80	2,5
HF80...HSKA80	–	100	239	HSK-A80	80	0,0
HF80...HSKA100	–	100	239	HSK-A100	80	0,0
HF80...DIN50ADB	–	80	304	DIN50ADB	80	0,0
HF80...BT50ADB	–	80	304	BT50ADB	80	0,0

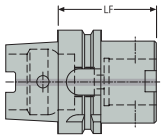
Schäfte und Verlängerungen für HF80-080-C6 (weitere Informationen siehe Seco Werkzeugsysteme).

Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
HA10-C6-063-110	10197967	110	HSK-A100	C6	3,6
C6-390B.140-40085	02924116	85	DIN40	C6	1,8
C6-390B.140-50030	02924117	30	DIN50	C6	2,4
C6-390B.140-50080	02924118	80	DIN50	C6	3,6
C6-390B.55-40075	02925971	75	BT40	C6	1,7
C6-390B.58-50100	02925973	100	BT50	C6	4,6
C6-390B.58-50050	02925972	50	BT50	C6	3,5

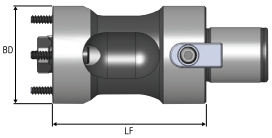
Bezeichnung Zug	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
C6-391.01-63100A	75039887	–	C6	C6	2,2
C6-391.01-63140A	00004840	–	C6	C6	3,1
C6-391.01-63060	02300834	–	C6	C6	1,3

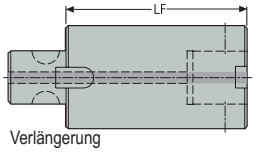
HF80

Graflex®-Schaft für ∅ 84,5–119,499 mm

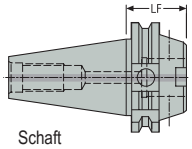


Reibahlenhalter





Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF80-080-G6	02698873	–	80	G6	80	2,6
HF80...HSKA80	–	100	239	HSK-A80	80	0,0
HF80...HSKA100	–	100	239	HSK-A100	80	0,0
HF80...DIN50ADB	–	80	304	DIN50ADB	80	0,0
HF80...BT50ADB	–	80	304	BT50ADB	80	0,0
	–	–	–	–	–	–

Schäfte und Verlängerungen für HF80-080-G6 (weitere Informationen siehe Seco Werkzeugsysteme).

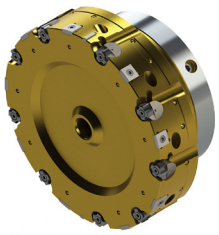
Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
EM93044013670	00086923	70	HSK-A63	G6	1,3
EM930440136120	00086924	120	HSK-A63	G6	2,38
EM930640136120	00086931	120	HSK-A100	G6	3,9
EM930640136160	00086932	160	HSK-A100	G6	4,8
EM34694013660	02503303	60	DIN40	G6	1,3
EM346940136120	02503304	120	DIN40	G6	2,7
EM34144013650	02503373	50	BT40	G6	1,2
EM341440136120	02503374	120	BT40	G6	2,8
EM34714013645	02503317	45	DIN50	G6	2,9
EM347140136100	02503318	100	DIN50	G6	4,1
EM347140136140	02503319	140	DIN50	G6	5,1
EM34164013663	02503383	63	BT50	G6	4,3
EM341640136100	02503384	100	BT50	G6	4,7
EM341640136140	02503385	140	BT50	G6	5,6

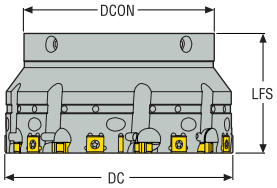
Schäfte und Verlängerungen für HF32-050-G3 (weitere Informationen siehe Seco Werkzeugsysteme).

Bezeichnung Zug	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
M402660	00056765	–	G6	G6	1,4
M402661	00056766	–	G6	G6	2,2
M402662	00056767	–	G6	G6	2,9

HF85

Köpfe für RNAX Wendeplatten, Durchgangsbohrung ∅ 119,5–154,499 mm / 4.705-6.083”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	RNAX1005...
HF85-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	RNAX1005...
HF85-129.5/134.499-09-100	129,5 *5.098*	134,499 *5.295*	63,0 *2.480*	100,0 *3.937*	4,42 *9.740*	9	RNAX1005...
HF85-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	RNAX1005...
HF85-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	RNAX1005...
HF85-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	RNAX1005...
HF85-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85 09-100	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

Zubehör

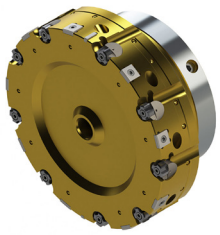
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85 09-100	H00-2020	T00-09P20

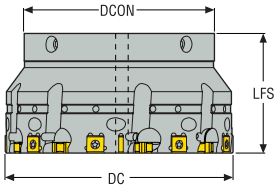
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Köpfe für RNAX Wendeplatten, Grundlochbohrung ∅ 119,5–154,499 mm / 4.705-6.083”





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF85B-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	RNAX1005...
HF85B-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	RNAX1005...
HF85B-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	RNAX1005...
HF85B-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	RNAX1005...
HF85B-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	RNAX1005...
HF85B-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	RNAX1005...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF85B 09-100	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

Zubehör

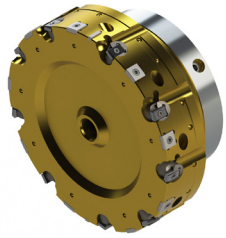
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF85B 09-100	H00-2020	T00-09P20

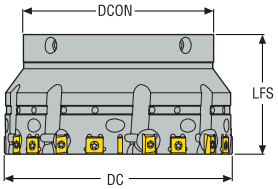
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-09P20 für Wendeplattenschrauben

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Köpfe für LNEG Wendeplatten, Durchgangsbohrung ∅ 119,5–154,499 mm / 4.705–6.083”





–Wendeplatten, Sorten und Geometrien siehe Seite(n) 424–425
–Schnittdaten siehe Seite(n) 450–456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	LNEG1003...
HF86-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	LNEG1003...
HF86-129.5/134.499-09-100	129,5 *5.098*	134,499 *5.295*	63,0 *2.480*	100,0 *3.937*	4,42 *9.740*	9	LNEG1003...
HF86-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	LNEG1003...
HF86-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	LNEG1003...
HF86-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	LNEG1003...
HF86-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86 09-100	SH4075S	CARTCYHF20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

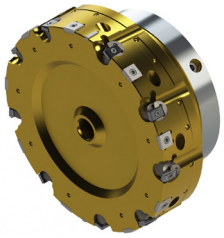
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86 09-100	H00-2020	T00-07P09

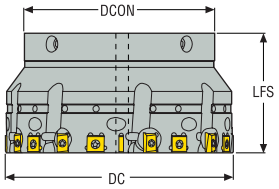
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment
T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Köpfe für LNEG Wendeplatten, Grundlochbohrung ∅ 119,5–154,499 mm / 4.705-6.083"





—Wendeplatten, Sorten und Geometrien siehe Seite(n) 424-425
—Schnittdaten siehe Seite(n) 450-456

Bezeichnung	DCN	DCX	LFS	DCON	Gewicht		WSP
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
HF86B-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	LNEG1003...
HF86B-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	LNEG1003...
HF86B-129.5/134.499-09-100	129,5 *5.098*	134,499 *5.295*	63,0 *2.480*	100,0 *3.937*	4,42 *9.740*	9	LNEG1003...
HF86B-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	LNEG1003...
HF86B-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	LNEG1003...
HF86B-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	LNEG1003...
HF86B-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	LNEG1003...

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Kassette	Spannschraube	Schraube für WSP	Schlüssel	Einstell-schlüssel	Pratze
HF86B 09-100	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Zubehör

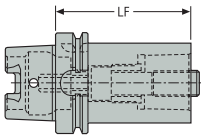
Für Halter	Drehmoment-schlüssel	Torx-Schlüssel für WSP/Spannschraube
HF86B 09-100	H00-2020	T00-07P09

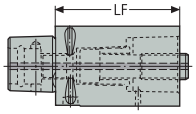
Hinweis
Drehmoment-Schraubendreher H00-2020 für Spannschrauben
Drehmoment-Schraubendreher T00-07P09 für Wendeplattenschrauben

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

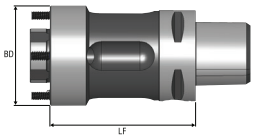
HF100

Seco Capto™ Schaft für ∅ 119,5–154,499 mm

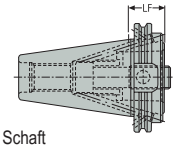




Verlängerung



Reibahlenhalter



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF100-100-C8	02688649	–	100	C8	100	4,9
HF100...HSKA80	–	100	238	HSK-A80	100	0,0
HF100...HSKA100	–	100	238	HSK-A100	100	0,0
HF100...DIN50ADB	–	100	238	DIN50ADB	100	0,0
HF100...BT50ADB	–	100	238	BT50ADB	100	0,0

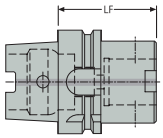
Schäfte und Verlängerungen für HF100-100-C8 (weitere Informationen siehe Seco Werkzeugsysteme).

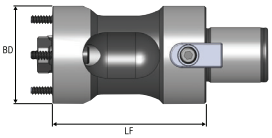
Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
HA10-C8-080-120	10197968	120	HSK-A100	C8	4,8
C8-390B.140-50070	02924119	70	DIN50	C8	3,7
C8-390B.140-50120	02924120	120	DIN50	C8	5,5
C8-390B.58-50070	02925974	70	BT50	C8	4,0
C8-390B.58-50120	02925975	120	BT50	C8	5,9

Bezeichnung Zug	Produktnummer	LF	Kegel	Seco Capto™ Größe	Gewicht
		mm			kg
C8-391.01-80100A	75039888	–	C8	C8	3,7
C8-391.01-80125A	00004841	–	C8	C8	4,6

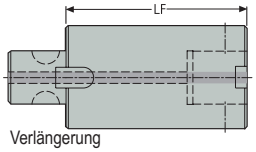
HF100

Graflex®-Schaft für ∅ 119,5–154,499 mm

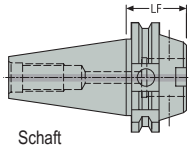




Reibahlenhalter



Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Kegel	BD	Gewicht
		mm	mm	mm	mm	kg
HF100-100-G7	02698874	–	100	G7	100	5,2
HF100...HSKA80	–	100	238	HSK-A80	100	0,0
HF100...HSKA100	–	100	238	HSK-A100	100	0,0
HF100...DIN50ADB	–	100	238	DIN50ADB	100	0,0
HF100...BT50ADB	–	100	238	BT50ADB	100	0,0

Schäfte und Verlängerungen für HF100-100-G7 (weitere Informationen siehe Seco Werkzeugsysteme).

Bezeichnung Aufnahmen	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
EM93064014685	00074385	85	HSK-A100	G7	4,0
EM930640146160	00086933	160	HSK-A100	G7	7,67
EM34714014650	02503320	50	DIN50	G7	3,3
EM347140146120	02503321	120	DIN50	G7	6,5
EM347140146200	02503324	200	DIN50	G7	10,4
EM34164014665	02503386	65	BT50	G7	4,4
EM341640146120	02503387	120	BT50	G7	6,9
EM341640146200	02503388	200	BT50	G7	10,7

Bezeichnung Zug	Produktnummer	LF	Kegel	Graflex Größe	Gewicht
		mm			kg
M402770	00056768	–	G7	G7	2,9
M402771	00056769	–	G7	G7	4,4
M402772	00056770	–	G7	G7	5,8

Schnittdaten – LNEG...-EB45 Metrisch

SMG		a_p (∅)	f				v_c		
			z=3	z=5	z=7	z=9	RX2000	CF	RX1500
P1	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	120 (80-200)	180 (120-250)	220 (120-300)
P2	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	120 (80-200)	180 (120-250)	220 (120-300)
P3	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	120 (80-200)	180 (120-250)	220 (120-300)
P4	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P5	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P6	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P7	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P8	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)	60 (50-100)	80 (60-120)
P11	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)	60 (50-100)	80 (60-120)
P12	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	30 (25-55)	45 (40-80)	65 (45-95)
M1	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	35 (25-60)	–	–
M2	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	35 (25-60)	–	–
M3	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	35 (25-60)	–	–
M4	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	25 (20-50)	–	–
M5	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	25 (20-50)	–	–
K1	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	–	220 (150-300)
K2	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)	–	70 (50-120)
K3	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	–	220 (150-300)
K4	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	100 (60-120)	150 (110-200)
K5	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	100 (60-120)	150 (110-200)
K6	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	–	220 (150-300)
K7	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	–	220 (150-300)
H3	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H5	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H7	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H8	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H11	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H12	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H21	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–
H31	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	–	–

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – LNEG...-EB45 *Zoll*

SMG		a_p (∅)	f				v_c		
			z=3	z=5	z=7	z=9	RX2000	CF	RX1500
P1	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	395 (260-655)	590 (395-820)	720 (395-985)
P2	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	395 (260-655)	590 (395-820)	720 (395-985)
P3	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	395 (260-655)	590 (395-820)	720 (395-985)
P4	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130-395)	260 (195-490)	330 (260-655)
P5	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130-395)	260 (195-490)	330 (260-655)
P6	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130-395)	260 (195-490)	330 (260-655)
P7	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130-395)	260 (195-490)	330 (260-655)
P8	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	130 (100-230)	195 (165-330)	260 (195-395)
P11	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	130 (100-230)	195 (165-330)	260 (195-395)
P12	LNEG1003-EB45	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.010-0.053	100 (85-185)	150 (135-265)	215 (150-315)
M1	LNEG1003-EB45	0.004–0.008	0.006–0.012	0.010–0.020	0.014–0.028	0.018–0.035	115 (80-195)	–	–
M2	LNEG1003-EB45	0.004–0.008	0.006–0.012	0.010–0.020	0.014–0.028	0.018–0.035	115 (80-195)	–	–
M3	LNEG1003-EB45	0.004–0.008	0.006–0.012	0.010–0.020	0.014–0.028	0.018–0.035	115 (80-195)	–	–
M4	LNEG1003-EB45	0.004–0.008	0.006–0.012	0.010–0.020	0.014–0.028	0.018–0.035	80 (65-165)	–	–
M5	LNEG1003-EB45	0.004–0.008	0.006–0.012	0.010–0.020	0.014–0.028	0.018–0.035	80 (65-165)	–	–
K1	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	–	720 (490-985)
K2	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	165 (115-260)	–	230 (165-395)
K3	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	–	720 (490-985)
K4	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165-395)	330 (195-395)	490 (360-655)
K5	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165-395)	330 (195-395)	490 (360-655)
K6	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	–	720 (490-985)
K7	LNEG1003-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	–	720 (490-985)
H3	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H5	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H7	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H8	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H11	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H12	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H21	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–
H31	LNEG1003-EB45	0.004–0.008	0.004–0.010	0.006–0.016	0.010–0.020	0.012–0.028	65 (35-100)	–	–

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – LNEG...-EB845 Metrisch

SMG		a_p (∅)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P1	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P2	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P3	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P4	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P5	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P6	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P7	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P8	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	40 (30-70)
P11	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	40 (30-70)
P12	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	30 (25-55)
M1	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M2	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M3	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M4	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	25 (20-50)
M5	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	25 (20-50)
K1	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K2	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	50 (35-80)
K3	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K4	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)
K5	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)
K6	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K7	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – LNEG...-EB845 *Zoll*

SMG		a_p (∅)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P1	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*395 (260-655)*
P2	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*395 (260-655)*
P3	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*395 (260-655)*
P4	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P5	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P6	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P7	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P8	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*130 (100-230)*
P11	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*130 (100-230)*
P12	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*100 (85-185)*
M1	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*115 (80-195)*
M2	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*115 (80-195)*
M3	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*115 (80-195)*
M4	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*80 (65-165)*
M5	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*80 (65-165)*
K1	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*
K2	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*165 (115-260)*
K3	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*
K4	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*230 (165-395)*
K5	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*230 (165-395)*
K6	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*
K7	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – LNEG...-EB1570 Metrisch

SMG		a_p (∅)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P4	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P5	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P6	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P7	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P8	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)
P11	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)
P12	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	30 (25-55)
K1	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K2	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)
K3	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K4	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)
K5	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)
K6	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K7	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – LNEG...-EB1570 *Zoll*

SMG		a_p (∅)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P4	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P5	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P6	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P7	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P8	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*130 (100–230)*
P11	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*130 (100–230)*
P12	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*100 (85–185)*
K1	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*
K2	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*165 (115–260)*
K3	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*
K4	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165–395)*
K5	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165–395)*
K6	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*
K7	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Schnittdaten – RNAX...-EB45 Metrisch

SMG		a_p (∅)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K2	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)	70 (50-120)
K3	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K4	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K5	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K6	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K7	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)

SMG = Seco Werkstoff-Gruppe. a_p = mm. f = mm/U. v_c= m/min. Alle Schnittdaten sind Startwerte

Schnittdaten – RNAX...-EB45 *Zoll*

SMG		a_p (∅)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490-985)*
K2	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*165 (115-260)*	*230 (165-395)*
K3	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490-985)*
K4	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165-395)*	*490 (360-655)*
K5	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165-395)*	*490 (360-655)*
K6	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490-985)*
K7	*RNAX1005-EB45*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490-985)*

SMG = Seco Werkstoff-Gruppe. a_p = *Zoll*. f = in/U. v_c= sf/min. Alle Schnittdaten sind Startwerte

Schnittdaten – RNAX...-EB845 Metrisch

SMG		a_p (∅)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)
K2	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	50 (35-80)	70 (50-120)
K3	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)
K4	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)	150 (110-200)
K5	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)	150 (110-200)
K6	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)
K7	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)

SMG = Seco Werkstoff-Gruppe. a_p = *Zoll*. f = in/U. v_c= sf/min. Alle Schnittdaten sind Startwerte

Schnittdaten – RNAX...-EB845 *Zoll*

SMG		a_p (∅)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*	*720 (490-985)*
K2	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*165 (115-260)*	*230 (165-395)*
K3	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*	*720 (490-985)*
K4	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*230 (165-395)*	*490 (360-655)*
K5	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*230 (165-395)*	*490 (360-655)*
K6	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*	*720 (490-985)*
K7	*RNAX1005-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*	*720 (490-985)*

SMG = Seco Werkstoff-Gruppe. a_p = *Zoll*. f = in/U. v_c= sf/min. Alle Schnittdaten sind Startwerte

Schnittdaten – RNAX...-EB1570 Metrisch

SMG		a_p (∅)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K2	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)	70 (50-120)
K3	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K4	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K5	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K6	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K7	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Startwerte

Schnittdaten – RNAX...-EB1570 *Zoll*

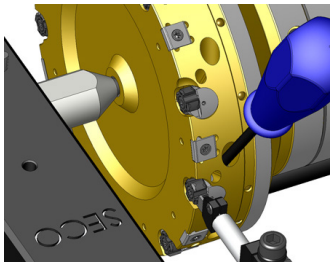
SMG		a_p (∅)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490- 985)*
K2	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*165 (115-260)*	*230 (165- 395)*
K3	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490- 985)*
K4	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165-395)*	*490 (360- 655)*
K5	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165-395)*	*490 (360- 655)*
K6	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490- 985)*
K7	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490- 985)*

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
f = in/U
v_c= sf/min
Alle Schnittdaten sind Startwerte

Einstellhinweise

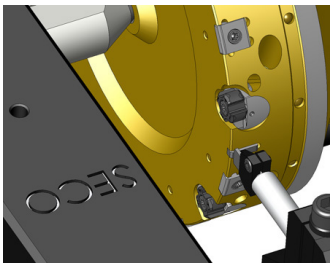
1.

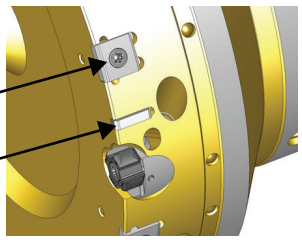
- Klemmschraube der Kassette lösen.
- Wendeschneidplatte wechseln oder eine neue einsetzen.
- Einstellschraube durch eine Vierteldrehung lösen und Kassette leicht zurückdrücken.
- Kassettenschraube sanft anziehen 0,5 Nm *(4.4 in/lbs)*.

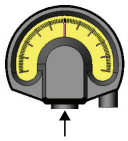


2.

- Die Messuhr auf der entsprechenden Führungsleiste auf Null stellen.
- Der Messpunkt muss hinter dem Anstellwinkel liegen.

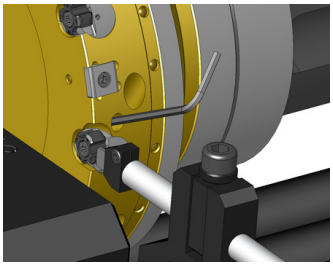


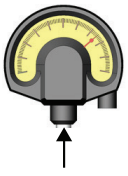




3.

- Wendeschneidplatte mittels Einstellschraube 0,025 mm *(0.001”)* über der Führungsleiste einsetzen.
- Einstellverfahren für alle WSP wiederholen.





4.

- Zum Schluss Kassettenschraube anziehen 2 Nm *(17.7 in/lbs)*.

Hinweis: Wenn die geforderten Durchmesser während der Einstellung überschritten werden, noch einmal von neuem beginnen, um das Spiel der Einstellschrauben zu eliminieren.

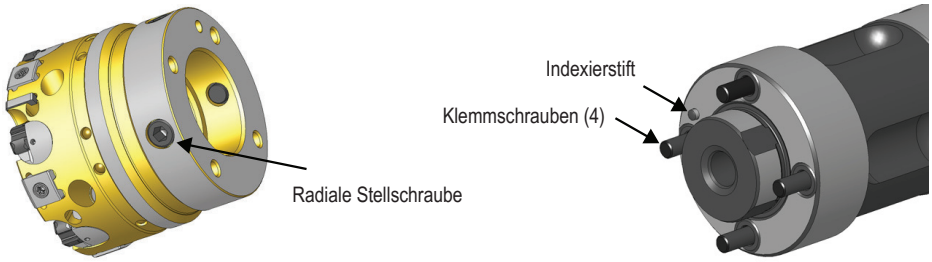
Einstellhinweise

1.

Montage

- Kontaktflächen sorgfältig reinigen.
- Die 4 radialen Einstellschrauben lösen, so dass sie bei der Montage nicht stören.
- Reibkopf auf den Adapter (Indexierstift) setzen und die vier Klemmschrauben leicht anziehen.

Montage (Abb.1)

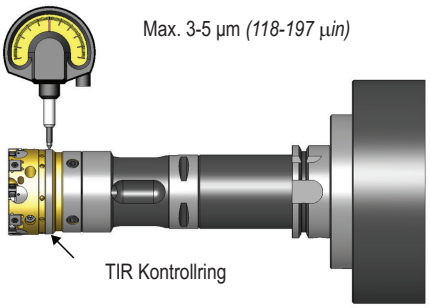


2.

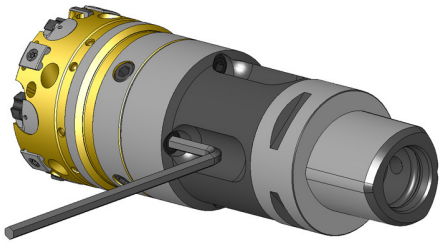
Einstellung:

- Werkzeug in die Spindel einsetzen.
- Messuhr wie in Bild 2 dargestellt positionieren.
- Spindel lösen, so dass sie von Hand frei gedreht werden kann.
- Rundlaufkorrektur mit Hilfe der in Bild 4 abgebildeten Einstellschrauben (Skizze 3) vornehmen.
- Die maximale Rundlaufabweichung beträgt 5 µm *(197 µin)*.
- Bei Rundlaufabweichung kleiner als 10 µm *(394 µin)*, das Werkzeug final spannen (Abb. 1), siehe Drehmomentempfehlungen in Tabelle.

Einstellung in der Maschinenspindel (Zeichnungen 2)



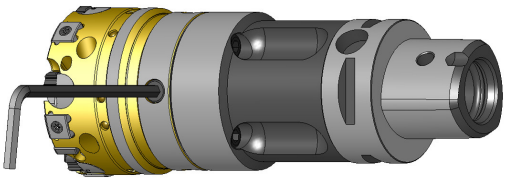
Klemmschrauben (Abb. 3)



3.

- Rundlaufeinstellung beenden (max. 5 µm) *(max. 197 µin)*.

Radiale Einstellschraube (Abb. 4)



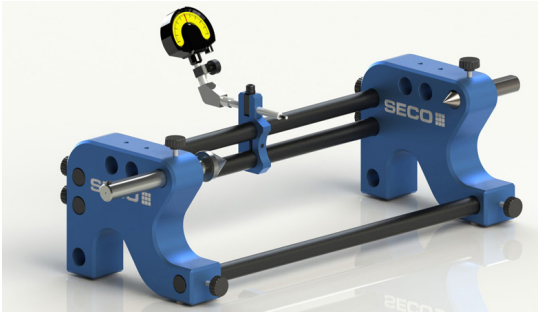
Drehmomenttabelle

Durchm. (mm)	*Durchmesser Zoll*	**Adapter-Größe**	**Spann-schraube**	**Anzugs-moment (Nm)**	*Anzugs-moment in/lbs*
39.5-59.499	*1.555-2,342*	HF32	CHC M3 x 16	2,7	*24*
59.5-84.499	*2.342-3,372*	HF55	CHC M5 x 25	5,7	*50*
84.5-119.499	*3.372-4,705*	HF80	CHC M6 x 25	9,8	*87*
119.5-154.499	*4.705-6,083*	HF100	CHC M8 x 30	24	*212*

Einstellgerät – Spannvorrichtungen für eine Messuhr

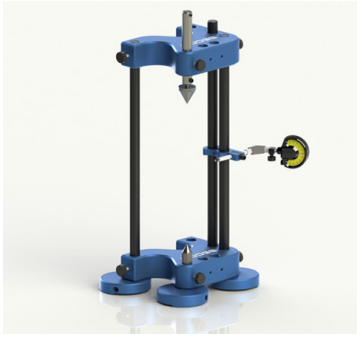
SF-210340-C160: Bezeichnung 02885391

- Horizontales Gestell
- Erste Wahl für Xfix-Reibahlen
- 1 Messuhr
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 340 mm *(13,386 Zoll)*
- Im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,244 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620



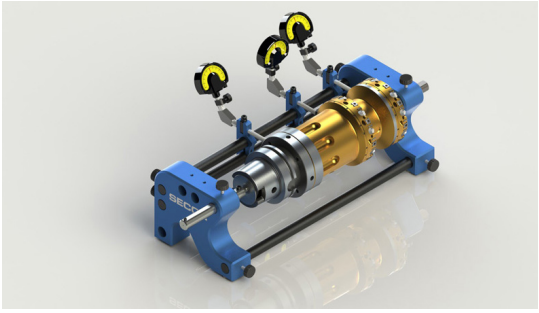
SF-210290V-C160: Bezeichnung 02885392

- Vertikales Gestell
- Erste Wahl für Xfix-Reibahlen
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 290 mm *(11,417 Zoll)*
- Im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,244 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620

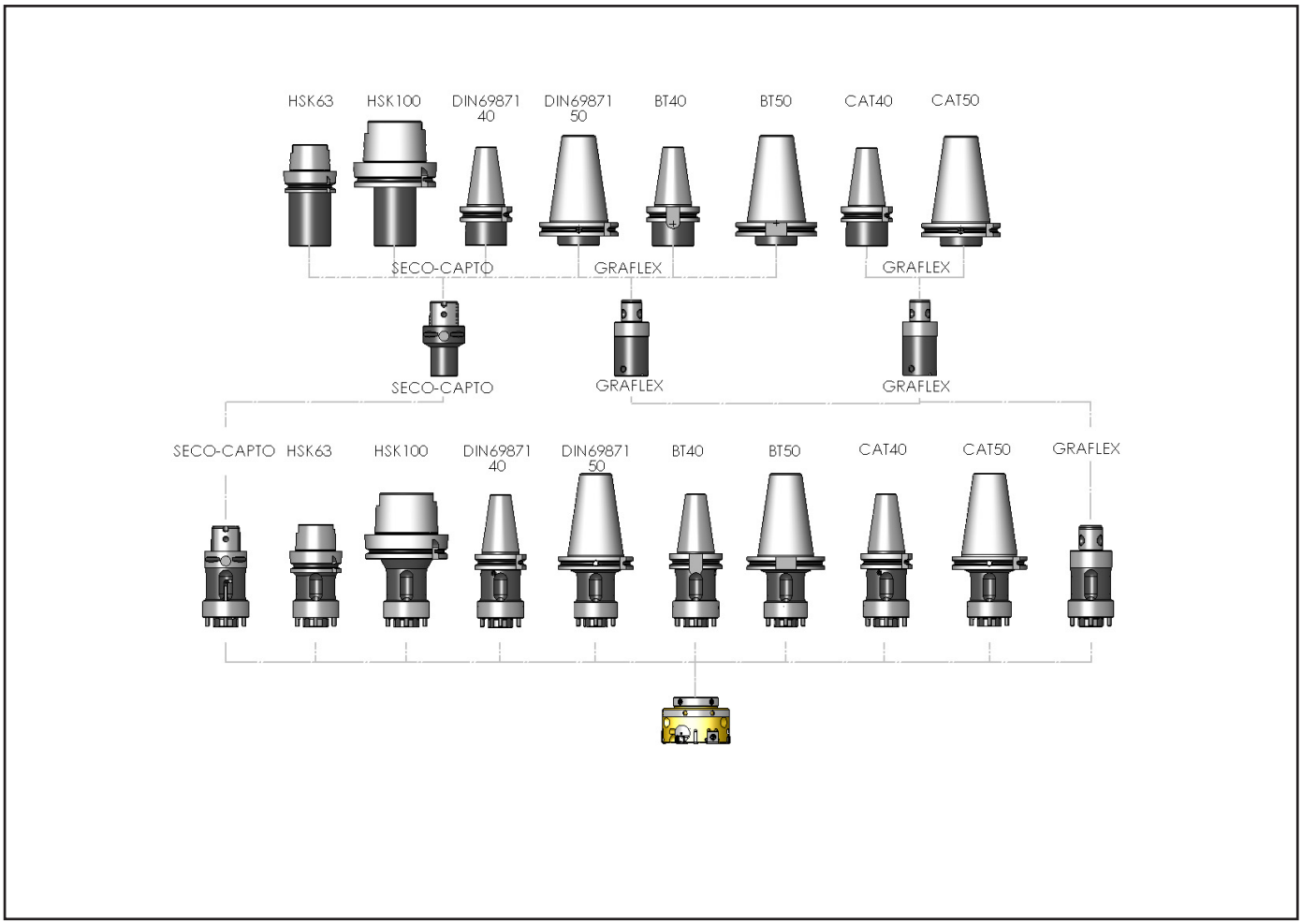


Einstellgerät – Spannvorrichtungen für mehrere Messuhren

Weitere Informationen zur Einstellung mit mehreren Messuhren, finden Sie im Kapitel „Einstellgerät“ Seite 473-478.



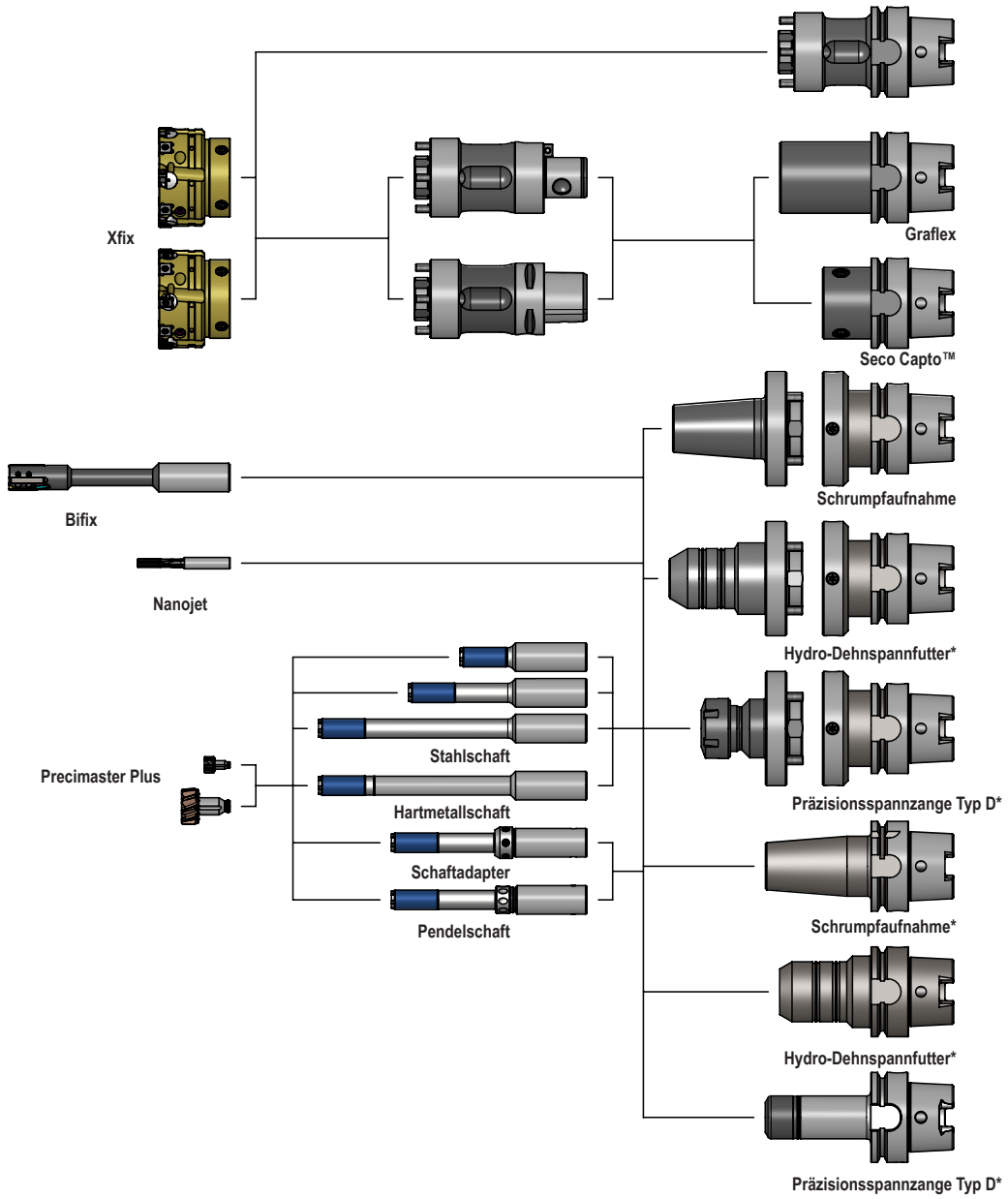
Werkzeugsystem-Übersicht



Durchm. (mm)	*Durchmesser Zoll*	Maximales Längen-Durchmesser-Verhältnis
39.5-59.499	*1.555-2,342*	6,5 x D
59.5-84.499	*2.342-3,372*	4,5 x D
84.5-119.499	*3.372-4,705*	3,3 x D
119.5-154.499	*4.705-6,083*	2,5 x D

Hinweis: Für Durchmesser > 100 mm *(3.937")* oder L > 3 x D zulässiges Max.-Gewicht des Werkzeugs in der Maschine überprüfen.

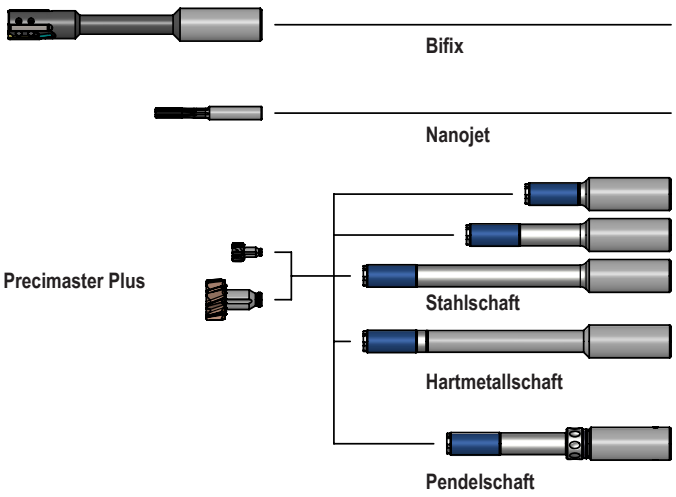
Rotierender Einsatz



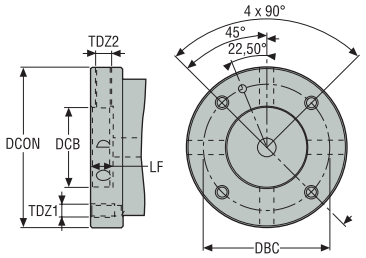
* Siehe Seco Katalog Werkzeug-Systeme

Für beste Ergebnisse empfehlen wir eine stabile Klemmung (mit Hydro-Dehnspannfutter, Spannzange Typ D oder Schrumpffutter).

Statischer Einsatz



Flanschabmessung

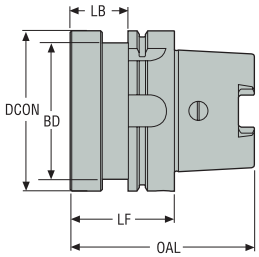


DCON	DBC +/- 0,1	DCB F8	LF	TDZ1	TDZ2
60	44	30	12	M5	M8x1
70	53	35	12	M6	M8x1
80	63	40	12	M6	M8x1
100	79	50	14	M8	M10x1
117	96	60	14	M8	M10x1
140	119	80	14	M10	M10x1

Ersatzteile, im Lieferumfang enthalten

Für Halter	Einstellschraube	Spannschraube
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
70	HCM8X16X1/ISO4028	CHCM6X20/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Schnittstelle HSK-A



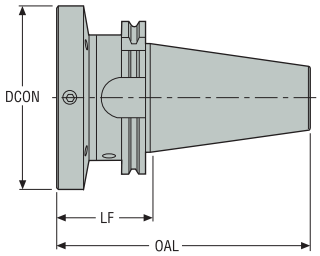
—Hinweis: Kühlmittelrohr und Schrauben im Lieferumfang enthalten

Bezeichnung	Produktnummer	Aufnahme	DCON	BD	LB	LF	OAL	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-23405100001	02836663	HSK-A 100	60,0 *2.362*	60,0 *2.362*	26,0 *1.024*	55,0 *2.165*	105,0 *4.134*	2,5 *5.510*
SAH-2340550001	02836566	HSK-A 50	60,0 *2.362*	42,0 *1.654*	34,0 *1.339*	60,0 *2.362*	85,0 *3.346*	0,95 *2.090*
SAH-2340580001	02836655	HSK-A 80	60,0 *2.362*	60,0 *2.362*	24,0 *0.945*	50,0 *1.969*	90,0 *3.543*	1,4 *3.090*
SAH-2340563001	02836574	HSK-A 63	60,0 *2.362*	53,0 *2.087*	34,0 *1.339*	60,0 *2.362*	92,0 *3.622*	1,2 *2.650*
SAH-23405100007	02836664	HSK-A 100	70,0 *2.756*	70,0 *2.756*	26,0 *1.024*	55,0 *2.165*	105,0 *4.134*	2,7 *5.950*
SAH-2340563003	02836575	HSK-A 63	70,0 *2.756*	53,0 *2.087*	34,0 *1.339*	60,0 *2.362*	92,0 *3.622*	1,3 *2.870*
SAH-2340580003	02836657	HSK-A 80	70,0 *2.756*	67,0 *2.638*	34,0 *1.339*	60,0 *2.362*	100,0 *3.937*	1,5 *3.310*
SAH-23405100002	02836665	HSK-A 100	80,0 *3.150*	80,0 *3.150*	26,0 *1.024*	55,0 *2.165*	105,0 *4.134*	2,9 *6.390*
SAH-2340563002	02836576	HSK-A 63	80,0 *3.150*	53,0 *2.087*	34,0 *1.339*	60,0 *2.362*	92,0 *3.622*	1,4 *3.090*
SAH-2340580002	02836658	HSK-A 80	80,0 *3.150*	67,0 *2.638*	34,0 *1.339*	60,0 *2.362*	100,0 *3.937*	1,6 *3.530*
SAH-2340563004	02836577	HSK-A 63	100,0 *3.937*	53,0 *2.087*	39,0 *1.535*	65,0 *2.559*	97,0 *3.819*	1,95 *4.300*
SAH-23405100003	02836666	HSK-A 100	100,0 *3.937*	85,0 *3.346*	36,0 *1.417*	65,0 *2.559*	115,0 *4.528*	3,5 *7.720*
SAH-2340580004	02836660	HSK-A 80	100,0 *3.937*	67,0 *2.638*	39,0 *1.535*	65,0 *2.559*	105,0 *4.134*	2,2 *4.850*

Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube	Spannschraube
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
70	HCM8X16X1/ISO4028	CHCM6X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Schnittstelle DIN 69871



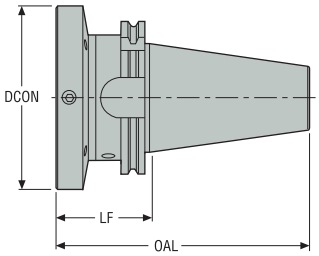
—Hinweis: Schrauben im Lieferumfang enthalten

Bezeichnung	Produktnummer	Aufnahme	DCON	LF	OAL	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-2340640201	02836683	DIN40 ADB	60,0 *2.362*	50,0 *1.969*	118,4 *4.661*	1,3 *2.870*
SAH-2340650201	02836687	DIN50 ADB	60,0 *2.362*	50,0 *1.969*	151,8 *5.976*	3,1 *6.830*
SAH-2340650202	02836690	DIN50 ADB	80,0 *3.150*	50,0 *1.969*	151,8 *5.976*	3,5 *7.720*
SAH-2340640202	02836685	DIN40 ADB	80,0 *3.150*	55,0 *2.165*	123,4 *4.858*	1,7 *3.750*
SAH-2340640203	02836686	DIN40 ADB	100,0 *3.937*	60,0 *2.362*	128,4 *5.055*	2,3 *5.070*
SAH-2340650203	02836691	DIN50 ADB	100,0 *3.937*	60,0 *2.362*	161,8 *6.370*	4,3 *9.480*

Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube	Spannschraube
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Schnittstelle ANSI CAT



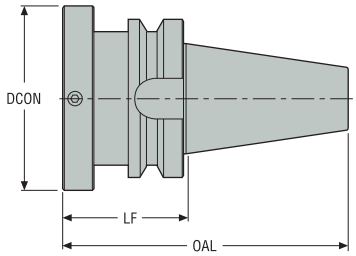
—Hinweis: Schrauben im Lieferumfang enthalten
—Anzugsbolzen mit zölligem Gewinde

Bezeichnung	Produktnummer	Aufnahme	DCON	LF	OAL	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-2784940201	02836698	CAT 40	60,0 *2.362*	50,0 *1.969*	118,4 *4.661*	1,1 *2.430*
SAH-2784950201	02836707	CAT 50	60,0 *2.362*	50,0 *1.969*	151,8 *5.976*	3,1 *6.830*
SAH-2784940202	02836702	CAT 40	80,0 *3.150*	60,0 *2.362*	128,4 *5.055*	1,8 *3.970*
SAH-2784950202	02836709	CAT 50	80,0 *3.150*	60,0 *2.362*	161,8 *6.370*	3,4 *7.500*
SAH-2784940203	02836704	CAT 40	100,0 *3.937*	60,0 *2.362*	128,4 *5.055*	2,3 *5.070*
SAH-2784950203	02836710	CAT 50	100,0 *3.937*	80,0 *3.150*	181,8 *7.157*	5,5 *12.130*

Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube	Spannschraube
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Schnittstelle BT



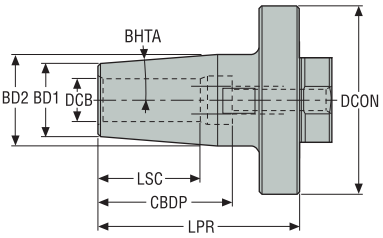
—Hinweis: Schrauben im Lieferumfang enthalten

Bezeichnung	Produktnummer	Aufnahme	DCON	LF	OAL	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-2340740001	02836717	BT40 ADB	60,0 *2.362*	55,0 *2.165*	120,4 *4.740*	1,4 *3.090*
SAH-2340750001	02836724	BT50 ADB	60,0 *2.362*	70,0 *2.756*	171,8 *6.764*	4,2 *9.260*
SAH-2340740004	02836718	BT40 ADB	70,0 *2.756*	55,0 *2.165*	120,4 *4.740*	1,5 *3.310*
SAH-2340750002	02836725	BT50 ADB	70,0 *2.756*	70,0 *2.756*	171,8 *6.764*	4,4 *9.700*
SAH-2340740002	02836719	BT40 ADB	80,0 *3.150*	65,0 *2.559*	130,4 *5.134*	2,0 *4.410*
SAH-2340750003	02836726	BT50 ADB	80,0 *3.150*	70,0 *2.756*	171,8 *6.764*	4,6 *10.140*
SAH-2340740003	02836721	BT40 ADB	100,0 *3.937*	60,0 *2.362*	125,4 *4.937*	2,7 *5.950*
SAH-2340750004	02836727	BT50 ADB	100,0 *3.937*	70,0 *2.756*	171,8 *6.764*	5,1 *11.240*

Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube	Spannschraube
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
70	HCM8X16X1/ISO4028	CHCM6X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Schrumpfaufnahme Adapter



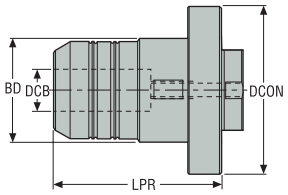
—Hinweis: Einstellschrauben im Lieferumfang enthalten

Bezeichnung	Produktnummer	DCON	BD2	BD1	DCB	LSC	CBDP	LPR	Gewicht	BHTA°
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
SAH-2341008236	10280202	60,0 *2.362*	27,0 *1.063*	21,0 *0.827*	8,0 *0.315*	26,0 *1.024*	36,0 *1.417*	70,0 *2.756*	0,5 *1.100*	4.5
SAH-2341012238	02836737	60,0 *2.362*	32,0 *1.260*	24,0 *0.945*	12,0 *0.472*	34,0 *1.339*	47,5 *1.870*	70,0 *2.756*	0,52 *1.150*	4.5
SAH-2341016241	02836741	70,0 *2.756*	34,0 *1.339*	27,0 *1.063*	16,0 *0.630*	39,0 *1.535*	50,5 *1.988*	75,0 *2.953*	0,7 *1.540*	4.5
SAH-2341020251	02836742	80,0 *3.150*	42,0 *1.654*	33,0 *1.299*	20,0 *0.787*	41,0 *1.614*	52,5 *2.067*	80,0 *3.150*	1,0 *2.200*	4.5
SAH-2341025260	02836743	100,0 *3.937*	53,0 *2.087*	44,0 *1.732*	25,0 *0.984*	47,0 *1.850*	58,5 *2.303*	80,0 *3.150*	2,2 *4.850*	4.5
SAH-2341032261	02836744	100,0 *3.937*	53,0 *2.087*	44,0 *1.732*	32,0 *1.260*	51,0 *2.008*	62,5 *2.461*	80,0 *3.150*	2,5 *5.510*	4.5

Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube
60	HCM6X12/ISO4028
70/80	HCM6X16/ISO4028
100	HCM8X12X1/ISO4028

Hydrodehnspannfutter Adapter



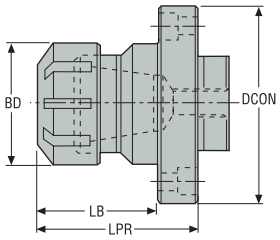
—Hinweis: Einstellschrauben im Lieferumfang enthalten

Bezeichnung	Produktnummer	DCON	BD	DCB	LPR	Gewicht
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-2341106240	10280197	60,0 *2.362*	26,0 *1.024*	6,0 *0.236*	50,0 *1.969*	0,8 *1.760*
SAH-2341116253	02836749	70,0 *2.756*	38,0 *1.496*	16,0 *0.630*	50,0 *1.969*	0,75 *1.650*
SAH-2341104267	10280198	80,0 *3.150*	22,5 *0.886*	4,0 *0.157*	66,0 *2.598*	0,9 *1.980*
SAH-2341106268	10280199	80,0 *3.150*	26,5 *1.043*	6,0 *0.236*	64,5 *2.539*	0,9 *1.980*
SAH-2341108269	10280200	80,0 *3.150*	28,0 *1.102*	8,0 *0.315*	77,5 *3.051*	1,1 *2.430*
SAH-2341110242	10280201	80,0 *3.150*	30,0 *1.181*	10,0 *0.394*	77,5 *3.051*	1,1 *2.430*
SAH-2341112255	02836752	80,0 *3.150*	32,0 *1.260*	12,0 *0.472*	77,5 *3.051*	1,1 *2.430*
SAH-2341116256	02836754	80,0 *3.150*	38,0 *1.496*	16,0 *0.630*	82,5 *3.248*	1,2 *2.650*
SAH-2341120257	02836755	80,0 *3.150*	42,0 *1.654*	20,0 *0.787*	82,5 *3.248*	1,3 *2.870*
SAH-2341125258	02836756	80,0 *3.150*	50,0 *1.969*	25,0 *0.984*	90,0 *3.543*	1,7 *3.750*
SAH-2341112259	02836757	100,0 *3.937*	32,0 *1.260*	12,0 *0.472*	90,0 *3.543*	1,9 *4.190*
SAH-2341125260	02836758	100,0 *3.937*	50,0 *1.969*	25,0 *0.984*	100,0 *3.937*	2,8 *6.170*
SAH-2341132261	02836759	100,0 *3.937*	60,0 *2.362*	32,0 *1.260*	103,0 *4.055*	2,9 *6.390*

Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube
60	HCM6X12/ISO4028
70/80	HCM6X16/ISO4028
100	HCM8X12X1/ISO4028

ER-Spannzangenfutter Adapter



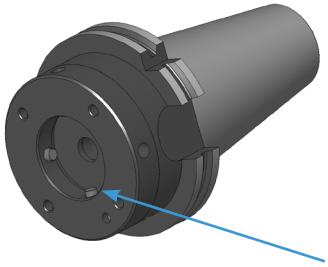
—Hinweis: Einstellschrauben im Lieferumfang enthalten

Bezeichnung	Produktnummer	Größe	DCON	BD	LB	LPR	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-23412ER25254	02836762	ER25	80,0 *3.150*	42,0 *1.654*	45,0 *1.772*	60,0 *2.362*	1,0 *2.200*
SAH-23412ER32255	02836763	ER32	80,0 *3.150*	50,0 *1.969*	45,0 *1.772*	60,0 *2.362*	1,2 *2.650*
SAH-23412ER40256	02836764	ER40	100,0 *3.937*	63,0 *2.480*	50,0 *1.969*	70,0 *2.756*	1,6 *3.530*

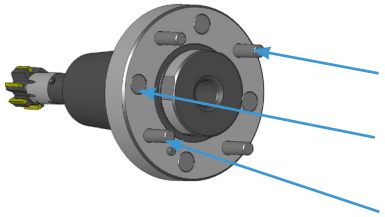
Ersatzteile, im Lieferumfang enthalten

Für DCON	Einstellschraube
80	HCM6X16/ISO4028
100	HCM8X12X1/ISO4028

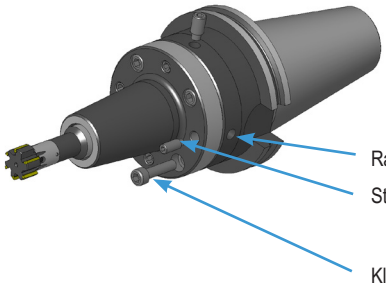
Montagehinweise



– Kontaktoberfläche reinigen
– Sicherstellen, dass die radialen Einstellschrauben die Einheit nicht behindern

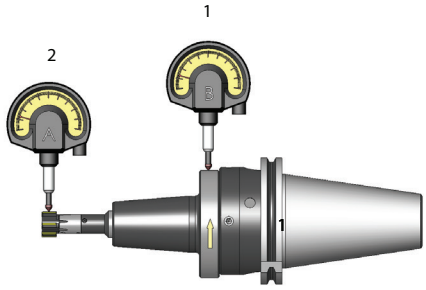
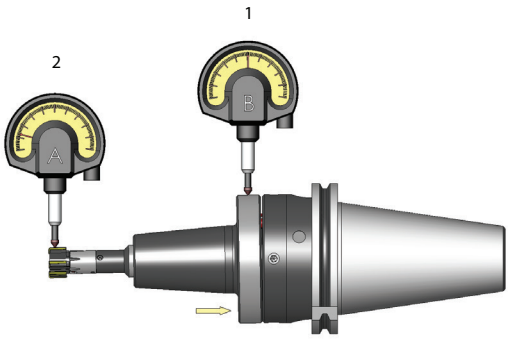
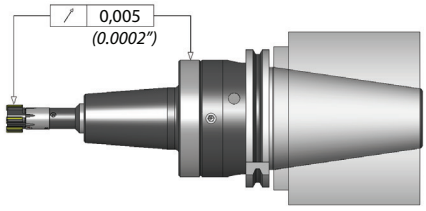


– Sicherstellen, dass die Winkeleinstellschrauben die Einheit nicht behindern



– Weiter montieren und Klemmschrauben dabei leicht anziehen (x4)

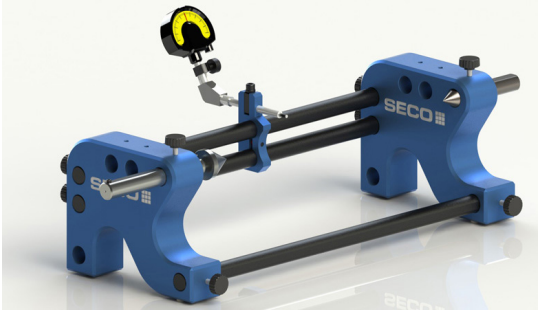
Einstellhinweise

– Werkzeug in die Maschinenspindel einsetzen – Messuhr 1 wie dargestellt aufstellen (Messuhr 2 hier nicht erforderlich) – Werkzeug manuell in die niedrigste Position drehen – Ausgleich des radialen Rundlaufs siehe Pfeil – Ausgleich überprüfen und ggf. wiederholen	
– Werkzeug in die Maschinenspindel einsetzen – Messuhr 2 wie dargestellt aufstellen – Werkzeug manuell in die niedrigste Position drehen – Ausgleich des radialen Rundlaufs siehe Pfeil – Ausgleich überprüfen und ggf. wiederholen	
– Nach der Einstellung beträgt die Rundlaufabweichung <5 µm *(197 µin)*. Klemmung abschließen, um den Werkzeugverbund zu sichern. – Der einstellbare Adapter kann mit jeder beliebigen Einstellvorrichtung außerhalb der Maschine voreingestellt werden. – Die Feineinstellung muss stets in der Maschinenspindel erfolgen – Eine Mikrometrische Messuhr verwenden. Für beide Einstellvorgänge kann dieselbe Messuhr verwendet werden.	

Einstellgerät – Spannvorrichtungen für eine Messuhr

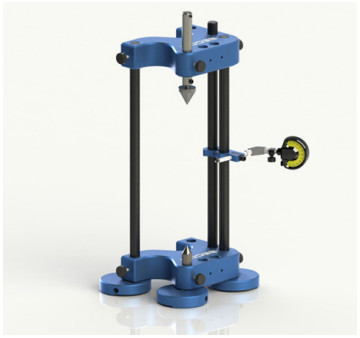
SF-210340-C160: Bezeichnung 02885391

- Horizontales Gestell
- Erste Wahl für Xfix-Reibahlen
- 1 Messuhr
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 340 mm *(13,386 Zoll)*
- im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620



SF-210290V-C160: Bezeichnung 02885392

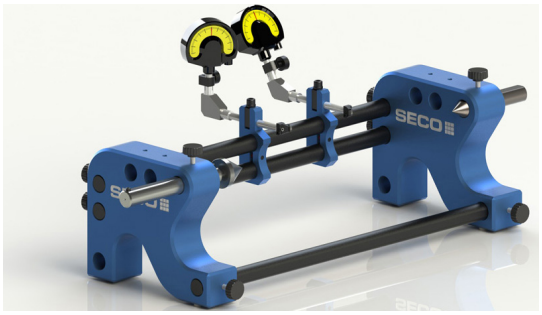
- Vertikales Gestell
- Erste Wahl für Xfix-Reibahlen
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 290 mm *(11,417 Zoll)*
- im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620



Einstellgerät – Spannvorrichtungen für zwei Messuhren

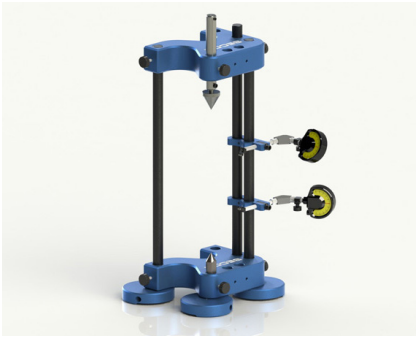
SF-210340-C160C190: Bezeichnung 02885393

- Horizontales Gestell
- Erste Wahl für Bifix-Reibahlen
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 340 mm *(13,386 Zoll)*
- Im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620 Lieferung



SF-210290V-C160C190: Bezeichnung 02885394

- Vertikales Gestell
- Erste Wahl für Bifix-Reibahlen
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 290 mm *(11,417 Zoll)*
- im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620

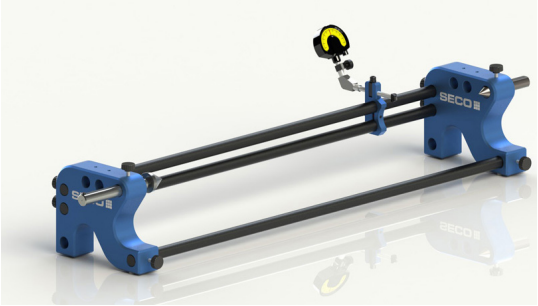


Weitere Informationen hierzu erhalten Sie von Ihrem zuständigen Seco Tools Ansprechpartner.

Einstellgerät – Spannvorrichtungen für eine Messuhr mit großer Kapazität

SF-210740-C160: Bezeichnung 02885385

- Horizontales Gestell
- Erste Wahl für Xfix-Reibahlen
- 1 Messuhr
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 740 mm *(29,134 Zoll)*
- im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620



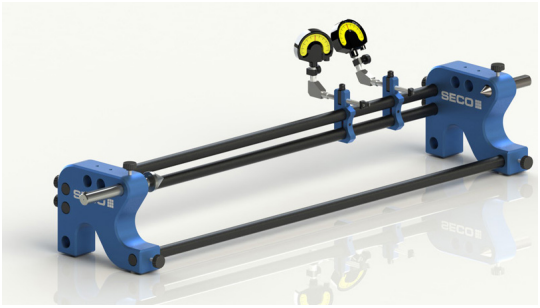
SF-210690V-C160: Bezeichnung 02885387

- Vertikales Gestell
- Erste Wahl für Xfix-Reibahlen
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 690 mm *(27,165 Zoll)*
- im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620

Einstellgerät – Spannvorrichtungen für zwei Messuhren mit großer Kapazität

SF-210740-C160C190: Bezeichnung 02885388

- Horizontales Gestell
- Erste Wahl für Bifix-Reibahlen
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 740 mm *(29.134")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.224")* Durchmesser für HSK 63/80/100 und Capto C8
- Zentrierspitze SSC5700 mit Bezeichnung 02208620 ist im Lieferumfang enthalten.



SF-210690V-C160C190: Bezeichnung 02885390

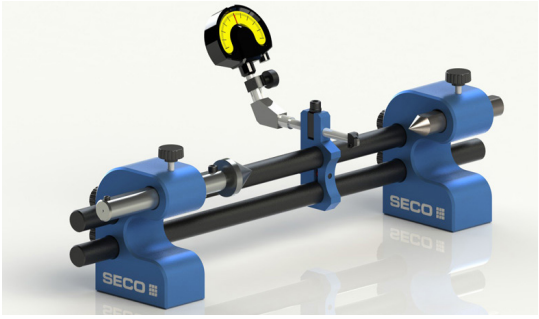
- Vertikales Gestell
- Erste Wahl für Bifix-Reibahlen
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 690 mm *(27,165 Zoll)*
- im Lieferumfang enthalten: zusätzliche gefederte Zentrierspitze mit 57 mm *(2,224 Zoll)* Durchmesser für HSK 63/80/100 und Capto C8 SSC5700 Teilenr. 02208620

Weitere Informationen hierzu erhalten Sie von Ihrem zuständigen Seco Tools Ansprechpartner.

Einstellvorrichtung – Kompakt

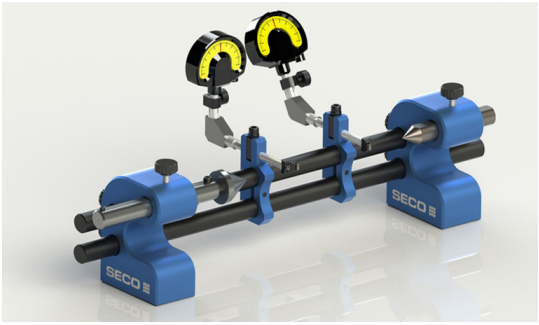
SF-60200-C160: Bezeichnung 02885395

- Horizontales Gestell
- Erste Wahl für Durchmesser kleiner als 60 mm *(2,362")*
- 1 Messuhr
- Maximaler Werkzeugdurchmesser: 60,5 mm *(82.382")*
- Maximale Werkzeuglänge: 200 mm *(7.874")*



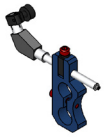
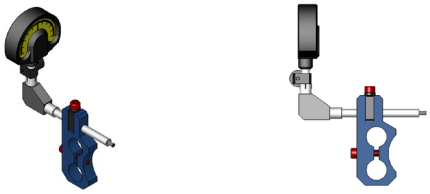
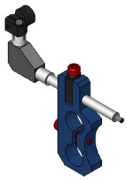
SF-60200-C160C190: Bezeichnung 02885396

- Horizontales Gestell
- Erste Wahl für Durchmesser kleiner als 60 mm *(2,362")*
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 60,5 mm *(82.382")*
- Maximale Werkzeuglänge: 200 mm *(7.874")*

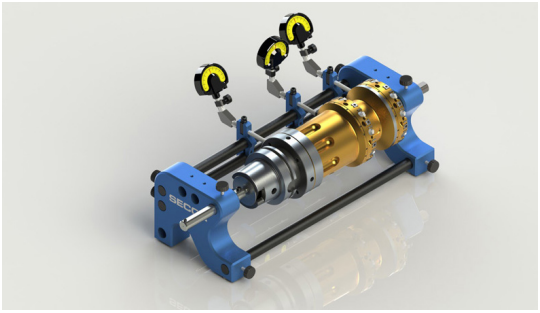


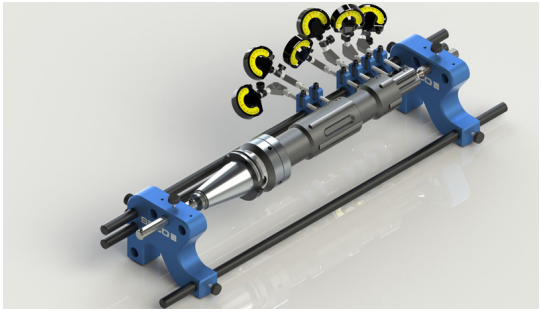
Weitere Informationen hierzu erhalten Sie von Ihrem zuständigen Seco Tools Ansprechpartner.

Zusätzliche Messfühler

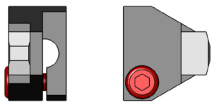
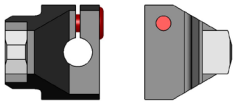
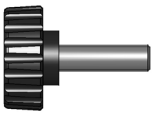
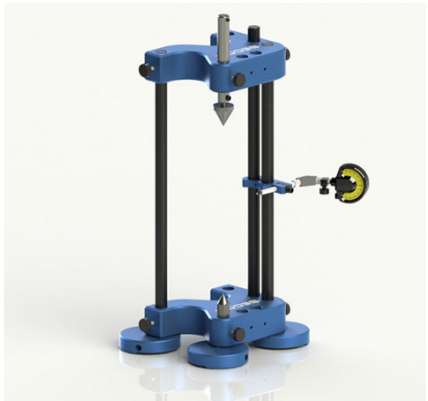
	SFB-60: Bezeichnung 02208619 – Gewinkelter Halter 60° – Messuhr im Lieferumfang enthalten – Messtaster nicht im Lieferumfang enthalten, siehe Seite 477
	**SFB-60 WC: Bezeichnung 02885754** – Gewinkelter Halter 60° – Messuhr und Messtaster nicht im Lieferumfang enthalten, siehe Seite 477
	**SFB-90: Bezeichnung 02208622** – Gewinkelter Halter 90° – Messuhr im Lieferumfang enthalten – Messtaster nicht im Lieferumfang enthalten, siehe Seite 477
	**SFB-90 WC: Bezeichnung 02885755** – Gewinkelter Halter 90° – Messuhr und Messtaster nicht im Lieferumfang enthalten, siehe Seite 477
	DG-1: Bezeichnung 75079579 – Messuhr, 1 µm *(39 µin)*

Beispiele von Einstellvorrichtungen mit mehreren Messuhren

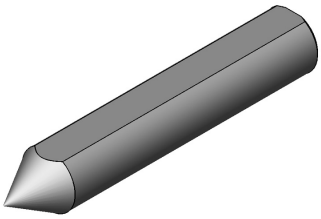
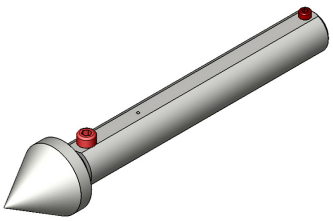
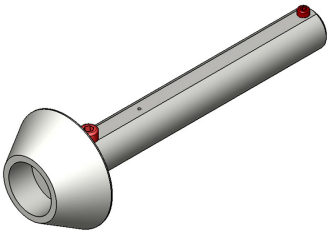




Zubehör

	SMES-406: Bezeichnung 02819156 – Messpunkt für Xfix-Reibahlen – Durchmesser 4 mm *(0,157")* – Hartmetall-Spitze
	**SMES-900: Bezeichnung 02208610** – Messpunkt für Bifix-Reibahlen – Hartmetall-Spitze
	**SMES-909: Bezeichnung 02980090** – Messpunkt für Bifix-Reibahlen – Hartmetall-Spitze – Versatz 9 mm *(0.354")*
	**SFHS-20: Bezeichnung 02884025** – Handschraube – Geeignet für alle Einstellgeräte
	**SFVST- 100: Bezeichnung 02884026** – Stahlhalterung (3 Stück) – 100 mm *(3.937")*Durchmesser – Geeignet um horizontale Einstellgeräte vertikal zu nutzen

Zentrierspitzen

SFC-2000HM: Bezeichnung 02884023 – Vollhartmetall-Zentrierspitze – Durchmesser 20 mm *(0.787")* – Geeignet für Xfix, Precifix und Bifix (Standardprodukte und Sonderlösungen) – Für die Werkzeugvorderseite	
SSC-3400: Bezeichnung 02208617 – Gefederte Zentrierspitze – Durchmesser 34 mm *(1,339")* – Geeignet für Xfix und Bifix (Standardprodukte und Sonderlösungen) – Für die Werkzeugrückseite – Nicht geeignet für HSK63/80/100 und Capto C8	
SSC5700: Bezeichnung 02208620 – Gefederte Zentrierspitze – Kegelstumpf-Durchmesser 57 mm *(2,244")* – Geeignet für Xfix und Bifix (Standardprodukte und Sonderlösungen) – Für die Werkzeugrückseite – Geeignet für HSK63/80/100 und Capto C8	

Übersicht

RB750 Ausdrehköpfe, Schruppausdrehen

Doppelschneider mit integriertem Kupplungsmechanismus für Wendeschneidplatten-Halter

Seite(n) 485-491

- Hohe Zeitspanvolumen, präzise Bohrungsgeometrie und Bohrungsposition
- Symmetrische oder asymmetrische Positionierung
- Symmetrische Einstellung der Wendeschneidplatten-Halter durch Kupplungsmechanismus
- Mit Graflex® oder Seco Capto™-Anschluss

Durchmesserbereich 18 bis 205 mm
(0.709 bis 8.071")

IT 9/10

RB610 Ausdrehköpfe, Schruppausdrehen

Doppelschneider, kurze Längen

Seite(n) 497-500

- Hohe Zeitspanvolumen, präzise Bohrungsgeometrie und geometrische Position
- Sowohl symmetrische als auch asymmetrische Position der Wendeschneidplatten-Halter möglich
- Mit Graflex®-Anschluss für das modulare Graflex®-System
- Mit GL- oder BA-Anschluss für Steadyline® schwingungsdämpfende Aufnahmen

Durchmesserbereich von 28 mm bis 116 mm
(1.102 bis 4.567")

IT 9/10

FB760 Ausdrehköpfe, Typ Axiabore™, Feinausdrehen

Feinausdrehköpfe für axiale Werkzeuge

Seite(n) 506-524

- Mikrometrische Einstellungen für hohe Präzision ab IT5
- Hohe Werkzeugsteifigkeit für präzise Bohrungsgeometrie und geometrische Position
- Nanobore™ Ausdrehkopf für kleinere Durchmesser
- Axialibrabore™ und Axialibrabore™ Plus sind feinauswuchtbar, geeignet für HSM
- Vielzweck-Adapter (MPA) für größere Ausdrehdurchmesser, Zapfendrehen und Nutstechen
- Mit Graflex® oder Seco Capto™-Anschluss
- Auch als digitale Version erhältlich, für eine einfache und schnelle Einstellung des Durchmessers

Durchmesserbereich 0,3 bis 108 mm
(0.012 bis 4.252")

sowie Zapfendrehen und Nutstechen

IT 5/6

Graflex® und Seco Capto™

Grundaufnahmen, Verlängerungen und Reduzierstücke der Reihen Graflex® und Seco Capto™ zum Bau von Bohrstangen

Seite(n) 598-649

- Bohrstangenbaugruppen können schnell zusammengebaut werden, um die Anforderungen möglichst genau zu erfüllen, mit den modularen Systemen Graflex oder Seco Capto™, einschließlich einer Vielzahl von Grundaufnahmen und Zwischenelementen.
- Beide Systeme bieten einen starren und präzisen Anschluss zum Schruppen oder Schlichten von Bohrungen.
- Die Module können auch eine große Anzahl von Werkzeughaltern wie Spannzangenfutter, Hydrospannfutter usw. aufnehmen (siehe Katalog Werkzeug-Systeme).

Übersicht

FB780, FB790, FB620 Feinausdrehköpfe, radial

Feinausdrehköpfe mit radialen Wendeplattenhaltern

Seite(n) 543-551

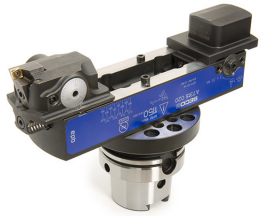
- Mikrometrische Einstellungen für hohe Präzision bei einem Durchmesser von 2,5 Mikrometern bis IT 5
- Präzise Bohrungsgeometrie und geometrische Position
- Libraflex® Ausdrehköpfe A790 sind feinauswuchtbar, für Hochgeschwindigkeitsbearbeitungen
- Bohrungen (bis zu 7 x D) mit Hartmetall-Verlängerungen oder Steadyline®-Bohrstangen (bis zu 10 x D)
- Auch zum Anfasen und Rückwärtssenken
- Mit Graflex® oder Seco Capto™-Anschluss für modulare Systeme
- Mit GL- oder BA-Anschluss für Steadyline® schwingungsdämpfende Aufnahmen

Durchmesserbereich 15 bis 205 mm
(0.591 bis 8.071")

IT 5 und IT 6

BB731S Brückenwerkzeuge und JBB731S Jumbo Brückenwerkzeuge, BB732 Brückenwerkzeuge für Steadyline®

Zum Schrupp- und Feinausdrehen großer Durchmesser



Seite(n) 553-570

BB731S & JBB731S:

- Ausdrehblöcke verfügbar zum Schrupp- und Feinausdrehen, Zapfendrehen und Rückwärtssenken
- Stabile Ausführung für hohe Zeitspanvolumen beim Schruppausdrehen
- Einstellung über Mikrometer-Spindel zum Feinausdrehen
- Optimierte Ausdrehblock-Ausführung und Jumbo-Brückenwerkzeuge aus hochfestem Aluminium für hohe Geschwindigkeiten
- Zur Montage auf Fräsaufnahmen, Typ Flanschbefestigung

BB732:

- für den Einsatz mit Steadyline® Aufnahmen für Aufsteckfräser für tiefes Bohren ausgelegt, bessere Oberflächengüte, höhere Produktivität und längere Standzeit beim tiefen Bohren mit großen Durchmessern
- Durchmesserbereich von 114-300 mm (4,488-11,811") beim Schruppen und 315 mm (12,402") beim Schlichten

Durchmesserbereich 204 bis 3205 mm
(8.031-126.181")

IT 5/6 (zum Feinausdrehen) oder 9/10 (zum Schrup-pausdrehen)
+ Zapfendrehen

IT6

Durchmesserbereich 114 bis 315 mm
(4.488-12,402")

Wendeschneidplatten zum Ausdrehen

Seite(n) 584-596

- Zum Ausdrehen in allen Werkstoffen
- Hohe Zähigkeit für Schruppbearbeitungen
- Positive Geometrien zum Feinausdrehen
- Sortenauswahl für hohe Standzeit

Graflex® oder Seco Capto™ modulares Aufnahmesystem

Seite(n) 597-599

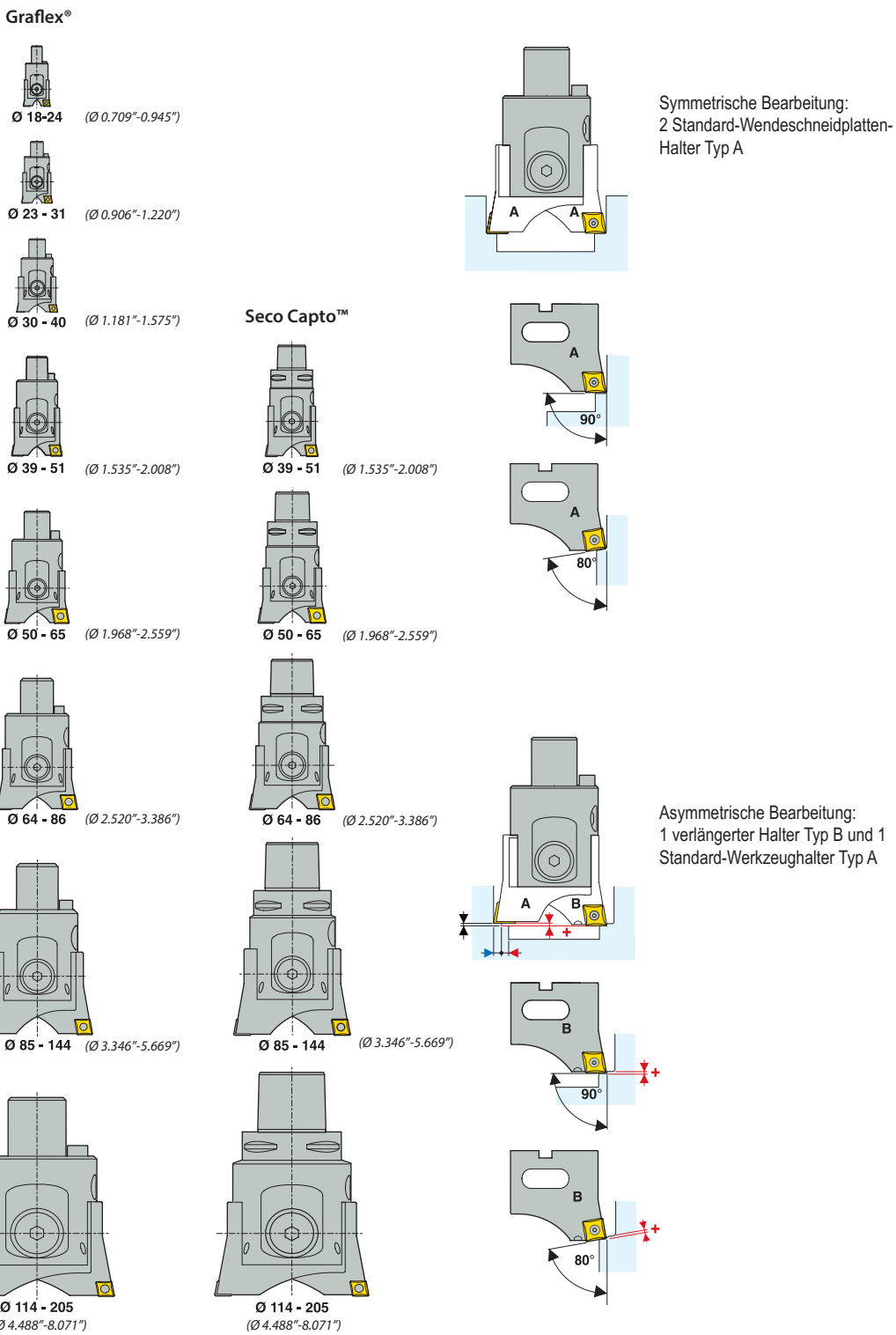
- Alle Ausdrehköpfe haben einen Graflex®- oder einen Seco Capto™-Anschluss und sind daher äußerst flexibel einsetzbar. Sie eignen sich für eine Vielzahl von Ausdrehtiefen und -durchmessern.
- Wählen Sie die gewünschten Graflex®- oder Seco Capto™-Aufsteckhalter und Zwischenelemente aus (HSK, DIN, BT, ANSI-CAT, Seco Capto™)
- Ersatzteile für Graflex®-Anschlüsse sind im entsprechenden Kapitel zu finden

Schruppausdrehen

Das Programm an Schruppausdrehwerkzeugen von Seco erhöht Zeitspanvolumen und Genauigkeit mit starker, steifer Leistung. Ausgelegt für symmetrische und asymmetrische Bearbeitung. Schwingungsdämpfende Steadyline™-Lösungen vervollständigen das Programm für noch mehr Stabilität in tiefen Kavitäten und mit großen Auskragungen.

- RB 750 Schruppausdrehköpfe bieten höchste Schruppleistung
- RB 610 Schruppausdrehköpfe sind kurze, einfache und robuste Ausdrehköpfe zum Schruppen

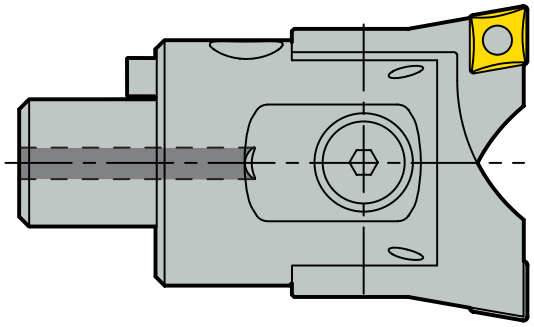
Übersicht Schruppausdrehköpfe



Merkmale

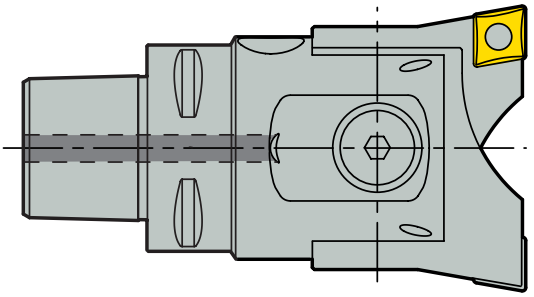
Graflex® Schruppausdrehköpfe

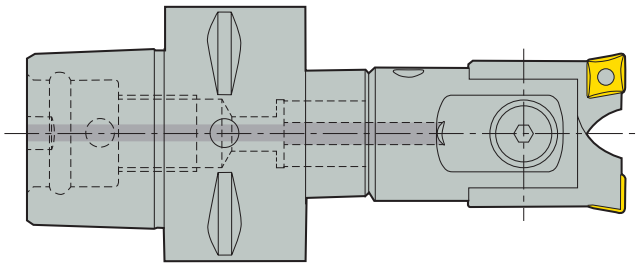
– Durchmesserbereich von 18 bis 205 mm *(0.709-8.071")*
– 8 Schruppausdrehköpfe RB 750 mit Graflex® Anschluss für Bohrungen im Durchmesser von 18 bis 205 mm *(0.709-8.071")*



Seco Capto™ Schruppausdrehköpfe

– **Hinweis:** Der kleinste Durchmesser, der mit dem kleinsten Seco-Capto™-C3-Schruppausdrehkopf zu erzielen ist, beträgt 39 mm *(1.535")* Durchmesser.
– Für Durchmesser von 18 bis 40 mm *(0.709-1.575")* Graflex®-Ausdrehköpfe mit Anschlussgröße G0 bis G2 in Verbindung mit dem passenden Seco-Capto™/Graflex® Adapter einsetzen.
– **Hinweis:** Merkmale, Empfehlungen (Montagehinweise, Durchmessereinstellung, Empfehlungen zum Rückwärtssenken, Herausforderungen, Bearbeitungs- und Schnittdatenempfehlungen), geeignete Wendeschneidplatten-Halter und Wendeschneidplatten sind identisch für beide RB 750 Schruppausdrehkopf-Typen, die ungeachtet des Anschlusses denselben Ausdrehbereich aufweisen.
– Modulare Verbünde und Zerspanungsbedingungen für Seco Capto™ und Graflex®-Adapter und modulare Erweiterungen: siehe Katalog Werkzeug-Systeme



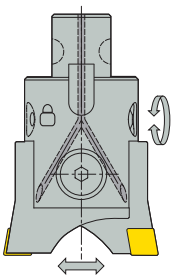


Merkmale

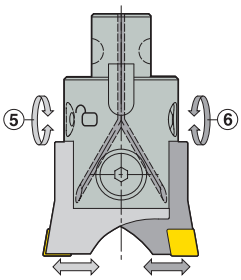
Ein Schruppausdrehwerkzeug besteht aus einem Werkzeugkörper (Kopf) und zwei Wendeschneidplatten-Haltern.

Eine symmetrische oder asymmetrische Einstellung der Wendeschneidplatten-Halter ist möglich:

Der Wendeschneidplatten-Halter wird durch einen Kupplungsmechanismus symmetrisch eingestellt (nicht beim kleinsten Kopf 18 bis 24 mm *(0,709-0,9445")*. Hierbei werden beide Wendeschneidplatten-Halter gleichzeitig durch den Verzahnungsmechanismus der Einstellschrauben eingestellt. Eine Durchmessereinstellung ist ohne Voreinstellung möglich (Einstellung = 0,1 mm *(0.004")* auf den Durchmesser). Den Verzahnungsmechanismus lösen, so dass jede Einstellschraube nur einen Wendeschneidplatten-Halter einstellt.



Symmetrisch eingestellt



Asymmetrisch eingestellt

Symmetrische Bearbeitung:

Bei der symmetrischen Bearbeitung werden beide Schneiden auf den selben Durchmesser eingestellt. Hierfür sind zwei identische Standard-Wendeschneidplatten-Halter Typ A (mit identischem Einstellwinkel) erforderlich.

Asymmetrische Bearbeitung:

Asymmetrische Bearbeitung heißt, dass eine Schneide als Vorschneider auf einen kleineren Durchmesser eingestellt wird als die zweite Schneide (Einstellung auf den Fertigdurchmesser). Hierfür benötigt man einen Standard-Werkzeughalter Typ A und einen verlängerten Werkzeughalter Typ B, mit dem der erforderliche (+) axiale Versatz erzielt wird.

Wendeplattenhalter mit 90° oder 80° Einstellwinkel

A75…CC… und A75…CP… Wendeschneidplatten-Halter haben einen Einstellwinkel von 90° für rhombische Wendeschneidplatten, für Grundlochbohrungen und für geringe Anforderungen an die Maschinenspindelleistung.
A75…SC… Wendeschneidplatten-Halter haben einen 80° Einstellwinkel für quadratische Wendeschneidplatten, für Durchgangsbohrungen und Hochleistungsbearbeitungen.
Die Schneidenausrichtung entspricht der ISO-Norm.

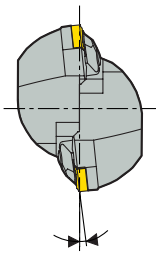
Wendeplattenhalter-Typ CC, CP, SC oder CN

A750...CC..., A750...CP... und A750...SC... Wendeschneidplatten-Halter haben einen Spanwinkel von 0° (GAMO) und einen Neigungswinkel von 0° (LAMS).

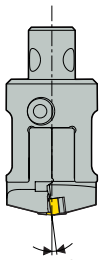
A750...CN... Wendeschneidplatten-Halter haben einen Spanwinkel von -6° (GAMO) und einen Neigungswinkel von -6° (LAMS) und ermöglichen daher den Einsatz von negativen CNMM-Wendeschneidplatten und insbesondere die Verwendung der CNMG-Wendeschneidplatten mit 4 Schneidkanten.

In diesem Fall ist die Wahl der empfohlenen CN...-Wendeschneidplatte und die Einhaltung der Schnittdatenempfehlungen (siehe Seite 588) besonders wichtig.

Die Verwendung anderer Wendeschneidplatten, z. B. mit kleinerem effektiven Spanwinkel und/oder falschen Schnittdaten, kann zu hohen Belastungen während der Zerspanung und damit zu Beschädigungen an Maschine oder Werkstück führen.

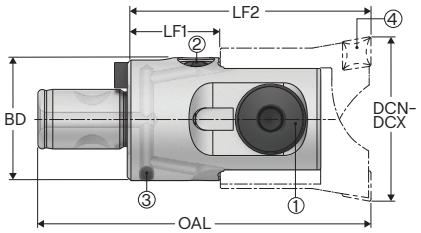


GAMO



LAMS

RB750
Graflex®

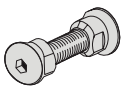


1. Schraube
2. Einstellschraube
3. Spannschraube des Kupplungsmechanismus
4. Schraube für WSP

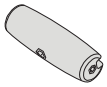
–Symmetrische oder asymmetrische Einstellung ist möglich
–Gleichzeitige Einstellung durch den Kupplungsmechanismus der Wendeplattenhalter

Bezeichnung	Produkt-nummer	Maschinen-seite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Symmetrische Einstellung		Asymmetrische Einstellung		Max. Dreh-zahl
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Ja	Nein	Ja	Nein	
A75000	00026687	G0	18,0 *0.709*	24,0 *0.945*	38,0 *1.496*	12,5 *0.492*	35,0 *1.378*	16,5 *0.650*	0,1 *0.220*		■	■		15000
A75010	00026688	G1	23,0 *0.906*	31,0 *1.220*	42,5 *1.673*	13,5 *0.531*	40,0 *1.575*	21,5 *0.846*	0,1 *0.220*	■		■		12000
A75020	00026689	G2	30,0 *1.181*	40,0 *1.575*	51,0 *2.008*	16,0 *0.630*	46,0 *1.811*	27,0 *1.063*	0,2 *0.440*	■		■		9500
A75030	00026690	G3	39,0 *1.535*	51,0 *2.008*	69,0 *2.717*	24,0 *0.945*	65,0 *2.559*	35,0 *1.378*	0,3 *0.660*	■		■		7500
A75040	00026691	G4	50,0 *1.969*	65,0 *2.559*	78,0 *3.071*	27,0 *1.063*	72,0 *2.835*	43,0 *1.693*	0,5 *1.100*	■		■		5700
A75050	00026692	G5	64,0 *2.520*	86,0 *3.386*	92,0 *3.622*	30,0 *1.181*	82,0 *3.228*	54,0 *2.126*	0,9 *1.980*	■		■		4500
A75060	00026693	G6	85,0 *3.346*	144,0 *5.669*	119,0 *4.685*	37,0 *1.457*	105,0 *4.134*	70,0 *2.756*	1,8 *3.970*	■		■		3500
A75070	00026694	G7	114,0 *4.488*	205,0 *8.071*	143,0 *5.630*	39,0 *1.535*	120,0 *4.724*	95,0 *3.740*	3,7 *8.160*	■		■		2500

Ersatzteile, im Lieferumfang enthalten

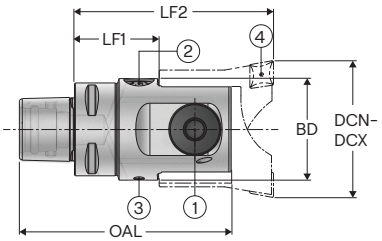
Für Kopf	Schraube	Mitnehmer
		
A75000	90A75000	90M0
A75010	90A75010	90M11
A75020	90A75020	90M21
A75030	90A75030	90M31
A75040	90A75040	90M41
A75050	90A75050	90M51
A75060	90A75060	90M61
A75070	90A75070	90M71

Zubehör

Für Kopf	Schlüssel für Pratze	Antriebsschlüssel	Schlüssel für WSP	Schlüssel (Quergriff)	Einstell-schlüssel
					
A75000	03HL03	–	H4B-T07P	DOUBLE-T	H1.5-2D
A75010	03HL03	H4B-T06P	H4B-T07P	DOUBLE-T	H1.5-2D
A75020	03HL04	H4B-T07P	–	DOUBLE-T	H2.0-2D
A75030	03HL05	H4B-T08P	–	DOUBLE-T	H2.0-2D
A75040	03HL05	H4B-T09P	–	DOUBLE-T	H2.5-2D
A75050	03HL06	–	–	DOUBLE-T	03M03C
A75060	03HL08	–	–	DOUBLE-T	H04-4
A75070	03HL10	H4B-T15P	H4B-T15PL	DOUBLE-T	H04-4

RB750

Seco Capto™

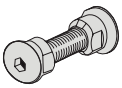


1. Schraube
2. Einstellschraube
3. Spannschraube des Kupplungsmechanismus
4. Schraube für WSP

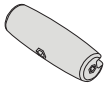
–Symmetrische oder asymmetrische Einstellung ist möglich
–Gleichzeitige Einstellung durch den Kupplungsmechanismus der Wendeplattenhalter

Bezeichnung	Produkt-nummer	Maschinen-seite	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Symmetrische Einstellung		Asymmetrische Einstellung		Max. Dreh-zahl
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Ja	Nein	Ja	Nein	
C3-391.0750-30	02809726	C3	39,0 *1.535*	51,0 *2.008*	73,0 *2.874*	29,0 *1.142*	70,0 *2.756*	35,0 *1.378*	0,3 *0.660*	■		■		7500
C4-391.0750-40	02809728	C4	50,0 *1.969*	65,0 *2.559*	88,0 *3.465*	37,0 *1.457*	82,0 *3.228*	43,0 *1.693*	0,6 *1.320*	■		■		5700
C5-391.0750-50	02809733	C5	64,0 *2.520*	86,0 *3.386*	102,0 *4.016*	40,0 *1.575*	92,0 *3.622*	54,0 *2.126*	1,0 *2.200*	■		■		4500
C6-391.0750-60	02809735	C6	85,0 *3.346*	144,0 *5.669*	129,0 *5.079*	49,0 *1.929*	117,0 *4.606*	70,0 *2.756*	1,9 *4.190*	■		■		3500
C8-391.0750-70	02809736	C8	114,0 *4.488*	205,0 *8.071*	159,0 *6.260*	57,0 *2.244*	138,0 *5.433*	95,0 *3.740*	4,1 *9.040*	■		■		2500

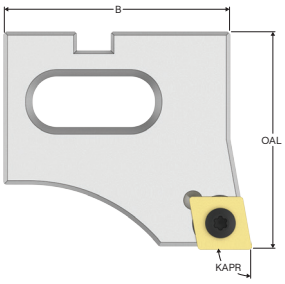
Ersatzteile, im Lieferumfang enthalten

Für Kopf	Schraube
	
C3-...-30	90A75030
C4-...-40	90A75040
C5-...-50	90A75050
C6-...-60	90A75060
C8-...-70	90A75070

Zubehör

Für Kopf	Schlüssel für Pratze	Antriebsschlüssel	Schlüssel (Quergriff)	Einstell-schlüssel
				
C3-...-30	03HL05	H4B-T08P	DOUBLE-T	H2.0-2D
C4-...-40	03HL05	H4B-T09P	DOUBLE-T	H2.5-2D
C5-...-50	03HL06	–	DOUBLE-T	03M03C
C6-...-60	03HL08	–	DOUBLE-T	H04-4
C8-...-70	03HL10	–	DOUBLE-T	H04-4

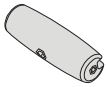
Wendeplattenhalter 90° für Wendeplatten CC.. und CP..



- Für Schruppausdrehköpfe RB 750
- Für das symmetrische Ausdrehen sind zwei normale Wendeplattenhalter vom Typ A erforderlich.
- Für den versetzten Einsatz sind zwei Wendeplattenhalter erforderlich: ein normaler vom Typ A und ein verlängerter vom Typ B.

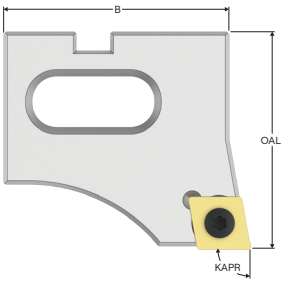
Bezeichnung	Produktnummer	WSP-Halter Typ	Für Kopf	Bereich DCN-DCX ∅		OAL	B	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
A75000CP0590	00026695	Standard Typ A	RB 75000	18,0 *0.709*	24,0 *0.945*	22,5 *0.886*	16,5 *0.650*	0,1 *0.2*	90	CP...0502...
A75010CC0690	00026696	Standard Typ A	RB 75010	23,0 *0.906*	31,0 *1.220*	26,5 *1.043*	21,5 *0.846*	0,1 *0.2*	90	CC...0602...
A75020CC0690	00026697	Standard Typ A	RB 75020	30,0 *1.181*	40,0 *1.575*	30,0 *1.181*	27,0 *1.063*	0,1 *0.2*	90	CC...0602...
A75030CC0990	00026698	Standard Typ A	RB 75030	39,0 *1.535*	51,0 *2.008*	41,0 *1.614*	35,0 *1.378*	0,1 *0.2*	90	CC...09T3...
A75040CC1290	00026699	Standard Typ A	RB 75040	50,0 *1.969*	65,0 *2.559*	45,0 *1.772*	43,0 *1.693*	0,2 *0.4*	90	CC...1204...
A75050CC1290	00026700	Standard Typ A	RB 75050	64,0 *2.520*	86,0 *3.386*	52,0 *2.047*	54,0 *2.126*	0,3 *0.7*	90	CC...1204...
A75060CC1290	00026701	Standard Typ A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,6 *1.3*	90	CC...1204...
A75060CC1690	00030763	Standard Typ A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,6 *1.3*	90	CC...1605...
A75065CC1290	00026702	Standard Typ A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	0,9 *2.0*	90	CC...1204...
A75065CC1690	00030765	Standard Typ A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	0,9 *2.0*	90	CC...1605...
A75070CC1290	00026703	Standard Typ A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,0 *3.189*	95,0 *3.740*	1,2 *2.7*	90	CC...1204...
A75070CC1690	00030766	Standard Typ A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,0 *3.189*	95,0 *3.740*	1,2 *2.7*	90	CC...1605...
A75075CC1290	00026704	Standard Typ A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,0 *3.189*	141,0 *5.551*	2,0 *4.4*	90	CC...1204...
A75075CC1690	00030771	Standard Typ A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,0 *3.189*	141,0 *5.551*	2,0 *4.4*	90	CC...1605...

Ersatzteile, im Lieferumfang enthalten

Für WSP	Schlüssel für WSP	Schlüssel (Quergriff)	Schraube
			
CC...0602...	H4B-T07P	DOUBLE-T	C02504-T07P
CC...09T3...	H4B-T15P	DOUBLE-T	C04008-T15P
CC...1204...	H4B-T15P	DOUBLE-T	C05012-T15P
CC...1605...	H4B-T15P	DOUBLE-T	C05012-T15P
CP...0502...	H4B-T07P	DOUBLE-T	C02245-T07P

Zum Schrupp-Ausdrehen empfohlene Wendeplatten siehe Seite(n) 588

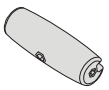
Wendeplattenhalter 90° für Wendeplatten CC.. und CP..



- Für Schruppausdrehköpfe RB 750
- Für das symmetrische Ausdrehen sind zwei normale Wendeplattenhalter vom Typ A erforderlich.
- Für den versetzten Einsatz sind zwei Wendeplattenhalter erforderlich: ein normaler vom Typ A und ein verlängerter vom Typ B.

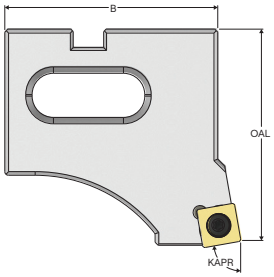
Bezeichnung	Produktnummer	WSP-Halter Typ	Für Kopf	Bereich DCN-DCX ∅		OAL	B	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
A75001CP0590	00026705	Weit Typ B	RB 75000	18,0 *0.709*	24,0 *0.945*	22,8 *0.898*	16,5 *0.650*	0,1 *0.2*	90	CP...0502...
A75011CC0690	00026706	Weit Typ B	RB 75010	23,0 *0.906*	31,0 *1.220*	26,85 *1.057*	21,5 *0.846*	0,1 *0.2*	90	CC...0602...
A75021CC0690	00026707	Weit Typ B	RB 75020	30,0 *1.181*	40,0 *1.575*	30,35 *1.195*	27,0 *1.063*	0,1 *0.2*	90	CC...0602...
A75031CC0990	00026708	Weit Typ B	RB 75030	39,0 *1.535*	51,0 *2.008*	41,4 *1.630*	35,0 *1.378*	0,1 *0.2*	90	CC...09T3...
A75041CC1290	00026709	Weit Typ B	RB 75040	50,0 *1.969*	65,0 *2.559*	46,5 *1.831*	43,0 *1.693*	0,2 *0.4*	90	CC...1204...
A75051CC1290	00026710	Weit Typ B	RB 75050	64,0 *2.520*	86,0 *3.386*	52,6 *2.071*	54,0 *2.126*	0,25 *0.6*	90	CC...1204...
A75061CC1290	00026711	Weit Typ B	RB 75060	85,0 *3.346*	115,0 *4.528*	68,6 *2.701*	70,0 *2.756*	0,6 *1.3*	90	CC...1204...
A75061CC1690	00030774	Weit Typ B	RB 75060	85,0 *3.346*	115,0 *4.528*	68,6 *2.701*	70,0 *2.756*	0,6 *1.3*	90	CC...1605...
A75066CC1290	00026712	Weit Typ B	RB 75060	114,0 *4.488*	144,0 *5.669*	68,6 *2.701*	100,0 *3.937*	1,0 *2.2*	90	CC...1204...
A75066CC1690	00030775	Weit Typ B	RB 75060	114,0 *4.488*	144,0 *5.669*	68,6 *2.701*	100,0 *3.937*	0,91 *2.0*	90	CC...1605...
A75071CC1290	00026713	Weit Typ B	RB 75070	114,0 *4.488*	160,0 *6.299*	81,6 *3.213*	95,0 *3.740*	1,2 *2.7*	90	CC...1204...
A75071CC1690	00030776	Weit Typ B	RB 75070	114,0 *4.488*	160,0 *6.299*	81,6 *3.213*	95,0 *3.740*	1,16 *2.6*	90	CC...1605...
A75076CC1290	00026714	Weit Typ B	RB 75070	159,0 *6.260*	205,0 *8.071*	81,6 *3.213*	141,0 *5.551*	2,0 *4.4*	90	CC...1204...
A75076CC1690	00030778	Weit Typ B	RB 75070	159,0 *6.260*	205,0 *8.071*	81,6 *3.213*	141,0 *5.551*	0,9 *2.0*	90	CC...1605...

Ersatzteile, im Lieferumfang enthalten

Für WSP	Schlüssel (Quergriff)	Schlüssel	Schraube
			
CC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
CC...09T3...	DOUBLE-T	H6B-T15P	C04008-T15P
CC...1204...	DOUBLE-T	H6B-T15P	C05012-T15P
CC...1605...	DOUBLE-T	H6B-T15P	C05012-T15P
CP...0502...	DOUBLE-T	H4B-T07P	C02245-T07P

Zum Schrupp-Ausdrehen empfohlene Wendeplatten siehe Seite(n) 588

Wendeplattenhalter 80° für Wendeplatten SC..

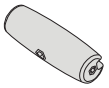


- Für Schruppausdrehköpfe RB 750
- Für das symmetrische Ausdrehen sind zwei normale Wendeplattenhalter vom Typ A erforderlich.
- Für den versetzten Einsatz sind zwei Wendeplattenhalter erforderlich: ein normaler vom Typ A und ein verlängerter vom Typ B.

Bezeichnung	Produktnummer	WSP-Halter Typ	Für Kopf	Bereich DCN-DCX ∅		OAL	B	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
A75000SC0580	00026715	Standard Typ A	RB 75000	18,0 *0.709*	24,0 *0.945*	22,5 *0.886*	16,5 *0.650*	0,1 *0.2*	80	SC...0502...
A75010SC0680	00026716	Standard Typ A	RB 75010	23,0 *0.906*	31,0 *1.220*	26,5 *1.043*	21,5 *0.846*	0,1 *0.2*	80	SC...0602...
A75020SC0680	00026717	Standard Typ A	RB 75020	30,0 *1.181*	40,0 *1.575*	30,0 *1.181*	27,0 *1.063*	0,1 *0.2*	80	SC...0602...
A75030SC0980	00026718	Standard Typ A	RB 75030	39,0 *1.535*	51,0 *2.008*	41,0 *1.614*	35,0 *1.378*	0,1 *0.2*	80	SC...09T3...
A75040SC1280	00026719	Standard Typ A	RB 75040	50,0 *1.969*	65,0 *2.559*	45,0 *1.772*	43,0 *1.693*	0,2 *0.4*	80	SC...1204...
A75050SC1280	00051986	Standard Typ A	RB 75050	64,0 *2.520*	86,0 *3.386*	52,0 *2.047*	54,0 *2.126*	0,3 *0.7*	80	SC...1204...
A75060SC1280	00052207	Standard Typ A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,56 *1.2*	80	SC...1204...
A75060SC1580	00039863	Standard Typ A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,56 *1.2*	80	SC...1505...
A75065SC1280	00051989	Standard Typ A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	1,0 *2.2*	80	SC...1204...
A75065SC1580	00039865	Standard Typ A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	1,0 *2.2*	80	SC...1505...
A75070SC1280	00026723	Standard Typ A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,4 *3.205*	95,0 *3.740*	1,2 *2.7*	80	SC...1204...
A75070SC1580	00039867	Standard Typ A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,4 *3.205*	95,0 *3.740*	1,18 *2.6*	80	SC...1505...
A75075SC1280	00026724	Standard Typ A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,4 *3.205*	141,0 *5.551*	2,2 *4.9*	80	SC...1204...
A75075SC1580	00039869	Standard Typ A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,4 *3.205*	141,0 *5.551*	2,1 *4.6*	80	SC...1505...
A75001SC0580	00092946	Weit Typ B	RB 75000	18,0 *0.709*	24,0 *0.945*	23,2 *0.913*	16,5 *0.650*	0,01 *0.0*	80	SC...0502...
A75011SC0680	00092947	Weit Typ B	RB 75010	23,0 *0.906*	31,0 *1.220*	27,3 *1.075*	21,5 *0.846*	0,02 *0.0*	80	SC...0602...
A75021SC0680	00092948	Weit Typ B	RB 75020	30,0 *1.181*	40,0 *1.575*	30,9 *1.217*	27,0 *1.063*	0,04 *0.1*	80	SC...0602...
A75031SC0980	00092949	Weit Typ B	RB 75030	39,0 *1.535*	51,0 *2.008*	42,2 *1.661*	35,0 *1.378*	0,08 *0.2*	80	SC...09T3...
A75041SC1280	00092961	Weit Typ B	RB 75040	50,0 *1.969*	65,0 *2.559*	46,4 *1.827*	43,0 *1.693*	0,2 *0.4*	80	SC...1204...
A75051SC1280	00092962	Weit Typ B	RB 75050	64,0 *2.520*	86,0 *3.386*	53,7 *2.114*	54,0 *2.126*	0,3 *0.7*	80	SC...1204...
A75061SC1580	00039864	Weit Typ B	RB 75060	85,0 *3.346*	115,0 *4.528*	70,3 *2.768*	70,0 *2.756*	0,57 *1.3*	80	SC...1505...
A75061SC1280	00092963	Weit Typ B	RB 75060	85,0 *3.346*	115,0 *4.528*	69,8 *2.748*	70,0 *2.756*	0,57 *1.3*	80	SC...1204...
A75066SC1280	00092964	Weit Typ B	RB 75060	114,0 *4.488*	144,0 *5.669*	69,8 *2.748*	100,0 *3.937*	0,96 *2.1*	80	SC...1204...
A75066SC1580	00039866	Weit Typ B	RB 75060	114,0 *4.488*	144,0 *5.669*	70,3 *2.768*	100,0 *3.937*	0,96 *2.1*	80	SC...1505...
A75071SC1280	00092965	Weit Typ B	RB 75070	114,0 *4.488*	160,0 *6.299*	82,8 *3.260*	95,0 *3.740*	1,2 *2.7*	80	SC...1204...
A75071SC1580	00039868	Weit Typ B	RB 75070	114,0 *4.488*	160,0 *6.299*	83,3 *3.280*	95,0 *3.740*	1,21 *2.7*	80	SC...1505...

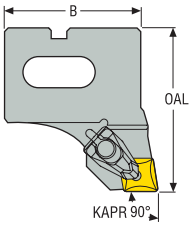
Bezeichnung	Produktnummer	WSP-Halter Typ	Für Kopf	Bereich DCN-DCX ∅		OAL	B	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
A75076SC1280	00092968	Weit Typ B	RB 75070	159,0 *6.260*	205,0 *8.071*	82,8 *3.260*	141,0 *5.551*	2,16 *4.8*	80	SC...1204...
A75076SC1580	00039870	Weit Typ B	RB 75070	159,0 *6.260*	205,0 *8.071*	83,3 *3.280*	141,0 *5.551*	2,14 *4.7*	80	SC...1505...

Ersatzteile, im Lieferumfang enthalten

Für WSP	Schlüssel (Quergriff)	Schlüssel	Schraube
			
SC...0502...	DOUBLE-T	H4B-T07P	C02245-T07P
SC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
SC...09T3...	DOUBLE-T	–	C04008-T15P
SC...09T3...	DOUBLE-T	H6B-T15P	C04008-T15P
SC...1204...	DOUBLE-T	H6B-T15P	C05012-T15P
SC...1204...	DOUBLE-T	H6B-T15PL	C05012-T15P
SC...1505...	DOUBLE-T	H6B-T15P	C05012-T15P

Zum Schrupp-Ausdrehen empfohlene Wendeplatten siehe Seite(n) 588

Wendeplattenhalter 90° für Wendeplatten CN..



- Für Schruppausdrehköpfe RB 750
- Zum symmetrischen Ausdrehen sind zwei normale Wendeplattenhalter vom Typ A erforderlich (verlängerte Wendeplattenhalter vom Typ B für CN..-Wendeschneidplatten nicht verfügbar)
- GAMO = Spanwinkel = - 6°
- LAMS = Neigungswinkel = - 6°

Bezeichnung	Produktnummer	WSP-Halter Typ	Für Kopf	Bereich DCN-DCX ∅		OAL	B	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
A75050CN1290	02786307	Standard Typ A	RB 75050	64,0 *2.520*	86,0 *3.386*	63,0 *2.480*	55,0 *2.165*	0,4 *0.9*	90	CN...1204...
A75060CN1290	02786308	Standard Typ A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	69,5 *2.736*	0,6 *1.3*	90	CN...1204...
A75065CN1290	02786309	Standard Typ A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	99,5 *3.917*	0,9 *2.0*	90	CN...1204...
A75070CN1290	02786310	Standard Typ A	RB 75070	114,0 *4.488*	160,0 *6.299*	85,0 *3.346*	95,0 *3.740*	1,2 *2.7*	90	CN...1204...
A75075CN1290	02786311	Standard Typ A	RB 75070	159,0 *6.260*	205,0 *8.071*	85,0 *3.346*	140,0 *5.512*	2,03 *4.5*	90	CN...1204...

Ersatzteile, im Lieferumfang enthalten

Für WSP	Schraube	Klemmkit	Auflageplatte	Schlüssel
CN...1204...	CSC6312-T15P	CD12-S12	UCN120612	H6B-T15P

Zum Schrupp-Ausdrehen empfohlene Wendeplatten siehe Seite(n) 588

Instruktionen
Empfehlungen zur Bearbeitung

Spindelleistung:

Da beim Schruppausdrehen eine hohe Maschinenleistung gefordert wird empfehlen wir, zu prüfen, ob die Maschine hierfür geeignet ist. Asymmetrische Bearbeitung reduziert den Leistungsbedarf, da der Vorschub für die gesamte Schnitttiefe im Vergleich zur symmetrischen Bearbeitung durch zwei dividiert wird.
Sie erreichen beste Ergebnisse mit interner Kühlschmierstoffzufuhr (höhere Schnittdaten, bessere Oberflächengüte, bessere Spanabfuhr, längere Standzeit der Wendeschneidplatten).

Weitere Details finden Sie in der Bedienungsanleitung, die mit der Steadyline®-Bohrstange geliefert wird.
Diese Gebrauchsanweisung steht auch auf www.secotools.com zum Download bereit.

Maximale Schnittgeschwindigkeit für Schruppausdrehköpfe

Kopf	Durchmesserbereich mm	*Kapazität ∅ Zoll*	Max. Drehzahl	Angenommene max. Schnittgeschwindigkeit v_c bei min. Deckelung. m/min *(sf/min)*	Angenommene max. Schnittgeschwindigkeit v_c bei max. Deckelung. m/min *(sf/min)*
Schrupp-Ausdrehköpfe (mit zwei identischen, symmetrisch eingestellten Wendeplattenhaltern), mit Graflex®-Anschluss					
A75000	18-24	*0.709-0.945*	15000	848 *(2782)*	1131 *(3711)*
A75010	23-31	*0.906-1.220*	12000	867 *(2844)*	1169 *(3835)*
A75020	30-40	*1.181-1.575*	9500	895 *(2936)*	1194 *(3917)*
A75030	39-51	*1.535-2.008*	7500	919 *(3015)*	1202 *(3944)*
A75040	50-65	*1.969-2.559*	5700	895 *(2936)*	1164 *(3819)*
A75050	64-86	*2.520-3.386*	4500	905 *(2969)*	1216 *(3990)*
A75060	85-115	*3.346-4.528*	3500	935 *(3068)*	1264 *(4147)*
A75060	114-144	*4.488-5.669*	2700	967 *(3173)*	1221 *(4006)*
A75070	114-160	*4.488-6.299*	2500	895 *(2936)*	1257 *(4124)*
A75070	159-205	*6.260-8.071*	2000	999 *(3278)*	1288 *(4226)*
Schrupp-Ausdrehköpfe (mit zwei identischen, symmetrisch eingestellten Wendeplattenhaltern), mit Seco Capto™ Anschluss					
C3-391.0750-30	39-51	*1.535-2.008*	7500	919 *(3015)*	1202 *(3944)*
C4-391.0750-40	50-65	*1.969-2.559*	5700	895 *(2936)*	1164 *(3819)*
C5-391.0750-50	64-86	*2.520-3.386*	4500	905 *(2969)*	1216 *(3990)*
C6-391.0750-60	85-115	*3.346-4.528*	3500	935 *(3068)*	1264 *(4147)*
C6-391.0750-60	114-144	*4.488-5.669*	2700	967 *(3173)*	1221 *(4006)*
C8-391.0750-70	114-160	*4.488-6.299*	2500	895 *(2936)*	1257 *(4124)*
C8-391.0750-70	159-205	*6.260-8.071*	2000	999 *(3278)*	1288 *(4226)*

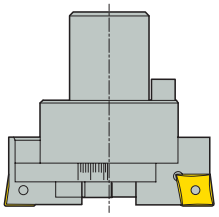
Hinweis: Die maximalen Geschwindigkeiten beziehen sich auf die mechanische Konstruktion und die Auswuchtqualität. Die Geschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Bearbeitungsbedingungen wie zu bearbeitenden Werkstoff, Schneidkante (Wendeschneidplatte), Werkzeuglänge und Maschinenspindel gewählt werden. Bei Geschwindigkeiten ab ca. 8000 U/min sollten die Grundaufnahmen und die Verlängerungen/Reduzierungen feinausgewuchtet sein.

Problembehandlung

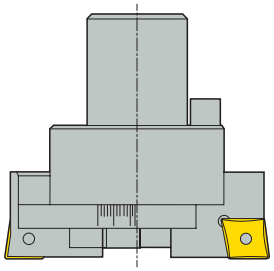
Position	Mögliche Ursache	Lösung
Keine Spankontrolle	Vorschub zu niedrig	Vorschub erhöhen
	Zu große Schnitttiefe	Versetzte Bearbeitung wählen
Rattern und Vibrationen	Zu hohe Geschwindigkeit	Geschwindigkeit, nicht Vorschub reduzieren
	Extremes Längen-Durchmesser-Verhältnis	Werkzeug kürzen, um Stabilität zu erhöhen
		Außendurchmesser der Aufnahme und des Zwischenstückes erhöhen
		Eine Steadyline-Bohrstange verwenden
		Hartmetall-Verlängerungen einsetzen
	Zu großer Wendeschneidplatten-Radius	Wendeschneidplatte mit kleinerem Radius verwenden
	Instabiles Werkstück	Klemmung verbessern
	Einstellwinkel k beträgt 80°	Winkel k =90° und CC..Wendeschneidplatte einsetzen
Abplatzungen oder Wendeschneidplattenbruch	Falsche Wendeschneidplatte	Zähere Sorte wählen
		Größeren Radius wählen, falls verfügbar
	Schwere Schnittunterbrechungen	Geschwindigkeit und Vorschub reduzieren
	Spänestau	Freiwinkel von Ausdrehwerkzeug/Bohrungsdurchmesser prüfen
		Spankontrolle verbessern, Vorschub erhöhen
Geringe Standzeit	Falsche Wendeschneidplatte	Verschleißfestere Sorte wählen
	Zu hohe Schnittgeschwindigkeit	Geschwindigkeit reduzieren
	Abplatzungen an der Wendeschneidplatte	Schnitttiefe und Vorschub prüfen
	Zu niedriger Kühlschmierstoffdruck	Kühlschmierstoffdruck erhöhen
Keine Späneabfuhr	Ausdrehwerkzeug zu lang	Wenn möglich, kleineren Kopf mit verlängerter Aufnahme wählen
	Zu große Schnitttiefe	Versetzte Bearbeitung wählen; CC..-WSP anstelle von CN.. -WSP einsetzen (besonders bei Einsatz der Ausdrehköpfe mit kleinen Durchmessern).
	Nicht genug Platz unterhalb der Bohrung	Werkstück höher aufspannen
	Keine Spankontrolle	Siehe oben
Zu schwache Maschinenleistung	Zu hoher Vorschub	Vorschub reduzieren (jedoch nicht auf unter 25% des WSP-Radius)
	Zu große Schnitttiefe	Versetzte Bearbeitung wählen
	Geringe Maschinenleistung	Drehzahl im Bereich niedriger Spindelleistung
		Drehzahl im Bereich Gangschaltung
		Höheren WSP-Spanwinkel (evtl. HSS) einsetzen
		Schnitttiefe reduzieren
Extreme Gratbildung am Bohrungsaustritt	Zu hoher Vorschub	Vorschub reduzieren
	Wendeschneidplatten-Halter Typ CC, 90°	80° Vierkant-WSP-Halter einsetzen
	Schnittkräfte zu hoch	Schnitttiefe reduzieren
		WSP-Radius reduzieren

RB 610 Schruppausdrehköpfe – Übersicht

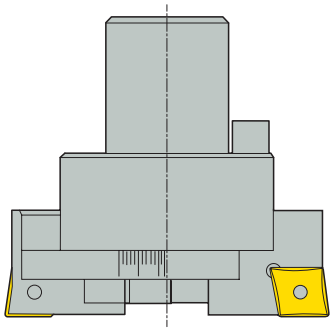
Graflex®-Anschluss



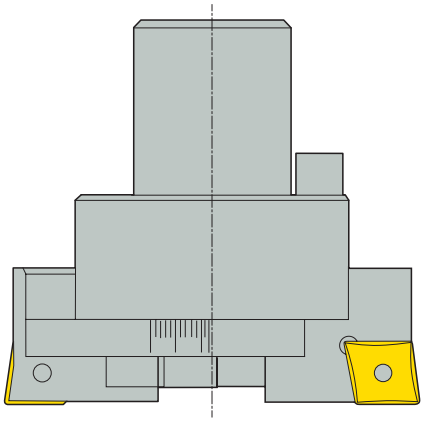
Ø 39–51 mm *(Ø 1.535–2.008")*



Ø 50–65 mm *(Ø 1.969–2.559")*

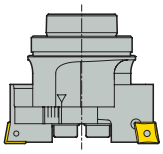


Ø 64–86 mm *(Ø 2.520–3.386")*

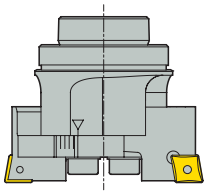


Ø 85–115 mm *(Ø 3.346–4.528")*

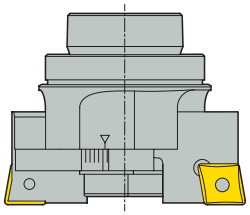
GL-Anschluss



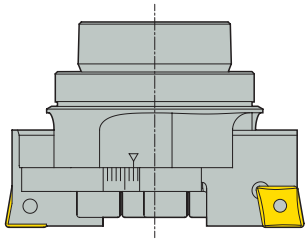
Ø 28–37 mm *(Ø 1.102–1.457")*



Ø 36–46 mm *(Ø 1.417–1.811")*

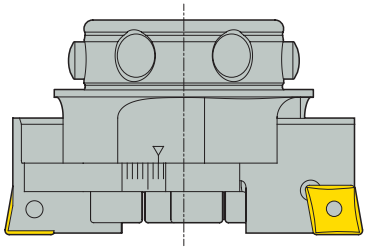


Ø 45–56 mm *(Ø 1.772–2.205")*

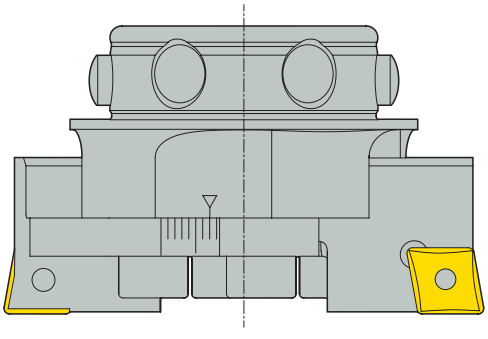


Ø 55–69 mm *(Ø 2.165–2.717")*

BA-Anschluss



Ø 66–88 mm *(Ø 2.598–3.465")*



Ø 86–116 mm *(Ø 3.386–4.567")*

RB 610 Schruppausdrehköpfe

Merkmale

– Ein Schruppausdrehkopf ist ein Verbund aus 1 Körper (Kopf) und 2 Wendeplattenhaltern
– Präzise Bohrungsgeometrie bei gegossenen oder vorgebohrten Bohrungen
– Geringe Unwucht dank der symmetrischen Ausführung

Kompaktes Design

– Kurzer Werkzeugkörper für mehr Steifigkeit.
– Beste Schwingungsdämpfung in Verbindung mit Steadyline®-Bohrstangen
– Geringes Gewicht für mehr Spindelbeschleunigung

Schnelle Einstellung

– Jeder Wendeschneidplatten-Halter hat einen Einstellmechanismus auf Druck und Zug, der eine einfache und schnelle Durchmessereinstellung mittels Voreinstellung erlaubt.
– Die Positionierung der Wendeschneidplatten-Halter ist durch die Durchmesser-Skalierung leicht erkennbar.

Wendeplattenhalter

– A610…CC… Wendeschneidplatten-Halter haben einen 90° Einstellwinkel für rhombische Wendeschneidplatten, 0° Spanwinkel und 0° Neigungswinkel.
– Die Wendeschneidplatten-Halter sind sowohl geeignet für RB 610 Graflex® als auch für RB 610 GL Schneidköpfe.

Produktivität

– Hohe Steifigkeit durch enge Passung der Wendeschneidplatten-Halter in den Körper und große Klemmschrauben.
– Die Schnitttiefe ap kann bis zur Hälfte der Wendeschneidplatten-Breite betragen. Dies ermöglicht eine Maximierung des Zeitspanvolumens und eine volle Nutzung der Wendeschneidplatten.
– Bei asymmetrischer Bearbeitung wird eine Unterlegscheibe verwendet (im Lieferumfang des Kopfes enthalten), die für den Versatz eines Wendeschneidplatten-Halters und damit für die Erhöhung oder die Teilung des radialen Versatzes sorgt.
– Verfügbar mit interner Kühlschmierstoffzufuhr direkt auf die Schneiden

Produktprogramm

– RB 610 Schruppausdrehköpfe sind mit der maschinenseitigen Schnittstelle Graflex® für allgemeine Bearbeitungen bis 6 x D erhältlich
– RB 610 Schruppausdrehköpfe mit maschinenseitige Schnittstellen GL und BA eignen sich für große Auskragungen mit der schwingungsdämpfenden Steadyline®-Aufnahme.

RB 610 Graflex®

– Graflex®: 4 kompakte Schruppausdrehköpfe für den Durchmesserbereich von 39 bis 115 mm *(1,535–4,528 Zoll)*
– Das flexible modulare Graflex®-System ermöglicht optimale Ausdrehkombinationen mit Graflex®-Adaptern, Zwischenelementen und Ausdrehköpfen.

RB 610 GL und BA für schwingungsdämpfende Steadyline®-Bohrstangen

GL

BA

– GL: 4 kurze und kompakte Schruppausdrehköpfe für den Durchmesserbereich von 28 bis 69 mm *(1.102 – 2.717")*
– BA: 2 kurze und kompakte Schruppausdrehköpfe für den Durchmesserbereich von 66 bis 116 mm *(2,598–4,567 Zoll)*
– Speziell geeignet für Steadyline®-Bohrstangen. Die Ausdreh-Ergebnisse beim Einsatz auf langen Steadyline®-Bohrstangen entsprechen denen auf nicht gedämpften, kürzeren Kombinationen (<6 x D).

RB 610 Schruppausdrehköpfe

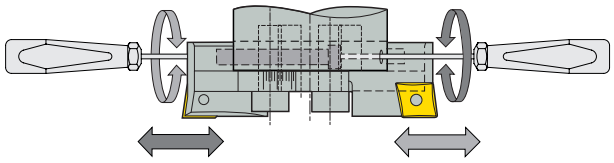
Symmetrische Bearbeitung:

Bei der symmetrischen Bearbeitung werden beide Schneiden auf denselben Durchmesser eingestellt.

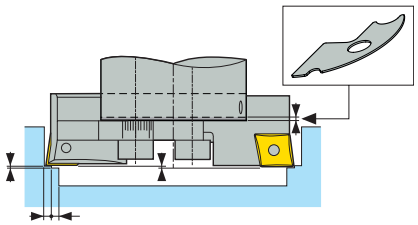
Asymmetrische Bearbeitung:

Asymmetrische Bearbeitung heißt, dass eine Schneide als Vorschneider (tritt als erste in die Bohrung ein) auf einen kleineren Durchmesser eingestellt wird als die zweite Schneide (Einstellung auf den Fertigdurchmesser): Dies erfordert eine Unterlegscheibe (im Lieferumfang des Kopfes enthalten), die zwischen den Körper des Ausdrehkopfes und einen Wendeschneidplatten-Halter gelegt wird, um den (+) axialen Versatz zu erzielen, siehe nachstehende Tabelle.

Unterlegscheibe, Teilenr.	Dicke (mm)	*Dicke (Zoll)*
AU6101003	0,2	*0.008*
AU6103003	0,4	*0.016*
AU6104003	0,5	*0.020*
AU6105003	0,6	*0.024*
AU6106003	0,6	*0.024*

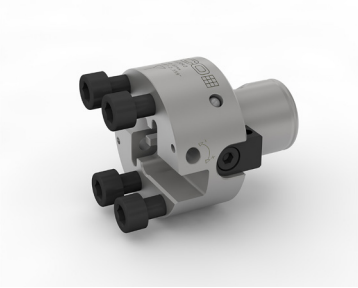


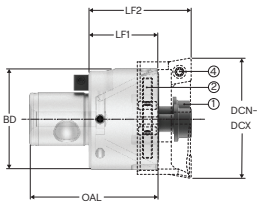
Symmetrische Bearbeitung



Asymmetrische Bearbeitung

RB610
Graflex®





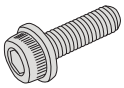
—Modi für symmetrischen und versetzten Einsatz sind möglich
—Individueller Wendeplattenhalter-Einstellmechanismus
—Innere Kühlmittelzufuhr zur Schneidkante

1. Spannschraube
2 & 4. Schlüssel für Durchmessereinstellung und Befestigungsschraube für Wendeplatte

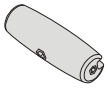
Bezeichnung	Produktnummer	Maschinenseite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Max. U/min*
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A61030	02904453	G3	39,0 *1.535*	51,0 *2.008*	43,5 *1.713*	23,5 *0.925*	36,4 *1.433*	34,0 *1.339*	0,2 *0.4*	7500
A61040	02904454	G4	50,0 *1.969*	65,0 *2.559*	45,5 *1.791*	21,5 *0.846*	35,3 *1.390*	43,0 *1.693*	0,3 *0.7*	5700
A61050	02904455	G5	64,0 *2.520*	86,0 *3.386*	55,0 *2.165*	25,0 *0.984*	42,3 *1.665*	54,0 *2.126*	0,7 *1.5*	4500
A61060	02904457	G6	85,0 *3.346*	115,0 *4.528*	69,0 *2.717*	29,0 *1.142*	47,8 *1.882*	63,0 *2.480*	1,0 *2.2*	3500

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 500
* Weitere Informationen zur max. Drehzahl siehe Anleitungsseiten. Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

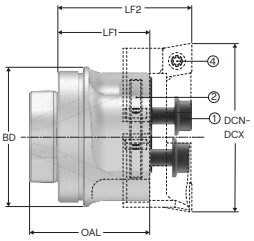
Für Kopf	Schraube	Auflageplatte, versetzte Bearbeitung	Mitnehmer
			
A61030	950DC0616	AU6103003	90M31
A61040	950D0616	AU6104003	90M41
A61050	950D0820	AU6105003	90M51
A61060	950D0822	AU6106003	90M61

Zubehör

Für Kopf	Schlüssel für Pratze	Schlüssel (Quergriff)
		
A61030	03HL05	DOUBLE-T
A61040	03HL05	DOUBLE-T
A61050	03HL06	DOUBLE-T
A61060	03HL06	DOUBLE-T

RB610 Compact

GL



—Entwickelt für GL25, GL32, GL40 und GL50 Steadyline®-Dreh- und Bohrstangen
—Modi für symmetrischen und versetzten Einsatz sind möglich
—Individueller Wendeplattenhalter-Einstellmechanismus
—Innere Kühlmittelzufuhr zur Schneidkante

1. Spannschraube
2 & 4. Schlüssel für Durchmessereinstellung und Befestigungsschraube für Wendeplatte

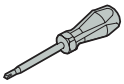
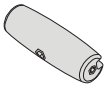
Bezeichnung	Produktnummer	Maschinenseite GL Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Max. U/min*
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
GL25-RB610-10	03307854	GL25	28,0 *1.102*	37,0 *1.457*	21,7 *0.854*	16,2 *0.638*	25,0 *0.984*	25,0 *0.984*	0,1 *0.2*	9500
GL32-0610-20	02904458	GL32	36,0 *1.417*	46,0 *1.811*	27,6 *1.087*	21,1 *0.831*	32,0 *1.260*	32,0 *1.260*	0,1 *0.2*	7500
GL40-0610-30	02904459	GL40	45,0 *1.772*	56,0 *2.205*	31,6 *1.244*	22,1 *0.870*	35,0 *1.378*	40,0 *1.575*	0,2 *0.4*	5700
GL50-0610-40	02904460	GL50	55,0 *2.165*	69,0 *2.717*	33,7 *1.327*	22,2 *0.874*	36,0 *1.417*	50,0 *1.969*	0,3 *0.7*	4500

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 500
* Weitere Informationen zur max. Drehzahl siehe Anleitungsseiten. Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

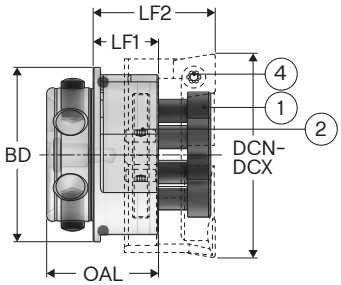
Für Kopf	Schraube	Auflageplatte, versetzte Bearbeitung
GL25-0610-10	950D0410	AU6101003
GL32-0610-20	950DC0412	AU6102003
GL40-0610-30	950DC0616	AU6103003
GL50-0610-40	950D0616	AU6104003

Zubehör

Für Kopf	Schlüssel für Pratze	Schlüssel für WSP	Schlüssel (Quergriff)
			
GL25-0610-10	03HL03	T07P-3	–
GL32-0610-20	03HL03	H4B-T07P	DOUBLE-T
GL40-0610-30	03HL05	–	DOUBLE-T
GL50-0610-40	03HL05	–	DOUBLE-T

RB610

BA



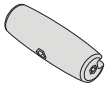
—Entwickelt für BA60 und BA80 Steadyline®-Dreh- und Bohrstangen
—Modi für symmetrischen und versetzten Einsatz sind möglich
—Individueller Wendeplattenhalter-Einstellmechanismus
—Innere Kühlmittelzufuhr zur Schneidkante

1. Spannschraube
2 & 4. Schlüssel für Durchmessereinstellung und Befestigungsschraube für Wendeplatte

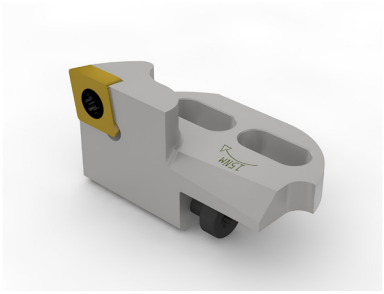
Bezeichnung	Produktnummer	Maschinenseite BA Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Max. U/min*
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BA060-RB610-50	03204092	BA060	66,0 *2.598*	88,0 *3.465*	38,5 *1.516*	22,5 *0.886*	39,8 *1.567*	60,0 *2.362*	0,7 *1.5*	4000
BA080-RB610-60	03204093	BA080	86,0 *3.386*	116,0 *4.567*	44,5 *1.752*	22,5 *0.886*	41,3 *1.626*	80,0 *3.150*	1,2 *2.7*	3000

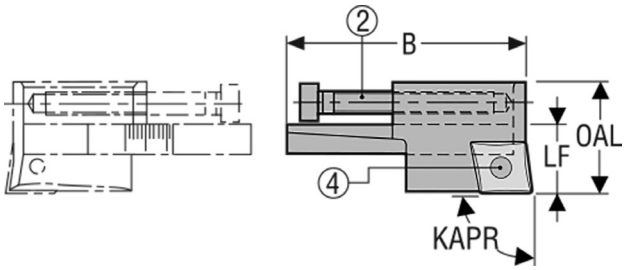
Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 500
* Weitere Informationen zur max. Drehzahl siehe Anleitungsseiten. Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Schlüssel für Pratze	Spannschraube	Schlüssel (Quergriff)	Auflageplatte, versetzte Bearbeitung
				
BA060-RB610-50	03HL06	950D0820	DOUBLE-T	AU6105003
BA080-RB610-60	03HL06	950D0822	DOUBLE-T	AU6106003

WSP-Halter



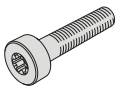


2. Einstellschraube
4. Schraube für WSP

–Geeignet für Ausdrehköpfe RB 610 mit Graflex®-, GL- oder BA-Anschluss

Bezeichnung	Produktnummer	Für Kopf	Werkstückseite Bereich DCN-DCX		OAL	LF	B	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
A61010CC0690	03307856	RB 61010	28,0 *1.102*	37,0 *1.457*	4,7 *0.185*	8,8 *0.346*	21,75 *0.856*	0,1 *0.2*
A61020CC0690	02971268	RB 61020	36,0 *1.417*	46,0 *1.811*	17,6 *0.693*	10,9 *0.429*	26,0 *1.024*	0,1 *0.2*
A61030CC0990	02904461	RB 61030	39,0 *1.535*	56,0 *2.205*	21,6 *0.850*	12,9 *0.508*	33,0 *1.299*	0,1 *0.2*
A61040CC0990	02904462	RB 61040	50,0 *1.969*	69,0 *2.717*	22,5 *0.886*	13,8 *0.543*	43,8 *1.724*	0,1 *0.2*
A61050CC1290	02904463	RB 61050	64,0 *2.520*	86,0 *3.386*	12,0 *0.472*	17,3 *0.681*	57,4 *2.260*	0,2 *0.4*
A61060CC1290	02904464	RB 61060	85,0 *3.346*	115,0 *4.528*	30,5 *1.201*	18,8 *0.740*	75,0 *2.953*	0,2 *0.4*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube für WSP	Einstellschraube
		
A61010CC0690	C02504-T07P	–
A61020CC0690	C02504-T07P	19A61020
A61030CC0990	C04008-T15P	19A61030
A61040CC0990	C04008-T15P	19A61040
A61050CC1290	C05012-T15P	19A61050
A61060CC1290	C05012-T15P	19A61060

Zum Schrupp-Ausdrehen empfohlene Wendeplatten siehe Seite(n) 588
Hinweis: Ein Schlüssel für die Wendeplattenklemmung mit Schrauben ist Teil des Lieferumfangs für Köpfe RB 610.

RB 610 Schruppausdrehköpfe – Hinweise

Empfohlene Anzugsmomente Maximaler Vorschub pro Umdrehung bei asymmetrischer Bearbeitung.

RB 610 Schruppausdrehköpfe – Größe	30	40	50	60
Anzugsmoment für Spannschraube zum Spannen der Wendeschneidplatten-Halter (Nm)	2 x 25	4 x 25	4 x 40	4 x 40
f max. Vorschub bei asymmetrischer Bearbeitung (mm/U) *(Zoll/U)*	0,4 *(0.016 “)*	0,5 *(0.020 “)*	0,6 *(0.024 “)*	0,6 *(0.024 “)*

Empfohlene Zerspanungsbedingungen Spindelleistung:

Da beim Schruppausdrehen eine hohe Maschinenleistung gefordert wird empfehlen wir, zu prüfen, ob die Maschine hierfür geeignet ist. Asymmetrische Bearbeitung reduziert den Leistungsbedarf, da der Vorschub für die gesamte Schnitttiefe im Vergleich zur symmetrischen Bearbeitung durch zwei dividiert wird. Sie erreichen beste Ergebnisse mit interner Kühlschmierstoffzufuhr (höhere Schnittdaten, bessere Oberflächengüte, bessere Spanabfuhr, längere Standzeit der Wendeschneidplatten).

Weitere Details finden Sie in der Bedienungsanleitung, die mit der Steadyline®-Bohrstange geliefert wird. Diese Gebrauchsanweisung steht auch auf www.secotools.com zum Download bereit.

Maximale Geschwindigkeiten für RB 610 Schruppausdrehköpfe

ANMERKUNG: Die maximalen Schnittgeschwindigkeiten, die auf den Produktseiten genannt werden, beziehen sich auf das mechanische Design und die Auswuchtqualität der Ausdrehköpfe.

Die Geschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Bearbeitungsbedingungen wie zu bearbeitenden Werkstoff, Schneidkante (Wendeschneidplatte), Werkzeuglänge und Maschinenspindel gewählt werden.

Bei Anwendungen mit Steadyline®-Bohrstangen dürfen die maximalen Drehzahlen der Bohrstange nicht überschritten werden: Sie finden diese in der Bedienungsanleitung, die mit den Steadyline®-Dreh- und Bohrstangen geliefert wird.

Feinausdrehen

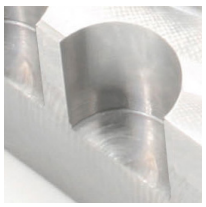
Die Feinausdrehprodukte von Seco eignen sich für eine Vielzahl an Bohrungsgrößen und Werkstoffen. Sie ermöglichen Präzisionseinstellungen im Mikrometerbereich, Oberflächengüten mit Ra <1 (RMS 44 µ/Zoll) und Bohrungen mit Toleranz IT5. Mit konsistentem Fokus auf Präzision und Steifigkeit ist das Einhalten auch der strengsten Komponenteneigenschaften ein Leichtes. Schwingungsdämpfende Steadyline™-Lösungen vervollständigen das Programm für noch mehr Stabilität mit großen Auskragungen.

- FB 760 Axiabore Digitale und analoge Ausdrehköpfe wurden für hohe Präzision und hohe Oberflächengüten bei kleinen Durchmessern entwickelt.
- Unser Angebot an Axiabore™-Feinbohrköpfen beinhaltet jetzt auch eine Digitalversion, was die Arbeit erleichtert und die Häufigkeit von Anwendungsfehlern reduziert. Die Digitalversion hilft beim einfacheren und schnelleren Einrichten und bietet hohe Prozesssicherheit und Effizienz beim Feinbohren von Teilen mit hohen Toleranzen.
- FB 620/780/790 radiale Feinausdrehköpfe bieten höchste Bohrungsgeometrien bei großen Durchmessern (bis 205 mm).

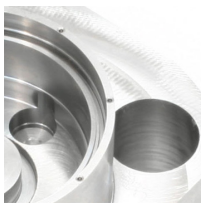
Übersicht

Zapfendrehen

Nutstechen

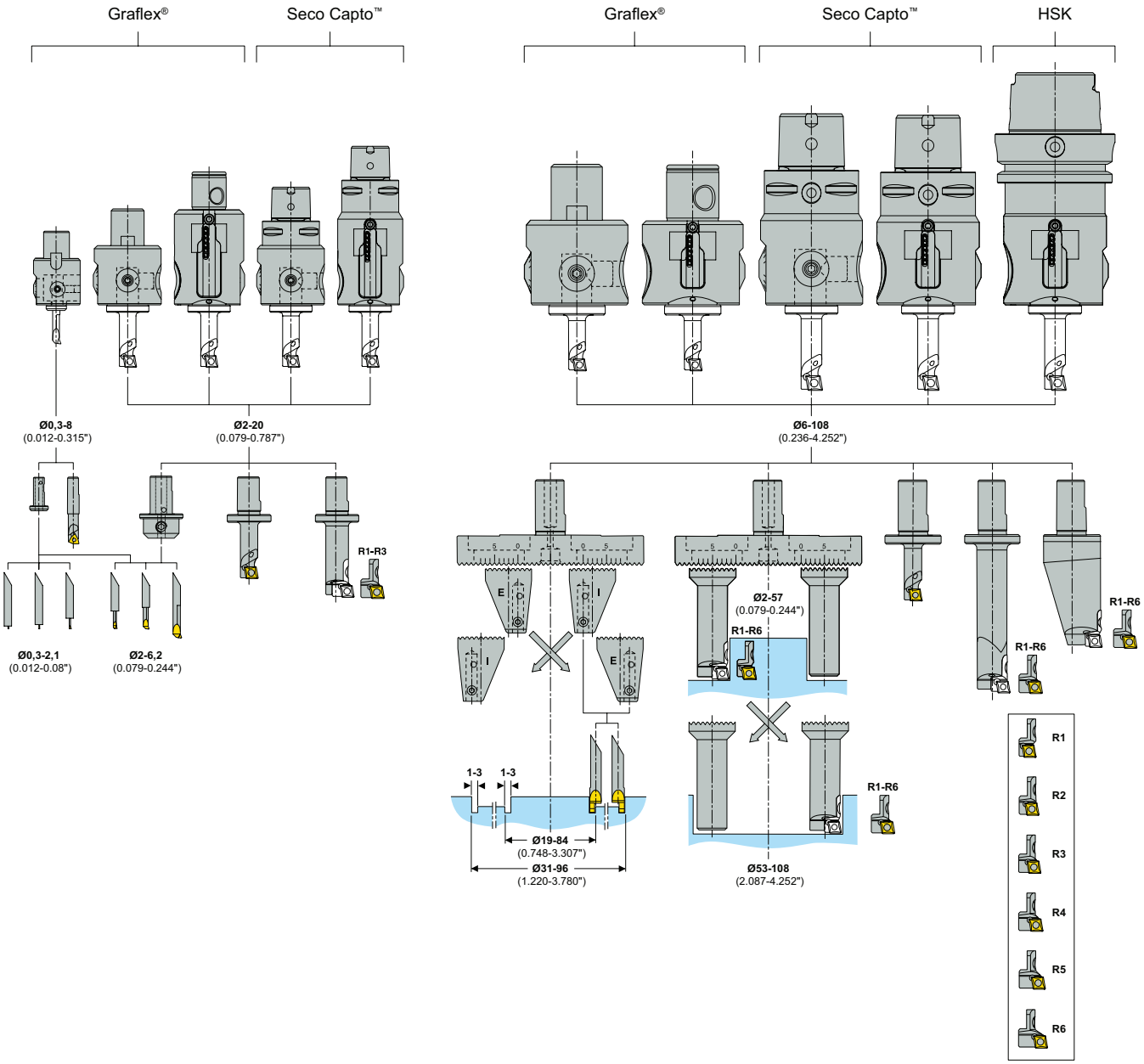


Ausdrehen mit unterbrochenem Schnitt



Ausdrehen

Übersicht


Graflex®
Seco Capto™
Graflex®
Seco Capto™
HSK
Ø0,3-8
(0.012-0.315")
Ø2-20
(0.079-0.787")
Ø6-108
(0.236-4.252")
R1-R3
Ø0,3-2,1
(0.012-0.08")
Ø2-6,2
(0.079-0.244")
E
I
1-3
1-3
Ø19-84
(0.748-3.307")
Ø31-96
(1.220-3.780")
Ø2-57
(0.079-0.244")
R1-R6
R1-R6
R1-R6
R1-R6
Ø53-108
(2.087-4.252")
R1
R2
R3
R4
R5
R6

Digitale Feinausdrehköpfe axiale Ausführung

Die digitalen Axial-Feinausdrehköpfe liefern hervorragende Ergebnisse beim Feinspindeln (IT5 ist erreichbar). Sie ersetzen die Verwendung einer analogen Einstellskala durch eine abnehmbare, universelle Digitalanzeige: Während die Einstellskala eines herkömmlichen, analogen Ausdrehkopfes nicht immer einfach zur Durchmessereinstellung an der Maschine zu verwenden ist, ermöglicht das große Display der FB 760 D-Serie eine komfortable und zuverlässige Einstellung des Durchmessers.

Die Serie FB 760 D verändert die Vorgehensweise beim Bohren, denn sie macht ein Voreinstellgerät überflüssig: Alle Voreinstellungs- und Einstellvorgänge werden direkt an der Maschine mit Hilfe des universellen digitalen Display-Controllers vorgenommen.

Bohrstangen
Durchmesser von 2–108 mm (Ø 0,079"–4,252"), Einstellwinkel 98°. Die Bohrstangen sind mit Schneidenausrichtung gemäß ISO versehen.

Aufbewahrungsbox
Die Digitalanzeige wird mit einer einzigartigen und nachhaltigen Verpackungsbox geliefert.

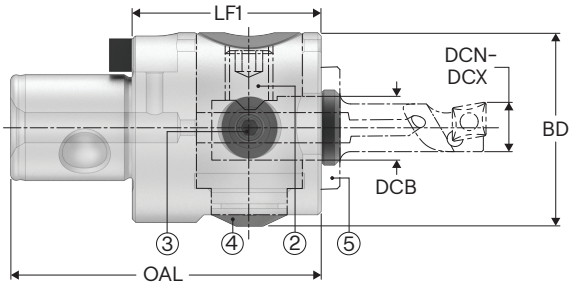
Merkmale

Universelle Digitalanzeige, für Feinausdrehköpfe FB 760 D
Der universelle digitale Display-Controller ist für beliebig viele Ausdrehköpfe geeignet. Er ist mit einem großen Display ausgestattet.

Die universelle Digitalanzeige soll Ihnen die Arbeit erleichtern:
- Display zur Erleichterung des Ablesens – Auflösung 1 µm
- Intuitives und benutzerfreundliches System, einfaches Umschalten zwischen Absolut-/Relativmodus und mm/Zoll-Modus
- Selbsthaltender Controller: Sobald er mit dem Ausdrehkopf verbunden ist, bleibt dern Controller an seiner Position und der Bediener kann mit beiden Händen die Durchmessereinstellung vornehmen.
- Der Universal Digital Display Controller ist für eine beliebige Anzahl an Ausdrehköpfen geeignet. Der universelle digitale Display-Controller wird mit einem USB-Kabel geliefert und kann über den USB-Anschluss Ihres Geräts oder Computers aufgeladen werden.

FB 760 – Axiabore™ Köpfe, nicht auswuchtbar

Graflex®



–Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)
–Axiabore™ Plus – ermöglicht Ausdrehen sowie Zapfendrehen und Plan-Nutstechen

3. Spannschraube
4. Spannschraube
2. Schraube
5. Bohrstange

Bezeichnung	Produkt-nummer	Maschinenseite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	BD	DCB	Gewicht	*	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		Max. U/min**	Max. m/min**
A76001	02462575	G2	0,3 *0.012*	8,0 *0.315*	41,0 *1.614*	25,0 *0.984*	25,0 *0.984*	6,0 *0.236*	0,2 *0.4*		30000	1500
A76002	02594930	G3	2,0 *0.079*	20,0 *0.787*	52,0 *2.047*	32,0 *1.260*	36,5 *1.437*	12,0 *0.472*	0,4 *0.9*		12000	1500
A76003	02594935	G5	6,0 *0.236*	108,0 *4.252*	75,0 *2.953*	45,0 *1.772*	54,0 *2.126*	16,0 *0.630*	0,9 *2.0*	*	8000	1000

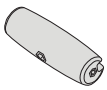
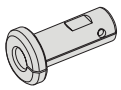
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Werkzeuge siehe Seite(n) 516–518

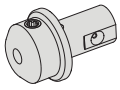
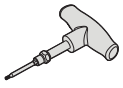
*Kapazitäten – Axiabore™ Plus – Ausdrehkopf 6–108 mm (0,236–4,252 Zoll) , Zapfendrehen 2–57 mm (0,079–2,244 Zoll), Plan-Nutstechen 19–96 mm (0,748–3,780 Zoll).
*Max. 5000 U/min bei Verwendung des MPA.

**Maximale Geschwindigkeit, je nachdem, welche zuerst erreicht wird, ohne eine davon zu überschreiten.

Ersatzteile, im Lieferumfang enthalten

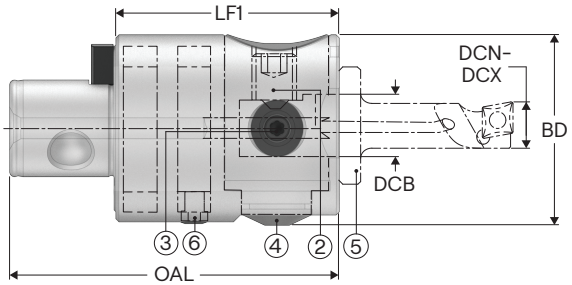
Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube	Dichtschraube	Hülse	Mitnehmer
							
A76001	–	DOUBLE-T	H4B-H2.0	19M4001A	950A0406	05A7600604	90M21
A76002	AU7601212	–	03M03C	19A71030	–	–	90M3A
A76003	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	–	–	90M5A

Zubehör

Für Kopf	Hülse	Drehmomentschlüssel für Befestigungsschraube	Drehmomentschlüssel für Schraube und Befestigungsschraube
			
A76001	–	–	H00-2009
A76002	05A7601204	–	H00-3030
A76003	–	H00T-4060	–

FB 760 – Axiabore™ Köpfe, auswuchtbar

Graflex®



—Integriertes Auswuchtsystem LibraOne auf Grundlage eines einzelnen Auswuchteinstellrings
—Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)

6. Spannschraube 2
3. Spannschraube 1
4. Spannschraube
2. Schraube
5. Bohrstange

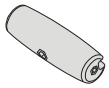
Bezeichnung	Produkt-nummer	Maschinenseite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	BD	DCB	Gewicht	*	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		Max. U/min**	Max. m/min**
A76013	02594943	G5	6,0 *0.236*	33,0 *1.299*	95,0 *3.740*	65,0 *2.559*	54,0 *2.126*	16,0 *0.630*	1,2 *2.7*	*	20000	1500

Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

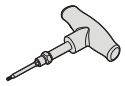
Werkzeuge siehe Seite(n) 516–518

*Kapazitäten – Axialibrabore™ Plus – Kopf, ausgewuchtet.
**Maximale Geschwindigkeit, je nachdem, welche zuerst erreicht wird, ohne eine davon zu überschreiten.

Ersatzteile, im Lieferumfang enthalten

Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube 1	Befestigungsschraube 2	Mitnehmer
						
A76013	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	AU7601318	90M5A1

Zubehör

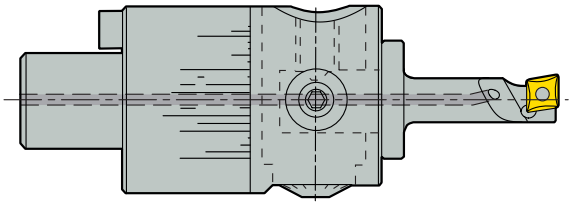
Für Kopf	Drehmomentschlüssel für Befestigungsschraube	Drehmomentschlüssel für Schraube und Befestigungsschraube
		
A76013	H00-4020-60	H00T-4060

5 Feinausdrehköpfe Typ Axiabore™ für Durchmesserbereich 0,3–108 mm (0.012–4.252")

Auswahl von Köpfen vom Typ Axiabore™	Durchmesser-bereich mm	*Kapazität ∅ Zoll*	HSM/Max. Geschw.	Digital	Auswuchtbar	Bohrungs-geometrie	Wirtschaftlich
Nanobore™ (größe 1)	0,3-8	*0.012–0.315"*	30000 Drehzahl			■■	■■
Axiabore™ (größe 2)	2-20	*0.079–0.787"*	12000 Drehzahl			■	■■
Digitale Köpfe Axiabore™ (größe 2)	2-20	*0.079–0.787"*	12000 Drehzahl	✓		■	■■
Axiabore™ Plus (größe 3)	6-108	*0.236–4.252"*	8000* Drehzahl oder 1000 m/min			■	■■■
Digitale Axiabore™ Plus (größe 3)	6-108	*0.236–4.252"*	8000* Drehzahl oder 1000 m/min	✓		■	■■■
Axialibrabore™ Plus (größe 3)	6-108	*0.236–4.252"*	20000* Drehzahl oder 1500 m/min		✓	■■	■

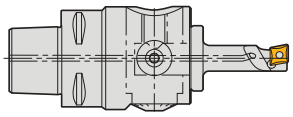
* Max. 5000 U/min bei Verwendung des MPA.

5 köpfe des Typs Axiabore™ gibt es mit Graflex®, Seco Capto™ oder HSK-A-Anschluss



Nanobore™ (größe 1)
Axiabore™ (größe 2)
Digitale Axiabore™ (größe 2)
Axiabore™ Plus (größe 3)
Digitale Axiabore™ Plus (größe 3)
Axialibrabore™ Plus (größe 3)

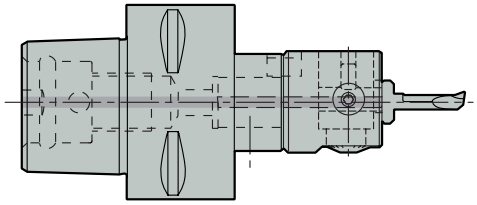
2 Axiabore™ Feinausdrehköpfe FB 760 mit Seco Capto™ Anschluss für Bohrungen im Durchmesserbereich von 2 bis 108 mm *(0.079–4.252")*



Axiabore™ – C3-391.0760-02
Axiabore™ Plus – C5-391.0760-03
Digitale Axiabore™ – C3-391.FB760-02-D
Digitale Axiabore™ Plus – C5-391.FB760-03-D

ANMERKUNG: Der kleinste Durchmesser, der mit dem Seco Capto™ Feinausdrehkopf mit C3-Anschluss zu erzielen ist, beträgt 2 mm *(0.079")*. Setzen Sie für Durchmesser von 0,3 bis 8 mm *(0.012-0.315")* den Nanobore™-Kopf mit Anschlussgröße G2 in Verbindung mit dem passenden Seco Capto™/Graflex®-Adapter ein.

Seco Capto™-Adapter und Graflex®-Kopf im Durchmesserbereich von: 0,3 bis 8 mm *(0.012–0.315")*



Seco Capto™ und Graflex®-Adapter und modulare Erweiterungen: siehe Katalog Werkzeug-Systeme

ANMERKUNG: Merkmale, Hinweise (Montageanweisungen, Durchmessereinstellung, MPA-Zusammenstellung, maximale Geschwindigkeiten, Schnittdatenempfehlungen, Herausforderung), geeignete Werkzeuge und Wendeschneidplatten-Halter sind identisch für beide Feinausdrehköpfe 760, die ungeachtet des Anschlusses denselben Ausdrehbereich aufweisen.

Digitalanzeige für digitale Feinausdrehköpfe

Bohrstangen

Hinweis: Auf den Produktseiten ist dargestellt, welche Bohrstange für welchen Kopf geeignet ist.

Ausdrehwerkzeug, Vollhartmetall Schaftdurchmesser 4 mm *(0.1574")* für kleinste Durchmesser von 0,3 bis 6,2 mm *(0.012–0.244")*, Einstellwinkel 98°. Für den Einsatz mit Nanobore™ und Axia(libra)bore™ sind Reduzierbuchsen erforderlich. Die Bohrstangen sind maschinenseitig mit einer keilförmigen Anlagefläche für Schneidenausrichtung gemäß ISO versehen.

Ausdrehwerkzeug, Wendeschneidplatten-Typ Schaftdurchmesser 6, 12 oder 16 mm *(0.236, 0.472, 0.630")* für Durchmesser von 6 bis 13 mm *(0.236–0.512")*, Stahl-Ausführung für kurze Werkzeuge, Hartmetall-Ausführung für lange Werkzeuge. Für Wendeschneidplatten WB..0301... oder CC..0602... und 90° Einstellwinkel. Modulare Bohrstangen können direkt an den Ausdrehkopf montiert werden. Die Schneidenausrichtung entspricht der ISO-Norm.

Bohrstange, modular, bestehend aus einem Schaft und einem WSP-Halter für Durchmesser von 13 bis 63 mm *(0.512–2.480")*. Schäfte mit Durchmesser 12 oder 16 mm *(0.472, 0.630")* in Stahlausführung für kurze, Hartmetall für lange und Leicht-/Aluminium-Ausführung für größte Durchmesser. Modulare Bohrstangen können direkt an den Ausdrehkopf montiert werden.

Die 6 Wendeschneidplatten-Halter für Wendeschneidplatten CC..0602.. und 90° Einstellwinkel sind kompatibel mit allen Aufnahmen zum Aufbau eines großen Ausdrehbereichs auf einem gemeinsamen Schaft.

Vielzweck-Adapter (MPA)

MPA zum Ausdrehen und Zapfendrehen sowie zum Nutstechen mit Axiabore™ Plus-Kopf. MPA und Bohrstange haben eine doppelt verzahnte Schnittstelle für präzise Ausrichtung sowie 2,5 mm Steigung im Durchmesser *(0,098)*. Sie enthalten auch eine Kühldüse für interne Kühlschmierstoffzufuhr direkt auf die Schneide.

Wählen Sie die Komponenten zur Zusammenstellung eines Werkzeugs auf Basis des MPA mit Hilfe der Auswahl-Tabellen aus. Montage, siehe Kapitel Hinweise.

Zusammenstellen einer Kombination zum Ausdrehen oder Zapfendrehen
Zum Ausdrehen und Zapfendrehen wird dieselbe Aufnahme verwendet, die mit einem Wendeschneidplatten-Halter und einem Gegengewicht ausgerüstet wird. - Ausdreh-Kombination: Passenden Wendeplattenhalter zum Ausdrehen auf die Aufnahme mit Hilfe der Auswahl-Tabelle „Zapfendrehen“ (siehe nachfolgende Produkt-Seiten) auswählen.

- Zapfendreh-Kombination: Passenden Wendeplattenhalter zum Ausdrehen auf die Aufnahme mit Hilfe der Auswahl-Tabelle „Zapfendrehen“ (siehe nachfolgende Produkt-Seiten) auswählen. Montage, siehe Kapitel Hinweise.

Zusammenstellen einer Kombination zum Nutstechen

– Eine Kombination zum Einstechen besteht aus einem Paar WSP-Halter zum Einstechen (einem Halter E = externe Position und einem Halter I = innere Position) einem Einstechwerkzeug “gegen den Zapfen” oder “gegen die Bohrung”. Wenn keine Störkontur bearbeitet wird, sind beide Werkzeugtypen geeignet. Siehe Auswahltabelle “Einstechwerkzeuge zum Einstechen mit MPA”

Merkmale

Nanobore™ Feinausdrehkopf, Produktnummer A76001

Ultrakleiner Ausdrehkopf für Bohrungen mit 0,3 bis 8 mm *(0.012–0.315")* Durchmesser
Außendurchmesser 25 mm *(0.984")*, Länge 25 mm *(0.984")*, mit Graflex®-Anschlussgröße G2, Anschlussdurchmesser 6 mm *(0.236")*.
Schnittgeschwindigkeiten 30.000 U/m oder 1.500 m/min (je nachdem, welcher Wert zuerst erreicht wird) für die Hochleistungsbearbeitung sehr kleiner Durchmesser.

Die Reduzierbuchsen 6 bis 4 mm *(0.236–0.157")* mit keilförmiger Verbindung und Stift zur Montage der Hartmetallbohrstangen gehören zum Lieferumfang des Ausdrehkopfes.

Einstellung des Durchmessers: 2,5 µm *(0,0001")*

Axiabore™ Kopf, Produktnummer A76002

Kleiner Ausdrehkopf für Bohrungen mit 2 bis 20 mm *(0.079–0.787")*Durchmesser
Außendurchmesser 36,5 mm *(1.401")*, Länge 32 mm *(1.260")*, mit Graflex®-Anschlussgröße G3 und Seco Capto™-Anschlussgröße C3, Anschlussdurchmesser 12 mm *(0.472")*. Die Ausdrehkopfgrößen wurden für schwierig zu erreichende Bohrungen optimiert.

Die Reduzierhülsen 12–4 mm *(0,472–0,157 Zoll)* mit keilförmiger Verbindung und Stift zur Montage der massiven Ausdrehwerkzeuge gehören zum Lieferumfang des Ausdrehkopfes.

ANMERKUNG: Es können auch kleinere Werkzeuge des Nanobore™-Programms 0,3 bis 2,1 mm *(0.012–0.083")* eingesetzt werden, dadurch ist die Geschwindigkeit jedoch auf 12.000 U/min begrenzt. Der Nanobore®-Kopf sollte bevorzugt werden.

Einstellung des Durchmessers: 2,5 µm *(0,0001")* beim Durchmesser für analoge Köpfe, 1 µm *(0,00004")* beim Durchmesser für digitale Köpfe

Axiabore™ Plus - Ausdrehkopf Produktnummer A76003 und C5-391.0760-03

Vielseitig einsetzbarer Kopf zum Feinausdrehen im Durchmesserbereich von 6 bis 108 mm *(0.236–4.252")*, Zapfendrehen im Durchmesserbereich von 2 bis 57 mm *(0.079–2.244")* und Nutstechen im Durchmesserbereich von 19 bis 96 mm *(0.748–3.780")*.
Außendurchmesser 54 mm *(2.126")*, Länge 45 mm *(1.772")*, mit Graflex®-Anschlussgröße 5 und Seco Capto™-Anschlussgröße 5, Anschlussdurchmesser 16 mm *(0.630")*.
Passende Bohrstangen: Alle Bohrstangen mit Schaftdurchmesser 16 mm *(0.630")*, zur direkten Montage in den Kopf.

Dieser Kopf wurde speziell für den Einsatz mit dem MPA (Multi Purpose Adapter) zum Feinausdrehen, Zapfendrehen und Nutstechen in einem großen Durchmesserbereich entwickelt.

Einstellung des Durchmessers: 2,5 µm *(0,0001")* beim Durchmesser für analoge Köpfe, 1 µm *(0,00004")* beim Durchmesser für digitale Köpfe

Axialibrabore™ Plus - Ausdrehkopf Produktnummer A76013

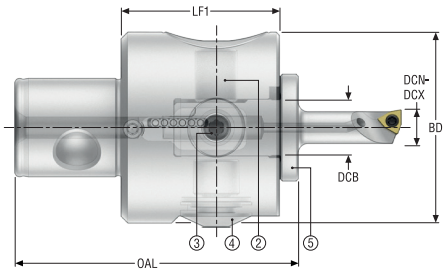
Auswuchtbarer Ausdrehkopf für Bohrungen mit 6 bis 33 mm *(0.236–1.299")* Durchmesser
Dieselben Merkmale wie der Axiabore™ Plus-Kopf, jedoch mit feinauswuchtbarer Länge des Kopfes 65 mm *(2.559")*.
Mit Graflex®-Größe G5
Feinauswuchtbare Köpfe erlauben höhere Geschwindigkeiten bis zu 20.000 U/min oder 1.500 m/min (je nachdem, welcher Wert als erstes erreicht wird), verbessern die Bohrungsgeometrie und schonen Aufnahmen und Maschinenspindel.
'LibraOne'-Auswuchtung erfolgt durch Einstellung des Skalenrings auf die Markierung des Ausdrehkopfes (siehe Auswuchtcode auf dem Werkzeug und Durchmesser der Bohrung). Es ist keine Auswuchttabelle erforderlich.
Feinauswuchtung nur möglich für die kleinsten Ausdrehwerkzeuge 6 bis 33 mm *(0.236–1.299")*.

ANMERKUNG: Bei Einsatz eines größeren Alu-Werkzeugs oder eines MPA-Werkzeugs vom Axiabore™ Plus auf den Axialibrabore™ Plus-Kopf ist eine Feinauswuchtung nicht möglich und der Skalenring sollte auf die Vorwuchtposition des Kopfes eingestellt werden (je nach durchgeführter Bearbeitung, siehe Kapitel Hinweise).
Die maximale Geschwindigkeit ist dieselbe wie bei Axiabore™ Plus.

Einstellung des Durchmessers: 2,5 µm *(0,0001")*

FB 760 D Digitale Köpfe Typ Axiabore, nicht auswuchtbar

Graflex®



—Kompatibel mit Digitalanzeige zur Darstellung der Feineinstellung auf dem großen Display (Digitalanzeige muss separat bestellt werden)
—Axiabore™ Plus – ermöglicht Ausdrehen sowie Zapfendrehen und Plan-Nutstechen

3. Pratze
4. Spannschraube
2. Schraube
5. Bohrstange

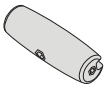
Bezeichnung	Produktnummer	Maschinenseite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	BD	DCB	Gewicht	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Max. U/min**	Max. m/min**
G3-FB760-02-D	10215570	G3	2,0 *0.079*	20,0 *0.787*	70,0 *2.756*	50,0 *1.969*	36,5 *1.437*	12,0 *0.472*	0,5 *1.1*	12000	1500
G5-FB760-03-D	10215571	G5	6,0 *0.236*	108,0 *4.252*	75,0 *2.953*	45,0 *1.772*	54,0 *2.126*	16,0 *0.630*	0,9 *2.0*	8000	1000

Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

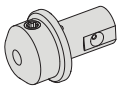
**Maximale Geschwindigkeit, je nachdem, welche zuerst erreicht wird, ohne eine davon zu überschreiten.

Wendeschneidplattenhalter sowie Lese- und Einstellgerät müssen separat bestellt werden, siehe nächste Seiten.

Ersatzteile, im Lieferumfang enthalten

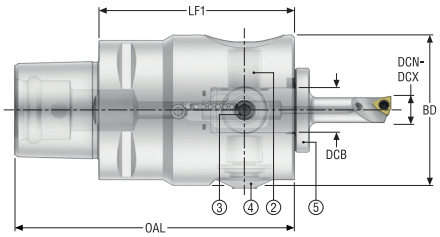
Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube
				
G3	AU7601212	–	03M03C	19A71030
G5	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

Zubehör

Für Kopf	Digitalanzeige	Reduzierbuchse	Drehmomentschlüssel
			
G3	990FBDD01-Y	05A7601204	H00-3030
G5	990FBDD01-Y	–	H00-3030

FB 760 D Digitale Köpfe Typ Axiabore

Seco Capto™



- Kompatibel mit Digitalanzeige zur Darstellung der Feineinstellung auf dem großen Display (Digitalanzeige muss separat bestellt werden)
- Axiabore™ Plus – ermöglicht Ausdrehen sowie Zapfendrehen und Plan-Nutstechen

3. Pratze
4. Spannschraube
2. Schraube
5. Bohrstange

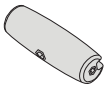
Bezeichnung	Produktnummer	Maschinenseite Capto Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	BD	DCB	Gewicht	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Max. U/min**	Max. m/min**
C3-391.FB760-02-D	10215575	C3	2,0 *0.079*	20,0 *0.787*	89,0 *3.504*	70,0 *2.756*	36,5 *1.437*	12,0 *0.472*	0,5 *1.1*	12000	1500
C5-391.FB760-03-D	10215576	C5	6,0 *0.236*	108,0 *4.252*	100,0 *3.937*	70,0 *2.756*	54,0 *2.126*	16,0 *0.630*	1,3 *2.9*	8000	1000

Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

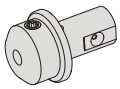
**Maximale Geschwindigkeit, je nachdem, welche zuerst erreicht wird, ohne eine davon zu überschreiten.

Wendeschneidplattenhalter sowie Lese- und Einstellgerät müssen separat bestellt werden, siehe nächste Seiten.

Ersatzteile, im Lieferumfang enthalten

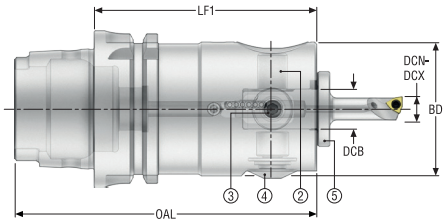
Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube
				
C3	AU7601212	–	03M03C	19A71030
C5	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

Zubehör

Für Kopf	Digitalanzeige	Reduzierbuchse	Drehmomentschlüssel
			
C3	990FBDD01-Y	05A7601204	H00-3030
C5	990FBDD01-Y	–	H00-3030

FB 760 – Axiabore™-Köpfe

HSK-A



—Kompatibel mit Digitalanzeige zur Darstellung der Feineinstellung auf dem großen Display (Digitalanzeige muss separat bestellt werden)
—Axiabore™ Plus – ermöglicht Ausdrehen sowie Zapfendrehen und Plan-Nutstechen

3. Pratze
4. Spannschraube
2. Schraube
5. Bohrstange

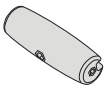
Bezeichnung	Produktnummer	Maschinenseite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	BD	DCB	Gewicht	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Max. U/min**	Max. m/min**
HSKA63-FB760-03-D	10215578	HSK-A63	6,0 *0.236*	108,0 *4.252*	122,0 *4.803*	90,0 *3.543*	54,0 *2.126*	16,0 *0.630*	1,8 *4.0*	8000	1000

Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

**Maximale Geschwindigkeit, je nachdem, welche zuerst erreicht wird, ohne eine davon zu überschreiten.

Wendeschneidplattenhalter sowie Lese- und Einstellgerät müssen separat bestellt werden, siehe nächste Seiten.

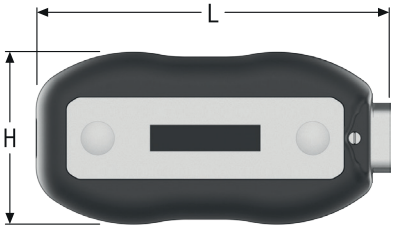
Ersatzteile, im Lieferumfang enthalten

Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube
				
HSKA	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

Zubehör

Für Kopf	Digitalanzeige	Drehmomentschlüssel
HSKA	990FBDD01-Y	H00-3030

Digitalanzeige für digitale Ausdrehköpfe

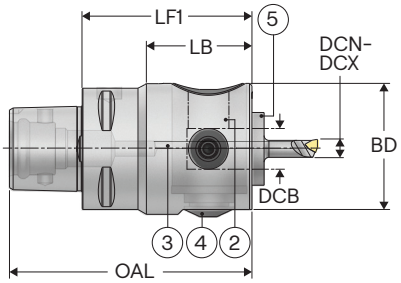


- Digitalanzeige für digitale Feinausdrehköpfe
- Für alle digitalen Ausdrehköpfe von Seco kann eine Digitalanzeige verwendet werden
- Durchmessereinstellung in mm oder Zoll
- Drehbares Display mit Magnet für besseren Halt während der Einrichtung des digitalen Ausdrehkopfes
- Mit wiederaufladbarem Einweg-Akku

Bezeichnung	Produktnummer	L	H	Gewicht
		mm *Zoll*	mm *Zoll*	kg *lbs*
990FBDD01	10215579	74,25 *2.92*	36 *1.42*	0,2 *0.008*

FB 760 – Axiabore™-Köpfe

Seco Capto™



—Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)
—Axiabore™ Plus – ermöglicht Ausdrehen sowie Zapfendrehen und Plan-Nutstechen

3. Pratze
4. Spannschraube
2. Schraube
5. Bohrstange

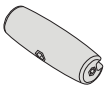
Bezeichnung	Produkt-nummer	Maschinenseite	Werkstückseite Bereich DCN-DCX		OAL	LF1	BD	DCB	Gewicht	*	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		Max. U/min**	Max. m/min**
C5-391.0760-03	02822777	C5	6,0 *0.236*	108,0 *4.252*	95,0 *3.740*	65,0 *2.559*	54,0 *2.126*	16,0 *0.630*	1,2 *2.7*	*	8000	1500

Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Werkzeuge siehe Seite(n) 516–518

*Max. 5000 U/min bei Verwendung des MPA.
**Kapazitäten – Axiabore™ Plus – Ausdrehkopf 6–108 mm (0,236–4,252 Zoll) , Zapfendrehen 2–57 mm (0,079–2,244 Zoll), Plan-Nutstechen 19–96 mm (0,748–3,780 Zoll).

Ersatzteile, im Lieferumfang enthalten

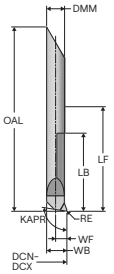
Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube
				
C5-...-03	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

Zubehör

Für Kopf	Drehmomentschlüssel für Schraube und Befestigungsschraube
C5-...-03	H00-3030

Ausdrehwerkzeuge, Vollhartmetall

Für Köpfe FB 760



—Geeignet für digitale und analoge Ausdrehköpfe
—KAPR 98°
—Schneidkantenausrichtung ISO
—Kühlmittel entlang des Werkzeugs
—Werkzeugwerkstoff: Vollhartmetall*

Bezeichnung	Produkt-nummer	Für Kopf	Bereich DCN-DCX mm***		OAL	LB	LF	DMM	WB	WF	RE	Emp-fohlene Schnitt-daten** a_p	Emp-fohlene Schnitt-daten** f	Gewicht	Auswuch-tung
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A761402	02462579	FB 76001	0,3 *0.012*	0,6 *0.024*	30,7 *1.209*	1,2 *0.047*	15,5 *0.610*	4,0 *0.157*	0,25 *0.010*	0,1 *0.004*	0,0 *0.0*	0,02 *0.001*	0,01 *0*	0,01 *0.0*	–
A761412	02462581	FB 76001	0,5 *0.020*	1,1 *0.043*	30,7 *1.209*	2,0 *0.079*	15,5 *0.610*	4,0 *0.157*	0,45 *0.018*	0,2 *0.008*	0,0 *0.0*	0,02 *0.001*	0,01 *0*	0,1 *0.2*	–
A761422	02462583	FB 76001	1,0 *0.039*	2,1 *0.083*	30,7 *1.209*	5,0 *0.197*	15,5 *0.610*	4,0 *0.157*	0,95 *0.037*	0,45 *0.018*	0,1 *0.004*	0,03 *0.001*	0,02 *0.001*	0,1 *0.2*	–
A761432	02462584	FB 76001/02/12	2,0 *0.079*	3,2 *0.126*	30,7 *1.209*	8,0 *0.315*	15,5 *0.610*	4,0 *0.157*	1,8 *0.071*	0,88 *0.035*	0,1 *0.004*	0,05 *0.002*	0,02 *0.001*	0,1 *0.2*	E13
A761442	02462586	FB 76001/02/12	3,0 *0.118*	4,7 *0.185*	30,7 *1.209*	10,0 *0.394*	15,5 *0.610*	4,0 *0.157*	2,75 *0.108*	1,35 *0.053*	0,15 *0.006*	0,06 *0.002*	0,03 *0.001*	0,1 *0.2*	E14
A761452	02462587	FB 76001/02/12	4,5 *0.177*	6,2 *0.244*	35,7 *1.406*	15,0 *0.591*	20,5 *0.807*	4,0 *0.157*	3,95 *0.156*	1,95 *0.077*	0,15 *0.006*	0,08 *0.003*	0,03 *0.001*	0,1 *0.2*	E15

*Bei diesen Werkzeugen mit einem Schaftdurchmesser von 4 mm muss eine Reduzierhülse verwendet werden, die zusammen mit den passenden Köpfen und Kits geliefert wird.

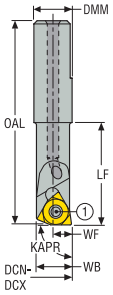
** Schnittgeschwindigkeiten siehe Seite(n) 592–595

***+0,1 mm Zusatzkapazität erreichbar.

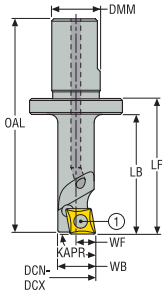
Bohrstangen, Wendeplattentyp

Für Köpfe FB 760

Design 1



Design 2



1 = Schraube für WSP

- Geeignet für digitale und analoge Ausdrehköpfe
- Schneidkantenausrichtung ISO
- Durchflusskühlmittel
- Nur zwei Wendeplattengrößen für alle Werkzeuge
- Werkzeugwerkstoff * = Stahl, Wendeschneidplattentyp
- Werkzeugwerkstoff ** = Hartmetall, Wendeschneidplattentyp
- KAPR 90°

Bezeichnung	Produkt-nummer	Werkzeug-material	Für Kopf	** Bereich DCN-DCX ∅		OAL	LB	LF	DMM	WB	WF	Gewicht	Abb.	Entspr. WSP-Größe	Auswuch-tung
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*			
A762001	02462590	*	FB 76001	6,0 *0.236*	8,0 *0.315*	31,7 *1.248*	0,0 –	16,0 *0.630*	6,0 *0.236*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	1	WB...0301..	–
A762002	02594947	*	FB 76002/12	6,0 *0.236*	8,0 *0.315*	39,7 *1.563*	16,0 *0.630*	20,0 *0.787*	12,0 *0.472*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	2	WB...0301..	S21
A762003	02594967	*	FB 76003/13	6,0 *0.236*	8,0 *0.315*	50,2 *1.976*	16,0 *0.630*	21,0 *0.827*	16,0 *0.630*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	2	WB...0301..	S31
A763002	02594948	*	FB 76002/12	8,0 *0.315*	10,0 *0.394*	45,7 *1.799*	22,0 *0.866*	26,0 *1.024*	12,0 *0.472*	7,4 *0.291*	3,9 *0.154*	0,1 *0.2*	2	WB...0301..	S22
A763003	02594968	*	FB 76003/13	8,0 *0.315*	10,0 *0.394*	56,2 *2.213*	22,0 *0.866*	27,0 *1.063*	16,0 *0.630*	7,4 *0.291*	3,9 *0.154*	0,1 *0.2*	2	WB...0301..	S32
A765002	02594957	*	FB 76002/12	10,0 *0.394*	13,0 *0.512*	53,5 *2.106*	30,0 *1.181*	34,0 *1.339*	12,0 *0.472*	9,35 *0.368*	4,8 *0.189*	0,1 *0.2*	2	CC...0602..	S23
A765003	02594969	*	FB 76003/13	10,0 *0.394*	13,0 *0.512*	64,0 *2.520*	30,0 *1.181*	35,0 *1.378*	16,0 *0.630*	9,35 *0.368*	4,8 *0.189*	0,1 *0.2*	2	CC...0602..	S33
A762201	02462591	**	FB 76001	6,0 *0.236*	8,0 *0.315*	41,7 *1.642*	0,0 –	26,0 *1.024*	6,0 *0.236*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	1	WB...0301..	–
A762202	02594958	**	FB 76002/12	6,0 *0.236*	8,0 *0.315*	50,7 *1.996*	27,0 *1.063*	31,0 *1.220*	12,0 *0.472*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	2	WB...0301..	E21
A762203	02594970	**	FB 76003/13	6,0 *0.236*	8,0 *0.315*	61,2 *2.409*	27,0 *1.063*	32,0 *1.260*	16,0 *0.630*	5,5 *0.217*	2,9 *0.114*	0,2 *0.4*	2	WB...0301..	E31
A763202	02594961	**	FB 76002/12	8,0 *0.315*	10,0 *0.394*	60,7 *2.390*	37,0 *1.457*	41,0 *1.614*	12,0 *0.472*	7,4 *0.291*	3,9 *0.154*	0,1 *0.2*	2	WB...0301..	E22
A763203	02594971	**	FB 76003/13	8,0 *0.315*	10,0 *0.394*	71,2 *2.803*	37,0 *1.457*	42,0 *1.654*	16,0 *0.630*	7,4 *0.291*	3,9 *0.154*	0,2 *0.4*	2	WB...0301..	E32
A765202	02594962	**	FB 76002/12	10,0 *0.394*	13,0 *0.512*	78,5 *3.091*	55,0 *2.165*	59,0 *2.323*	12,0 *0.472*	9,35 *0.368*	4,8 *0.189*	0,1 *0.2*	2	CC...0602..	E23
A765203	02594972	**	FB 76003/13	10,0 *0.394*	13,0 *0.512*	89,0 *3.504*	55,0 *2.165*	60,0 *2.362*	16,0 *0.630*	9,35 *0.368*	4,8 *0.189*	0,2 *0.4*	2	CC...0602..	E33

**+0,2 mm Zusatzkapazität erreichbar.

Ersatzteile, im Lieferumfang enthalten

Für WSP	Schraube für WSP
CC...0602..	C02504-T07P
WB...0301..	C02035-T06P

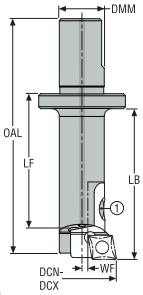
Zubehör

Schlüssel für WSP	Schlüssel (Quergriff)
H4B-T07P	DOUBLE-T
H4B-T06P	DOUBLE-T

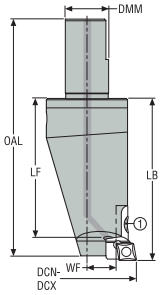
Bohrschäfte für modulare Feinausdrehwerkzeuge

Für Köpfe FB 760

Design 1



Design 2



1 = Spannschraube

- Mehrere Kapazitäten durch austauschbare Wendeplattenhalter möglich
- Schafttypen „Stahl" für kurze Stangen, „Hartmetall" für lange Stangen, „Aluminium" für große Stangen
- Durchflusskühlmittel

Bezeichnung	Produkt-nummer	Modularer Ausdreh-Schafttyp	Für Kopf	** Bereich DCN-DCX ∅		***	OAL	LB	LF	DMM	WF	Gewicht	Abb.
				mm *Zoll*	mm *Zoll*		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A760S20	02594963	Stahl	FB 76002/12	13,0 *0.512*	20,0 *0.787*		62,5 *2.461*	40,0 *1.575*	34,0 *1.339*	12,0 *0.472*	1,4 *0.055*	0,1 *0.2*	1
A760S30	02594973	Stahl	FB 76003/13	13,0 *0.512*	18,0 *0.709*		73,0 *2.874*	40,0 *1.575*	35,0 *1.378*	16,0 *0.630*	1,4 *0.055*	0,1 *0.2*	1
A760S31	02594974	Stahl	FB 76003/13	18,0 *0.709*	33,0 *1.299*		83,0 *3.268*	50,0 *1.969*	45,0 *1.772*	16,0 *0.630*	3,9 *0.154*	0,2 *0.4*	1
A760E20	02594964	Hartmetall	FB 76002/12	13,0 *0.512*	20,0 *0.787*		82,5 *3.248*	60,0 *2.362*	54,0 *2.126*	12,0 *0.472*	1,4 *0.055*	0,2 *0.4*	1
A760E30	02594965	Hartmetall	FB 76003/13	13,0 *0.512*	18,0 *0.709*		103,0 *4.055*	70,0 *2.756*	65,0 *2.559*	16,0 *0.630*	1,4 *0.055*	0,2 *0.4*	1
A760E31	02594966	Hartmetall	FB 76003/13	18,0 *0.709*	33,0 *1.299*		113,0 *4.449*	80,0 *3.150*	75,0 *2.953*	16,0 *0.630*	3,9 *0.154*	0,3 *0.7*	1
A760A32	02594977	Aluminium	FB 76003/13	33,0 *1.299*	48,0 *1.890*	***	88,0 *3.465*	60,0 *2.362*	50,0 *1.969*	16,0 *0.630*	11,5 *0.453*	0,2 *0.4*	2
A760A33	02594978	Aluminium	FB 76003/13	48,0 *1.890*	63,0 *2.480*	***	108,0 *4.252*	80,0 *3.150*	70,0 *2.756*	16,0 *0.630*	19,0 *0.748*	0,4 *0.9*	2

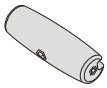
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird..

**+0,2 mm Zusatzkapazität erreichbar.
*** Bei Verwendung mit A760 13 ist keine Feinauswuchtung möglich. Wählen Sie (eine) geeignete Kombination(en) von Schaft und Wendeplattenhalter(n) aus der Auswahl-Tabelle auf Seite(n) 520.

Ersatzteile, im Lieferumfang enthalten

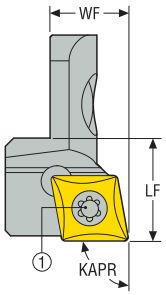
Für Kopf	Befestigungsschraube
A76002/12	C04008-T15P
A76003	C04008-T15P
A76003/13	C04008-T15P

Zubehör

Schlüssel (Quergriff)	Spannschlüssel
	
DOUBLE-T	H6B-T15P
DOUBLE-T	H6B-T15P
DOUBLE-T	H6B-T15P

Wendeplattenhalter für modulare Feinbohrstangen

Für Köpfe FB 760



—Anschlussgröße geeignet für alle Ausdrehschäfte (und Zapfendrehschäfte)
—Eine Wendeplattengröße für alle Wendeplattenhalter

1 = Schraube für WSP

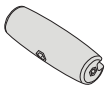
Bezeichnung	Produktnummer	LF	WF	Gewicht	Entspr. WSP-Größe	KRINS°
		mm *Zoll*	mm *Zoll*	kg *lbs*		
A765R1	02594979	10,0 *0.394*	4,95 *0.195*	0,1 *0.2*	CC...0602...	90
A765R2	02594983	10,0 *0.394*	6,2 *0.244*	0,1 *0.2*	CC...0602...	90
A765R3	02594984	10,0 *0.394*	7,45 *0.293*	0,1 *0.2*	CC...0602...	90
A765R4	02594987	10,0 *0.394*	8,7 *0.343*	0,1 *0.2*	CC...0602...	90
A765R5	02594989	10,0 *0.394*	9,97 *0.393*	0,1 *0.2*	CC...0602...	90
A765R6	02594990	10,0 *0.394*	11,2 *0.441*	0,1 *0.2*	CC...0602...	90

*WF bei Bestückung mit Wendeplatte Typ CC..060204.
Wählen Sie (eine) geeignete Kombination(en) von Schaft und Wendeplattenhalter(n) aus der Auswahl-Tabelle auf Seite(n) 520.

Ersatzteile, im Lieferumfang enthalten

Für WSP Größe	Schraube für WSP
CC...0602...	C02504-T07P

Zubehör

Schlüssel für WSP	Schlüssel (Quergriff)
	
H4B-T07P	DOUBLE-T

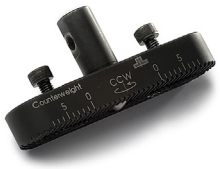
Auswahl-Tabelle:
Für Köpfe FB 760 passende Ausdrehwerkzeuge und Wendeplattenhalter

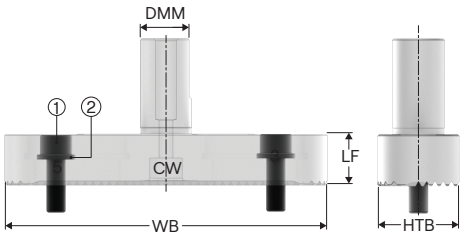
Für Kopf	Ausdrehkapazität DCN-DCX ∅ mm	*Zoll*	Ausdrehlänge LB mm	*Zoll*	Bezeichnung Ausdrehwerkzeug	Wendeplattenhalter	DMM mm	*Zoll*	Entspr. WSP-Größe	Werkzeugtyp
A760 01	0,3-0,6	*0.012-0.024*	1,2	*0.047*	A761402	–	4	*0.157*	–	Vollhartmetall
	0,5-1,1	*0.020-0.043*	2	*0.078*	A761412	–	4	*0.157*	–	Vollhartmetall
	1-2,1	*0.039-0.083*	-	-	A761422	–	4	*0.157*	–	Vollhartmetall
	2-3,2	*0.079-0.126*	8	*0.315*	A761432	–	4	*0.157*	–	Vollhartmetall
	3-4,7	*0.118-0.185*	10	*0.394*	A761442	–	4	*0.157*	–	Vollhartmetall
	4,5-6,2	*0.177-0.244*	15	*0.591*	A761452	–	4	*0.157*	–	Vollhartmetall
	6-8	*0.236-0.315*	16	*0.630*	A762001	–	6	*0.236*	WB..0301..	Stahl, Wendeplattentyp
	6-8	*0.236-0.315*	26	*1.024*	A762201	–	6	*0.236*	WB..0301..	Hartmetall, Wendeplattentyp
A760 02/ A760 12	2-3,2	*0.079-0.126*	8	*0.315*	A761432	–	4	*0.157*	–	Vollhartmetall
	3-4,7	*0.118-0.185*	10	*0.394*	A761442	–	4	*0.157*	–	Vollhartmetall
	4,5-6,2	*0.177-0.244*	15	*0.591*	A761452	–	4	*0.157*	–	Vollhartmetall
	6-8	*0.236-0.315*	16	*0.630*	A762002	–	12	*0.472*	WB..0301..	Stahl, Wendeplattentyp
	6-8	*0.236-0.315*	27	*1.063*	A762202	–	12	*0.472*	WB..0301..	Hartmetall, Wendeplattentyp
	8-10	*0.315-0.394*	22	*0.866*	A763002	–	12	*0.472*	WB..0301..	Stahl, Wendeplattentyp
	8-10	*0.315-0.394*	37	*1.457*	A763202	–	12	*0.472*	WB..0301..	Hartmetall, Wendeplattentyp
	10-13	*0.394-0.512*	30	*1.181*	A765002	–	12	*0.472*	CC..0602..	Stahl, Wendeplattentyp
	10-13	*0.394-0.512*	55	*2.165*	A765202	–	12	*0.472*	CC..0602..	Hartmetall, Wendeplattentyp
	13-15,5	*0.512-0.610*	40	*1.575*	A760S20	A765R1	12	*0.472*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	13-15,5	*0.512-0.610*	60	*2.362*	A760E20	A765R1	12	*0.472*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	15,5-18	*0.610-0.709*	40	*1.575*	A760S20	A765R2	12	*0.472*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	15,5-18	*0.610-0.709*	60	*2.362*	A760E20	A765R2	12	*0.472*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	18-20	*0.709-0.787*	40	*1.575*	A760S20	A765R3	12	*0.472*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	18-20	*0.709-0.787*	60	*2.362*	A760E20	A765R3	12	*0.472*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
A760 03/ A760 13	6-8	*0.236-0.315*	16	*0.630*	A762003	–	16	*0.630*	WB..0301..	Stahl, Wendeplattentyp
	6-8	*0.236-0.315*	32	*1.260*	A762203	–	16	*0.630*	WB..0301..	Hartmetall, Wendeplattentyp
	8-10	*0.315-0.394*	22	*0.866*	A763003	–	16	*0.630*	WB..0301..	Stahl, Wendeplattentyp
	8-10	*0.315-0.394*	37	*1.457*	A763203	–	16	*0.630*	WB..0301..	Hartmetall, Wendeplattentyp
	10-13	*0.394-0.512*	30	*1.181*	A765003	–	16	*0.630*	CC..0602..	Stahl, Wendeplattentyp
	10-13	*0.394-0.512*	55	*2.165*	A765203	–	16	*0.630*	CC..0602..	Hartmetall, Wendeplattentyp
	13-15,5	*0.512-0.610*	40	*1.575*	A760S30	A765R1	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	13-15,5	*0.512-0.610*	70	*2.756*	A760E30	A765R1	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	15,5-18	*0.610-0.709*	40	*1.575*	A760S30	A765R2	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	15,5-18	*0.610-0.709*	70	*2.756*	A760E30	A765R2	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	18-20,5	*0.709-0.807*	50	*1.969*	A760S31	A765R1	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	18-20,5	*0.709-0.807*	80	*3.150*	A760E31	A765R1	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	20,5-23	*0.807-0.906*	50	*1.969*	A760S31	A765R2	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	20,5-23	*0.807-0.906*	80	*3.150*	A760E31	A765R2	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	23-25,5	*0.906-1.00*	50	*1.969*	A760S31	A765R3	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	23-25,5	*0.906-1.00*	80	*3.150*	A760E31	A765R3	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	25,5-28	*1.004-1.102*	50	*1.969*	A760S31	A765R4	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	25,5-28	*1.004-1.102*	80	*3.150*	A760E31	A765R4	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	28-30,5	*1.102-1.201*	50	*1.969*	A760S31	A765R5	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	28-30,5	*1.102-1.201*	80	*3.150*	A760E31	A765R5	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	30,5-33	*1.201-1.299*	50	*1.969*	A760S31	A765R6	16	*0.630*	CC..0602..	Stahlschaft mit Wendeplattenhalter
	30,5-33	*1.201-1.299*	80	*3.150*	A760E31	A765R6	16	*0.630*	CC..0602..	Hartmetallschaft mit Wendeplattenhalter
	33-35,5*	*1.299-1.398**	60	*2.362*	A760A32	A765R1	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	35,5-38*	*1.299-1.496**	60	*2.362*	A760A32	A765R2	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	38-40,5*	*1.496-1.594**	60	*2.362*	A760A32	A765R3	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	40,5-43*	*1.594-1.693**	60	*2.362*	A760A32	A765R4	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	43-45,5*	*1.693-1.791**	60	*2.362*	A760A32	A765R5	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	45,5-48*	*1.791-1.890**	60	*2.362*	A760A32	A765R6	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	48-50,5*	*1.890-1.988**	80	*3.150*	A760A33	A765R1	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	50,5-53*	*1.988-2.087**	80	*3.150*	A760A33	A765R2	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	53-55,5*	*2.087-2.185**	80	*3.150*	A760A33	A765R3	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	55,5-58*	*2.185-2.283**	80	*3.150*	A760A33	A765R4	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	58-60,5*	*2.283-2.382**	80	*3.150*	A760A33	A765R5	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter
	60,5-63*	*2.382-2.480**	80	*3.150*	A760A33	A765R6	16	*0.630*	CC..0602..	Aluminiumschaft mit Wendeplattenhalter

Für größere Durchmesser siehe Abschnitt Mehrzweckadapter (MPA).
* Bei Verwendung mit A760 13 ist keine Feinauswuchtung möglich.

Vielzweck-Adapter (MPA)

Für Köpfe FB 760



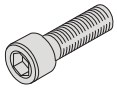


—Geeignet für digitale und analoge Köpfe Typ Axiabore™ Plus – nur Kopf A760 03*
—Zur Aufnahme eines Schaftes und eines Gegengewichts (zum Ausdrehen oder Zapfendrehen) oder von zwei Nutstechwerkzeughaltern (zum Plan-Nutstechen)
—Kühlung durch eine einstellbare Düse (3)

1. Schraube
2. Unterlegscheibe
3. Verstellbare Düse

		Bereich DCN-DCX ∅										
Bezeichnung	Produktnummer	Für Ausdreh		Zum Zapfendrehen		Zum Nutenstechen		HTB	LF	DMM	WB	Gewicht
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
BDA16BS25100	02595014	53,0 *2.087*	108,0 *4.252*	2,0 *0.079*	57,0 *2.244*	31,0 *1.220*	96,0 *3.780*	25,0 *0.984*	16,0 *0.630*	16,0 *0.630*	100,0 *3.937*	0,3 *0.660*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube	Unterlegscheibe
		
BDA16BS25100	950D0618	940ZC06

Zubehör

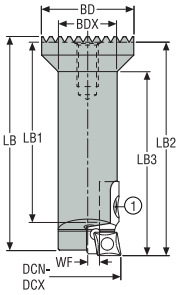
Für Kopf	Schlüssel für Pratze
BDA16BS25100	03HL05

*Bei Verwendung mit einem Kopf – Axialibrabore™ Plus – A760 13 ist keine Feinauswuchtung möglich, siehe Seite(n) 510
Wählen Sie die erforderlichen Komponenten für das Ausdrehen, Zapfendrehen oder Nutstechen aus. Siehe dazu die folgende(n) Seite(n) 525–536

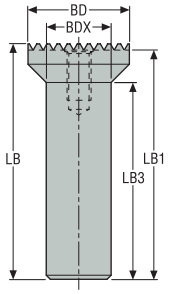
Schaft und Gegengewicht, zum Ausdrehen oder Zapfendrehen an einem MPA

Für Köpfe FB 760

Design A



Design B



—Passend für MPA
—Der Schaft kann zum Ausdrehen oder zum Zapfendrehen verwendet werden.
—Nimmt die gleichen Wendeplattenhalter wie die modularen Ausdrehschäfte auf

1. Schraube

			** Bereich DCN-DCX ∅												
Bezeichnung	Produkt-nummer	Abb.	Für Ausdreh		Zum Zapfendrehen		LB	LB1	LB2	LB3	WF	BDX	BD	Gewicht	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BAS25MH1660	02595019	Schaft*	53,0 *2.087*	108,0 *4.252*	2,0 *0.079*	57,0 *2.244*	58,5 *2.303*	48,5 *1.909*	58,5 *2.303*	50,0 *1.969*	4,0 *0.157*	16,0 *0.630*	25,0 *0.984*	0,1 *0.2*	A
BAS25CW1660	02595016	Gegenge-wicht	53,0 *2.087*	108,0 *4.252*	2,0 *0.079*	57,0 *2.244*	58,0 *2.283*	56,6 *2.228*	–	48,5 *1.909*	–	16,0 *0.630*	25,0 *0.984*	0,2 *0.4*	B

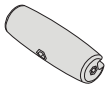
*Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 519

**Kapazitäten beim Ausdrehen und Zapfendrehen beziehen sich auf den ausgewählten Wendeplattenhalter und die Einstellposition der Schäfte mithilfe der Auswahl-Tabelle „Wendeplattenhalter zum Ausdrehen oder Zapfendrehen“ auf Seite(n) 525-536

Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube
BAS25CW1660	–
BAS25MH1660	C04008-T15P

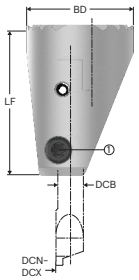
Zubehör

Für Halter	Schlüssel für Pratze	Schlüssel (Quergriff)
		
BAS25CW1660	–	–
BAS25MH1660	H6B-T15P	DOUBLE-T

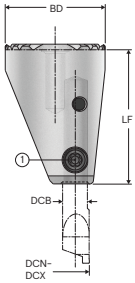
Nutstechwerkzeughalter, zum Plan-Nutstechen an einem MPA

Für Köpfe FB 760

I



E



—Passend für MPA
—Ein Nutstechwerkzeughalter wird entweder zum Halten eines Nutstechwerkzeugs oder als Gegengewicht verwendet.

1. Spannschraube

Bezeichnung	Produktnummer	Abb.	* Bereich DCN-DCX ∅ mm *Zoll*		DCB mm *Zoll*	LF mm *Zoll*	BD mm *Zoll*	Gewicht kg *lbs*	Abb.
BAS25FGI35	02595021	Aufnahmen zum Nutenstechen I (innen)*	19,0 *0.748*	76,0 *2.992*	6,0 *0.236*	35,0 *1.378*	25,0 *0.984*	0,1 *0.2*	I (Intern)
BAS25FGE35	02595020	Aufnahmen zum Nutenstechen E (außen)*	39,0 *1.535*	96,0 *3.780*	6,0 *0.236*	35,0 *1.378*	25,0 *0.984*	0,1 *0.2*	E (Extern)

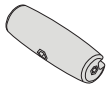
*Nutstechwerkzeuge müssen separat bestellt werden, siehe Seite(n) 524

* Die Kapazität beim Nutstechen bezieht sich auf das ausgewählte Nutstechwerkzeug sowie die Einstellposition und Ausrichtung des Nutstechwerkzeughalters, unter Verwendung der Auswahl-Tabelle „Nutstechwerkzeug gegen den Zapfen (oder gegen die Bohrung)" auf Seite(n) 525-536

Ersatzteile, im Lieferumfang enthalten

Für Halter	Befestigungsschraube
BAS25FGE35	950L0607T15P
BAS25FGI35	950L0607T15P

Zubehör

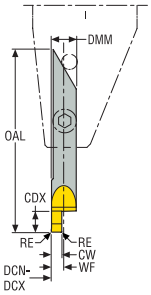
Für Halter	Schlüssel (Quergriff)	Spannschlüssel
		
BAS25FGE35	DOUBLE-T	H6B-T15P
BAS25FGI35	DOUBLE-T	H6B-T15P

Einstechwerkzeuge

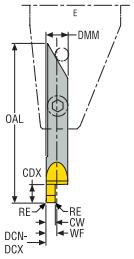
Für Köpfe FB 760

—Kann je nach Kapazität entweder für „Außen"- oder „Innen"-Nutstechwerkzeughalter verwendet werden.

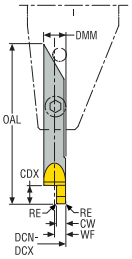
A



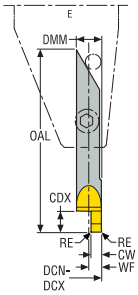
B



C



D



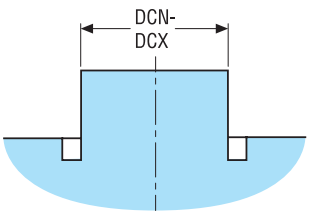
*** Bereich DCN-DCX ∅**

Bezeichnung	Produktnummer	Abb.	Ausführung A		Ausführung B		Ausführung C		Ausführung D		OAL	CW	RE	DMM	WF	Max. Einstechtiefe **	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
AFG0629101582	02595028	Außen	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	1,0 *0.039*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	2,0 *0.079*	0,07 *0.150*
AFG0629151582	02595029	Außen	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	1,5 *0.059*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	3,0 *0.118*	0,07 *0.150*
AFG0629201582	02595031	Außen	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	2,0 *0.079*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	4,0 *0.157*	0,1 *0.220*
AFG0629251582	02595032	Außen	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	2,5 *0.098*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	5,0 *0.197*	0,1 *0.220*
AFG0629301582	02595033	Außen	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	3,0 *0.118*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	6,0 *0.236*	0,1 *0.220*
AFG0629101581	02595022	Innen	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	1,0 *0.039*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	2,0 *0.079*	0,1 *0.220*
AFG0629151581	02595023	Innen	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	1,5 *0.059*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	3,0 *0.118*	0,07 *0.150*
AFG0629201581	02595024	Innen	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	2,0 *0.079*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	4,0 *0.157*	0,1 *0.220*
AFG0629251581	02595026	Innen	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	2,5 *0.098*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	5,0 *0.197*	0,1 *0.220*
AFG0629301581	02595027	Innen	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	3,0 *0.118*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	6,0 *0.236*	0,1 *0.220*

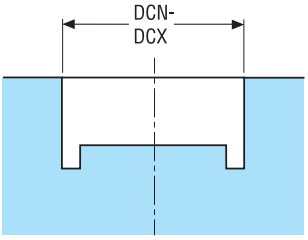
* Die Kapazität beim Nutstechen bezieht sich auf das ausgewählte Nutstechwerkzeug sowie die Einstellposition und Ausrichtung des Nutstechwerkzeughalters, unter Verwendung der Auswahl-Tabelle „Nutstechwerkzeug gegen den Zapfen (oder gegen die Bohrung)" auf Seite(n) 525–536

** Max. Nutstechtiefe CDX

Stechwerkzeug, außen

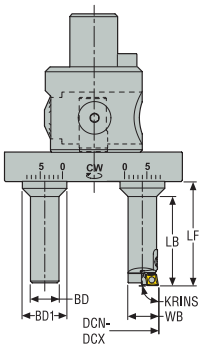


Stechwerkzeug, innen



Auswahl-Tabelle:
Für Köpfe FB 760 passende Ausdrehwerkzeuge und Wendeplattenhalter, Metrisch

Wählen Sie einen geeigneten Wendeplattenhalter aus, und notieren Sie die Position des Schaftes am MPA, um die erforderliche Bohrungskapazität zu erhalten.
Hinweis: Eine Ausdrehkombination besteht aus:
- einen – Axiabore™ Plus – Kopf (A760 03)
- einen MPA (BDA16BS25100)
- einen Schaft (BAS25MH1660)
- ein Gegengewicht (BAS25CW1660).
- einen Wendeplattenhalter (A765R.), aus der Tabelle auszuwählen
- eine Wendeplatte

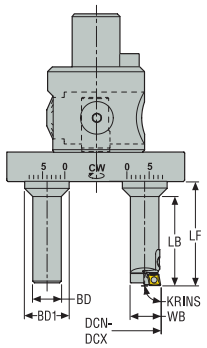


Bereich DCN-DCX mm*	Wendeplattenhalter-Bezeichnung	Schaftposition	Abmessungen in mm					Anschnittwinkel	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB	KRINS°	
53-55,5	A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
55,5-58	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
58-60,5	A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	0	16	25	58,5	50	19,5	90°	CC..0602..
60,5-63	A765 R2	1	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	0	16	25	58,5	50	20,7	90°	CC..0602..
63-65,5	A765 R1	2	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	1	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
65,5-68	A765 R2	2	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	1	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	0	16	25	58,5	50	23,3	90°	CC..0602..
68-70,5	A765 R1	3	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	2	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	1	16	25	58,5	50	22	90°	CC..0602..
70,5-73	A765 R2	3	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	2	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
73-75,5	A765 R1	4	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	3	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	2	16	25	58,5	50	22	90°	CC..0602..
75,5-78	A765 R2	4	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	3	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	2	16	25	58,5	50	23,2	90°	CC..0602..
78-80,5	A765 R1	5	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	4	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	3	16	25	58,5	50	22	90°	CC..0602..
80,5-83	A765 R2	5	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	4	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	3	16	25	58,5	50	23,2	90°	CC..0602..
83-85,5	A765 R1	6	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	5	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	4	16	25	58,5	50	22	90°	CC..0602..
85,5-88	A765 R2	6	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	5	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	4	16	25	58,5	50	23,2	90°	CC..0602..
88-90,5	A765 R1	7	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	6	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	5	16	25	58,5	50	22	90°	CC..0602..
90,5-93	A765 R2	7	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	6	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	5	16	25	58,5	50	23,2	90°	CC..0602..
93-95,5	A765 R1	8	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
95,5-98	A765 R2	8	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	7	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	6	16	25	58,5	50	23,2	90°	CC..0602..
98-100,5	A765 R3	8	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	7	16	25	58,5	50	22	90°	CC..0602..
100,5-103	A765 R4	8	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	7	16	25	58,5	50	23,2	90°	CC..0602..
103-105,5	A765 R5	8	16	25	58,5	50	22	90°	CC..0602..
105,5-108	A765 R6	8	16	25	58,5	50	23,2	90°	CC..0602..

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar.
Detaillierte Beschreibung der Wendeplattenhalter siehe Seite(n) 519

Auswahl-Tabelle:
Für Köpfe FB 760 passende Ausdrehwerkzeuge und Wendeplattenhalter, Zoll

Wählen Sie einen geeigneten Wendeplattenhalter aus, und notieren Sie die Position des Schaftes am MPA, um die erforderliche Bohrungskapazität zu erhalten.
Hinweis: Eine Ausdrehkombination besteht aus:
- einen – Axiabore™ Plus – Kopf (A760 03)
- einen MPA (BDA16BS25100)
- einen Schaft (BAS25MH1660)
- ein Gegengewicht (BAS25CW1660).
- einen Wendeplattenhalter (A765R.), aus der Tabelle auszuwählen
- eine Wendeplatte

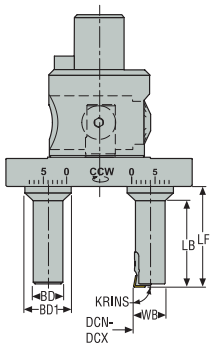


Kapazität DCN-DCX ∅ Zoll*	Wendeplattenhalter-Bezeichnung	Schaftposition	Abmessungen in Zoll					Anschnittwinkel	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB	KRINS°	
2.087-2.185	A765 R1	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
2.185-2.283	A765 R2	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
2.283-2.382	A765 R1	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
2.382-2.480	A765 R2	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
2.480-2.579	A765 R1	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
2.579-2.677	A765 R2	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.917*	90°	CC..0602..
2.677-2.776	A765 R1	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
2.776-2.874	A765 R2	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
2.874-2.972	A765 R1	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
2.972-3.071	A765 R2	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.071-3.169	A765 R1	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.169-3.268	A765 R2	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.268-3.366	A765 R1	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.366-3.465	A765 R2	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.465-3.563	A765 R1	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.563-3.661	A765 R2	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.661-3.760	A765 R1	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.760-3.858	A765 R2	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.858-3.957	A765 R3	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.957-4.055	A765 R4	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
4.055-4.154	A765 R5	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
4.154-4.252	A765 R6	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar.
Detaillierte Beschreibung der Wendeplattenhalter siehe Seite(n) 519

Auswahl-Tabelle:
Wendeplattenhalter zum Zapfendrehen mit MPA, für Köpfe FB 760, Metrisch

Wählen Sie einen geeigneten Wendeplattenhalter aus, und notieren Sie die Position des Schaftes am MPA, um die erforderliche Bohrungskapazität zu erhalten.
Hinweis: Eine Zapfendreh-Kombination erfordert:
- einen – Axiabore™ Plus – Kopf (A760 03)
- einen MPA (BDA16BS25100)
- einen Schaft (BAS25MH1660)
- ein Gegengewicht (BAS25CW1660).
- einen Wendeplattenhalter (A765R.), aus der Tabelle auszuwählen
- eine Wendeplatte

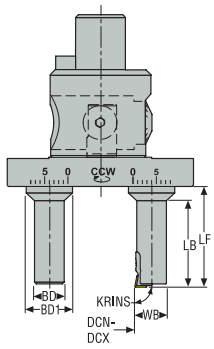


Bereich DCN-DCX mm*	Wendeplattenhalter-Bezeichnung	Schaftposition	Abmessungen in mm					Anschnittwinkel	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB	KRINS°	
2-4,5	A765 R6	0	16	25	58,5	50	23,2	90°	CC..0602..
4,5-7	A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
7-9,5	A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	0	16	25	58,5	50	20,7	90°	CC..0602..
9,5-12	A765 R5	1	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	0	16	25	58,5	50	19,5	90°	CC..0602..
12-14,5	A765 R6	2	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	1	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
14,5-17	A765 R5	2	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	1	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
17-19,5	A765 R6	3	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	2	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	1	16	25	58,5	50	18,2	90°	CC..0602..
19,5-22	A765 R5	3	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	2	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
22-24,5	A765 R6	4	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	3	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	2	16	25	58,5	50	18,2	90°	CC..0602..
24,5-27	A765 R5	4	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	3	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	2	16	25	58,5	50	17	90°	CC..0602..
27-29,5	A765 R6	5	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	4	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	3	16	25	58,5	50	18,2	90°	CC..0602..
29,5-32	A765 R5	5	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	4	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	3	16	25	58,5	50	17	90°	CC..0602..
32-34,5	A765 R6	6	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	5	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	4	16	25	58,5	50	18,2	90°	CC..0602..
34,5-37	A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	5	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	4	16	25	58,5	50	17	90°	CC..0602..
37-39,5	A765 R6	7	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	6	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	5	16	25	58,5	50	18,2	90°	CC..0602..
39,5-42	A765 R5	7	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	6	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	5	16	25	58,5	50	17	90°	CC..0602..
42-44,5	A765 R6	8	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	7	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	6	16	25	58,5	50	18,2	90°	CC..0602..
44,5-47	A765 R5	8	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	6	16	25	58,5	50	17	90°	CC..0602..
47-49,5	A765 R4	8	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	7	16	25	58,5	50	18,2	90°	CC..0602..
49,5-52	A765 R3	8	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	7	16	25	58,5	50	17	90°	CC..0602..
52-54,5	A765 R2	8	16	25	58,5	50	18,2	90°	CC..0602..
54,5-57	A765 R1	8	16	25	58,5	50	17	90°	CC..0602..

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar.
Detaillierte Beschreibung der Wendeplattenhalter siehe Seite(n) 519

Auswahl-Tabelle:
Wendeplattenhalter zum Zapfendrehen mit MPA, für Köpfe FB 760, Zoll

Wählen Sie einen geeigneten Wendeplattenhalter aus, und notieren Sie die Position des Schaftes am MPA, um die erforderliche Bohrungskapazität zu erhalten.
Hinweis: Eine Zapfendreh-Kombination erfordert:
- einen – Axiabore™ Plus – Kopf (A760 03)
- einen MPA (BDA16BS25100)
- einen Schaft (BAS25MH1660)
- ein Gegengewicht (BAS25CW1660).
- einen Wendeplattenhalter (A765R.), aus der Tabelle auszuwählen
- eine Wendeplatte

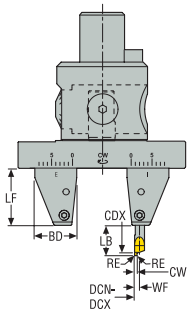


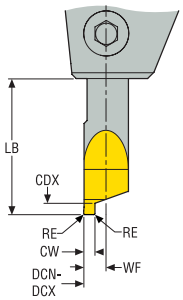
Kapazität DCN-DCX ∅ Zoll*	Wendeplattenhalter-Bezeichnung	Schaftposition	Abmessungen in Zoll					Anschnittwinkel	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB	KRINS°	
0.079-0.177	A765 R6	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
0.177-0.276	A765 R5	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
0.276-0.374	A765 R6	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
0.374-0.472	A765 R5	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
0.472-0.571	A765 R6	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
0.571-0.669	A765 R5	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
0.669-0.768	A765 R6	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
0.768-0.866	A765 R5	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
0.866-0.965	A765 R6	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
0.965-1.063	A765 R5	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.063-1.161	A765 R6	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.161-1.260	A765 R5	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.260-1.358	A765 R6	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.358-1.457	A765 R5	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.457-1.555	A765 R6	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.555-1.654	A765 R5	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.654-1.654	A765 R6	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.654-1.850	A765 R5	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.850-1.949	A765 R4	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.949-2.047	A765 R3	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
2.047-2.146	A765 R2	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
2.146-2.244	A765 R1	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar.
Detaillierte Beschreibung der Wendeplattenhalter siehe Seite(n) 519

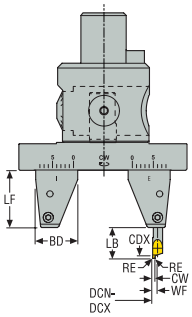
Auswahl-Tabelle:
Nutstechwerkzeug – gegen den Zapfen – zum Nutstechen mit MPA, für Köpfe FB 760, Metrisch

Montagekoffer 1

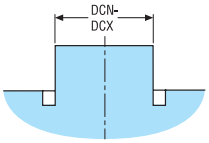




Montagekoffer 2



Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.



Hinweis: Eine Kombination zum Nutstechen – gegen den Zapfen – erfordert:

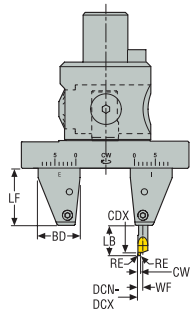
- ein – Axiabore™ Plus – Kopf (A760 03)
- ein MPA (BDA16BS25100)
- ein I (Innenposition) und ein E (Außenposition) Nutstechwerkzeughalter (BAS25FGI35 und BAS25FGE35), um entweder ein Nutstechwerkzeug zu halten oder als Gegengewicht zu fungieren (siehe Einstellposition in der Tabelle)
- ein Nutstechwerkzeug – gegen den Zapfen – (AFG...82), das in Bezug auf Nutbreite und Durchmesser aus der Tabelle ausgewählt werden muss.

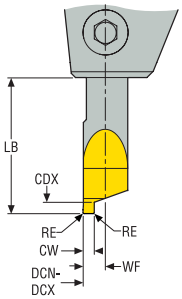
Bereich DCN-DCX mm*	Bezeichnung Nutstechwerkzeug „gegen den Zapfen“	Position Nutstechwerkzeughalter**	Abb.	Abmessungen in mm BD	CW	LF	LB	WF	RE	Max. Einstechtiefe CDX
19-24	AFG0629 10 1582	0-I	1	25	1	34	18	2,95	0,15	2,0
24-29		1-I	1	25	1	34	18	2,95	0,15	2,0
29-34		2-I	1	25	1	34	18	2,95	0,15	2,0
34-39		3-I	1	25	1	34	18	2,95	0,15	2,0
39-44		**0-E** / 4-I	1/2	25	1	34	18	2,95	0,15	2,0
44-49		**1-E** / 5-I	1/2	25	1	34	18	2,95	0,15	2,0
49-54		**2-E** / 6-I	1/2	25	1	34	18	2,95	0,15	2,0
54-59		**3-E** / 7-I	1/2	25	1	34	18	2,95	0,15	2,0
59-64		**4-E** / 8-I	1/2	25	1	34	18	2,95	0,15	2,0
64-69		5-E	2	25	1	34	18	2,95	0,15	2,0
69-74		6-E	2	25	1	34	18	2,95	0,15	2,0
74-79		7-E	2	25	1	34	18	2,95	0,15	2,0
79-84		8-E	2	25	1	34	18	2,95	0,15	2,0
19-24	AFG0629 15 1582	0-I	1	25	1,5	34	18	2,95	0,15	3,0
24-29		1-I	1	25	1,5	34	18	2,95	0,15	3,0
29-34		2-I	1	25	1,5	34	18	2,95	0,15	3,0
34-39		3-I	1	25	1,5	34	18	2,95	0,15	3,0
39-44		**0-E** / 4-I	1/2	25	1,5	34	18	2,95	0,15	3,0
44-49		**1-E** / 5-I	1/2	25	1,5	34	18	2,95	0,15	3,0
49-54		**2-E** / 6-I	1/2	25	1,5	34	18	2,95	0,15	3,0
54-59		**3-E** / 7-I	1/2	25	1,5	34	18	2,95	0,15	3,0
59-64		**4-E** / 8-I	1/2	25	1,5	34	18	2,95	0,15	3,0
64-69		5-E	2	25	1,5	34	18	2,95	0,15	3,0
69-74		6-E	2	25	1,5	34	18	2,95	0,15	3,0
74-79		7-E	2	25	1,5	34	18	2,95	0,15	3,0
79-84		8-E	2	25	1,5	34	18	2,95	0,15	3,0
19-24	AFG0629 20 1582	0-I	1	25	2	34	18	2,95	0,15	4,0
24-29		1-I	1	25	2	34	18	2,95	0,15	4,0
29-34		2-I	1	25	2	34	18	2,95	0,15	4,0
34-39		3-I	1	25	2	34	18	2,95	0,15	4,0
39-44		**0-E** / 4-I	1/2	25	2	34	18	2,95	0,15	4,0
44-49		**1-E** / 5-I	1/2	25	2	34	18	2,95	0,15	4,0
49-54		**2-E** / 6-I	1/2	25	2	34	18	2,95	0,15	4,0
54-59		**3-E** / 7-I	1/2	25	2	34	18	2,95	0,15	4,0
59-64		**4-E** / 8-I	1/2	25	2	34	18	2,95	0,15	4,0
64-69		5-E	2	25	2	34	18	2,95	0,15	4,0
69-74		6-E	2	25	2	34	18	2,95	0,15	4,0
74-79		7-E	2	25	2	34	18	2,95	0,15	4,0
79-84		8-E	2	25	2	34	18	2,95	0,15	4,0

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.
Detaillierte Beschreibung der Nutstechwerkzeuge siehe Seite(n) 524

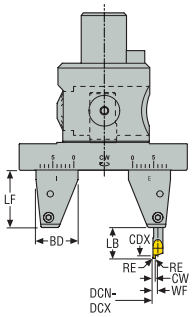
Auswahl-Tabelle:
Nutstechwerkzeug – gegen den Zapfen – zum Nutstechen mit MPA, für Köpfe FB 760, Metrisch

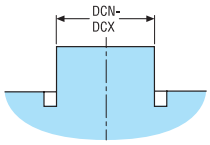
Montagekoffer 1





Montagekoffer 2



	Bereich DCN-DCX mm*	Bezeichnung Nutstechwerkzeug „gegen den Zapfen“	Position Nutstech-werkzeughal-ter**	Abb.	Abmessungen in mm						Max. Einstech-tiefe CDX
					BD	CW	LF	LB	WF	RE	
Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.	19-24	AFG0629 25 1582	0-I	1	25	2,5	34	18	2,95	0,15	5,0
	24-29		1-I	1	25	2,5	34	18	2,95	0,15	5,0
	29-34		2-I	1	25	2,5	34	18	2,95	0,15	5,0
	34-39		3-I	1	25	2,5	34	18	2,95	0,15	5,0
	39-44		**0-E** / 4-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	44-49		**1-E** / 5-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	49-54		**2-E** / 6-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	54-59		**3-E** / 7-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	59-64		**4-E** / 8-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	64-69		5-E	2	25	2,5	34	18	2,95	0,15	5,0
	69-74		6-E	2	25	2,5	34	18	2,95	0,15	5,0
	74-79		7-E	2	25	2,5	34	18	2,95	0,15	5,0
	79-84		8-E	2	25	2,5	34	18	2,95	0,15	5,0
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	24-29		1-I	1	25	3	34	18	2,95	0,15	6,0
	29-34		2-I	1	25	3	34	18	2,95	0,15	6,0
	34-39		3-I	1	25	3	34	18	2,95	0,15	6,0
	39-44		**0-E** / 4-I	1/2	25	3	34	18	2,95	0,15	6,0
	44-49		**1-E** / 5-I	1/2	25	3	34	18	2,95	0,15	6,0
	49-54		**2-E** / 6-I	1/2	25	3	34	18	2,95	0,15	6,0
	54-59		**3-E** / 7-I	1/2	25	3	34	18	2,95	0,15	6,0
	59-64		**4-E** / 8-I	1/2	25	3	34	18	2,95	0,15	6,0
	64-69		5-E	2	25	3	34	18	2,95	0,15	6,0
	69-74		6-E	2	25	3	34	18	2,95	0,15	6,0
	74-79		7-E	2	25	3	34	18	2,95	0,15	6,0
	79-84		8-E	2	25	3	34	18	2,95	0,15	6,0

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Detaillierte Beschreibung der Nutstechwerkzeuge siehe Seite(n) 524

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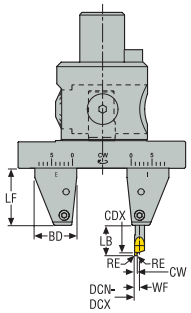
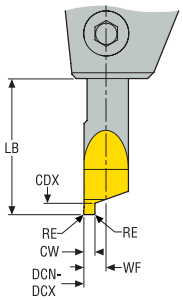
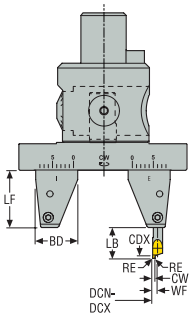
Montagekoffer 1





Montagekoffer 2



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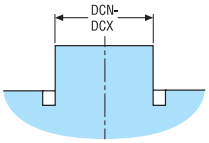

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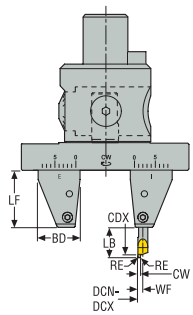
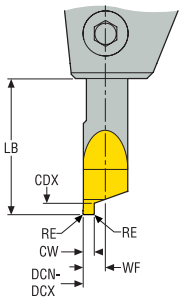
Kapazität DCN-DCX ∅ Zoll*	Bezeichnung Nutstechwerkzeug „gegen den Zapfen“	Position Nutstech-werkzeughalter**	Abb.	Abmessungen in Zoll BD	CW	LF	LB	WF	RE	Max. Einstech-tiefe CDX
0.748-0.945	AFG0629 10 1582	0-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
0.945-1.142		1-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.142-1.339		2-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.339-1.535		3-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.520-2.717		5-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.717-2.913		6-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.913-3.110		7-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.110-3.307		8-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
0.748-0.945	AFG0629 15 1582	0-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
0.945-1.142		1-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.142-1.339		2-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.339-1.535		3-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.520-2.717		5-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.717-2.913		6-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.913-3.110		7-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.110-3.307		8-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
0.748-0.945	AFG0629 20 1582	0-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
0.945-1.142		1-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.142-1.339		2-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.339-1.535		3-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.520-2.717		5-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.717-2.913		6-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.913-3.110		7-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.110-3.307		8-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.
Detaillierte Beschreibung der Nutstechwerkzeuge siehe Seite(n) 524

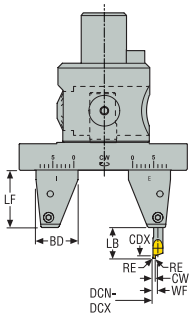
Auswahl-Tabelle:
Nutstechwerkzeug – gegen den Zapfen – zum Nutstechen mit MPA, für Köpfe FB 760, Zoll

Montagekoffer 1

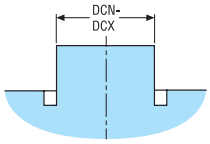




Montagekoffer 2



	Kapazität DCN-DCX ∅ Zoll*	Bezeichnung Nutstechwerkzeug „gegen den Zapfen“	Position Nutstech-werkzeughal-ter**	Abb.	Abmessungen in Zoll						Max. Einstech-tiefe CDX
					BD	CW	LF	LB	WF	RE	
Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.	*0.748-0.945*	AFG0629 25 1582	0-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	0.945-1.142		1-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.142-1.339		2-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.339-1.535		3-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.520-2.717		5-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.717-2.913		6-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.913-3.110		7-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	3.110-3.307		8-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
Hinweis: Eine Kombination zum Nutstechen – gegen den Zapfen – erfordert: – ein – Axiabore™ Plus – Kopf (A760 03) – ein MPA (BDA16BS25100) – ein I (Innenposition) und ein E (Außenposition) Nutstech-werkzeughalter (BAS25FGI35 und BAS25FGE35), um entweder ein Nutstechwerkzeug zu halten oder als Gegenge-wicht zu fungieren (siehe Einstellposition in der Tabelle) – ein Nutstechwerkzeug – gegen den Zapfen – (AFG...82), das in Bezug auf Nutbreite und Durchmesser aus der Tabelle ausgewählt werden muss.	*0.748-0.945*	AFG0629 30 1582	0-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	0.945-1.142		1-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.142-1.339		2-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.339-1.535		3-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.520-2.717		5-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.717-2.913		6-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.913-3.110		7-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	3.110-3.307		8-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236

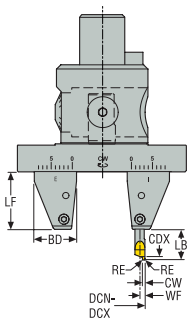


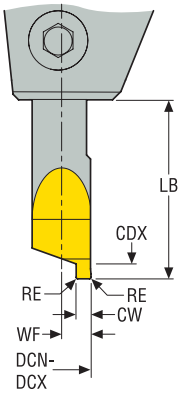
* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.

Detaillierte Beschreibung der Nutstechwerkzeuge siehe Seite(n) 524

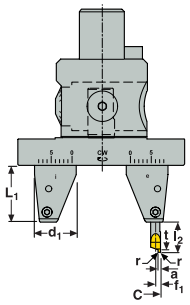
Auswahl-Tabelle:
Nutstechwerkzeug – gegen die Bohrung – zum Nutstechen mit MPA, für Köpfe FB 760, Metrisch

Montagekoffer 3

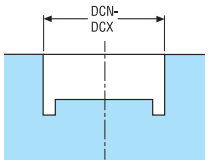




Montagekoffer 4



Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.



Hinweis: Eine Kombination zum Nutstechen – gegen die Bohrung – erfordert:

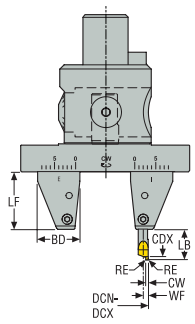
- ein – Axiabore™ Plus – Kopf (A760 03)
- ein MPA (BDA16BS25100)
- ein I (Innenposition) und ein E (Außenposition) Nutstechwerkzeughalter (BAS25FGI35 und BAS25FGE35), um entweder ein Nutstechwerkzeug zu halten oder als Gegengewicht zu fungieren (siehe Einstellposition in der Tabelle)
- ein Nutstechwerkzeug – gegen die Bohrung – (AFG...81), das in Bezug auf Nutbreite und Durchmesser aus der Tabelle ausgewählt werden muss.

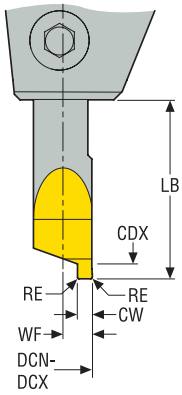
Bereich DCN-DCX mm*	Bezeichnung Nutstechwerkzeug „gegen die Bohrung“	Position Nutstechwerkzeughalter**	Abb.	Abmessungen in mm BD	CW	LF	LB	WF	RE	Max. Einstechtiefe CDX
31-36	AFG0629 10 1581	0-I	3	25	1	34	18	2,95	0,15	2,0
36-41		1-I	3	25	1	34	18	2,95	0,15	2,0
41-46		2-I	3	25	1	34	18	2,95	0,15	2,0
46-51		3-I	3	25	1	34	18	2,95	0,15	2,0
51-56		**0-E** / 4-I	3/4	25	1	34	18	2,95	0,15	2,0
56-61		**1-E** / 5-I	3/4	25	1	34	18	2,95	0,15	2,0
61-66		**2-E** / 6-I	3/4	25	1	34	18	2,95	0,15	2,0
66-71		**3-E** / 7-I	3/4	25	1	34	18	2,95	0,15	2,0
71-76		**4-E** / 8-I	3/4	25	1	34	18	2,95	0,15	2,0
76-81		5-E	4	25	1	34	18	2,95	0,15	2,0
81-86		6-E	4	25	1	34	18	2,95	0,15	2,0
86-91		7-E	4	25	1	34	18	2,95	0,15	2,0
91-96		8-E	4	25	1	34	18	2,95	0,15	2,0
31-36	AFG0629 15 1581	0-I	3	25	1,5	34	18	2,95	0,15	3,0
39-41		1-I	3	25	1,5	34	18	2,95	0,15	3,0
41-46		2-I	3	25	1,5	34	18	2,95	0,15	3,0
46-51		3-I	3	25	1,5	34	18	2,95	0,15	3,0
51-56		**0-E** / 4-I	3/4	25	1,5	34	18	2,95	0,15	3,0
56-61		**1-E** / 5-I	3/4	25	1,5	34	18	2,95	0,15	3,0
61-66		**2-E** / 6-I	3/4	25	1,5	34	18	2,95	0,15	3,0
66-71		**3-E** / 7-I	3/4	25	1,5	34	18	2,95	0,15	3,0
71-76		**4-E** / 8-I	3/4	25	1,5	34	18	2,95	0,15	3,0
76-81		5-E	4	25	1,5	34	18	2,95	0,15	3,0
81-86		6-E	4	25	1,5	34	18	2,95	0,15	3,0
86-91		7-E	4	25	1,5	34	18	2,95	0,15	3,0
91-96		8-E	4	25	1,5	34	18	2,95	0,15	3,0
31-36	AFG0629 20 1581	0-I	3	25	2	34	18	2,95	0,15	4,0
39-41		1-I	3	25	2	34	18	2,95	0,15	4,0
41-46		2-I	3	25	2	34	18	2,95	0,15	4,0
46-51		3-I	3	25	2	34	18	2,95	0,15	4,0
51-56		**0-E** / 4-I	3/4	25	2	34	18	2,95	0,15	4,0
56-61		**1-E** / 5-I	3/4	25	2	34	18	2,95	0,15	4,0
61-66		**2-E** / 6-I	3/4	25	2	34	18	2,95	0,15	4,0
66-71		**3-E** / 7-I	3/4	25	2	34	18	2,95	0,15	4,0
71-76		**4-E** / 8-I	3/4	25	2	34	18	2,95	0,15	4,0
76-81		5-E	4	25	2	34	18	2,95	0,15	4,0
81-86		6-E	4	25	2	34	18	2,95	0,15	4,0
86-91		7-E	4	25	2	34	18	2,95	0,15	4,0
91-96		8-E	4	25	2	34	18	2,95	0,15	4,0

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.
Detaillierte Beschreibung der Nutstechwerkzeuge siehe Seite(n) 524

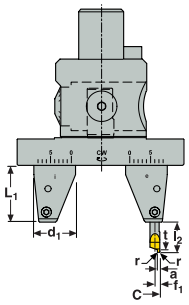
Auswahl-Tabelle:
Nutstechwerkzeug – gegen die Bohrung – zum Nutstechen mit MPA, für Köpfe FB 760, Metrisch

Montagekoffer 3

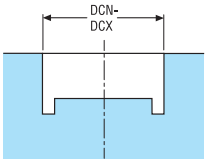




Montagekoffer 4



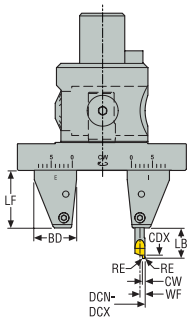
	Bereich DCN-DCX mm*	Bezeichnung Nutstechwerkzeug „gegen die Bohrung“	Position Nutstech-werkzeughal-ter**	Abb.	Abmessungen in mm BD	CW	LF	LB	WF	RE	Max. Einstech-tiefe CDX
Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.	31-36	AFG0629 25 1581	0-I	3	25	2,5	34	18	2,95	0,15	5,0
	36-41		1-I	3	25	2,5	34	18	2,95	0,15	5,0
	41-46		2-I	3	25	2,5	34	18	2,95	0,15	5,0
	46-51		3-I	3	25	2,5	34	18	2,95	0,15	5,0
	51-56		**0-E** / 4-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	56-61		**1-E** / 5-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	61-66		**2-E** / 6-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	66-71		**3-E** / 7-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	71-76		**4-E** / 8-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	76-81		5-E	4	25	2,5	34	18	2,95	0,15	5,0
	81-86		6-E	4	25	2,5	34	18	2,95	0,15	5,0
	86-91		7-E	4	25	2,5	34	18	2,95	0,15	5,0
	91-96		8-E	4	25	2,5	34	18	2,95	0,15	5,0
Hinweis: Eine Kombination zum Nutstechen – gegen die Bohrung – erfordert: – ein – Axiabore™ Plus – Kopf (A760 03) – ein MPA (BDA16BS25100) – ein I (Innenposition) und ein E (Außenposition) Nutstech-werkzeughalter (BAS25FGI35 und BAS25FGE35), um entweder ein Nutstechwerkzeug zu halten oder als Gegenge-wicht zu fungieren (siehe Einstellposition in der Tabelle) – ein Nutstechwerkzeug – gegen die Bohrung – (AFG...81), das in Bezug auf Nutbreite und Durchmesser aus der Tabelle ausgewählt werden muss.	31-36	AFG0629 30 1581	0-I	3	25	3	34	18	2,95	0,15	6,0
	39-41		1-I	3	25	3	34	18	2,95	0,15	6,0
	41-46		2-I	3	25	3	34	18	2,95	0,15	6,0
	46-51		3-I	3	25	3	34	18	2,95	0,15	6,0
	51-56		**0-E** / 4-I	3/4	25	3	34	18	2,95	0,15	6,0
	56-61		**1-E** / 5-I	3/4	25	3	34	18	2,95	0,15	6,0
	61-66		**2-E** / 6-I	3/4	25	3	34	18	2,95	0,15	6,0
	66-71		**3-E** / 7-I	3/4	25	3	34	18	2,95	0,15	6,0
	71-76		**4-E** / 8-I	3/4	25	3	34	18	2,95	0,15	6,0
	76-81		5-E	4	25	3	34	18	2,95	0,15	6,0
	81-86		6-E	4	25	3	34	18	2,95	0,15	6,0
	86-91		7-E	4	25	3	34	18	2,95	0,15	6,0
	91-96		8-E	4	25	3	34	18	2,95	0,15	6,0

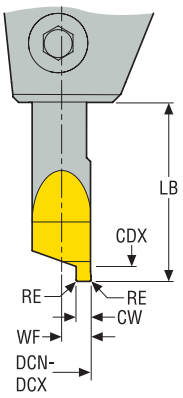


* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.
Detaillierte Beschreibung der Nutstechwerkzeuge siehe Seite(n) 524

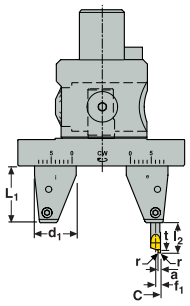
Auswahl-Tabelle:
Nutstechwerkzeug – gegen die Bohrung – zum Nutstechen mit MPA, für Köpfe FB 760, Zoll

Montagekoffer 3

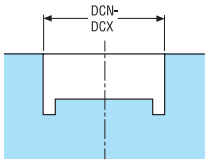




Montagekoffer 4



Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.



Hinweis: Eine Kombination zum Nutstechen – gegen die Bohrung – erfordert:

- ein – Axiabore™ Plus – Kopf (A760 03)
- ein MPA (BDA16BS25100)
- ein I (Innenposition) und ein E (Außenposition) Nutstechwerkzeughalter (BAS25FGI35 und BAS25FGE35), um entweder ein Nutstechwerkzeug zu halten oder als Gegengewicht zu fungieren (siehe Einstellposition in der Tabelle)
- ein Nutstechwerkzeug – gegen die Bohrung – (AFG...81), das in Bezug auf Nutbreite und Durchmesser aus der Tabelle ausgewählt werden muss.

Kapazität DCN-DCX ∅ Zoll*	Bezeichnung Nutstechwerkzeug „gegen die Bohrung“	Position Nutstech-werkzeughal-ter**	Abb.	Abmessungen in Zoll						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
1.220-1.417	AFG0629 10 1581	0-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.417-1.614		1-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.614-1.811		2-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.811-2.008		3-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.992-3.189		5-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.189-3.386		6-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.386-3.583		7-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.583-3.780		8-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.220-1.417	AFG0629 15 1581	0-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.417-1.614		1-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.614-1.811		2-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.811-2.008		3-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.992-3.189		5-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.189-3.386		6-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.386-3.583		7-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.583-3.780		8-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.220-1.417	AFG0629 20 1581	0-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.417-1.614		1-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.614-1.811		2-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.811-2.008		3-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.992-3.189		5-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.189-3.386		6-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.386-3.583		7-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.583-3.780		8-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157

* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.
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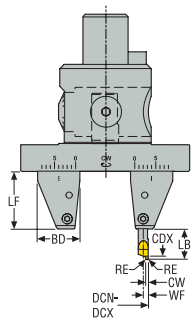
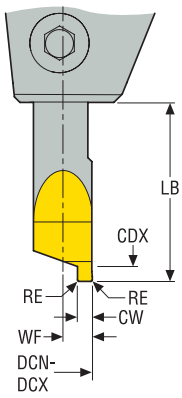
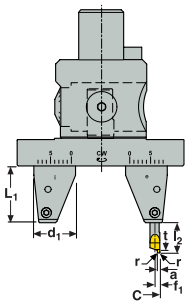
Auswahl-Tabelle:
Nutstechwerkzeug – gegen die Bohrung – zum Nutstechen mit MPA, für Köpfe FB 760, Zoll

Montagekoffer 3

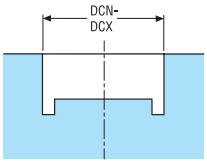




Montagekoffer 4



	Kapazität DCN-DCX ∅ Zoll*	Bezeichnung Nutstechwerkzeug „gegen die Bohrung“	Position Nutstech-werkzeughal-ter**	Abb.	Abmessungen in Zoll BD	CW	LF	LB	WF	RE	Max. Einstech-tiefe CDX
Wählen Sie das geeignete Nutstechwerkzeug aus, und notieren Sie sich die Position des Nutstechhalters am MPA, um die erforderliche Nutkapazität zu erhalten.	*1.220-1.417*	AFG0629 25 1581	0-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.417-1.614		1-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.614-1.811		2-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	1.811-2.008		3-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	2.992-3.189		5-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	3.189-3.386		6-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	3.386-3.583		7-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
	3.583-3.780		8-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
Hinweis: Eine Kombination zum Nutstechen – gegen die Bohrung – erfordert: – ein – Axiabore™ Plus – Kopf (A760 03) – ein MPA (BDA16BS25100) – ein I (Innenposition) und ein E (Außenposition) Nutstech-werkzeughalter (BAS25FGI35 und BAS25FGE35), um entweder ein Nutstechwerkzeug zu halten oder als Gegenge-wicht zu fungieren (siehe Einstellposition in der Tabelle) – ein Nutstechwerkzeug – gegen die Bohrung – (AFG...81), das in Bezug auf Nutbreite und Durchmesser aus der Tabelle ausgewählt werden muss.	*1.220-1.417*	AFG0629 30 1581	0-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.417-1.614		1-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.614-1.811		2-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	1.811-2.008		3-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	2.992-3.189		5-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	3.189-3.386		6-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	3.386-3.583		7-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
	3.583-3.780		8-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236



* +0,2 mm (0,008 Zoll) Zusatzkapazität erreichbar. ** Empfohlene Werte in **Fettdruck**.

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Instruktionen

Maximale Schnittgeschwindigkeiten – Ausdrehköpfe des Typs Axiabore™

Weitere Informationen finden Sie in der Bedienungsanleitung, die mit den GL-Bohrstangen geliefert wird.

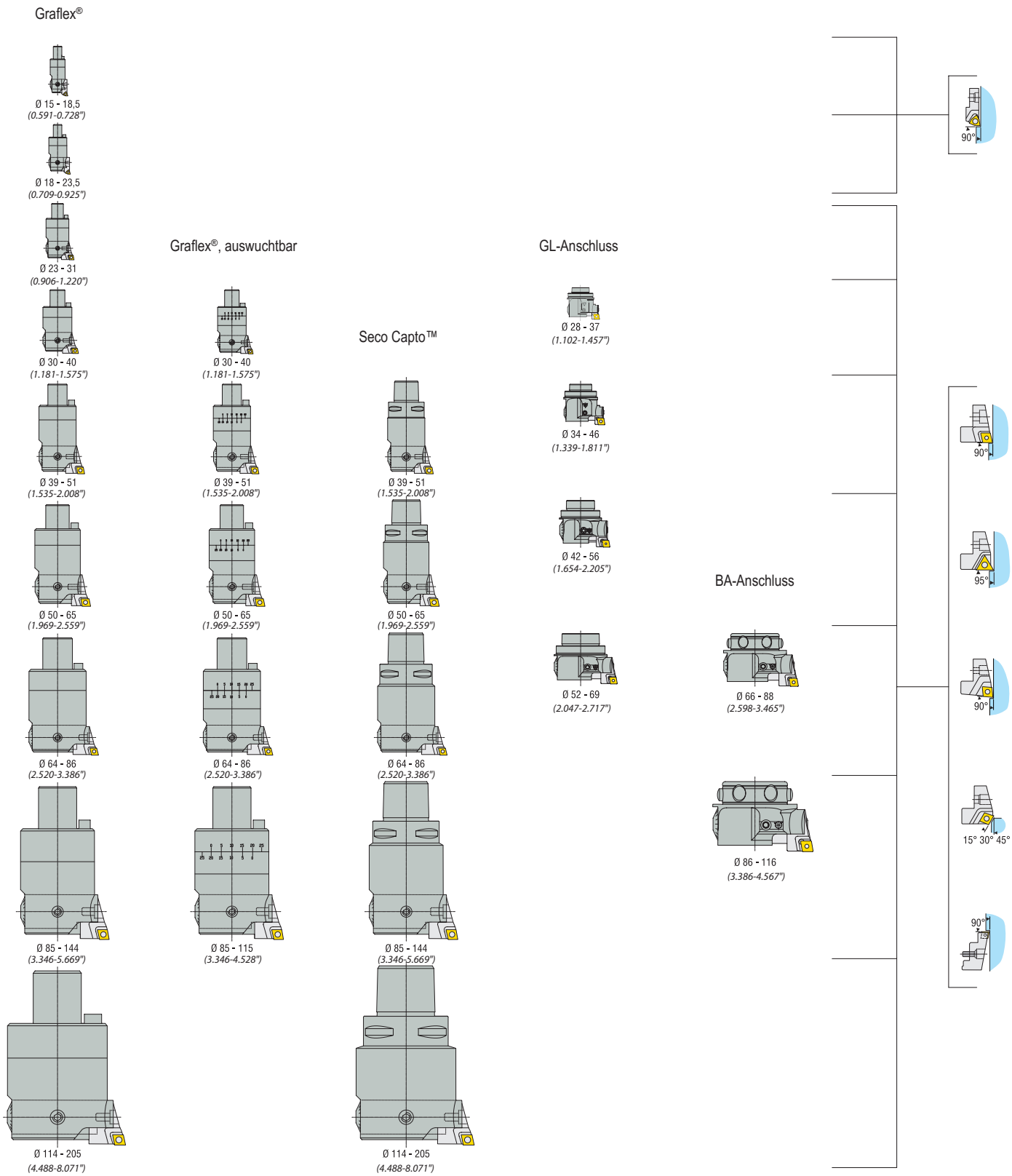
Kopf	Kapazität ∅ mm *(Zoll)*	Max. U/min mit Werkzeug (U/min)	Max. U/min mit MPA (U/min)	Max. Schnittgeschwindigkeit v_c bei min. Deckelung. m/min *(sf/min)*	Max. Schnittgeschwindigkeit v_c bei max. Deckelung. m/min *(sf/min)*
Axiabore™-Typ mit Graflex®-Anschluss					
A76001	0,3-8 *(0.0118-0.315)*	30000	–	28* *(92*)*	754* *(2474*)*
A76002	2-20 *(0.0787-0.787)*	12000	–	75* *(246*)*	754* *(2474*)*
A76003	6-108 *(0.236-4.25)*	8000**	5000	151* *(495*)*	1000*** *(3281***)*
A76013	6-33 *(0.236-1.30)*	20000**	5000	377* *(1237*)*	1500*** *(4921***)*
Axiabore™-Typ mit Seco Capto™-Anschluss					
C5-391.0760-03	6-108 *(0.236-4.25)*	8000*	5000	151* *(495*)*	1000** *(3281**)*

Hinweis: Die maximalen Geschwindigkeiten beziehen sich auf die mechanische Konstruktion und die Auswuchtqualität. Die Geschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Bearbeitungsbedingungen wie zu bearbeitenden Werkstoff, Schneidkante (Werkzeuge und Wendeschneidplatten), Werkzeuglänge und Maschinenspindel gewählt werden. Bei Geschwindigkeiten ab ca. 8000 U/min sollten die Aufsteckhalter und die Zwischenelemente feinausgewuchtet sein. Die Verwendung von auswuchtbaren Köpfen und feinauswuchtbaren Haltern verbessert die Werkzeugstandzeit und die Ausdrehleistung selbst bei niedrigeren Geschwindigkeiten.
* Angenommene max. Schnittgeschwindigkeit mit max. U/min.
** Nicht mit allen Werkzeugen erreichbar, siehe ***.
*** Die max. Schnittgeschwindigkeit darf nicht überschritten werden.

Einsatzhinweise (auch gültig für radiale Feinausdrehköpfe)

Position	Mögliche Ursache	Lösung
Geringe Standzeit	Falsche Schneidstoffsorte	Verschleißfestere Sorte wählen
	Zu hohe Schnittgeschwindigkeit	Schnittgeschwindigkeit senken
	Zu große Schnitttiefe	Schnitttiefe reduzieren
Rattern und Vibrationen	Zu hohe Schnittgeschwindigkeit	Schnittgeschwindigkeit senken
	Hohes Längen-Durchmesser-Verhältnis	Werkzeug kürzen, um Stabilität zu erhöhen
		Stabileres Ausdrehwerkzeug wählen
		Eine Steadyline-Bohrstange verwenden
		Hartmetall-Verlängerungen einsetzen
	Falsche Wendeschneidplatte	Eckenradius der WSP reduzieren
		Geschliffene WSP-Geometrie verwenden
	Falsches Aufmaß	Durchmesser der Vorbohrung ändern
Geringe Toleranz der Bohrung & Wiederholgenauigkeit	Ungenauer Werkzeugwechsel	Werkzeugschaft auf Beschädigung und Verschleiß prüfen.
		Spindel und Werkzeugschaft reinigen
	Aufmaßabweichungen	Durch Vorschlichtbearbeitungsschritt ergänzen
	Geringe Stabilität der Spindel	WSP mit schärfer geschliffener Geometrie verwenden
Unrundheit	Hohe Unwucht des Ausdrehwerkzeugs	Rundlauf der Spindel prüfen
		LIBRAFLEX® Ausdrehkopf einsetzen
		Einstellung des Skalenringes prüfen
		Geschwindigkeit reduzieren
	Hohe Schnittkräfte	Aufmaß und Vorschub prüfen
	Unzureichende Werkstück-Klemmung	Prüfen, ob gleichmäßige Werkstück-Klemmung besteht
	Nichtsymmetrisches Werkstück	Schnittkräfte reduzieren, geschliffene WSP verwenden
		Schnittgeschwindigkeit erhöhen, Vorschub reduzieren
Positionierungsfehler	Verlaufende Bohrung	Durch Vorschlichtbearbeitungsschritt ergänzen
	Zu große Schnitttiefe	Schnitttiefe verringern, zwei Durchgänge wählen
Mangelhafte Oberflächengüte	Falscher Radius der Wendeschneidplatte	Größeren WSP-Radius verwenden
	Zu hoher Vorschub	Vorschub auf max. 30 % des Eckenradius der WSP reduzieren
	Schlechte Spanabfuhr	Interne Kühlschmierstoffzufuhr verwenden
		WSP mit höherem Spanwinkel (evtl. HSS) einsetzen.
		Schnitttiefe prüfen
Konischer Eintritt	Vorzeitiger Verschleiß	Verschleißfestere Sorte wählen
		Schnittgeschwindigkeit modifizieren
		Kühlmitteldurchfluss erhöhen

Übersicht


Graflex®
Ø 15 - 18,5
(0.591-0.728")
Ø 18 - 23,5
(0.709-0.925")
Ø 23 - 31
(0.906-1.220")
Ø 30 - 40
(1.181-1.575")
Ø 39 - 51
(1.535-2.008")
Ø 50 - 65
(1.969-2.559")
Ø 64 - 86
(2.520-3.386")
Ø 85 - 144
(3.346-5.669")
Ø 114 - 205
(4.488-8.071")
Graflex®, auswuchtbar
Ø 30 - 40
(1.181-1.575")
Ø 39 - 51
(1.535-2.008")
Ø 50 - 65
(1.969-2.559")
Ø 64 - 86
(2.520-3.386")
Ø 85 - 115
(3.346-4.528")
Seco Capto™
Ø 39 - 51
(1.535-2.008")
Ø 50 - 65
(1.969-2.559")
Ø 64 - 86
(2.520-3.386")
Ø 85 - 144
(3.346-5.669")
Ø 114 - 205
(4.488-8.071")
GL-Anschluss
Ø 28 - 37
(1.102-1.457")
Ø 34 - 46
(1.339-1.811")
Ø 42 - 56
(1.654-2.205")
Ø 52 - 69
(2.047-2.717")
BA-Anschluss
Ø 66 - 88
(2.598-3.465")
Ø 86 - 116
(3.386-4.567")
90°
90°
95°
90°
15° 30° 45°
90°

Feinausdrehköpfe

Merkmale

Ein radiales Feinausdrehwerkzeug besteht aus einem Körper (Kopf) und einem Wendeschneidplatten-Halter. FB 620, FB 780 und FB 790 Feinausdrehkopf, radial:

Produktprogramm

Seco bietet eine große Auswahl an radialen Feinausdrehköpfen für Ihre Anforderungen.

FB 620, FB 780 und FB 790 radial, Feinausdrehkopf

– Mikrometrische Einstellungen: durch Mikrometer-Spindel (in Stufen von 0,01 mm *(0.0004")*) und Nonius (Teilstrich 2,5 µm *(98.4 µin)* im Durchmesser)
– Hohe Wiederholgenauigkeit
– Schneidenorientierung gemäß DIN 69871/ISO 7388 für SK und ISO 12164 für HSK
– Interne Kühlschmierstoffzufuhr durch den Kopf direkt auf die Schneide
– Ausdrehköpfe FB 780 und FB 620 auf mittlere Durchmessereinstellung vorausgewuchtet FB 790 ist auswuchtbar für beste Leistung.

Hinweis: Merkmale, Hinweise (Montageanweisungen, Durchmessereinstellung, Hinweise zum Rückwärtssenken, Herausforderungen, Bearbeitungs- und Schnittdatenempfehlungen), geeignete Wendeschneidplatten-Halter und Wendeschneidplatten sind identisch für FB 620, FB 780 und FB 790 Feinausdrehköpfe, die ungeachtet des Anschlusses denselben Ausdrehbereich aufweisen.

FB 620 Feinausdrehköpfe, radial, für Steadyline® schwingungsdämpfende Aufnahmen

GL

BA

– 4 Feinausdrehköpfe mit maschinenseitigem GL-Anschluss für den Durchmesserbereich von 27 bis 69 mm *(1.102–2.717")*
– 2 Feinausdrehköpfe mit maschinenseitigem BA-Anschluss für den Durchmesserbereich von 66 bis 116 mm *(2.598–4.567")*

Das kompakte Design erreicht höchste Schwingungsdämpfung in Kombination mit Steadyline®-GL-Dreh- und Bohrstangen.

FB 780 – Feinausdrehköpfe, radial

9 Präzisions-Ausdrehköpfe mit Graflex®-Anschluss für Präzisionsbohrungen im Durchmesserbereich von 15 bis 205 mm *(0.591–8.071")* mit radial montierten Wendeschneidplatten-Haltern.

5 Präzisionsausdrehköpfe mit Seco Capto™-Anschluss für Feinausdrehen im Durchmesserbereich von 39 bis 205 mm *(1.535–8.071")*.

Seco Capto™-Adapter und Graflex®-Kopf im Durchmesserbereich von: ∅ 15-40 mm *(0.591–1.575")*.

Hinweis: Der kleinste Durchmesser, der mit dem Seco Capto™ Feinausdrehkopf mit C3-Anschluss zu erzielen ist, beträgt 39 mm *(1.535")*. Für Durchmesser von 15 bis 40 mm *(Ø 0,591–1,575 Zoll)* Graflex®-Ausdrehköpfe mit Anschlussgröße G0 bis G2 in Verbindung mit dem passenden Seco Capto™/Graflex® Adapter einsetzen. Damit bieten sich auch beim Einsatz von Graflex®-Verlängerungen modulare Lösungsansätze.

Hinweis: Merkmale, Hinweise (Montageanweisungen, Durchmessereinstellung, Hinweise zum Rückwärtssenken, Herausforderungen, Bearbeitungs- und Schnittdatenempfehlungen), geeignete Wendeschneidplatten-Halter und Wendeschneidplatten sind identisch für beide FB 780 Feinausdrehköpfe, die ungeachtet des Anschlusses denselben Ausdrehbereich aufweisen.

FB 790 Auswuchtbare Feinausdrehköpfe, radial

5 auswuchtbare 'Libraflex®'-Ausdrehköpfe mit Graflex®-Anschluss für Präzisionsbohrungen von 30 bis 115 mm *(Ø 1,181–4,528 Zoll)* für hohe Geschwindigkeit (bis zu 1500 m/min *4921 ft/min*), mit radial montierten Wendeschneidplatten-Haltern.

Ausgewuchtete Werkzeuge schonen Aufnahmen und Spindel. Schnittdaten können optimiert werden. Selbst bei normalen Geschwindigkeiten werden hervorragende Ergebnisse erzielt.

Die Auswuchtung erfolgt durch Einstellung der beiden Skalenringe in Abstimmung mit dem zu bearbeitenden Durchmesser (keine Auswuchttabelle notwendig).

Merkmale

WSP-Halter

Ein radiales Feinausdrehwerkzeug besteht aus einem Körper (Kopf) und einem Wendeschneidplatten-Halter.

Das umfangreiche Programm an Wendeschneidplatten-Haltern zum Ausdrehen, Anfasen und Rückwärtssenken kann sowohl mit FB 620, FB 780 als auch mit FB 790 radialen Feinausdrehköpfen eingesetzt werden.

Wendeschneidplatten-Halter für Feinausdrehköpfe

FBIH 782: Einstellwinkel 90° für WB-Wendeschneidplatten
FBIH 724: Einstellwinkel 90° für TC-Wendeschneidplatten
FBIH 725: Einstellwinkel 90° für CC-Wendeschneidplatten
FBIH 726: Einstellwinkel 95° für CC-Wendeschneidplatten

Hinweis: Verwenden Sie einen Einstellwinkel von 95° beim Ausspindeln von Grundlochbohrungen.

Wendeschneidplatten-Halter zum Anfasen, Durchmesserbereich von 23 bis 160 mm *(0.906–6.299")*

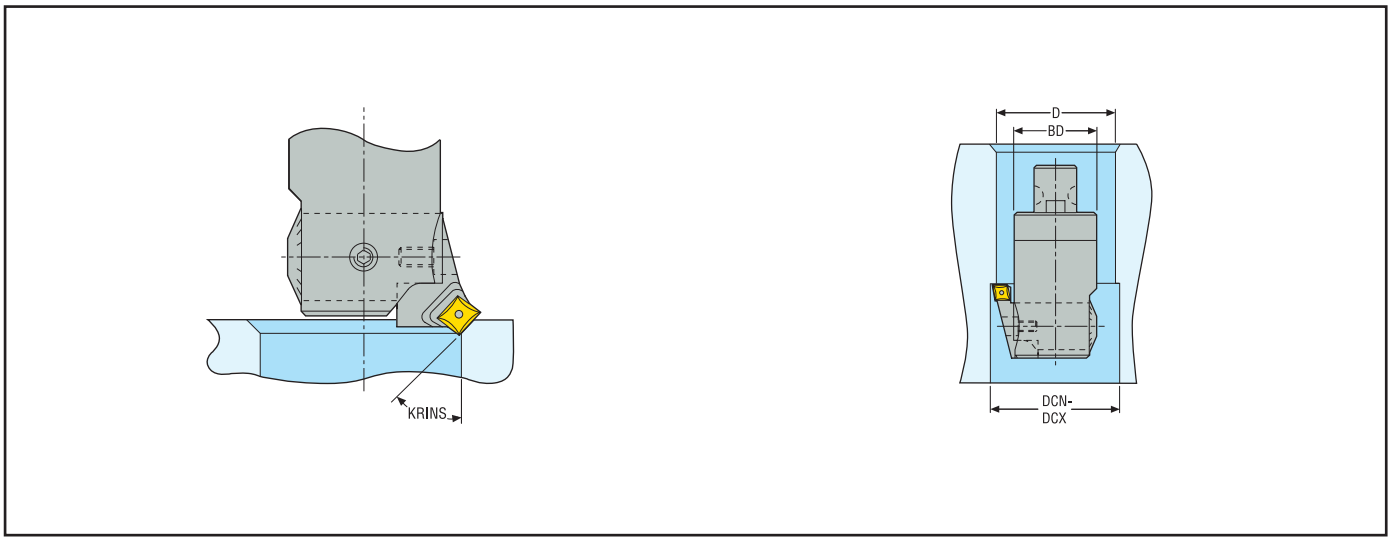
FBIH 729 ist mit 15°, 30° oder 45° Einstellwinkel für CC-Wendeschneidplatten verfügbar.

Libraflex® Auswuchtung ist auch für Wendeschneidplatten-Halter zum Anfasen zu erzielen.

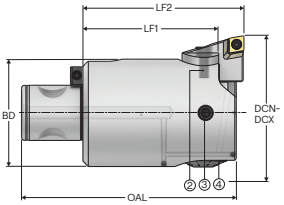
Wendeschneidplatten-Halter zum Rückwärtssenken, Durchmesserbereich von 26,5 bis 164 mm *(1.043–6.457")*

FBIH A789 mit Einstellwinkel 90° für CC-Wendeschneidplatten verfügbar.

Beim Einsatz von Wendeschneidplatten-Haltern zum Hinterdrehen ist eine Libraflex®-Auswuchtung nicht möglich. Hier wird die höchste Unwuchtreduzierung erzielt, indem man beide Wuchtringe auf die höchste Skalierung stellt.



FB780
Graflex®



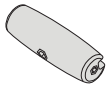
—Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)

2. Schraube
3. Spannschraube
4. Spannschraube

Bezeichnung	Produkt-nummer	Maschinen-seite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	WSP-Halter Größe
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A78008	00056632	G0	15,0 *0.591*	18,5 *0.728*	44,0 *1.732*	27,5 *1.083*	35,0 *1.378*	14,0 *0.551*	0,1 *0.2*	09
A78009	00056633	G0	18,0 *0.709*	23,5 *0.925*	44,0 *1.732*	27,5 *1.083*	35,0 *1.378*	17,0 *0.669*	0,1 *0.2*	09
A78010	00072991	G1	23,0 *0.906*	31,0 *1.220*	51,5 *2.028*	32,5 *1.280*	40,0 *1.575*	21,5 *0.846*	0,2 *0.4*	10
A78020	00072992	G2	30,0 *1.181*	40,0 *1.575*	59,5 *2.343*	37,5 *1.476*	45,0 *1.772*	27,0 *1.063*	0,3 *0.7*	20
A78030	00072993	G3	39,0 *1.535*	51,0 *2.008*	82,0 *3.228*	54,5 *2.146*	65,0 *2.559*	35,0 *1.378*	0,6 *1.3*	30
A78040	00072995	G4	50,0 *1.969*	65,0 *2.559*	93,0 *3.661*	61,5 *2.421*	72,0 *2.835*	43,0 *1.693*	0,9 *2.0*	40
A78050	00072996	G5	64,0 *2.520*	86,0 *3.386*	109,0 *4.291*	71,5 *2.815*	82,0 *3.228*	54,0 *2.126*	1,6 *3.5*	50
A78060	00056551	G6	85,0 *3.346*	144,0 *5.669*	140,0 *5.512*	88,5 *3.484*	105,0 *4.134*	70,0 *2.756*	3,2 *7.1*	*60/65*
A78070	00056552	G7	114,0 *4.488*	205,0 *8.071*	160,0 *6.299*	98,5 *3.878*	115,0 *4.528*	95,0 *3.740*	6,4 *14.1*	*70/75*

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 548, 549–551
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

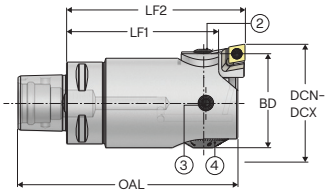
Für Halter	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube	Mitnehmer
					
A78008	960D30050S	DOUBLE-T	H4B-H2.0	19A7100403	–
A78009	LBHF0306R	DOUBLE-T	H4B-H2.0	19A71000	90M0
A78010	19TB0305	DOUBLE-T	H4B-H2.0	19A71000	90M1
A78020	19TB0305	H4B-H2.0	–	950L0406	90M2
A78030	19TB04075	–	03M03C	950L0608	90M3
A78040	19TB04075	–	03M03C	950L0612	90M4
A78050	950D0410	–	03M03C	950L0616	90M5
A78060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	90M6
A78070	950D0616	DOUBLE-T	H6B-H5.0L	950L1030	90M7

Zubehör

Drehmomentschlüssel für Schraube und Befestigungsschraube
H00-2009
H00-2009
H00-2009
H00-2009
H00-3030
H00-3030
H00-3030
H00T-50100
H00T-50100

FB780

Seco Capto™



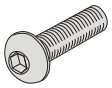
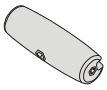
—Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)

2. Schraube
3. Spannschraube
4. Spannschraube

Bezeichnung	Produkt-nummer	Maschinen-seite	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	WSP-Halter Größe
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
C3-391.0780-30	02809740	C3	39,0 *1.535*	51,0 *2.008*	86,0 *3.386*	59,5 *2.343*	70,0 *2.756*	35,0 *1.378*	0,6 *1.3*	30
C4-391.0780-40	02809742	C4	50,0 *1.969*	65,0 *2.559*	103,0 *4.055*	71,5 *2.815*	82,0 *3.228*	43,0 *1.693*	1,0 *2.2*	40
C5-391.0780-50	02809744	C5	64,0 *2.520*	86,0 *3.386*	119,0 *4.685*	81,5 *3.209*	92,0 *3.622*	54,0 *2.126*	1,7 *3.8*	50
C6-391.0780-60	02809745	C6	85,0 *3.346*	144,0 *5.669*	150,0 *5.906*	100,5 *3.957*	117,0 *4.606*	70,0 *2.756*	3,3 *7.3*	60
C8-391.0780-70	02809747	C8	114,0 *4.488*	205,0 *8.071*	181,0 *7.126*	121,5 *4.783*	138,0 *5.433*	95,0 *3.740*	7,1 *15.7*	70

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 548, 549–551
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

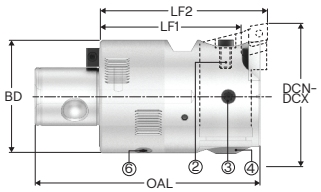
Für Halter	Schraube	Schlüssel	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube
					
C3-391.0780-30	19TB04075	03M03C	–	–	950L0608
C4-391.0780-40	19TB04075	03M03C	–	–	950L0612
C5-391.0780-50	950D0410	03M03C	–	–	950L0616
C6-391.0780-60	950D0612	–	DOUBLE-T	H6B-H5.0L	950L0616
C8-391.0780-70	950D0616	–	DOUBLE-T	H6B-H5.0L	950L1030

Zubehör

Für Halter	Drehmomentschlüssel für Schraube und Befestigungsschraube
C3-391.0780-30	H00-3030
C4-391.0780-40	H00-3030
C5-391.0780-50	H00-3030
C6-391.0780-60	H00T-50100
C8-391.0780-70	H00T-50100

FB780 Libraflex®, auswuchtbar

Graflex®



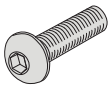
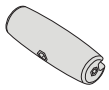
- Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)
- Auswuchten durch Einstellung der beiden Ringe in Abstimmung mit dem zu bearbeitenden Durchmesser.
- Geschwindigkeiten v_c bis zu 1.495 m/min und mehr siehe Seite(n) 552

6. Spannschraube 2
2. Schraube
3. Spannschraube 1
4. Spannschraube

Bezeichnung	Produkt-nummer	Maschinen-seite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	WSP-Halter Größe
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A79020	00055932	G2	30,0 *1.181*	40,0 *1.575*	59,5 *2.343*	37,5 *1.476*	45,0 *1.772*	27,0 *1.063*	0,3 *0.7*	20
A79030	00056005	G3	39,0 *1.535*	51,0 *2.008*	82,0 *3.228*	54,5 *2.146*	65,0 *2.559*	35,0 *1.378*	0,6 *1.3*	30
A79040	00056006	G4	50,0 *1.969*	65,0 *2.559*	93,0 *3.661*	61,5 *2.421*	72,0 *2.835*	43,0 *1.693*	0,9 *2.0*	40
A79050	00056007	G5	64,0 *2.520*	86,0 *3.386*	109,0 *4.291*	71,5 *2.815*	82,0 *3.228*	54,0 *2.126*	1,5 *3.3*	50
A79060	00001451	G6	85,0 *3.346*	115,0 *4.528*	140,0 *5.512*	88,5 *3.484*	105,0 *4.134*	70,0 *2.756*	3,0 *6.6*	60

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 548, 549-551
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

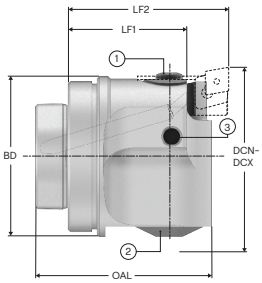
Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube 1	Befestigungsschraube 2	Mitnehmer
						
A79020	19TB0305	DOUBLE-T	H4B-H2.0	950L0406	960D30045S	90M2
A79030	19TB04075	–	03M03C	950L0608	AU7901030	90M3
A79040	19TB04075	–	03M03C	950L0612	AU7901040	90M4R
A79050	950D0410	–	03M03C	950L0616	AU7901050	90M51
A79060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	AU7901060	90M6

Zubehör

Für Kopf	Drehmomentschlüssel für Befestigungsschraube	Drehmomentschlüssel für Schraube und Befestigungsschraube
A79020	–	H00-2009
A79030	H00-3020	H00-3030
A79040	H00-3020	H00-3030
A79050	H00-3020	H00-3030
A79060	H00T-5050	H00T-50100

FB 620 GL – Schlicht-Ausdrehköpfe

Compact mit GL-Anschluss



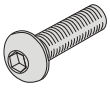
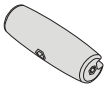
- Entwickelt für GL25, GL32, GL40 und GL50 Steadyline®-Dreh- und Bohrstangen
- Innere Kühlmittelzufuhr zur Schneidkante
- Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)

1. Schraube
2. Spannschraube
3. Spannschraube

Bezeichnung	Produkt-nummer	Maschinen-seite GL Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Max. U/min**
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
GL32-0620-20	02904469	GL32	34,0 *1.339*	46,0 *1.811*	35,2 *1.386*	23,7 *0.933*	32,0 *1.260*	32,0 *1.260*	0,2 *0.4*	7000
GL40-0620-30	02904470	GL40	42,0 *1.654*	56,0 *2.205*	40,7 *1.602*	24,7 *0.972*	35,0 *1.378*	40,0 *1.575*	0,3 *0.7*	5600
GL50-0620-40	02904471	GL50	52,0 *2.047*	69,0 *2.717*	43,7 *1.720*	25,7 *1.012*	36,0 *1.417*	50,0 *1.969*	0,4 *0.9*	4800

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 548, 549–551
** Weitere Informationen zur max. Drehzahl siehe Anleitungsseiten.
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

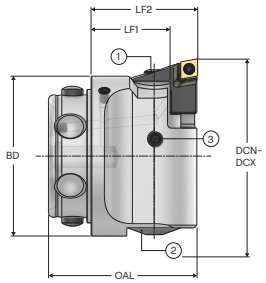
Für Kopf	Schraube	Schlüssel für Pratze	Schlüssel (Quergriff)	Befestigungsschraube
				
GL32-0620-20	19TB0305	H4B-H2.0	DOUBLE-T	950L0406
GL40-0620-30	19TB04075	03M03C	–	950L0608
GL50-0620-40	19TB04075	03M03C	–	950L0608

Zubehör

Für Kopf	Drehmomentschlüssel für Schraube und Befestigungsschraube
GL32-0620-20	H00-2009
GL40-0620-30	H00-3030
GL50-0620-40	H00-3030

FB 620 BA – Schlicht-Ausdrehköpfe

mit BA-Anschluss



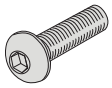
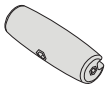
- Entwickelt für BA60 und BA80 Steadyline®-Dreh- und Bohrstangen
- Innere Kühlmittelzufuhr zur Schneidkante
- Einstellung durch Mikrometerspindel (Stufe 0,01 mm und Nonius 2,5 µm, am Durchmesser)

1. Schraube
2. Spannschraube
3. Spannschraube

Bezeichnung	Produkt-nummer	Maschinen-seite BA Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Max. U/min**
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BA060-FB620-50	03204094	BA060	65,0 *2.559*	87,0 *3.425*	55,7 *2.193*	29,7 *1.169*	40,0 *1.575*	60,0 *2.362*	0,7 *1.5*	4000
BA080-FB620-60	03204095	BA080	85,0 *3.346*	115,0 *4.528*	58,2 *2.291*	26,7 *1.051*	41,2 *1.622*	80,0 *3.150*	1,2 *2.7*	3000

Wendeplattenhalter müssen separat bestellt werden, siehe Seite(n) 501
** Weitere Informationen zur max. Drehzahl siehe Anleitungsseiten.
Beachten Sie, dass das Gewicht der Bohrstange nicht berücksichtigt wird.

Ersatzteile, im Lieferumfang enthalten

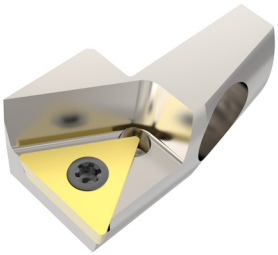
Für Kopf	Schraube	Schlüssel	Schlüssel (Quergriff)	Schlüssel	Befestigungsschraube
					
BA060-FB620-50	19TB04075	03M03C	–	–	950L0608
BA080-FB620-60	950D0514	–	DOUBLE-T	H6B-H5.0L	950L0608

Zubehör

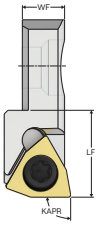
Für Kopf	Drehmomentschlüssel für Schraube und Befestigungsschraube
BA060-FB620-50	H00-3030
BA080-FB620-60	H00T-50100

WSP-Halter

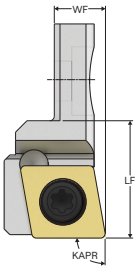
für Feinausdrehköpfe FB 620 / 780 / 790



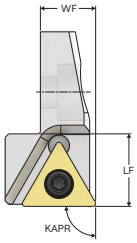
A



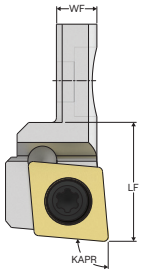
B



C



D

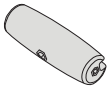


—Geeignet für radiale Ausdrehköpfe FB 620/780/790
—**Präzisionsauswuchten von Köpfen FB A790 ist bei Verwendung der großen Wendeplattenhalter nicht möglich.

Bezeichnung	Produkt-nummer	WSP-Halter Typ	Bereich DCN-DCX ∅		LF	WF	Gewicht	Für Kopf	KRINS°	**	WSP-Halter Größe	Entspr. WSP-Größe	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*						
A78209	00056634	90° für WB-WSP	15,0 *0.591*	23,5 *0.925*	7,2 *0.283*	4,0 *0.157*	0,1 *0.220*	FB 78008 / FB 78009	90		09	WB...0301...	A
A72510	00056580	90° für CC-WSP	23,0 *0.906*	31,0 *1.220*	10,3 *0.406*	4,5 *0.177*	0,1 *0.220*	FB 78010 / FB62010	90		10	CC...0602...	B
A72520	00056581	90° für CC-WSP	30,0 *1.181*	46,0 *1.811*	8,3 *0.327*	5,0 *0.197*	0,1 *0.220*	FB 78020 / FB 79020 / FB 62020	90		20	CC...0602...	B
A72530	00056582	90° für CC-WSP	39,0 *1.535*	56,0 *2.205*	10,3 *0.406*	8,0 *0.315*	0,1 *0.220*	FB 78030 / FB 79030 / FB 62030	90		30	CC...0602...	B
A72540	00056583	90° für CC-WSP	50,0 *1.969*	69,0 *2.717*	10,3 *0.406*	9,5 *0.374*	0,1 *0.220*	FB 78040 / FB 79040 / FB 62040	90		40	CC...0602...	B
A72550	00056584	90° für CC-WSP	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,5 *0.492*	0,1 *0.220*	FB 78050 / FB 79050 / FB 62050	90		50	CC...0602...	B
A7256A	02689978	90° für CC-WSP	85,0 *3.346*	115,0 *4.528*	14,5 *0.571*	18,5 *0.728*	0,1 *0.220*	BA080-FB620-60	90		6A	CC...09T3...	B
A72560	00056585	90° für CC-WSP	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	90		60	CC...09T3...	B
A72565	00056587	90° für CC-WSP	114,0 *4.488*	144,0 *5.669*	16,5 *0.650*	33,7 *1.327*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	90	**	65	CC...09T3...	B
A72570	00056588	90° für CC-WSP	114,0 *4.488*	160,0 *6.299*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78070	90		70	CC...09T3...	B
A72575	00056589	90° für CC-WSP	159,0 *6.260*	205,0 *8.071*	16,5 *0.650*	41,7 *1.642*	0,2 *0.440*	FB 78070	90		75	CC...09T3...	B
A72430	00056572	90° für TC-WSP	39,0 *1.535*	56,0 *2.205*	10,3 *0.406*	7,9 *0.311*	0,1 *0.220*	FB 78030 / FB 79030 / FB 62030	90		30	TC...1102...	C
A72440	00056573	90° für TC-WSP	50,0 *1.969*	69,0 *2.717*	10,3 *0.406*	9,4 *0.370*	0,1 *0.220*	FB 78040 / FB 79040 / FB 62040	90		40	TC...1102...	C
A72450	00056574	90° für TC-WSP	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,4 *0.488*	0,1 *0.220*	FB 78050 / FB 79050 / FB 62050	90		50	TC...1102...	C
A72460	00056575	90° für TC-WSP	85,0 *3.346*	115,0 *4.528*	16,3 *0.642*	18,9 *0.744*	0,1 *0.220*	FB 78060 / FB 79060 / FB 731S500	90		60	TC...1102...	C
A72465	00056577	90° für TC-WSP	114,0 *4.488*	144,0 *5.669*	16,5 *0.650*	33,7 *1.327*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	90	**	65	TC...1102...	C
A72470	00056578	90° für TC-WSP	114,0 *4.488*	160,0 *6.299*	16,3 *0.642*	18,9 *0.744*	0,2 *0.440*	FB 78070	90		70	TC...1102...	C
A72475	00056579	90° für TC-WSP	159,0 *6.260*	205,0 *8.071*	16,5 *0.650*	41,7 *1.642*	0,2 *0.440*	FB 78070	90		75	TC...1102...	C
A72610	00056590	95° für CC-WSP	23,0 *0.906*	31,0 *1.220*	10,3 *0.406*	4,5 *0.177*	0,1 *0.220*	FB 78010	95		10	CC...0602...	D
A72620	00056591	95° für CC-WSP	30,0 *1.181*	46,0 *1.811*	8,3 *0.327*	5,0 *0.197*	0,1 *0.220*	FB 78020 / FB 79020 / FB 62020	95		20	CC...0602...	D
A72630	00056592	95° für CC-WSP	39,0 *1.535*	56,0 *2.205*	10,3 *0.406*	8,0 *0.315*	0,1 *0.220*	FB 78030 / FB 79030 / FB 62030	95		30	CC...0602...	D
A72640	00056593	95° für CC-WSP	50,0 *1.969*	69,0 *2.717*	10,3 *0.406*	9,5 *0.374*	0,1 *0.220*	FB 78040 / FB 79040/ FB 62040	95		40	CC...0602...	D
A72650	00056594	95° für CC-WSP	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,5 *0.492*	0,1 *0.220*	FB 78050 / FB 79050 / FB 62050	95		50	CC...0602...	D
A72660	00056595	95° für CC-WSP	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	95		60	CC...09T3...	D
A72665	00056597	95° für CC-WSP	114,0 *4.488*	144,0 *5.669*	16,5 *0.650*	33,7 *1.327*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	95	**	65	CC...09T3...	D

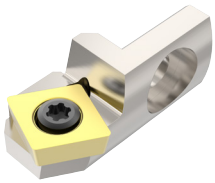
Bezeichnung	Produkt-nummer	WSP-Halter Typ	Bereich DCN-DCX ∅		LF	WF	Gewicht	Für Kopf	KRINS°	**	WSP-Halter Größe	Entspr. WSP-Größe	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*						
A72670	00056598	95° für CC-WSP	114,0 *4.488*	160,0 *6.299*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78070	95		70	CC...09T3...	D
A72675	00056599	95° für CC-WSP	159,0 *6.260*	205,0 *8.071*	16,5 *0.650*	41,7 *1.642*	0,2 *0.440*	FB 78070	95		75	CC...09T3...	D

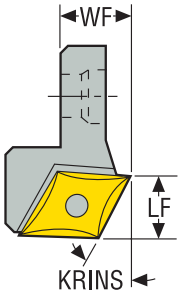
Ersatzteile, im Lieferumfang enthalten

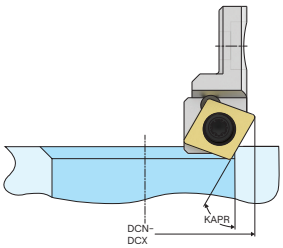
Für WSP	Schlüssel für WSP	Schraube für WSP	Schlüssel (Quergriff)
			
WB...0301...	H4B-T06P	C02035-T06P	DOUBLE-T
CC...0602...	H4B-T07P	C02504-T07P	DOUBLE-T
CC...09T3...	H4B-T15P	C04008-T15P	DOUBLE-T
TC...1102...	H4B-T07P	C02504-T07P	DOUBLE-T

Wendeschneidplatten-Halter zum Anfasen

für Feinausdrehköpfe FB 620 / 780 / 790







–Geeignet für radiale Ausdrehköpfe FB 620/780/790

Bezeichnung	Produkt-nummer	Für Kopf	WSP-Halter Größe	Bereich DCN-DCX ∅		LF	WF	Gewicht	KRINS°	KAPR°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*			
A72910CC0630	00086885	FB 78010	10	23,0 *0.906*	31,0 *1.220*	10,8 *0.425*	4,5 *0.177*	0,1 *0.220*	30	30	CC...0602...
A72920CC0630	00086888	FB 78020 / FB 79020/ GL32-0620-20	20	30,0 *1.181*	46,0 *1.811*	10,0 *0.394*	4,9 *0.193*	0,1 *0.220*	30	30	CC...0602...
A72930CC0630	00086891	FB 78030 / FB 79030 / FB 62030	30	39,0 *1.535*	56,0 *2.205*	10,5 *0.413*	8,1 *0.319*	0,1 *0.220*	30	30	CC...0602...
A72940CC0630	00086894	FB 78040 / FB 79040 / FB 62040	40	50,0 *1.969*	69,0 *2.717*	10,5 *0.413*	9,5 *0.374*	0,1 *0.220*	30	30	CC...0602...
A72950CC0630	00086897	FB 78050 / FB 79050	50	64,0 *2.520*	86,0 *3.386*	10,5 *0.413*	12,5 *0.492*	0,1 *0.220*	30	30	CC...0602...
A72960CC0930	00086900	FB 78060 / FB 79060 / A731S500	60	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	19,1 *0.752*	0,08 *0.180*	30	30	CC...09T3...
A72970CC0930	00086903	FB 78070	70	114,0 *4.488*	160,0 *6.299*	16,4 *0.646*	18,8 *0.740*	0,09 *0.200*	30	30	CC...09T3...
A72910CC0645	00086886	FB 78010	10	23,0 *0.906*	31,0 *1.220*	11,5 *0.453*	4,5 *0.177*	0,01 *0.020*	45	45	CC...0602...
A72920CC0645	00086889	FB 78020 / FB 79020 / FB 62020	20	30,0 *1.181*	46,0 *1.811*	10,0 *0.394*	5,0 *0.197*	0,1 *0.220*	45	45	CC...0602...
A72930CC0645	00086892	FB 78030 / FB 79030 / FB 62030	30	39,0 *1.535*	56,0 *2.205*	10,5 *0.413*	8,1 *0.319*	0,1 *0.220*	45	45	CC...0602...
A72940CC0645	00086895	FB 78040 / FB 79040 / FB 62040	40	50,0 *1.969*	69,0 *2.717*	10,5 *0.413*	9,5 *0.374*	0,1 *0.220*	45	45	CC...0602...
A72950CC0645	00086898	FB 78050 / FB 79050	50	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,4 *0.488*	0,02 *0.040*	45	45	CC...0602...
A72960CC0945	00086901	FB 78060 / FB 79060 / A731S500	60	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	19,1 *0.752*	0,2 *0.440*	45	45	CC...09T3...
A72970CC0945	00086904	FB 78070	70	114,0 *4.488*	160,0 *6.299*	16,4 *0.646*	18,8 *0.740*	0,09 *0.200*	45	45	CC...09T3...

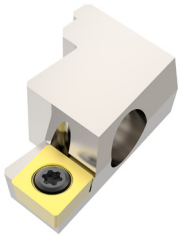
Ersatzschrauben und -schlüssel für Wendeplatten siehe Seite(n) 596
**Informationen zur Kapazität DC mit Brückenwerkzeugen und Jumbo-Brückenwerkzeugen siehe Seite 560

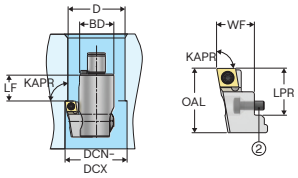
Ersatzteile, im Lieferumfang enthalten

Für WSP	Schlüssel für WSP	Schraube für WSP	Schlüssel (Quergriff)
CC...0602...	H4B-T07P	C02504-T07P	DOUBLE-T
CC...09T3...	H4B-T15P	C04008-T15P	DOUBLE-T

Wendeschneidplatten-Halter zum Rückwärtssenken

für Feinausdrehköpfe FB 620 / 780 / 790





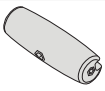
—Geeignet für radiale Ausdrehköpfe FB 620/780/790
—*Präzisionsauswuchten von Köpfen FB 790 ist bei Verwendung der Rückwärtssenk-Wendeplattenhalter nicht möglich.
—KRINS 90°
—Geeignete Wendeplattengröße: CC...0602...

Bezeichnung	Produktnummer	Für Kopf	Bereich DCN-DCX		LF	BD	OAL	LPR	WF	Gewicht
			mm	*(Zoll)*	mm *(Zoll)*	mm *(Zoll)*	mm *(Zoll)*	mm *(Zoll)*	mm *(Zoll)*	kg *(lbs)*
A789X10CC0690	00086907	A78010 A78020 & A79020 GL32-0620-20	39,5-47,5 46-56 49,7-61,7	*(1.555-1.870)* *(1.811-2.205)* *(1.957-2.429)*	16,5 *(0.650)* 21,5 *(0.846)* 7,75 *(0.305)*	21,5 *(0.846)* 27 *(1.063)* 32 *(1.260)*	30,5 *(1.201)*	16,0 *(0.630)*	12,8 *(0.504)*	0,01 *(0.020)*
A789X30CC0690	00086910	A78030 & A79030 A78040 & A79040 A78050 & A79050 GL40-0620-30 GL50-0620-40	53-65 61-76 69-91 57,6-70,2 67,6-80,2	*(2.087-2.559)* *(2.402-2.992)* *(2.717-3.583)* *(2.268-2.764)* *(2.661-3.157)*	32 *(1.260)* 39 *(1.535)* 49 *(1.929)* 1,75 *(0.069)* 2,75 *(0.108)*	35 *(1.378)* 43 *(1.693)* 54 *(2.126)* 40 *(1.575)* 50 *(1.969)*	30,0 *(1.181)*	23,0 *(0.906)*	15,0 *(0.591)*	0,03 *(0.070)*
A789X60CC0690	00086909	A78060 & A79060	89-119 *	*(3.504-4.685 *)*	50 *(1.969)*	70 *(1.969)*	50,0 *(1.969)*	38,5 *(1.516)*	21,0 *(0.827)*	0,09 *(0.200)*
A789X70CC0690	00086911	A78070	118-164	*(4.646-6.457)*	60 *(2.362)*	95 *(2.362)*	50,0 *(1.969)*	38,5 *(1.516)*	21,0 *(0.827)*	0,1 *(0.220)*

*Informationen zur Rückwärtssenk-Kapazität DC mit Brückenwerkzeugen und Jumbo-Brückenwerkzeugen siehe Seite 564
Ersatzschrauben und -schlüssel für Wendeplatten siehe Seite(n) 596
Im Lieferumfang der Wendeplattenhalter zum Fein-Rückwärtssenken ist eine spezielle Wendeplattenhalter-Klemmschraube enthalten, die anstelle der mit den Ausdrehköpfen gelieferten Standard-Klemmschraube verwendet wird.

DCN/DCX min. = D+BD / 2 + 0,5 mm (0,02 Zoll) ab Durchmesser 39,5 bis 47,5 mm (1,555 Zoll–1,870 Zoll)
DCB/DCX min. = D+BD / 2 + 1 mm (0,039 Zoll) ab Durchmesser 46 bis 64 mm (1,811–2,520 Zoll)

Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube	Schraube für WSP	Schlüssel (Quergriff)	Schlüssel
				
A789X10CC0690	950F0308	C02504-T07P	DOUBLE-T	H4B-T07P
A789X30CC0690	950F0410	C02504-T07P	DOUBLE-T	H4B-T07P
A789X60CC0690	–	C02504-T07P	DOUBLE-T	H4B-T07P
A789X70CC0690	–	C02504-T07P	DOUBLE-T	H4B-T07P

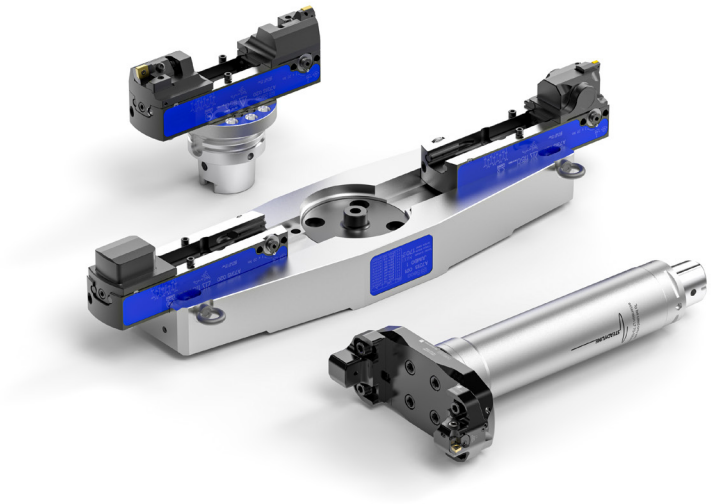
FB 780/ 790 Feinausdrehköpfe

Empfehlungen zur Bearbeitung
Weitere Informationen finden Sie in der Bedienungsanleitung, die mit den GL-Bohrstangen geliefert wird.

Maximale Geschwindigkeiten für radiale Feinausdrehköpfe
Die maximalen Schnittgeschwindigkeiten, die auf den Produktseiten genannt werden, beziehen sich auf das mechanische Design und die Auswuchtqualität der Ausdrehköpfe. Die Geschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Bearbeitungsbedingungen wie zu bearbeitenden Werkstoff, Schneidkante (Wendeschneidplatte), Werkzeuglänge und Maschinenspindel gewählt werden. Bei Anwendungen mit Steadyline®-Bohrstangen dürfen die maximalen Drehzahlen der Bohrstange nicht übertroffen werden: Sie finden diese in der Bedienungsanleitung, die mit den Steadyline®-Bohrstangen geliefert wird.
Die unten genannten maximalen Drehzahlen gelten für Ausdrehköpfe mit Wendeplattenhaltern zum Ausdrehen oder Anfasen. Für Wendeschneidplatten-Halter zum Rückwärtssenken auf FB 620, FB 790 oder FB 780 halten Sie sich an die maximalen Drehzahlen für A780.. etc.

Kopf	Kapazität ∅ mm *(Zoll)*	Max. Drehzahl	Angenommene max. Schnittgeschwindigkeit v_c bei min. Deckelung. m/min *(sf/min)*	Angenommene max. Schnittgeschwindigkeit v_c bei max. Deckelung. m/min *(sf/min)*
FB 620 Feinausdrehköpfe, mit maschinenseitigem GL- und BA-Anschluss, für schwingungsdämpfende Steadyline®-Dreh- und Bohrstangen				
GL25-FB620-10	27-35 *(1.063-1.378)*	9000	760 *(2493)*	1000 *(3281)*
GL32-FB620-20	34-46 *(1.339-1.811)*	7000	748 *(2454)*	1012 *(3320)*
GL32-FB620-30	42-56 *(1.654-2.205)*	5600	739 *(2425)*	985 *(3232)*
GL32-FB620-40	52-69 *(2.047-2.717)*	4800	784 *(2572)*	1040 *(3412)*
BA060-FB620-50	66-88 *(2.598-3.465)*	4000	830 *(2723)*	1105 *(3625)*
BA080-FB620-60	86-116 *(3.386-4.567)*	3000	810 *(2657)*	1093 *(3586)*
FB 790 Feinausdrehköpfe, auswuchtbar, mit Graflex®-Anschluss				
A79020	30-40 *(1.181-1.575)*	16000	1508 *(4948)*	2011 *(6598)*
A79030	39-51 *(1.535-2.008)*	12250	1501 *(4925)*	1963 *(6440)*
A79040	50-65 *(1.969-2.559)*	10000	1571 *(5154)*	2042 *(6699)*
A79050	64-86 *(2.520-3.386)*	7500	1508 *(4948)*	2026 *(6647)*
A79060	85-115 *(3.346-4.528)*	5600	1495 *(4905)*	2023 *(6637)*
FB 780 Feinausdrehköpfe, mit Graflex®-Anschluss				
A78008	15-18,5 *(0.591-0.728)*	16000	754 *(2474)*	930 *(3051)*
A78009	18-23,5 *(0.709-0.925)*	13000	735 *(2411)*	960 *(3150)*
A78010	23-31 *(0.906-1.220)*	10000	723 *(2372)*	974 *(3196)*
A78020	30-40 *(1.181-1.575)*	8000	754 *(2474)*	1005 *(3297)*
A78030	39-51 *(1.535-2.008)*	6000	735 *(2411)*	961 *(3153)*
A78040	50-65 *(1.969-2.559)*	5000	785 *(2575)*	1021 *(3350)*
A78050	64-86 *(2.520-3.386)*	3700	744 *(2441)*	1000 *(3281)*
A78060	85-115 *(3.346-4.528)*	2700	721 *(2365)*	975 *(3199)*
	114-144 *(4.488-5.669)*	2200	788 *(2585)*	995 *(3264)*
A78070	114-160 *(4.488-6.299)*	2000	716 *(2349)*	1005 *(3297)*
	159-205 *(6.260-8.071)*	1600	799 *(2621)*	1030 *(3379)*
FB 780 Feinausdrehköpfe, mit Seco Capto™-Anschluss				
C3-391.0780-30	39-51 *(1.535-2.008)*	6000	735 *(2411)*	961 *(3153)*
C4-391.0780-40	50-65 *(1.969-2.559)*	5000	785 *(2575)*	1021 *(3350)*
C5-391.0780-50	64-86 *(2.520-3.386)*	3700	744 *(2441)*	1000 *(3281)*
C6-391.0780-60	85-115 *(3.346-4.528)*	2700	721 *(2365)*	975 *(3199)*
	114-144 *(4.488-5.669)*	2200	788 *(2585)*	995 *(3264)*
C8-391.0780-70	114-160 *(4.488-6.299)*	2000	716 *(2349)*	1005 *(3297)*
	159-205 *(6.260-8.071)*	1600	799 *(2621)*	1030 *(3379)*

Hinweis: Die maximalen Geschwindigkeiten beziehen sich auf die mechanische Konstruktion und die Auswuchtqualität. Die Geschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Bearbeitungsbedingungen wie zu bearbeitenden Werkstoff, Schneidkante (Wendeschneidplatte), Werkzeuglänge und Maschinenspindel gewählt werden. Bei Geschwindigkeiten ab ca. 8000 U/min sollten die Grundaufnahmen und die Verlängerungen/Reduzierungen feinausgewuchtet sein.



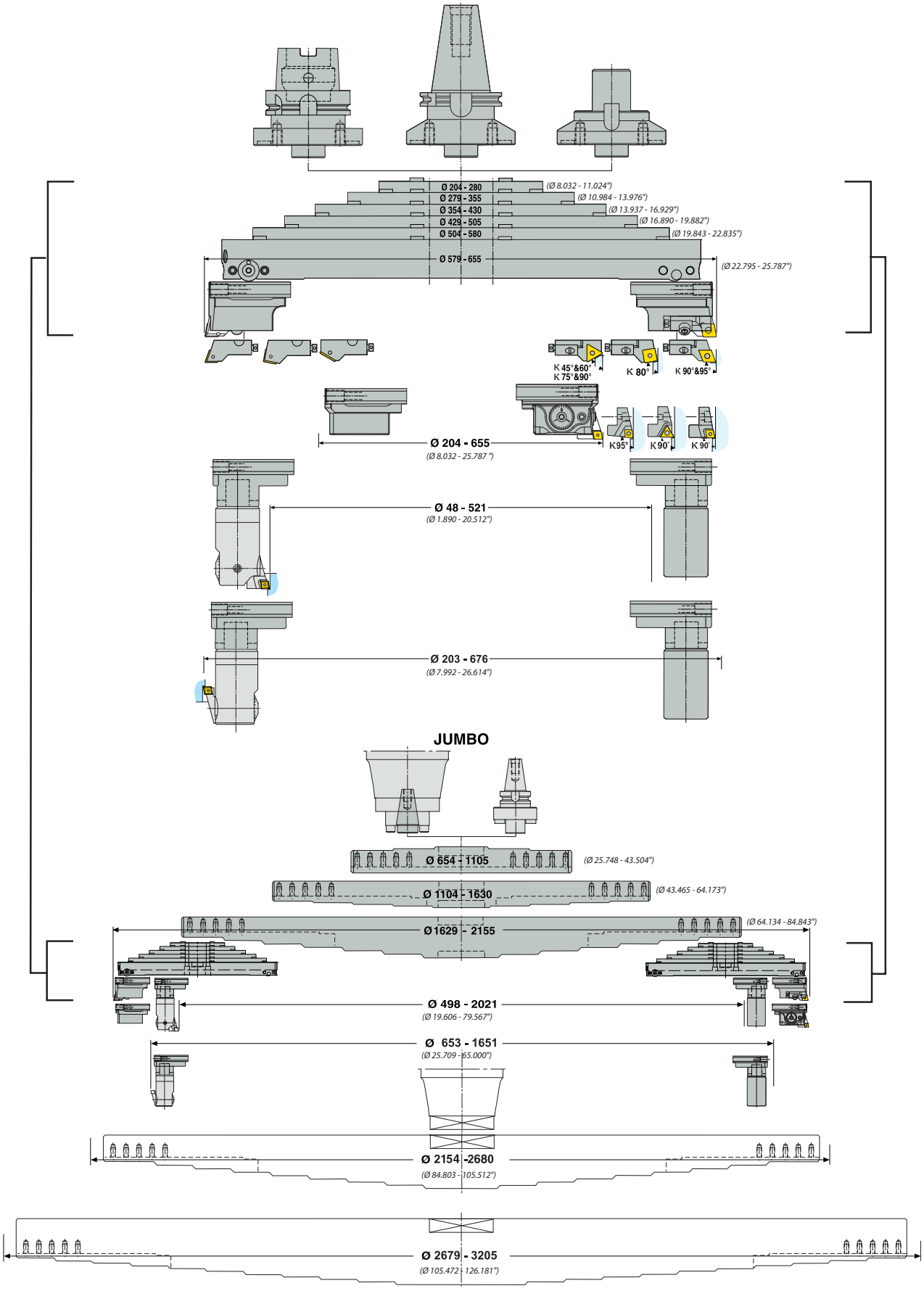
Ausdrehlösungen für große Durchmesser

Seco Tools bietet ein komplettes Programm an Brückenwerkzeugen und Jumbo-Brückenwerkzeugen zum Ausdrehen, Zapfendehen und Rückwärtssenken bei großen Bohrdurchmessern.

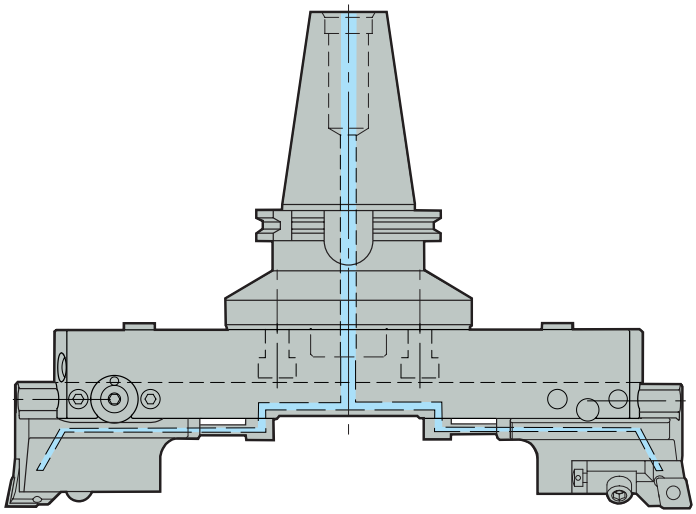
Modulare Kombination – Brücken und Blöcke

Produktfamilie		Durchmesserbereich	Bearbeitung	Kapazitäten	Details
BB731	Entwickelt für maximale Flexibilität. BB731 Brücken-werkzeuge sind in einer großen Auswahl an Durchmessern als Standardprodukte erhältlich.	204 - 655 mm (8.03" - 25.78")	Ausbdrehen Zapfendrehenn Rückwärtssenken	Siehe Seite(n) 559-564	Siehe Seite(n) 565
JBB731	Seco Jumbo-Brückenwerkzeuge werden aus hochfestem Aluminium mit Schnittstellen aus Stahl hergestellt.	654 - 3,205 mm (25.75" - 126.18")	Ausbdrehen Zapfendrehenn Rückwärtssenken	Siehe Seite(n) 559.564	Siehe Seite(n) 566-568
BB732	BB732-Bohrstangen sind für den Einsatz mit Steadyline® Aufnahmen für Aufsteckfräser ausgelegt und meistern tiefe Bohrungen mit hoher Oberflächengüte, gesteigerter Produktivität und großem Werkzeugüberstand.	Schruppausdre-hen 114 - 301 mm (4,488 - 11.850") Feinausdrehen 114 - 315 mm (4,488 - 12.402")	Tiefe Bohrungen	Siehe Seite(n) 571.576	Siehe Seite(n)579

Übersicht


Ø 204 - 280
(Ø 8.032 - 11.024")
Ø 279 - 355
(Ø 10.984 - 13.976")
Ø 354 - 430
(Ø 13.937 - 16.929")
Ø 429 - 505
(Ø 16.890 - 19.882")
Ø 504 - 580
(Ø 19.843 - 22.835")
Ø 579 - 655
(Ø 22.795 - 25.787")
K 45°&60°
K 75°&90°
K 80°
K 90°&95°
Ø 204 - 655
(Ø 8.032 - 25.787 ")
K95°
K 90°
K 90°
Ø 48 - 521
(Ø 1.890 - 20.512")
Ø 203 - 676
(Ø 7.992 - 26.614")
JUMBO
Ø 654 - 1105
(Ø 25.748 - 43.504")
Ø 1104 - 1630
(Ø 43.465 - 64.173")
Ø 1629 - 2155
(Ø 64.134 - 84.843")
Ø 498 - 2021
(Ø 19.606 - 79.567")
Ø 653 - 1651
(Ø 25.709 - 65.000")
Ø 2154 -2680
(Ø 84.803 - 105.512")
Ø 2679 - 3205
(Ø 105.472 - 126.181")

Merkmale: Serie BB731



Anwendung

— Ausdrehen (Schruppen & Feinausdrehen) Ø 204 – 655 mm (8.032 – 25.787”).

— Zapfendrehen Ø 48 – 521 mm (1.890 – 20.512”).

— Rückwärtsdrehen Ø 203 mm – 676 mm (7.992 – 26.614”).

Vorteile und Merkmale

— Brückenwerkzeuge haben Maschinenanschlüsse mit Durchmessern von 130 mm (5.118”) zur direkten Montage auf Aufnahmen (SK und HSK) oder mittels Graflex®-Adapter.

— Die Brückenwerkzeuge können Schrupp- und Feinausdrehköpfe sowie Gegengewichte oder Graflex®-Ausdrehblöcke aufnehmen.

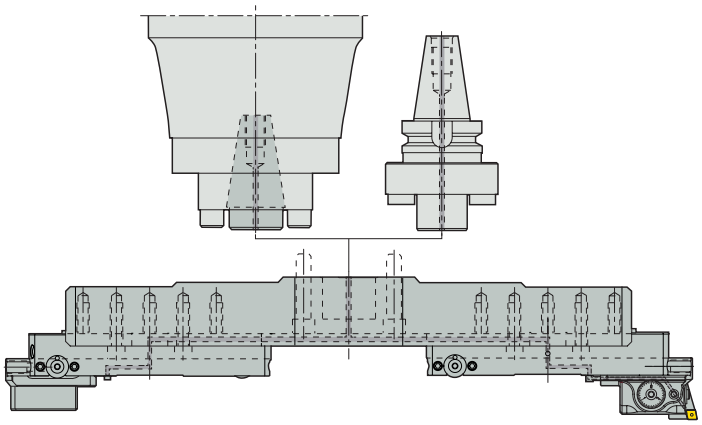
— Die Ausdrehblöcke werden durch zwei mit drei Spannschrauben versehene Zylinder auf dem Brückenwerkzeug montiert und befestigt. Eine der Spannschrauben verfügt über einen Anschlag, der verhindert, dass der Block sich aus dem Brückenwerkzeug löst. Präzise und stufenlose Durchmessereinstellung 38 mm (Ø 1.496”) im Radius) mit Hilfe der Einstellschraube des Blocks, die mit dem Mitnehmer des Brückenwerkzeugs verbunden ist.

— Durch Einsatz eines Graflex®-Adapters der Größe 7 und eines Flansches kann die Auskraglänge vergrößert werden, siehe Graflex® modulares System.

— Die Brücken lassen sich in 30°-Schritten an den Graflex®-Adapteraufnahmen einstellen, welche für den Einsatz in Werkzeugmagazinen geeignet sind.

— Kühlschmierstoffzufuhr über das Brückenwerkzeug und die Ausdrehblöcke, direkt auf die Schneide.

Merkmale: JBB731 Programm



Anwendung

— Ausdrehen (Schruppen & Feinausdrehen) Ø 654 – 3078 mm (25.748“ – 121.181“).

— Zapfendrehen Ø 498 – 3071 mm (19.606–120.906“).

— Rückwärtsdrehen Ø 653 – 3226 mm (25.709 – 127.008“).

Vorteile und Merkmale

— Jumbo-Brückenwerkzeuge werden aus hochfestem Aluminium mit Spindelschnittstellen aus Stahl hergestellt.

— Sie wurden entwickelt, um zwei klassische Brückenwerkzeuge aus der BB731-Serie in mehreren Positionen zu halten.

— Jumbo-Brückenwerkzeuge werden mit zwei Umsetzringen geliefert.

— Die Größen A731S001, 002 und 003 werden mit 4 Sicherungsschrauben geliefert.

— Kann auf einer Fräsaufnahme montiert werden, Typ Flanschbefestigung 569, Zapfen Ø 60 mm (Ø 2.362“) oder direkt auf die Maschinenspindel (DIN 2079/50 werkstückseitig) montiert werden.

— Verwenden Sie den in den Zubehörteilen gezeigten Zentrierzapfen.

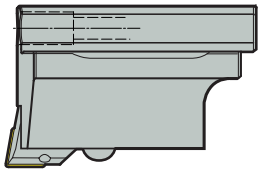
Größen A731S004-...* und A731S005-...* sind auf Anfrage erhältlich, mit normalen oder speziellen Möglichkeiten zur Spindelbefestigung, entsprechend der Maschine:

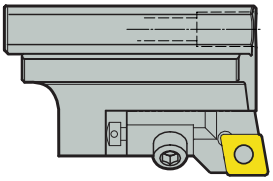
Kapazität ∅ mm *(Zoll)*	**Bezeichnung**	**Abmessungen in mm (Zoll) siehe Zeichnung auf Produktseite**							
		DCB	**LF**	**HTB**	**LB**	**CBDP**	**WB**	**DCON**	**Gewicht**
2154-2680 *(84.803-105.512”)*	A731S004-...*	*	70 *(2.75591”)*	300 *(11.811”)*	160 *(6.29921”)*	*	2140 *(84.25197”)*	*	*
2679-3205 *(105.472-126.181”)*	A731S005-...*	*	110 *(4.33071”)*	400 *(15.748”)*	200 *(7.87402”)*	*	2665 *(104.9213”)*	*	*

* Bezeichnungscode und Abmessungen werden in Bezug auf den Typ der Spindelbefestigung vervollständigt.

Merkmale: Ausdrehblöcke für die Serien BB731 und JBB731

Schruppausdrehblock





Anwendung

— Kassetten erhältlich mit 90° und 80° Steigungswinkel.

— Kassetten mit ISO5611/h1 = 16 mm (0.629“) Anschlussgröße sind ebenfalls geeignet.

Vorteile und Merkmale

— Zwei gleiche Ausdrehköpfe sind erforderlich, um ein Schruppwerkzeug zusammenzustellen. Jeder Ausdrehkopf ist mit einem Kurzklemmhalter versehen.

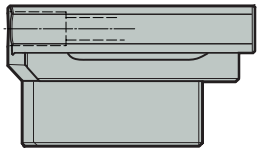
— Umfangreiches Programm unterschiedlicher Kassetten.

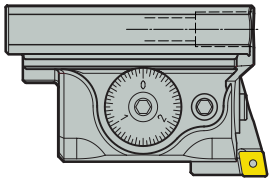
— Kassetten mit 90° Einstellwinkel, für nahezu alle Schruppbearbeitungen bei geringem Energieverbrauch.

— Kassetten mit 80° Einstellwinkel, für Durchgangsbohrungen (und zum Anfasen), insbesondere bei Guss, zur Vermeidung von Fehlern beim Werkzeugaustritt. Höherer Energieverbrauch
— Beide Durchmesser können sowohl axial vorstehen als auch asymmetrisch eingestellt werden.

— Ein Distanzstück zur Anhebung der voreilenden Schneide ist als Zubehör verfügbar (Produktnummer 18LS0316). Montage und Einstellung, siehe Seite(n) 559-564.

Feinausdrehblock





Anwendung

— Große Auswahl an Wendeschneidplatten-Haltern, erhältlich in 90° und 95° KAPR.

— Passende Wendeschneidplatten-Halter A72460, A72560, A72660.

Vorteile und Merkmale

— Ein großer Feinausdrehkopf benötigt einen Feinausdrehblock mit einem Wendeplattenhalter und einen Gegengewichtsblock.

— Feinausdrehblöcke mit interner Kühlschmierstoffzufuhr, direkt auf die Schneide.

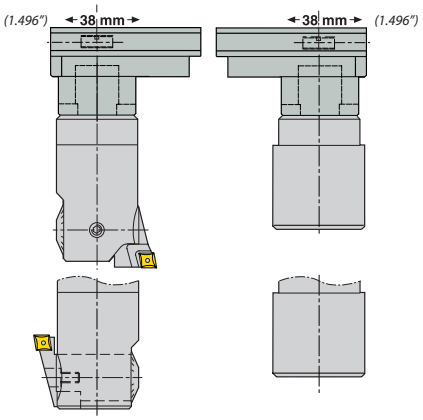
— Wendeschneidplatten-Blöcke mit integrierten Sicherheitsmechanismen, die verhindern, dass sich die Blöcke bei höheren Drehzahlen durch Zentrifugalkräfte vom Brückenwerkzeug (von der Aufnahme) lösen.

Merkmale: Graflex® Ausdrehblock, zum Zapfendrehen oder Rückwärtsdrehen

Thema 1

Anwendung

- Dieser Ausdrehkopf besitzt eine Graflex®-Verbindung der Größe G5.
- Mögliche Verwendung für Zapfendrehen oder Rückwärtsdrehen.
- Montage und Einstellung, siehe Seite(n) 559-564.
- **ANMERKUNG:** Diese neuen Ausdrehblöcke sind auch mit den vorherigen Brückenwerkzeugen einsetzbar.



Vorteile und Merkmale

- Jeder Graflex®-Ausdrehkopf, jedes Sonder- oder Standardwerkzeug oder jedes Graflex®-Standardmodul der Größe G5 kann auf das Brückenwerkzeug montiert werden.
- Die Zeichnung zeigt z.B. Aufbauten zum Zapfendrehen oder Rückwärtsdrehen mit zwei Graflex®-Ausdrehblöcken, bestückt mit einem Graflex®-Feinausdrehkopf A78050 mit Wendeschneidplatten-Halter (z.B. A72550 zum Zapfendrehen), einem Wendeschneidplatten-Halter zum Außendrehen (z.B. A789X30CC0690) und einem Graflex®-Gegengewicht (z.B. Produktnummer BM050W78050).
- Das Graflex®-Element kann an zwei Positionen auf der Brücke montiert werden, da es zweimal zwei Positionen für die Kugelschrauben und zwei Zapfenkerben um 180° versetzt gibt.
- Die Schruppausdrehblöcke bieten interne Kühlschmierstoffzufuhr direkt auf die Schneide.
- Die Ausdrehblöcke (Produktnummer A731S 400, A731S 500, A731S 600, A731S 40128) sind auch mit den vorherigen Brückenwerkzeugen einsetzbar (Produktnummer A731 0_0 -ohne S-).
- Es gelten die Montagehinweise und maximalen Drehzahlen der vorherigen Brückenwerkzeuge.
- Um das Gleichgewicht zu wahren, verwenden und mischen Sie nicht neue und vorherige Blöcke auf demselben Brückenwerkzeug.

Thema 2

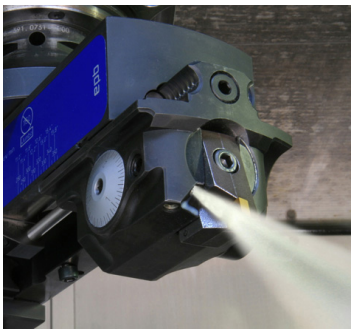
Hinweise zur Auswahl des Zubehörs für interne Kühlschmierstoffzufuhr

Schruppen (Brückenwerkzeug mit zwei Schrupp-Ausdrehblöcken):

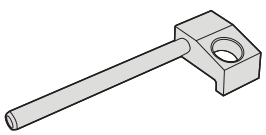
Für eine direkte Kühlschmierstoffzufuhr auf beide Schneiden sind 2 Kühlrohrverbindungen (Produktnummer AU731S00700) zur Montage auf das Brückenwerkzeug und 2 Kühldüsen-Sets (Produktnummer AU731S40700) zur Montage auf jeden Schruppausdrehblock erforderlich. Verwenden Sie für interne Kühlschmierstoffzufuhr durch den Kühlmittelkanal des Ausdrehblocks 2 Kühlrohrverbindungen (Produktnummer AU731S00700) zur Montage auf dem Brückenwerkzeug.

Feinausdrehen (Brückenwerkzeug mit 1 Feinausdrehblock und 1 Gegengewicht):

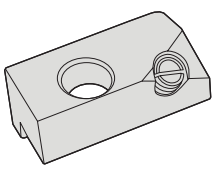
Verwenden Sie 1 Kühlrohrverbindung (Produktnummer AU731S00700) zur Montage auf dem Brückenwerkzeug zur Verbindung mit dem Feinausdrehblock. Da der Feinausdrehblock bereits standardmäßig eine Kühlmitteldüse aufweist, wird damit eine zielgerichtete Kühlschmierstoffzufuhr erreicht.
Zapfendrehen (z. B. Brückenwerkzeug mit 2 Graflex®-Ausdrehblöcken, mit einem Feinausdrehkopf und einem Gegengewicht): 1 Kühlrohrverbindung (Produktnummer AU731S00700) zur Montage auf dem Brückenwerkzeug zur Verbindung mit dem Graflex®-Feinausdrehblock verwenden. Durch den zentralen Kühlmittelkanal des Graflex®-Ausdrehblocks wird das Kühlmittel zum montierten Ausdrehkopf geleitet.



Kühlrohrverbindung
(Produktnummer AU731S00700)



Kühldüsen-Set
(Produktnummer AU731S40700)



ANMERKUNG: Der maximale Kühlmitteldruck beträgt 70 bar.

Ausdrehköpfe für Brückenwerkzeuge

Eine Feinausdrehkombination für Durchmesser bis zu 655 mm *(Ø 25.787")* **besteht aus: 1 Brückenwerkzeug (A731S 0_0) + 2 Schruppausdrehblöcke (2x A731S 400) mit 2 Kurzklemmhaltern*.**

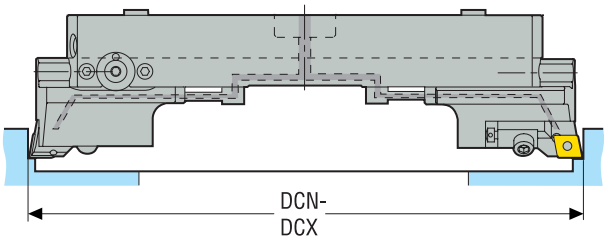


Abb. 1

Eine Feinausdrehkombination für Durchmesser bis zu 655 mm *(Ø 25.787")* **besteht aus: 1 Brückenwerkzeug (A731S 0_0) + 1 Feinausdrehblock (A731S 500) mit 1 Wendeschneidplatten-Halter Größe 60** + 1 Gegengewichtsblock (A731S 600).**

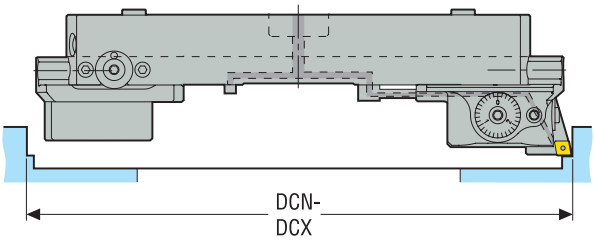


Abb. 2

Eine Feinausdrehkombination für Durchmesser bis zu 3205 mm *(Ø 126.181")* **besteht aus: 1 Jumbo-Brückenwerkzeug (A731S 00_) + 2 Brückenwerkzeuge (A731S 0_0) + 2 Schruppausdrehblöcke (2x A731S 400) mit 2 Kurzklemmhaltern*.**

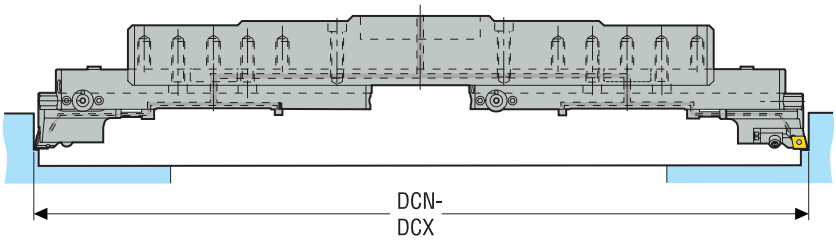


Abb. 3

Eine Feinausdrehkombination für Durchmesser bis zu 3205 mm *(Ø 126.181")* **besteht aus: 1 Jumbo-Brückenwerkzeug (A731S 00_) + 2 Brückenwerkzeuge (A731S 0_0) + 1 Feinausdrehblock (A731S 500) mit 1 Wendeschneidplatten-Halter Größe 60** + 1 Gegengewichtsblock (A731S 600).**

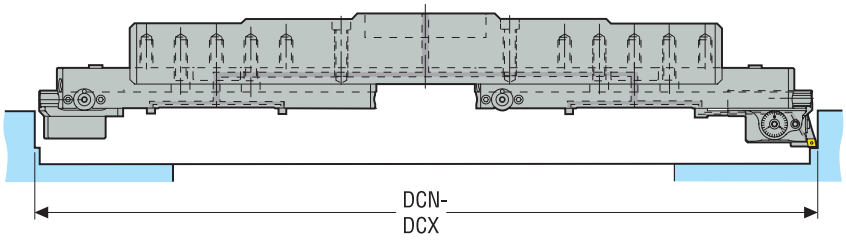


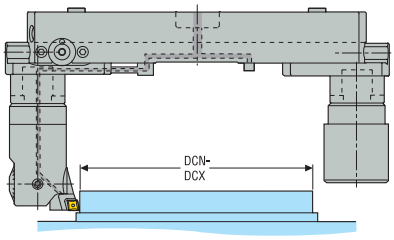
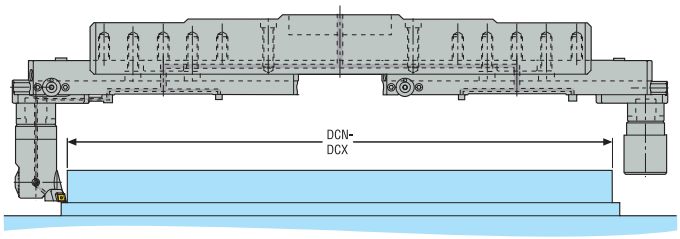
Abb. 4

* Kassetten müssen separat bestellt werden.
** Wendeschneidplatten-Halter müssen separat bestellt werden.

Zusammenstellung von Brückenwerkzeug-Ausdreh-Kombinationen: Auswahltabelle für Brückenwerkzeuge, um einen erforderlichen Ausdreh-Durchmesser zusammenzustellen

Zum Ausdrehen DCN-DCX ∅ mm	*Zum Ausdrehen DCN-DCX ∅ Zoll*	Jumbo Brückenwerkzeug	Klassische Brückenwerkzeuge	Schruppausdrehen		Feinausdrehen	
					Abb.		Abb.
204-280	*8.031-11.024*	–	A731S 010	2x A731S 400 + 2 Kassetten	1	A731S 500 + 1 Wendeplattenhalter + A731S 600	2
279-355	*10.984-13.976*	–	A731S 020				
354-430	*13.937-16.929*	–	A731S 030				
429-505	*16.890-19.882*	–	A731S 040				
504-580	*(19.843-22.835*	–	A731S 050				
579-655	*22.795-25.787*	–	A731S 060				
654-805	*25.748-31.693*	A731S 001	2x A731S 010	2x A731S 400 + 2 Kassetten	3	A731S 500 + 1 Wendeplattenhalter + A731S 600	4
654-880	*25.748-34.646*		2x A731S 020				
804-955	*31.654-37.598*		2x A731S 030				
879-1030	*34.606-40.551*		2x A731S 040				
1029-1105	*40.512-43.504*		2x A731S 050				
1104-1255	*43.465-49.409*	A731S 002	2x A731S 010	2x A731S 400 + 2 Kassetten	3	A731S 500 + 1 Wendeplattenhalter + A731S 600	4
1104-1330	*43.465-52.362*		2x A731S 020				
1179-1405	*46.417-55.315*		2x A731S 030				
1254-1480	*49.370-58.268*		2x A731S 040				
1329-1555	*52.323-61.220*		2x A731S 050				
1404-1630	*55.276-64.173*		2x A731S 060				
1629-1780	*64.134-70.079*	A731S 003	2x A731S 010	2x A731S 400 + 2 Kassetten	3	A731S 500 + 1 Wendeplattenhalter + A731S 600	4
1629-1855	*64.134-73.031*		2x A731S 020				
1704-1930	*67.087-75.984*		2x A731S 030				
1779-2005	*70.039-78.937*		2x A731S 040				
1854-2080	*72.992-81.890*		2x A731S 050				
1929-2155	*75.945-84.843*		2x A731S 060				
2154-2305	*84.803-90.748*	A731S 004	2x A731S 010	2x A731S 400 + 2 Kassetten	3	A731S 500 + 1 Wendeplattenhalter + A731S 600	4
2154-2380	*84.803-93.701*		2x A731S 020				
2229-2455	*87.756-96.654*		2x A731S 030				
2304-2530	*90.709-99.606*		2x A731S 040				
2379-2605	*93.661-105.512*		2x A731S 050				
2454-2680	*96.614-105.512*		2x A731S 060				
2679-2830	*105.472-111.417*	A731S 005	2x A731S 010	2x A731S 400 + 2 Kassetten	3	A731S 500 + 1 Wendeplattenhalter + A731S 600	4
2679-2905	*105.472-114.370*		2x A731S 020				
2754-2980	*108.425-117.323*		2x A731S 030				
2829-3055	*111.378-120.276*		2x A731S 040				
2904-3130	*114.331-123.228*		2x A731S 050				
2979-3205	*117.283-126.181*		2x A731S 060				

Brückenwerkzeug-Kombinationen zum Zapfendrehen:

Eine Feinausdrehkombination zum Zapfendrehen für Durchmesser bis zu 521 mm *(Ø 20.512")* besteht aus: 1 Brückenwerkzeug (A731S 0_0) + 2 Graflex® Blöcke (2 x A731S 40128) + z. B. 1 Feinausdrehkopf (A780 50) mit 1 Wendeschneidplatten-Halter Größe 60* + 1 Gegengewicht (BM050W78050).
 Abb. 1
Eine Feinausdrehkombination für Durchmesser bis zu 3205 mm *(Ø 120.906")* besteht aus: 1 Jumbo-Brückenwerkzeug (A731S 00_) + 2 Brückenwerkzeuge (A731S 0_0) + 2 Schruppausdrehblöcke (2x A731S 400) mit 2 Kurzklemmhaltern*.
 Abb. 2
* Wendeschneidplatten-Halter müssen separat bestellt werden.

Brückenwerkzeug-Kombinationen zum Rückwärtssenken: Auswahltabelle für Brückenwerkzeuge, um einen erforderlichen Zapfendreh-Durchmesser zusammenzustellen

Zum Zapfendrehen DCN-DCX ∅ mm	*Zum Zapfendrehen* **DCN-DCX ∅** *Zoll*	**Jumbo Brückenwerkzeug**	**Klassische Brückenwerkzeuge**	**Zum Zapfendrehen**	**Abb.**
48-146	*1.890-5.748*	–	A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter + 1x BM050W78050	1
123-221	*4.843-8.701*	–	A731S 020		
198-296	*7.795-11.654*	–	A731S 030		
273-371	*10.748-14.606*	–	A731S 040		
348-446	*13.701-17.559*	–	A731S 050		
423-521	*16.654-20.512*	–	A731S 060		
498-671	*19.606-26.417*	A731S 001	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter + 1x BM050W78050	2
498-746	*19.606-29.370*		2x A731S 020		
648-821	*25.512-32.323*		2x A731S 030		
723-896	*28.465-35.276*		2x A731S 040		
873-971	*34.370-38.228*		2x A731S 050		
948-1121	*37.323-44.134*	A731S 002	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter + 1x BM050W78050	2
948-1196	*37.323-47.087*		2x A731S 020		
1098-1271	*43.228-50.039*		2x A731S 030		
1173-1346	*46.181-52.992*		2x A731S 040		
1323-1421	*52.087-55.945*		2x A731S 050		
1398-1496	*55.039-58.898*		2x A731S 060		
1473-1646	*57.992-64.803*	A731S 003	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter + 1x BM050W78050	2
1473-1721	*57.992-67.756*		2x A731S 020		
1623-1796	*63.898-70.709*		2x A731S 030		
1698-1871	*66.850-73.661*		2x A731S 040		
1848-1946	*72.756-76.614*		2x A731S 050		
1923-2021	*75.709-79.567*		2x A731S 060		
1998-2171	*78.661-85.472*	A731S 004	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter + 1x BM050W78050	2
1998-2246	*78.661-88.425*		2x A731S 020		
2148-2321	*84.567-91.378*		2x A731S 030		
2223-2396	*87.520-94.331*		2x A731S 040		
2373-2471	*93.425-97.283*		2x A731S 050		
2448-2546	*96.378-100.236*		2x A731S 060		
2523-2696	*99.331-106.142*	A731S 005	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter + 1x BM050W78050	2
2523-2771	*99.331-109.094*		2x A731S 020		
2973-2846	*117.047-112.047*		2x A731S 030		
2748-2921	*108.189-115.000*		2x A731S 040		
2898-2996	*114.094-117.953*		2x A731S 050		
2973-3071	*117.047-120.906*		2x A731S 060		

Brückenwerkzeug-Kombinationen zum Zapfendrehen:

Eine Feinausdrehkombination zum Rückwärtssenken für Durchmesser bis zu 676 mm *(Ø 26,614 Zoll)* besteht aus: 1 Brückenwerkzeug (A731S 0_0) + 2 Graflex® Blöcke (2 x A731S 40128) + z. B. 1 Feinausdrehkopf (A780 50) mit 1 Wendeschneidplatten-Halter zum Rückwärtssenken Größe 50* + 1 Gegengewicht (BM050W78050).

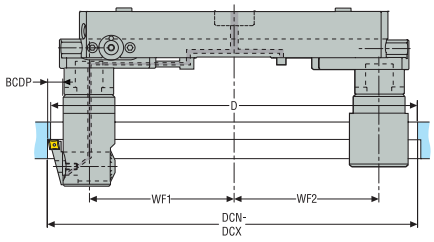


Abb. 1

Eine Feinausdrehkombination zum Rückwärtssenken für Durchmesser bis zu 3226 mm (Ø 127.008") besteht aus: 1 Jumbo-Brückenwerkzeug (A731S 00_) + 2 Brückenwerkzeuge (A731S 0_0) + z. B. 1 Feinausdrehkopf (A780 50) mit 1 Wendeschneidplatten-Halter Größe 50* + 1 Gegengewicht (BM050W78050).

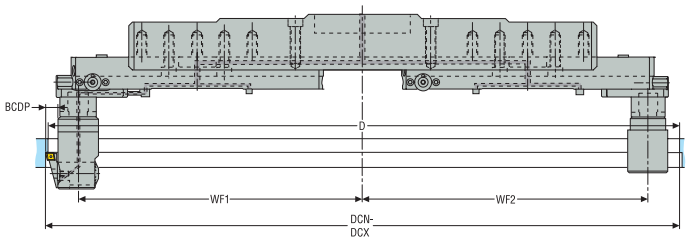


Abb. 2

* Wendeschneidplatten-Halter müssen separat bestellt werden.

Bestimmung des Mindest-Zugangsdurchmessers (Dmin)

Auswuchtung: WF1 = WF2

D min = DC + 5- BCDP

BCDP = Abstand zwischen Schneidkante und Grundkörper des Ausdrehkopfes A78050 (7,5 < BCDP < 18,5).

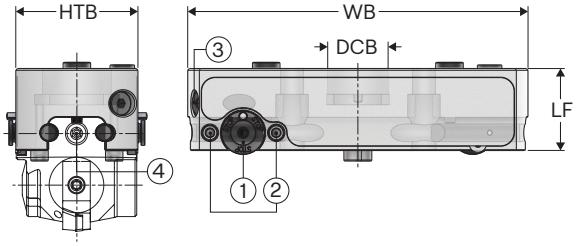
Zwei extreme Beispiele:

Ausdrehkopf A78050 auf Mindest-Bereich eingestellt: D min = DCN - 2,5
Ausdrehkopf A78050 auf maximalen Bereich eingestellt: D min = DCX -13,5

Brückenwerkzeug-Kombinationen zum Rückwärtssenken: Auswahltabelle für Brückenwerkzeuge, um einen erforderlichen Rückwärtssenk-Durchmesser zusammenzustellen

Zum Rückwärtssenken DCN-DCX ∅ mm	*Zum Rückwärtssenken DCN-DCX ∅ Zoll*	Jumbo Brückenwerkzeug	Klassische Brückenwerkzeuge	Zum Rückwärtssenken	
					Abb.
203-301	*7.992-11.850*	–	A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter zum Rückwärtssenken + 1x BM050W78050	1
278-376	*10.945-14.803*	–	A731S 020		
353-451	*13.898-17.756*	–	A731S 030		
428-526	*16.850-20.709*	–	A731S 040		
503-601	*19.803-23.661*	–	A731S 050		
578-676	*22.756-26.614*	–	A731S 060		
653-826	*25.709-32.520*	A731S 001	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter zum Rückwärtssenken + 1x BM050W78050	2
653-901	*25.709-35.472*		2x A731S 020		
803-976	*31.614-38.425*		2x A731S 030		
878-1051	*34.567-41.378*		2x A731S 040		
1028-1126	*40.472-44.331*		2x A731S 050		
1103-1276	*43.425-50.236*	A731S 002	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter zum Rückwärtssenken + 1x BM050W78050	2
1103-1351	*43.425-53.189*		2x A731S 020		
1253-1426	*49.331-56.142*		2x A731S 030		
1328-1501	*52.283-59.094*		2x A731S 040		
1478-1576	*58.189-62.047*		2x A731S 050		
1553-1651	*61.142-65.000*		2x A731S 060		
1628-1801	*64.094-70.906*	A731S 003	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter zum Rückwärtssenken + 1x BM050W78050	2
1628-1876	*64.094-73.858*		2x A731S 020		
1778-1951	*70.000-76.811*		2x A731S 030		
1853-2026	*72.953-79.764*		2x A731S 040		
2003-2101	*78.858-82.717*		2x A731S 050		
2078-2176	*81.811-85.669*		2x A731S 060		
2153-2326	*84.764-91.575*	A731S 004	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter zum Rückwärtssenken + 1x BM050W78050	2
2153-2401	*84.764-94.528*		2x A731S 020		
2303-2476	*90.669-97.480*		2x A731S 030		
2378-2551	*93.622-100.433*		2x A731S 040		
2528-2626	*99.528-103.386*		2x A731S 050		
2603-2701	*102.480-106.339*		2x A731S 060		
2678-2851	*105.433-112.244*	A731S 005	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Wendeplattenhalter zum Rückwärtssenken + 1x BM050W78050	2
2678-2926	*105.433-115.197*		2x A731S 020		
2828-3001	*111.339-118.150*		2x A731S 030		
2903-3076	*114.291-121.102*		2x A731S 040		
3053-3151	*120.197-124.055*		2x A731S 050		
3128-3226	*123.150-127.008*		2x A731S 060		

BB 731S0x0 – Brückenwerkzeuge



—Kühlmittel durch das Brückenwerkzeug

1. Spannschraube mit Anschlag
2. Spannschraube
3. Mitnehmer
4. Durchmesser-Einstellschraube

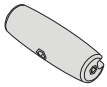
Bezeichnung	Produktnummer	Werkstückseite Bereich DCN-DCX		HTB	WB	DCB	LF	Gewicht
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
A731S010	02753664	204,0 *8.031*	280,0 *11.024*	70,0 *2.756*	195,0 *7.677*	40,0 *1.575*	47,0 *1.850*	3,6 *7.9*
A731S020	02753668	279,0 *10.984*	355,0 *13.976*	70,0 *2.756*	269,0 *10.591*	40,0 *1.575*	47,0 *1.850*	5,1 *11.2*
A731S030	02753670	354,0 *13.937*	430,0 *16.929*	70,0 *2.756*	344,0 *13.543*	40,0 *1.575*	47,0 *1.850*	6,5 *14.3*
A731S040	02753673	429,0 *16.890*	505,0 *19.882*	70,0 *2.756*	419,0 *16.496*	40,0 *1.575*	47,0 *1.850*	7,9 *17.4*
A731S050	02753675	504,0 *19.843*	580,0 *22.835*	70,0 *2.756*	494,0 *19.449*	40,0 *1.575*	47,0 *1.850*	10,5 *23.2*
A731S060	02753677	579,0 *22.795*	655,0 *25.787*	70,0 *2.756*	569,0 *22.402*	40,0 *1.575*	47,0 *1.850*	12,3 *27.1*

Anzugsdrehmoment 20 Nm der Spannschrauben (2) und der Spannschraube mit Anschlag (1).
Vor dem Einstellen des Durchmessers sicherstellen, dass der Mitnehmer eingerastet ist. Informationen finden Sie in der Bedienungsanleitung, die mit den Brückenwerkzeugen und Ausdrehblöcken geliefert wird.
Max. Drehzahl, siehe Seite(n) 570
Informationen zu Zapfendreh-Kapazitäten siehe Guide auf Seite(n) 561-562
Für größere Durchmesser siehe Jumbo-Brückenwerkzeuge auf Seite(n) 566

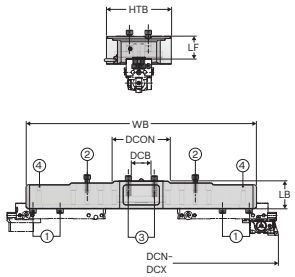
Ersatzteile, im Lieferumfang enthalten

Für Halter	Befestigungsschraube
A731S010-60	19A71060

Zubehör

Für Halter	Schlüssel (Quergriff)	Schlüssel	Spannschlüssel
			
A731S010-60	DOUBLE-T	H6B-H5.0L	03HL05

JBB 731S00 – Jumbo-Brückenwerkzeuge



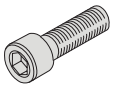
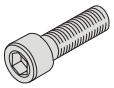
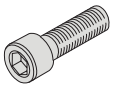
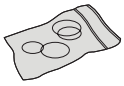
—Jumbo-Brückenwerkzeuge sind so konstruiert, dass sie zwei klassische Brückenwerkzeuge in mehreren Positionen halten können.
—Durchflusskühlmittel Jumbo-Brückenwerkzeuge

1. Schraube
2. Spannschraube
3. Befestigungsschraube
4. Verschlussstopfen

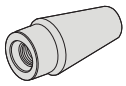
Bezeichnung	Produkt-nummer	Werkstückseite Bereich DCN-DCX		HTB	LF	WB	DCON	DCB	CBDP	LB	Gewicht	**
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A731S001	02828506	654,0 *25.748*	1105,0 *43.504*	180,0 *7.087*	63,0 *2.480*	640,0 *25.197*	135,0 *5.315*	60,0 *2.362*	24,0 *0.945*	77,0 *3.031*	20,25 *44.6*	
A731S002	02828516	1104,0 *43.465*	1630,0 *64.173*	200,0 *7.874*	50,0 *1.969*	1090,0 *42.913*	135,0 *5.315*	60,0 *2.362*	24,0 *0.945*	80,0 *3.150*	34,5 *76.1*	
A731S003	02904383	1629,0 *64.134*	2155,0 *84.843*	200,0 *7.874*	50,0 *1.969*	1615,0 *63.583*	135,0 *5.315*	60,0 *2.362*	24,0 *0.945*	80,0 *3.150*	67,0 *147.7*	**

Kapazitäten zum Ausdrehen, Zapfendrehen und Rückwärtssenken für Kombinationen von Jumbo- und Brückenwerkzeugen siehe Guide auf Seite(n) 559–564
**Größere Größen A731S004–... (∅ 2154–2680 mm) und A731S005–... (∅ 2679–3205 mm) auf Anfrage erhältlich, siehe Guide auf Seite(n) 560

Ersatzteile, im Lieferumfang enthalten

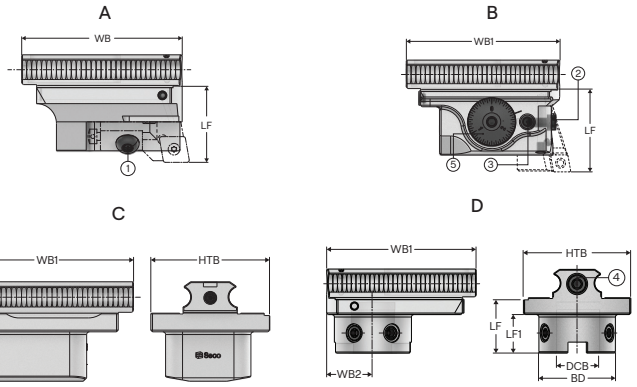
Für DCN-DCX	Schraube	Feststellschraube	Schraube für Hebel	Befestigungsschraube	O-Ring	Dichtstopfen
						
654-1105	950D1240	950D1670	90AS03	950D1250	90JT02	AU731S01100
1104-1630	950D1240	950D1680	90AS03	950D1250	90JT02	AU731S01100
1629-2155	950D1240	950D16120	90AS03	950D1250	90JT02	AU731S01100

Zubehör

Für DCN-DCX	Zentrierzapfen
	
654-1105	E447153960
1104-1630	E447153960
1629-2155	E447153960

Der Satz O-Ring-Dichtungen enthält 6 O-Ring-Dichtungen ∅ 6 mm (0,236 Zoll) für die Kühlmittelkanäle und 1 O-Ring-Dichtung ∅ 60 mm (2,362 Zoll) für die Haltebohrung der Jumbo-Brückenwerkzeuge.

BBB 731S0xx – Ausdrehblöcke für Brückenwerkzeuge



—Zur Montage auf Brückenwerkzeugen
—Kühlmittel durch die Schrupp-, Fein- und Graflex-Ausdrehblöcke

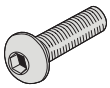
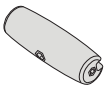
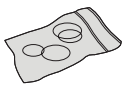
1. Schraube
5. Spannschraube
3. Spannschraube

2. Schraube
4. Durchmesser-Einstellschraube

Bezeichnung	Produkt-nummer	Ausdrehblock Typ	Werkstückseite Bereich DCN-DCX		HTB	LF	LF1	WB1	WB2	DCB	BD	Gewicht	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
A731S400	02753679	Schruppausdrehblock*	204,0 *8.031*	2155,0 *84.843*	70,0 *2.756*	47,0 *1.850*	–	97,0 *3.819*	–	–	–	1,4 *3.1*	A
A731S500	02753680	Feinausdrehblock**	204,0 *8.031*	2155,0 *84.843*	70,0 *2.756*	47,0 *1.850*	–	97,0 *3.819*	–	–	–	1,5 *3.3*	B
A731S600	02753682	Gegengewicht	204,0 *8.031*	2155,0 *84.843*	70,0 *2.756*	–	–	97,0 *3.819*	–	–	–	1,6 *3.5*	C
A731S40128	02753687	Graflex Größe G5***	48,0 *1.890*	2021,0 *79.567*	70,0 *2.756*	36,0 *1.417*	25,0 *0.984*	97,0 *3.819*	30,0 *1.181*	28,0 *1.102*	50,0 *1.969*	1,0 *2.2*	D

* Kassetten müssen separat bestellt werden, siehe Seite(n) 569
** Feinausdreh-Wendeplattenhalter Größe 60 separat zu bestellen, siehe Seite 548, 549
*** Bei Verwendung von Ausdrehkopf A78050 Gegengewicht BM050W78050 verwenden, siehe Zubehör unten.

Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube	Klemmschraube für Trommel	Schlüssel (Quergriff)	Schlüssel	Spannschlüssel	O-Ring
						
A731S400	950CB0830	–	DOUBLE-T	H6B-H5.0L	–	90JT01
A731S500	950D0612	950L1016	DOUBLE-T	H6B-H5.0L	–	90JT01
A731S600	–	–	DOUBLE-T	H6B-H5.0L	–	–
A731S40128	90F5	–	DOUBLE-T	H6B-H5.0L	03H05	90JT01

Der Satz O-Ring-Dichtungen enthält 6 O-Ring-Dichtungen ∅ 6 mm (0,236 Zoll) für die Kühlmittelkanäle und 1 O-Ring-Dichtung ∅ 60 mm (2,362 Zoll) für die Haltebohrung der Jumbo-Brückenwerkzeuge.

Zubehör

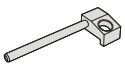
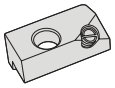
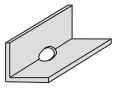
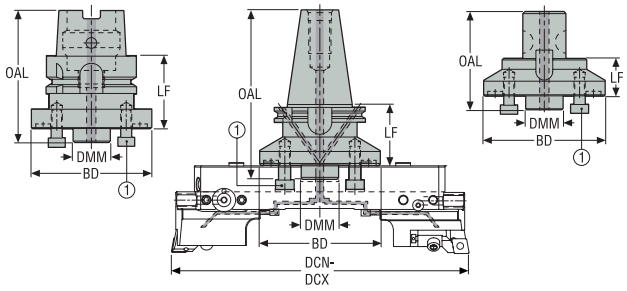
Für Halter	Verbindungsrohr	Kühlkit	Winkelblech	Gegengewicht
				
A731S400	AU731S00700	AU731S40700	18LS0316	–
A731S500	AU731S00700	–	–	–
A731S600	–	–	–	–
A731S40128	AU731S00700	–	–	BM050W78050

ABB 731 200 – Halter und Adapter für Brückenwerkzeuge



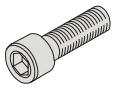
1. Einstellschraube

- HSK- und SK-Halter für kurze Anordnungen
- Graflex®-Adapter für verlängerte Anordnungen
- Brückenwerkzeug in 30°-Schritten einstellbar
- Lieferung mit einem O-Ring ∅ 58 x 3 mm zur Zapfendichtung

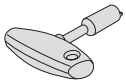
Bezeichnung	Produkt-nummer	Maschinenseitig	Größe	Werkstückseite Bereich DCN-DCX		OAL	LF	BD	DMM	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
E3471731200	02503392	DIN 69871-ADB	DIN50 ADB	204,0 *8.031*	655,0 *25.787*	166,75 *6.565*	65,0 *2.559*	130,0 *5.118*	40,0 *1.575*	5,9 *13.0*
E3416731200	02503393	BT JIS B 6339-ADB	BT50 ADB	204,0 *8.031*	655,0 *25.787*	166,75 *6.565*	65,0 *2.559*	130,0 *5.118*	40,0 *1.575*	5,64 *12.4*
E9306731200	02417268	ISO 12164-1/ DIN69893-A	HSK-A100	204,0 *8.031*	655,0 *25.787*	115,0 *4.528*	65,0 *2.559*	130,0 *5.118*	40,0 *1.575*	5,0 *11.0*
A731200	00056616	GRAFLEX	G7	204,0 *8.031*	655,0 *25.787*	90,0 *3.543*	40,0 *1.575*	130,0 *5.118*	40,0 *1.575*	4,0 *8.8*

Anzugsdrehmoment 80 Nm. Informationen finden Sie in der Bedienungsanleitung, die mit den Brückenwerkzeugen und Ausdrehblöcken geliefert wird.

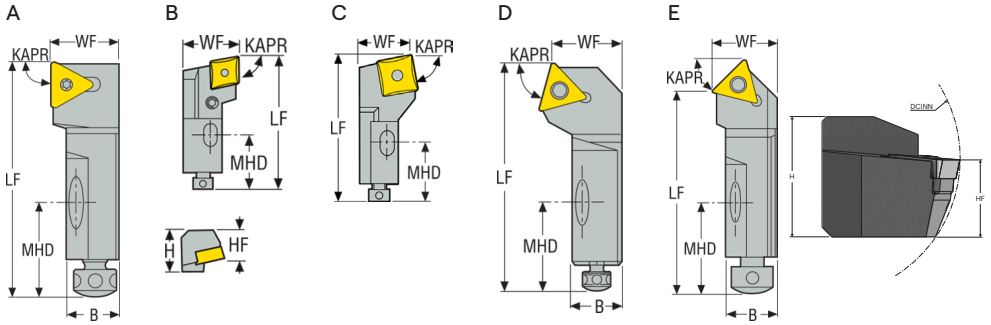
Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube	Schlüssel	Dichtschraube	Mitnehmer
				
E3471731200	950D1230	10SMS795	950A0606	–
E3416731200	950D1230	10SMS795	950A0606	–
E9306731200	950D1230	10SMS795	–	–
A731200	950D1230	10SMS795	–	90M7

Zubehör

Für Halter	Kühlmittelrohr	Dichtstopfen	Spannschlüssel
			
E3471731200	–	–	–
E3416731200	–	–	–
E9306731200	20E9306	02E9306	03E9306
A731200	–	–	–

Einbauhalter Schrupp-Ausdrehblock A731S400



—Zur Befestigung am Schruppausdrehblock

Bezeichnung	Produkt-nummer	KAPR°	LF	MHD	WF	B	H	HF	DCINN	Gewicht	Entspr. WSP-Größe	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
SCGCL16CA-16	00039871	90,0 °	55,0 *2.165*	25,0 *0.984*	25,0 *0.984*	17,5 *0.689*	20,0 *0.787*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	CC..16..	A
STGCL16CA-16	00009197	90,0 °	63,0 *2.480*	25,0 *0.984*	24,96 *0.983*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	A
STGCL16CA-22	02600181	90,0 °	55,0 *2.165*	25,0 *0.984*	25,0 *0.984*	17,5 *0.689*	20,0 *0.787*	16,0 *0.630*	50,0 *1.969*	0,2 *0.4*	TC..2204..	A
PCGNL16CA-12	02484356	90,2 °	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	36,0 *1.417*	0,2 *0.4*	CN..12..	B
SSRCL16CA-15	00039872	75,0 °	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	20,0 *0.787*	20,0 *0.787*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	SC..15..	C
STRCL16CA-16	00008750	75,0 °	63,0 *2.480*	25,0 *0.984*	24,96 *0.983*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	D
STRCL16CA-22	02585320	75,0 °	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	17,5 *0.689*	20,0 *0.787*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..2204..	D
STTCL16CA-16	00009194	60,0 °	63,0 *2.480*	25,0 *0.984*	14,96 *0.589*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	D
STSCL16CA-16	00009193	45,0 °	53,0 *2.087*	25,0 *0.984*	24,96 *0.983*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	E

Empfohlene Bearbeitungsbedingungen

Optimale Ergebnisse erzielen Sie mit Durchflusskühlmittel (höhere Schnittdaten, höhere Oberflächengüte, bessere Spanabfuhr).

Beim Schruppausdrehen ist die jeweilige Priorität entscheidend: Für höhere Vorschübe oder bessere Spanabfuhr wählen Sie eine symmetrische Einstellung der Klemmhalter (das meistgenutzte Verfahren mit doppeltem Vorschub im Vergleich zur asymmetrischen Einstellung); alternativ bietet eine asymmetrische Einstellung eine doppelte Schnitttiefe.
Beim Feinausdrehen in Stahl bei guten Bearbeitungsbedingungen eignen sich Cermet-Wendeschneidplatten für hohe Geschwindigkeiten und lange Standzeiten.

Weitere Details finden Sie in der Bedienungsanleitung, die mit den Ausdrehköpfe und mit den Steadyline®-Bohrstangen geliefert wird. Diese Bedienungsanleitung steht auch auf www.secotools.com zum Download zur Verfügung.

Fehlerbehebung

Siehe Kapitel „Herausforderungen“ im Kapitel Schruppausdrehen, Seite 493 oder Feinausdrehen, Seite 538 nach.

Maximale Geschwindigkeiten für Brückenwerkzeuge

Aufgrund der Größe der Ausdrehköpfe für Brückenwerkzeuge kann eine unsachgemäße Programmierung erhebliche Schäden verursachen.
Die nachstehenden maximalen Drehzahlen gelten für neue Brückenwerkzeugkombinationen unter Einsatz neuer Brückenwerkzeugtypen (Produktnummer A731S 0_0) Schruppausdreh-, Feinausdreh- und Gegengewichtsblöcke (Produktnummer A731S _00) sowie Jumbo-Brückenwerkzeuge (Produktnummer A731 00_). Informationen zu anderen Kombinationen erhalten Sie von Ihrem Seco-Ansprechpartner.

ANMERKUNG: Bei Verwendung neuer Ausdrehblöcke (Produktnummer A731S 400, A731S 500, A731S 600, A731S 40128) auf Brückenwerkzeugen der Vorgängerserie (Produktnummer A731 0_0, ohne S), gilt die für die Brückenwerkzeuge der Vorgängerserie empfohle Drehzahl. Um Unwuchten zu vermeiden, dürfen Brückenwerkzeuge der neuen Serie und der Vorgängerserie nicht auf demselben Brückenwerkzeug verwendet werden.

Kopf basiert auf	**Kapazität ∅ mm** *(Zoll)*	**Max. Drehzahl**	**Angenommene max. Schnittgeschwindigkeit v_c bei min. Deckelung. m/min** *(sf/min)*	**Angenommene max. Schnittgeschwindigkeit v_c bei max. Deckelung. m/min** *(sf/min)*
	Herstellungstoleranz Bohrer			
A731S010	204-280 *(8.0315-11.0236”)*	1600	1025 *(3363)*	1407 *(4616)*
A731S020	279-355 *(10.9843-13.9764”)*	1150	1007 *(3304)*	1282 *(4206)*
A731S030	354-430 *(13.937-16.9291”)*	900	1000 *(3281)*	1215 *(3986)*
A731S040	429-505 *(16.8898-19.8819”)*	750	1010 *(3314)*	1189 *(3901)*
A731S050	504-580 *(19.8425-22.8346”)*	650	1029 *(3376)*	1184 *(3885)*
A731S060	579-655 *(22.7953-25.7874”)*	550	1000 *(3281)*	1131 *(3711)*
	Jumbo Brückenwerkzeuge (mit zwei identischen Brückenwerkzeugen und Ausdrehblöcken)			
A731S001	654-1105 *(25.748-43.50394”)*	170	349 *(1145)*	590 *(1936)*
A731S002	1104-1630 *(43.46457-64.17323”)*	100	346 *(1135)*	512 *(1680)*
A731S003	1629-2155 *(64.13386-84.84252”)*	70	358 *(1175)*	473 *(1552)*
A731S004	2154-2680 *(84.80315-105.5118”)*	50	358 *(1175)*	420 *(1378)*
A731S005	2679-3205 *(105.4724-126.1811”)*	40	336 *(1102)*	402 *(1319)*

Hinweis: Die maximalen Geschwindigkeiten beziehen sich auf die mechanische Konstruktion und die Auswuchtqualität. Die Geschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Bearbeitungsbedingungen wie zu bearbeitenden Werkstoff, Schneidkante (Wendeschneidplatte), Werkzeuglänge und Maschinenspindel gewählt werden.

Übersicht BB732 — Brückenwerkzeuge für Steadyline®-Bohrstangen

Seco Capto™ Adapter
LF 70-130 mm

Steadyline® Aufsteckfräserdorn Ø 40
DIN / Seco Capto™ / HSK

Brücke SM40-BB732-011
Schruppen Ø 114-146 mm (4,488"-5,748")
Schlichten Ø 114-160 mm (4,488"-6,299")

Brücke SM40-BB732-012
Schruppen Ø 145-177 mm (5,709"-6,969")
Schlichten Ø 145-191 mm (5,709"-7,520")

Brücke SM40-BB732-013
Schruppen Ø 176-208 mm (6,930"-8,189")
Schlichten Ø 176-222 mm (6,930"-8,740")

Brücke SM40-BB732-014
Schruppen Ø 207-239 mm (8,150"-9,410")
Schlichten Ø 207-253 mm (8,150"-9,961")

Brücke SM40-BB732-015
Schruppen Ø 238-270 mm (9,370"-10,630")
Schlichten Ø 238-284 mm (9,370"-11,181")

Brücke SM40-BB732-016
Schruppen Ø 269-301 mm (10.591"-11.850")
Schlichten Ø269-315 mm (10.591"-12.402")

Schruppausdrehblock und Klemmhalter
Kassette für Wendeplatten CC12 / CC16
KAPR 91,5°

Schlichtausdrehblock und Klemmhalter
Kassette für Wendeplatten CC12 / CC09
KAPR 95,5°

Merkmale: BB732 Serie — Brückenwerkzeuge für Steadyline®-Bohrstangen

Anwendung

— Speziell entwickelt für tiefe Bohrarbeiten bis 576 mm, wo der Werkzeugüberstand das Risiko von Vibrationen erhöht.

— Schruppausdrehen Ø 114 – 301 mm (4.488" – 11.850"). Feinausdrehen Ø 114 – 315 mm (4.488" – 12.402").

— Tiefe Bohrungen mit Aufnahmedorn Ø 40 mm Steadyline® von 437 – 576 mm abhängig von der eingesetzten Werkzeugkombination.
Hohe Prozesssicherheit und Leistung auch bei unterbrochenem Schnitt, z. B. bei der Bearbeitung von Kompressor- oder Pumpengehäusen (Schnittparametergrenzen beachten).

— Bei tiefen Bohrungen mit größerem Durchmesser lassen sich höhere Schruppleistungen erzielen.

— Zur Montage auf Steadyline® Aufnahmen für Aufsteckfräser mit Aufnahmedorn 40 mm, für Gesamtfunktionslänge von 437 bis 576 mm:
-HSK-A100
-DIN50 ADB-BT50 TF ADB
-Seco Capto™ C8

Vorteile und Merkmale

— Gleiches Brückenwerkzeug zum Schruppen und Schlichten.

— Interne Kühlmittelzufuhr zur Schneide (zentrale Kühmittelzufuhr).

— Max. Kühlmitteldruck mit Steadyline® 70 bar (1000 PSI).

— Bis zu IT6 (Toleranzbereich) – Wiederholbarkeit.

— Bis zu Ra 0,6 beim Feinausdrehen.

— Bei Feinausdrehbearbeitungen liegt die Einstellgenauigkeit im Durchmesserbereich bei 2,5 µm.

— Wendeschneidplatten CC..09.. für Feinausdrehen und CC..12.. und CC..16.. für Schruppausdrehen erhältlich.

— Beim Schruppen sind symmetrische und asymmetrische Einstellungen möglich.

— Alle Brückenwerkzeuge sind für den Einsatz auf Steadyline® Aufnahmen für Aufsteckfräser mit Aufnahmedorn 40 mm
— ausgelegt.
Eine spezielle Steadyline® Bohrstange ist für die Montage auf Seco Capto™ Grundaufnahmen mit einer funktionalen Länge von 70 bis 130 mm ausgelegt, um eine größere Tiefe von bis zu 576 mm (22,7'') zu erreichen.

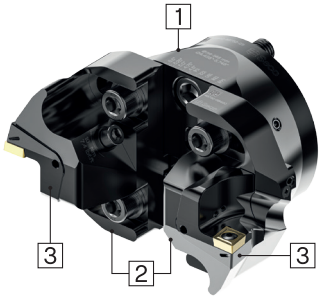
— Gleitschieber werden mittels Feststellschrauben formschlüssig gesichert, um einen zentrifugalbedingten Auswurf im Betrieb zu verhindern.

Erstellung von Brückenwerkzeugkombinationen zum Schruppausdrehen

Ein Brückensystem für die Schruppbearbeitung erfordert 1 Brückenwerkzeug + 2 Schruppausdrehblöcke + 2 gleiche Klemmhalter cc12 oder cc16

Schruppausdrehkombination (Abb. 5)

Montage		
Sr Nr	Produkt	Menge
1	Brücke	1
2	Gleitschieber zum Schruppausdrehen	2
3	Wendeplattenhalter	2



Brücke

6 Brückenwerkzeugausführungen für verschiedene Durchmesserbereiche.
Alle Brückenwerkzeuge zum Schruppen und Schlichten geeignet

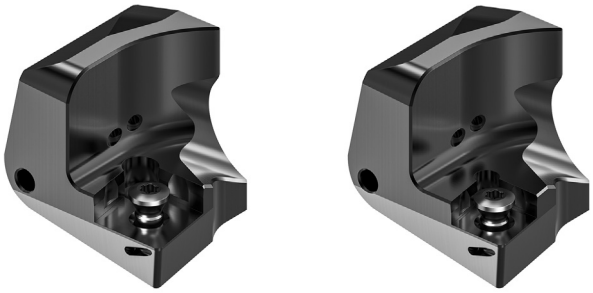
Schruppausdrehblock

Werkstückseitenkapazität DCN Ø 114 bis DCX Ø 301 mm.

Ein großer Doppelschneider erfordert zwei Gleitschieber für die Schruppbearbeitung, die jeweils mit einem Klemmhalter ausgestattet sind.

Kassette

Zwei Klemmhaltergrößen:
Klemmhalter mit CC12 und KAPR 91°
Klemmhalter mit CC16 und KAPR 91°

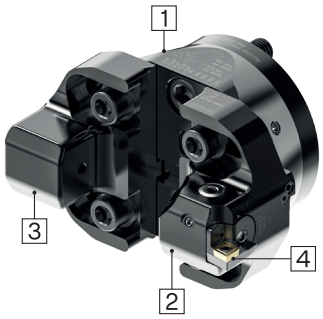


Erstellung von Brückenwerkzeugkombinationen zum Feinausdrehen

Für ein Brückenwerkzeugsystem zum Feinausdrehen werden 1 Brückewerkzeug + 1 Feinausdrehblock + 1 Wendeplattenhalter CC9 + 1 Gegengewichtsschieber benötigt

Feinausdrehkombination (Abb. 6)

Montage		
Sr Nr	Produkt	Menge
1	Brücke	1
2	Gleitschieber zum Feinausdrehen	1
3	Gegengewicht	1
4	Klemmhalter	1



Brücke

6 Brückenwerkzeugausführungen für verschiedene Durchmesserbereiche. Alle Brückenwerkzeuge zum Schruppen und Schlichten geeignet.

Alle Brückenwerkzeuge können nur auf SM40-Werkzeughaltern (Aufsteckfräserdurchmesser 40 mm) und geeigneter Ausführung mit Seco Capto verwendet werden.

Feinausdrehblock

Werkstückseitenkapazität DCN Ø 114 mm bis DCX Ø 315 mm.

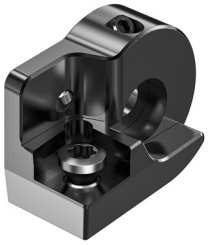
Gegengewicht

Die Ausrichtung des Gegengewichtsblocks erfolgt symmetrisch zum Werkzeugdurchmesser unter Verwendung der Brückenteilung.

Kurzklemmhalter

Kurzklemmhalter mit CC09-Wendeplatten und KAPR 95,5° für optimale Stabilität.

Kurzklemmhalter am Kolben des Gleitschiebers fixieren, um die Wendeschneidplatte mit einem Anzugsdrehmoment von 3 Nm (2,2 lbf·ft) zu spannen.

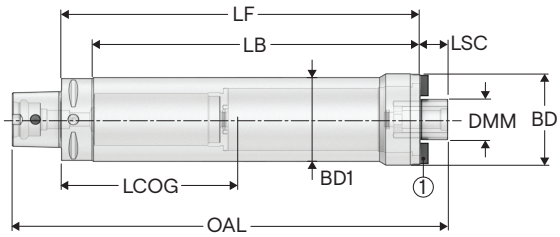


Zusammenstellung von Brückenwerkzeug-Ausdreh-Kombinationen: Auswahltabelle für Brückenwerkzeuge, um einen erforderlichen Ausdreh-Durchmesser zusammenzustellen

Zum Ausdrehen DCN-DCX ∅ mm	*Zum Ausdrehen DCN-DCX ∅ Zoll*	Brückenwerkzeuge	Schruppausdrehen		Feinausdrehen	
				Abb.		Abb.
114-146	*4.488-5.748*	SM40-BB732-011	2x BB732-RB400 + 2 Kassetten	5	BB732-FB500 + 1 Kassetten +BB732-FB600	6
145-177	*5.709-6.969*	SM40-BB732-012				
176-208	*6.929-8.189*	SM40-BB732-013				
207-239	*8.150-9.410*	SM40-BB732-014				
238-270	*9.370-.10.630*	SM40-BB732-015				
269-301	*10.591-11.850*	SM40-BB732-016				

Geeignete Steadyline® Bohrstangen für die Serie BB732

Brücken-werkzeuge	Durchmesser-bereich Schruppen	Durchmesser-bereich Schlichten	Funktionale Länge	Maschinenseitig	Steadyline® Aufsteckfräserdorne	Gesamtgewicht der Kombination in KG (lbs)	Gesamtes Kippmoment Nm (ft lb)
SM40-BB732-011	114-146 mm (4.488- 5.748")	114-160 mm (4.488-6.300")	446,5 mm	HSK-A100	E9306555540350	23.1 (50.92)	48.7
			446,5 mm	DIN50 ADB	E3471555540350	24.2 (53.35)	49.1 (36.21)
			446,5 mm	BT50 TF ADB	E3216555540350	24.5 (54.01)	49.2 (36.22)
			446,5 mm	Seco Capto™ C8	C8-391.5555-40350	22.6 (49.82)	48.6 (35.84)
			516,5-576,5 mm	Seco Capto™ C8 + zusätzliche Seco Capto™-Verlängerung	C8-SML40-350-KL1 + Seco Capto Grundaufnahme LF 70 bis 130 mm	Abgängig von der ausgewählten Seco Capto-Grundaufnahme	
SM40-BB732-012	145-177 mm (5.709-6.969")	145-191 mm (5.709-7.520")	446,5 mm	HSK-A100	E9306555540350	23.9 (52.69)	51.8 (38.20)
			446,5 mm	DIN50 ADB	E3471555540350	25.0 (55.11)	52.2 (38.50)
			446,5 mm	BT50 TF ADB	E3216555540350	25.4 (55.99)	52.3 (38.57)
			446,5 mm	BT50 TF ADB	E3216555540350	25.4 (55.99)	52.3 (38.57)
			446,5 mm	Seco Capto™ C8	C8-391.5555-40350	23.4 (51.58)	51.7 (38.13)
			516,5-576,5 mm	Seco Capto™ C8 + zusätzliche Seco Capto™-Verlängerung	C8-SML40-350-KL1 + Seco Capto Grundaufnahme LF 70 bis 130 mm	Abgängig von der ausgewählten Seco Capto-Grundaufnahme	
SM40-BB732-013	176-208 mm (6.929-8.189")	176-222 mm (6.929-8.740")	437,5 mm	HSK-A100	E9306555540350	23.9 (52.69)	51.7 (38.13)
			437,5 mm	DIN50 ADB	E3471555540350	25.1 (55.33)	52.2 (38.50)
			437,5 mm	BT50 TF ADB	E3216555540350	25.4 (55.99)	52.2 (38.50)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	23.5 (51.80)	51.6 (38.05)
			507,5-567,5 mm	Seco Capto™ C8 + zusätzliche Seco Capto™-Verlängerung	C8-SML40-350-KL1 + Seco Capto Grundaufnahme LF 70 bis 130 mm	Abgängig von der ausgewählten Seco Capto-Grundaufnahme	
SM40-BB732-014	207-239 mm (8.150-9.410")	207-253 mm (8.150-9.961")	437,5 mm	HSK-A100	E9306555540350	24.6 (54.23)	54 (39.82)
			437,5 mm	DIN50 ADB	E3471555540350	25.7 (56.65)	54.5 (40.19)
			437,5 mm	BT50 TF ADB	E3216555540350	26.0 (57.32)	54.6 (40.27)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	24.1 (53.13)	53.9 (39.75)
			507,5-567,5 mm	Seco Capto™ C8 + zusätzliche Seco Capto™-Verlängerung	C8-SML40-350-KL1 + Seco Capto Grundaufnahme LF 70 bis 130 mm	Abgängig von der ausgewählten Seco Capto-Grundaufnahme	
SM40-BB732-015	238-270 mm (9.370-10.630")	238-284 mm (9.370-11.181")	437,5 mm	HSK-A100	E9306555540350	25.2 (55.55)	56.4 (41.59)
			437,5 mm	DIN50 ADB	E3471555540350	26.3 (57.98)	56.8 (41.89)
			437,5 mm	BT50 TF ADB	E3216555540350	26.7 (58.86)	56.9 (41.96)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	24.7 (54.45)	56.3 (41.52)
			507,5-567,5 mm	Seco Capto™ C8 + zusätzliche Seco Capto™-Verlängerung	C8-SML40-350-KL1 + Seco Capto Grundaufnahme LF 70 bis 130 mm	Abgängig von der ausgewählten Seco Capto-Grundaufnahme	
SM40-BB732-016	269-301 mm (10.591-11.850")	269-315 mm (10.591-12.402")	437,5 mm	HSK-A100	E9306555540350	25.8 (56.87)	58.2 (42.92)
			437,5 mm	DIN50 ADB	E3471555540350	26.9 (59.30)	58.7 (43.29)
			437,5 mm	BT50 TF ADB	E3216555540350	27.3 (60.18)	58.7 (43.29)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	25.4 (55.99)	58.1 (42.85)
			507,5-567,5 mm	Seco Capto™ C8 + zusätzliche Seco Capto™-Verlängerung	C8-SML40-350-KL1 + Seco Capto Grundaufnahme LF 70 bis 130 mm	Abgängig von der ausgewählten Seco Capto-Grundaufnahme	



1. Mitnehmerstein

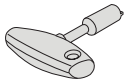
Bezeichnung	Produkt-nummer	Größe	DMM	LF	BD	BD1	LCOG	OAL	LB	LSC	Max. Dreh-zahl	RFID-Bohrung	Aus-wuch-tung	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
E9306555540350	02753468	HSK-A100	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	178,9 *7.043*	427,0 *16.811*	321,0 *12.638*	27,0 *1.063*	3000	1	PB	19,4 *42.8*
E3216555540350	02926043	BT50 TF ADB	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	169,0 *6.654*	478,8 *18.850*	312,0 *12.283*	27,0 *1.063*	3000	1	PB	20,7 *45.6*
E3471555540350	02753471	DIN50 ADB	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	171,4 *6.748*	478,75 *18.848*	330,9 *13.028*	27,0 *1.063*	3000	1	PB	20,4 *45.0*
C8-391.5555-40350	02753473	C8	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	182,6 *7.189*	425,0 *16.732*	317,0 *12.480*	27,0 *1.063*	3100	1	PB	19,0 *41.9*
C8-SML40-350-KL1	10249301	C8	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	82,0 *3.228*	189,5 *7.461*	425,0 *16.732*	320,0 *12.598*	27,0 *1.063*	2800	1	PB	15,5 *34.2*

Montagegewicht und Kippmoment prüfen

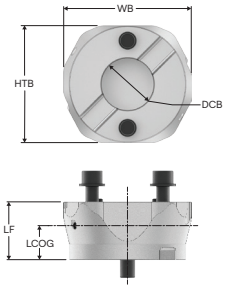
Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube	Dichtschraube	Mitnehmer
E930..	950D0616	–	16C2161621A
E321..	950D0616	950A0606	16C2161621A
E347..	950D0616	950A0606	16C2161621A
C8-391..	950D0616	–	16C2161621A
C8-SML..	950D0616	–	16C2161621A

Zubehör

Für Halter	Kühlmittelrohr	Dichtstopfen	Spannschlüssel 3
			
E930..	20E9306	02E9306	03E9306
E321..	–	–	–
E347..	–	–	–
C8-391..	–	–	–
C8-SML..	–	–	–

BB73201x — Brückenwerkzeuge für tiefe Bohrungen



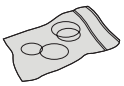
—Zur Montage auf einem Steadyline® Aufnahme für Aufsteckfräser mit 40 mm, siehe Seite(n) 577
—Kühlmittel durch das Brückenwerkzeug

Bezeichnung	Produktnummer	DCN	DCX	HTB	WB	DCB	LF	LCOG	Gewicht
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SM40-BB732-011	10270854	114,0 *4.488*	146,0 *5.748*	90,0 *3.543*	98,0 *3.858*	40,0 *1.575*	44,0 *1.732*	25,39 *1.000*	2,0 *4.4*
SM40-BB732-012	10270855	145,0 *5.709*	177,0 *6.969*	90,0 *3.543*	129,0 *5.079*	40,0 *1.575*	44,0 *1.732*	25,46 *1.002*	2,9 *6.4*
SM40-BB732-013	10270856	176,0 *6.929*	208,0 *8.189*	104,0 *4.094*	160,0 *6.299*	40,0 *1.575*	35,0 *1.378*	20,95 *0.825*	2,9 *6.4*
SM40-BB732-014	10270857	207,0 *8.150*	239,0 *9.409*	104,0 *4.094*	191,0 *7.520*	40,0 *1.575*	35,0 *1.378*	21,22 *0.835*	3,6 *7.9*
SM40-BB732-015	10270858	238,0 *9.370*	270,0 *10.630*	104,0 *4.094*	222,0 *8.740*	40,0 *1.575*	35,0 *1.378*	21,38 *0.842*	4,2 *9.3*
SM40-BB732-016	10270859	269,0 *10.591*	301,0 *11.850*	104,0 *4.094*	253,0 *9.961*	40,0 *1.575*	35,0 *1.378*	21,5 *0.846*	4,8 *10.6*

Anzugsdrehmoment 100 Nm (74 lbf. Ft)
Informationen finden Sie in der Bedienungsanleitung, die mit den Brückenwerkzeugen und Ausdrehblöcken geliefert wird.

Max. Drehzahl, siehe Seite(n) 570

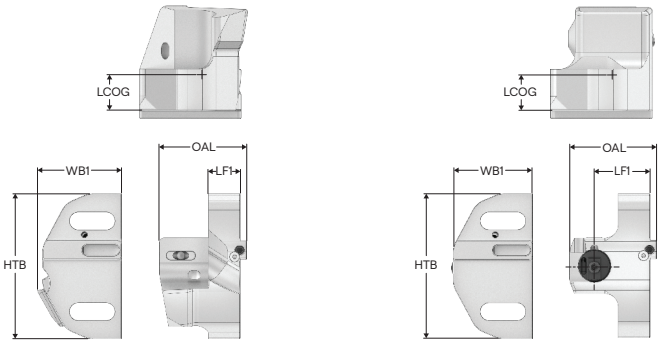
Ersatzteile, im Lieferumfang enthalten

Für Halter	Kit
	
SM40..011	90BB01
SM40..012	90BB01
SM40..013	90BB02
SM40..014	90BB02
SM40..015	90BB02
SM40..016	90BB02

Zubehör

Für Halter	Schlüssel für Pratze	Spannschlüssel
SM40..011	03HL10	03HL08
SM40..012	03HL10	03HL08
SM40..013	03HL10	03HL08
SM40..014	03HL10	03HL08
SM40..015	03HL10	03HL08
SM40..016	03HL10	03HL08

BB732 – Schrupp- und Feinausdrehblöcke für BB732-Brückenwerkzeuge

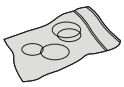


- Zur Montage auf Brückenwerkzeuge BB732
- Kühlschmiermittel durch Schrupp- und Feinausdrehblöcke
- Eine Schruppausdrehkombination erfordert zwei Schruppausdrehblöcke
- Eine Feinausdrehkombination erfordert einen Feinausdrehblock und ein Gegengewicht

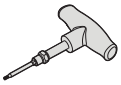
Bezeichnung	Produkt-nummer	Ausdrehblock Typ	Werkstückseite Bereich DCN-DCX		LCOG	HTB	OAL	LF1	WB1	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
BB732-RB400	10270863	Schruppausdrehblock	114,0 *4.488*	301,0 *11.850*	16,04 *0.631*	90,0 *3.543*	54,5 *2.146*	20,0 *0.787*	52,0 *2.047*	0,7 *1.5*
BB732-FB500	10270864	Feinausdrehblock	114,0 *4.488*	315,0 *12.402*	17,97 *0.707*	90,0 *3.543*	54,0 *2.126*	34,5 *1.358*	48,95 *1.927*	0,8 *1.8*
BB732-FB600	10270865	Gegengewicht	114,0 *4.488*	315,0 *12.402*	18,36 *0.723*	90,0 *3.543*	54,0 *2.126*	–	48,95 *1.927*	0,8 *1.8*

Kassetten müssen separat bestellt werden, siehe Seite(n) 569

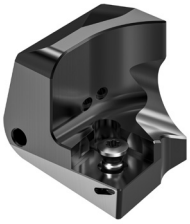
Ersatzteile, im Lieferumfang enthalten

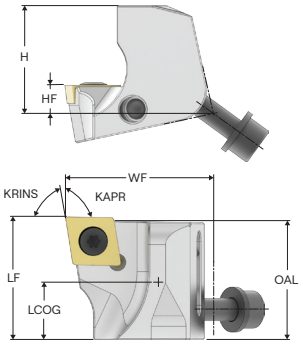
Für Halter	Kit
	
BB732-RB400	–
BB732-FB500	90FB00
BB732-FB600	–

Zubehör

Für Halter	Inbusschlüssel	Spannschlüssel	Drehmoment-schlüssel
			
BB732-RB400	03H03	03HL08	H00T-50100
BB732-FB500	–	03HL08	H00-3030
BB732-FB600	03H03	03HL08	–

Klemmhalter zum Schruppausdrehen, für Brückenwerkzeuge Schruppausdrehblöcke BB732-RB400

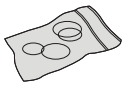




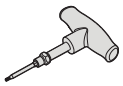
–Zur Montage auf einem Schruppausdrehblock für BB732

Bezeichnung	Produkt-nummer	KAPR°	KRINS°	Werkstückseite Bereich DCN-DCX		H	HF	WF	LF	LCOG	OAL	Gewicht	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BB732-RB400-CC1291	10270860	91.0 °	80.0	114,0 *4.488*	301,0 *11.850*	28,0 *1.102*	7,53 *0.296*	38,445 *1.514*	32,5 *1.280*	14,82 *0.583*	31,56 *1.243*	0,2 *0.4*	CC..12..
BB732-RB400-CC1691	10270862	91.0 °	80.0	114,0 *4.488*	301,0 *11.850*	28,0 *1.102*	7,52 *0.296*	38,445 *1.514*	32,5 *1.280*	14,54 *0.572*	31,42 *1.237*	0,2 *0.4*	CC..16..

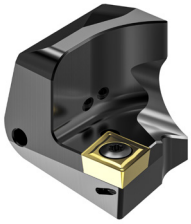
Ersatzteile, im Lieferumfang enthalten

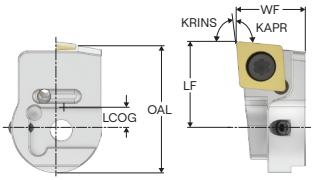
Für Halter	Kit
	
BB732-RB400-CC1291	90RB01
BB732-RB400-CC1691	90RB01

Zubehör

Für Halter	Inbusschlüssel	Schlüssel für Pratze	Schlüssel (Schraubendreher)	Drehmoment-schlüssel
				
BB732-RB400-CC1291	03H03	H00T-50100	T15P-2D	T00-15P50
BB732-RB400-CC1691	03H03	–	T15P-2D	H00T-50100

Klemmhalter zum Feinausdrehen, für Brückenwerkzeuge Feinausdrehblöcke BB732-FB500

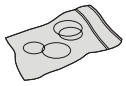




—Zur Montage auf einem Feinausdrehblock für BB732

Bezeichnung	Produkt-nummer	KAPR°	KRINS°	Werkstückseite Bereich DCN-DCX		WF	LF	LCOG	OAL	Gewicht	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BB732-FB500-CC0995	10270861	95.5 °	80.0	114,0 *4.488*	315,0 *12.402*	14,5 *0.571*	18,0 *0.709*	4,18 *0.165*	26,44 *1.041*	0,1 *0.2*	CC..09..

Ersatzteile, im Lieferumfang enthalten

Für Halter	Kit
	
BB732-FB500-CC0995	90FB01

Zubehör

Für Halter	Inbusschlüssel	Schlüssel (Schraubendreher)	Drehmoment-schlüssel
BB732-FB500-CC0995	03H03	T15P-2	H00-3030

Schnittdaten und Richtlinien

Die empfohlenen Startwerte für Wendeschneidplatten und Schneidstoffsorten, wie auf der Wendeschneidplattenverpackung angegeben, sind zu berücksichtigen. Dabei müssen jedoch zahlreiche weitere Einflussfaktoren beachtet werden – darunter der Werkzeugüberstand, der Einsatz der Steadyline® -Technologie, das Werkstückmaterial, die Klemmkraft der Spindelschnittstelle, das übertragbare Drehmoment bei gegebener Drehzahl sowie die verfügbare Antriebsleistung der Maschine (...).

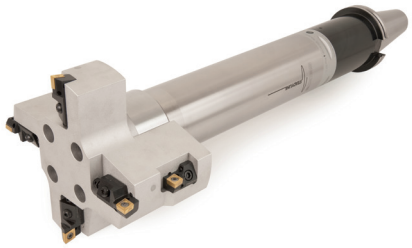
Die Kombination dieser Parameter kann Änderungen der üblichen Schnittbedingungen im Vergleich zu konventionelleren Anwendungen erfordern. Wenden Sie sich an Ihren lokalen Seco-Ansprechpartner, um Unterstützung bei der Optimierung der Schnittparameter für diese sensiblen Bearbeitungsvorgänge zu erhalten.

Alle Brückenwerkzeuge können nur auf SM40-Werkzeughaltern (Aufsteckfräserdurchmesser 40 mm) und geeigneter Ausführung mit Seco Capto verwendet werden.

Verwenden Sie nicht die maximale Drehzahl bei maximalem Drehmoment.

Ausdrehwerkzeuge nach Kundenwunsch

Seco Tools Tooling Systems greift auf langjährige Erfahrung im Bereich Sonderwerkzeuge zurück:



- schwingungsdämpfende Steadyline®-Aufnahmen zum Schruppen und Schlichten
- Mehrschneidige Bohrstangen
- Spezielle Verlängerungen mit Führungsleisten für große Auskragungen
- Kombi-Bohrstangen für Bohren, Spindeln, Anfasen, Reiben, Gewindeschneiden etc.

Weitere Informationen erhalten Sie auf Anfrage und auf www.secotools.com.

Wendeschneidplatten zum Ausdrehen – Auswahl

Die hier aufgeführten Wendeschneidplatten aus dem kompletten Seco Programm eignen sich ideal zum Ausdrehen. Die Wendeschneidplatten-Größen entsprechen dem Programm der Ausdrehköpfe.
Wendeschneidplatten zum Schruppausdrehen weisen hohe Zähigkeit und überwiegend positive Geometrien auf, um ein hohes Zeitspanvolumen zu erzielen und die Anforderung an die Spindel zu minimieren.

Wendeschneidplatten zum Feinausdrehen haben überwiegend positive Geometrien und kleine Radien, um enge Toleranzen und beste Oberflächengüten zu erzielen.

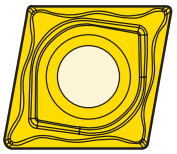
Code-Schlüssel, Beispiele

CCMT120408	–	M3	–	TP3501
1		2		3

1.
Größe (ISO-Bezeichnung)

2.
Geometrie

3.
Seco Sorte



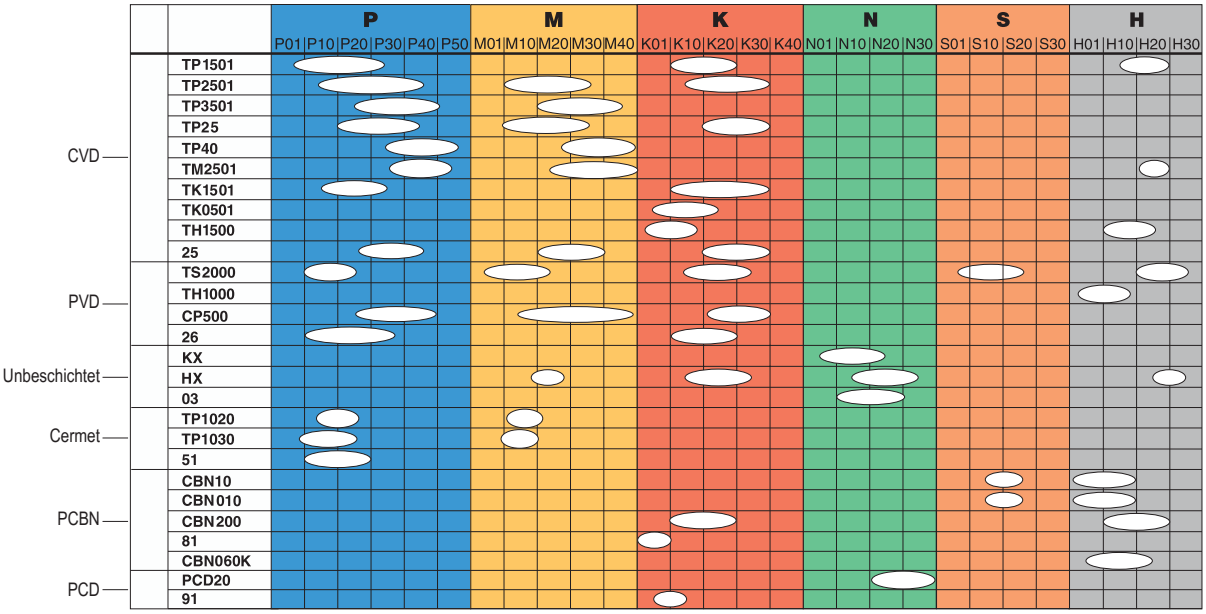
CCGT09T304	–	03	–	G3
1		2		3

1.
Größe (ISO-Bezeichnung)

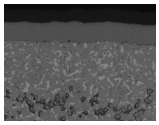
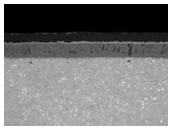
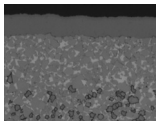
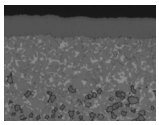
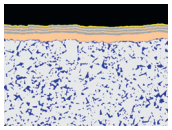
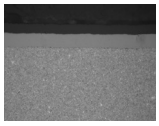
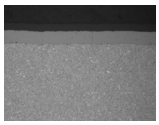
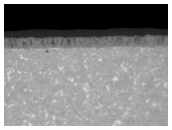
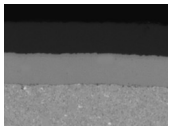
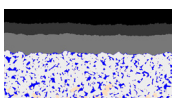
2.
Sorte

3.
Geometrien der Werkzeug-Systeme

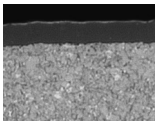
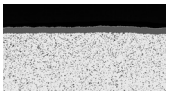
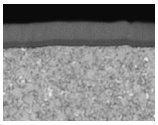
Schneidstoffe nach ISO-Werkstoff-Klassifizierung



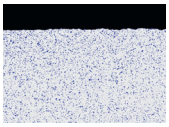
CVD-beschichtete Sorten zum Ausdrehen empfohlen

TP1501		Mit **Duratomic®**-Technologie beschichtete Sorte. Hochhitzebeständige und verschleißfeste Sorte, sehr gut geeignet für produktives allgemeines Drehen von Stählen und eine nützliche Absicherung für andere Werkstoffgruppengruppen. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TP25		Universalsorte für Vielseitigkeit und hohe Leistung in einer Vielzahl an Anwendungen in Stahl, Rostfrei und Guss. Zuverlässige Alternative für die Bearbeitung von Stahl bei begrenzter Schnittgeschwindigkeit oder hohen Anforderungen an die Oberflächengüte. Ergänzende Sorte zur Optimierung von leichteren Bearbeitungen in austenitisch rostfreiem Stahl. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TP2501		Mit **Duratomic®**-Technologie beschichtete Sorte. Entwickelt mit hoher Verschleißfestigkeit und Schneidenstabilität für eine Vielzahl von Drehanwendungen in Stählen sowie vielen rostfreien Stählen und Guss. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TP3501		TP3501 ist für Ausdreharbeiten gedacht, bei denen die Hauptanforderungen Zähigkeit und Zuverlässigkeit bei der Bearbeitung von Stählen und Rostfrei sind. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TP40		TP40 ist die Basissorte zum Drehen im Bereich P40. Sehr zähe Sorte für anspruchsvolle Arbeiten an Stahlguss- und -schmiedestücken sowie an allen Arten von Rostfrei. TiC/Ti(C,N) + TiN
TK0501		Mit **Duratomic®**-Technologie beschichtete Sorte. Eine extrem verschleißfeste Optimierungssorte für die Bearbeitung von Grauguss und einfacheren Arten von Kugelgraphitguss. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TK1501		Mit **Duratomic®**-Technologie beschichtete Sorte. Eine sehr verschleißfeste Sorte für Guss im Allgemeinen sowie in Stählen. Die Sorte ist besonders geeignet für die Bearbeitung von Kugelgraphitguss auch bei anspruchsvolleren Einrichtungen und unterbrochenen Schnitten. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TM2501		Duratomic®-Sorte. Leistungsfähige Sorte für Drehbearbeitungen von austenitisch-rostfreiem Stahl mit einer Kombination aus hoher Verschleißfestigkeit und guter Schneidkantenstabilität. Erste Wahl für Drehbearbeitungen von austenitisch rostfreiem Stahl. Auch geeignet für Drehbearbeitungen von Stählen mit stark unterbrochenem Schnitt. Ti(C,N) + Al_2O_3 + Einsatzerkennung
TH1500		Mit DURATOMIC®-Technologie beschichtete Sorte. Eine extrem harte Supermikrokornsorte zur Bearbeitung teilgehärteter Stähle, die eine Alternative zum Schlichten von Guss bietet. Ti (C, N) + Al_2O_3
25		Universalsorte Diese Sorte ist für eine Vielzahl an Ausdrehanwendungen in Stahl, Rostfrei und Guss gedacht. Gute Kombination aus Verschleißfestigkeit und Zähigkeit. Ti (C, N) + Al2O3.

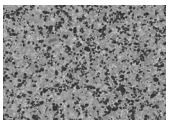
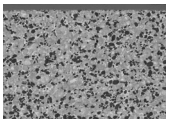
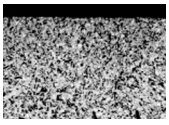
PVD-beschichtete Sorten zum Ausdrehen empfohlen

TS2000		Harte Mikrokornsorte, hauptsächlich für Schlichtarbeiten an Superlegierungen und Titanlegierungen gedacht. Zeigt auch bei Schlichtarbeiten an Rostfrei gute Leistung. (Ti,Al)N + TiN
CP500 & 26G6		Eine sehr zähe Mikrokörnung zum Schlichten und mittleren Schruppen von Rostfrei. Kann unterbrochene Schneidvorgänge sehr gut handhaben. CP500 ist auch eine Alternative für Aluminiumlegierungen. (Ti,Al)N + TiN
TH1000		Sehr harte Supermikrokornsorte für teilgehärtete Stahlteile und im Allgemeinen Werkstoffe wie Superlegierungen. Bietet dank bemerkenswerter Schneidkantenzähigkeit auch bei unterbrochenen Schnitten und bei der Entfernung harter Oberflächen eine hohe Leistung. Ti-Al-Si-N-Nanolaminatbeschichtung

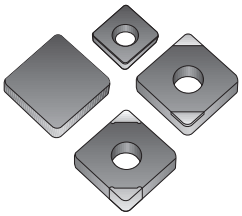
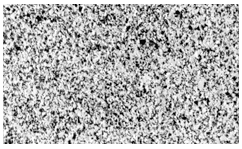
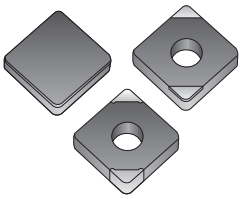
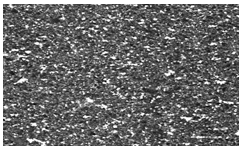
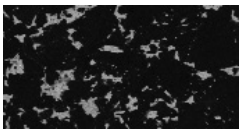
Zum Ausdrehen empfohlene unbeschichtete Sorten

KX & 03G3		Mikrokörnung für die Bearbeitung von Aluminium und anderen NE-Metallen.
HX		Unbeschichtete Universalsorte für die Bearbeitung von Guss und gehärteten Stählen, auch für NE-Metalle geeignet.

Cermet zum Ausdrehen empfohlen

TP1020		Cermet mit sehr hoher Verschleißfestigkeit für höchste Anforderungen an die Oberflächengüte mit Vorhersehbarkeit und Kontrolle bei Stahl und Rostfrei.
TP1030		PVD-beschichtetes Cermet mit sehr hoher Verschleißfestigkeit für hohe Anforderungen an Oberflächengüte und Produktivität mit Vorhersehbarkeit bei Stahl und Rostfrei. Ti-Al-Si-N-Nanolaminatbeschichtung.
51G1		Cermet mit sehr hoher Verschleißfestigkeit. Für Schlichtarbeiten an Stählen, bei denen strenge Anforderungen an die Oberflächengüte gestellt werden.

CBN- und PCD-Sorten zum Ausdrehen empfohlen

CBN010		Format: Massiv oder gelötet (einseitig und doppelseitig) Zusammensetzung: Sorte mit 50 % CBN-Gehalt mit einer durchschnittlichen Korngröße von 2 µm und einem TiC-Keramik-Bindemittel. Beschichtung: Unbeschichtet
CBN10 & 81B1		Sorte mit kubischem Bornitrid (CBN) für leicht glatte bis moderat unterbrochene Schnitte. Zum Feinausdrehen in gehärtetem Stahl und Superlegierungen.
CBN060K		Massiv, gelötete Spitzen (ein- und doppelseitig) oder Sinterschicht. Erste Wahl für glatte bis moderat unterbrochene Schnitte in gehärtetem Stahl (a_p < 0,5 mm). Neue (Ti,Si, Al)N PVD-Beschichtung, die speziell für die Hochgeschwindigkeitsbearbeitung entwickelt wurde. Neues einzigartiges Bindemittel auf Basis einer Superlegierung.
CBN200		Format: Massiv oder gelötet (einseitig) Zusammensetzung: Sorte mit 85% CBN-Gehalt mit durchschnittlicher Korngröße von 2 µm und einer Co-W-Al-Keramik-Bindephase. Beschichtung: Unbeschichtet
PCD20 & 91J3		PKD, polykristalliner Diamant, zum Ausdrehen in Aluminium und Al-Legierungen, Kupfer, Messing, Bronze und synthetischen Werkstoffen.

Wendeschneidplatten, empfohlen zum Schrupp-Ausdrehen, mit Schnittdaten

Bezeichnung	Beschichtet, Spanbrecher, linksschneidend			Beschichtet gepresster Spanbrecher					Beschichtet, Spanbrecher, linksschneidend	Schnitttiefe a_p mm *(Zoll)*	Vorschub pro Zahn f mm *(Zoll)*
	KX	HX	03D3	TP2501	TP3501	TP40	25C4	TK1501	CP500		
CPGT050204			02434654							2 *(0.079)*	0,08-0,2 *(0.0031-0.0079)*
CCMT060204-F1				02960857	03095430	00008505		03062942	00096854	2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060204-F2		74011732				74018652				2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCGT060204L-UX									02497631	2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCGT060204F-AL	00015710									2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060204-M3				02960858	03095431			03062944		2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT09T308-F1				02960861	03095443	00008518		03063857	00096858	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT09T308-MF2				02956309	03095446				02754822	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCGT09T304L-UX									02497640	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCGT09T308F-AL	00015754									2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT120408-F1				02960854	03095449			03062626		4 *(0.157)*	0,15-0,4 *(0.0059-0.0157)*
CCMT120408-MF2				02956311	03095452					4 *(0.157)*	0,15-0,4 *(0.0059-0.0157)*
CCGT120408L-UX									02610062	4 *(0.157)*	0,15-0,4 *(0.0059-0.0157)*
CCGT120408F-AL	00015790									5 *(0.197)*	0,15-0,4 *(0.0059-0.0157)*
SCMT060204-M3				02960423	03096621					2,5 *(0.098)*	0,1-0,22 *(0.0039-0.0087)*
SCMT09T308-F1				02960396	03096625			03062629	00099708	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
SCMT09T308-MF2				02956318	03096627				02755042	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
SCMT120408-F1				02960397	03096630				00099804	4 *(0.157)*	0,15-0,4 *(0.0059-0.0055)*
SCMT120408-M3				02960429	03096631			03063990		4 *(0.157)*	0,15-0,4 *(0.0059-0.0055)*
TCMT16T308-F1				02960408	03096643				00091357	5 *(0.197)*	0,15-0,4 *(0.0059-0.0055)*
TCMT16T308-MF2				02956323	03096645				02755046	5 *(0.197)*	0,15-0,4 *(0.0059-0.0055)*
TCGT16T308F-AL	00015875									4 *(0.157)*	0,15-0,4 *(0.0059-0.0055)*
SCMT150512-F2						74007348				7 *(0.276)*	0,2-0,5 *(0.0079-0.0197)*

Empfohlene Schnittgeschwindigkeiten siehe Seiten 592-595

CN.. Wendeplatten, empfohlen für Schrupp-Ausdrehen (doppelseitig)

Bezeichnung	Beschichtet gepresster Spanbrecher				Schnitttiefe a_p mm *(Zoll)*	Vorschub pro Zahn f mm *(Zoll)*
	TP3500	TP40	TM2501	TP25		
CNMG120408-M3			03275990	03275989	4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF3		74030598	03275999	03275998	4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF4			03273904		4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF1			03275995		4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MR7		74017309	03276001		4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*

Empfohlene Schnittgeschwindigkeiten siehe Seiten 592-595

Wendeschneidplatten zum Feinausdrehen, mit Schnittdaten

Bezeichnung	Beschichtet							Cermet			Schnitttiefe a_p mm *(Zoll)*	Vorschub pro Zahn f mm *(Zoll)*
	TP1501	TS2000	TK1501	CP500	26G6	TH1000	TH1500	51G1	TP1020	TP1030		
CCGT060200								00083915			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT0602005-F1				02430287							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060201-F1				02430307							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060202					00039546			00096634			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204					00081826			00048334			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204L-UX				02497631							2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060202-F1	02960383	02614299		00096853					02754786	02754435	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT060204-F1	02960856	02615873	03062942	00096854		02825858			02754791	02754792	2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMW060202F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW060204F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060202S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204E-L1-B											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T301-F1				02430311							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T302					00048337			00048339			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304					00077338			00048344			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304L-UX				02497640							2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT09T302-F1	02960837			00096856					02754805	02754806	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T304-F1	02960844	02615874	03063856	00096857		02731806			02754811	02754812	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T308-F1	02960853	02615876	03063857	00096858		02731807				02754821	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMW09T304F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW09T308F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304E-L1-B											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308E-L1-B											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110204								00000721			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110201-F1				02430376							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110202-F1				02430419							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110204-F1	02960401			02430421							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110208-F1	02960403			00098986							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204E-L1-C											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208E-L1-C											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMW110204F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030100								00083089			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102								00091845			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102L				02416632							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGW030102											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*

Die Tabelle wird auf der nächsten Seite fortgesetzt.

Empfohlene Schnittgeschwindigkeiten siehe Seiten 592-595

Wendeschneidplatten zum Feinausdrehen, mit Schnittdaten

Bezeichnung	CBN				PCD		Schnitttiefe a_p mm *(Zoll)*	Vorschub pro Zahn f mm *(Zoll)*
	CBN010	CBN060K	CBN200	81B1	PCD20	91J3		
CCGT060200							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT0602005-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060201-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060202							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204L-UX							2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060202-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT060204-F1							2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMW060202F-L1					00089760		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW060204F-L1					00005684		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060202S-01020-LF			02464698				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204S-01020-LF	02916281		02464699				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204E-L1-B	02843086	02776337	02649599				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T301-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T302							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304L-UX							2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT09T302-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T304-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T308-F1							2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMW09T304F-L1					00005686		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW09T308F-L1					00095357		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304E-L1-B	02843126	02776338	02649607				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308E-L1-B	02937148		02649608				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304S-01020-LF	02916282		02464702				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308S-01020-LF			02464703				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110204							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110201-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110202-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110204-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110208-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204E-L1-C	02848657	02776346					0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208E-L1-C	02848792						0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204S-01020-LF			02464742				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208S-01020-LF			02464744				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMW110204F-L1					00005689		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030100							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102L							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGW030102				00096761		00096763	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*

Empfohlene Schnittgeschwindigkeiten siehe Seiten 592-595

Empfohlene Schnittgeschwindigkeiten zum Ausdrehen (bezogen auf Werkstoff und Wendeplattensorte) – Metrisch

SMG	v_c (m/min)										
	KX & HX	03	TP40	TP1501	TP2501	TP3501	TK0501	TK1501	TH1000	TH1500	CP500
P1			60-180	60-350	60-250	60-230					80-200
P2			60-180	60-350	60-250	60-230					80-200
P3			60-180	60-350	60-250	60-230					80-200
P4			60-180	60-350	60-250	60-230					80-200
P5			60-150	60-300	60-250	60-230					80-200
P6			60-140	60-300	60-230	60-200					80-180
P7			60-140	60-300	60-230	60-200					80-160
P8			60-120	60-250	60-230	60-200					80-130
P11			60-120	60-300	60-250	60-200					80-180
M1			60-130	100-200	60-200	60-200					60-160
M2			60-130	100-200	60-200	60-200					60-160
M3			60-120	100-180	60-200	60-200					60-150
M4			60-110	100-180	60-190	60-190					60-150
M5			60-110	100-180	60-180	60-180					60-150
K1			60-140	100-250		60-180	60-230	60-230			60-160
K2			60-140	100-250		60-180	60-230	60-230			60-160
K3			60-140	100-250		60-180	60-230	60-230			60-160
K4			60-140	100-250		60-180	60-200	60-200			60-160
K5			60-140	100-250		60-180	60-200	60-200			60-160
K6			60-130	100-250		60-180	60-200	60-200			60-160
K7			60-130	100-250		60-180	60-200	60-200			60-160
N1	150-800	150-800									150-800
N2	150-800	150-800									150-800
N3	150-500	150-500									150-500
N11	150-400	150-400									150-400
S1	20-50	20-50									20-50
S2	20-50	20-50									20-50
S3	20-50	20-50									20-50
S11	20-50	20-50									20-50
S12	20-50	20-50									20-50
S13	20-50	20-50									20-50
H3									50-150	50-150	
H5									50-140	50-140	
H7									50-150	50-150	
H8									30-130	30-130	
H11									30-120	30-120	
H12									30-120	30-120	
H21											
H31											

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Empfohlene Schnittgeschwindigkeiten zum Ausdrehen (bezogen auf Werkstoff und Wendeplattensorte) – *Zoll*

SMG	v_c *(sf/min)*										
	KX & HX	03	TP40	TP1501	TP2501	TP3501	TK0501	TK1501	TH1000	TH1500	CP500
P1			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P2			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P3			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P4			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P5			*197-492*	*197-984*	*197-820*	*197-755*					*262-656*
P6			*197-459*	*197-984*	*197-755*	*197-656*					*262-591*
P7			*197-459*	*197-984*	*197-755*	*197-656*					*262-525*
P8			*197-394*	*197-820*	*197-755*	*197-656*					*262-427*
P11			*197-394*	*197-984*	*197-820*	*197-656*					*262-591*
M1			*197-427*	*328-656*	*197-656*	*197-656*					*197-525*
M2			*197-427*	*328-656*	*197-656*	*197-656*					*197-525*
M3			*197-394*	*328-591*	*197-656*	*197-656*					*197-492*
M4			*197-361*	*328-591*	*197-623*	*197-623*					*197-492*
M5			*197-361*	*328-591*	*197-591*	*197-591*					*197-492*
K1			*197-459*	*328-820*		*197-591*	*197-755*	*197-755*			*197-525*
K2			*197-459*	*328-820*		*197-591*	*197-755*	*197-755*			*197-525*
K3			*197-459*	*328-820*		*197-591*	*197-755*	*197-755*			*197-525*
K4			*197-459*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
K5			*197-459*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
K6			*197-427*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
K7			*197-427*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
N1	*492-2625*	*492-2625*									*492-2625*
N2	*492-2625*	*492-2625*									*492-2625*
N3	*492-1640*	*492-1640*									*492-1640*
N11	*492-1312*	*492-1312*									*492-1312*
S1	*66-164*	*66-164*									*66-164*
S2	*66-164*	*66-164*									*66-164*
S3	*66-164*	*66-164*									*66-164*
S11	*66-164*	*66-164*									*66-164*
S12	*66-164*	*66-164*									*66-164*
S13	*66-164*	*66-164*									*66-164*
H3									*164-492*	*164-492*	
H5									*164-459*	*164-459*	
H7									*164-492*	*164-492*	
H8									*98-427*	*98-427*	
H11									*98-394*	*98-394*	
H12									*98-394*	*98-394*	
H21											
H31											

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

Empfohlene Schnittgeschwindigkeiten zum Ausdrehen (bezogen auf Werkstoff und Wendeplattensorte) – Metrisch

SMG	v_c (m/min)												
	26	25	TS2000	TP1020	TP1030	51	CBN10/ CBN010	81	CBN200	82	PCD20	91	Axiabore
P1	80-200	60-180		100-350	100-350	100-350							80-250
P2	80-200	60-180		100-350	100-350	100-350							80-250
P3	80-200	60-180		100-350	100-350	100-350							80-250
P4	80-200	60-180		100-350	100-350	100-350							80-250
P5	80-200	60-180		100-350	100-350	100-350							70-230
P6	80-180	60-160		100-300	100-300	100-300							70-230
P7	80-160	60-160		100-250	100-250	100-250							70-230
P8	80-130	60-130		100-250	100-250	100-250							70-200
P11	80-180	60-150		100-300	100-300	100-300							70-200
M1	60-160	60-140	60-200	80-200	80-200	80-200							60-200
M2	60-160	60-140	60-200	80-200	80-200	80-200							60-200
M3	60-150	60-130	60-200	80-200	80-200	80-200							60-180
M4	60-150	60-120	60-180	80-180	80-180	80-180							60-170
M5	60-150	60-120	60-180	80-180	80-180	80-180							60-170
K1	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K2	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K3	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K4	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-130
K5	60-160	60-160		100-250	100-250	100-250							50-100
K6	60-160	60-160		100-180	100-180	100-180							50-100
K7	60-160	60-160		100-180	100-180	100-180							50-100
N1	150-800										300-1500	300-1500	200-800
N2	150-800										300-1500	300-1500	200-800
N3	150-500										200-800	200-800	200-800
N11	150-400										180-800	180-800	200-800
S1	20-50		20-80										20-60
S2	20-50		20-80										20-60
S3	20-50		20-80										60-50
S11	20-50		20-80										20-50
S12	20-50		20-80										20-50
S13	20-50		20-80										20-50
H3							80-180	80-180					
H5							80-200	80-200					
H7							80-150	80-150					
H8							80-150	80-150					
H11													
H12													
H21													
H31													

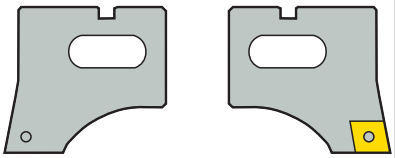
SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

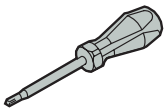
Empfohlene Schnittgeschwindigkeiten zum Ausdrehen (bezogen auf Werkstoff und Wendeplattensorte) – *Zoll*

SMG	v_c *(sf/min)*												
	26	25	TS2000	TP1020	TP1030	51	CBN10/ CBN010	81	CBN200	82	PCD20	91	Axiabore
P1	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P2	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P3	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P4	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P5	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*230-755*
P6	*262-591*	*197-525*		*328-984*	*328-984*	*328-984*							*230-755*
P7	*262-525*	*197-525*		*328-820*	*328-820*	*328-820*							*230-755*
P8	*262-427*	*197-427*		*328-820*	*328-820*	*328-820*							*230-656*
P11	*262-591*	*197-492*		*328-984*	*328-984*	*328-984*							*230-656*
M1	*197-525*	*197-459*	*197-656*	*262-656*	*262-656*	*262-656*							*197-656*
M2	*197-525*	*197-459*	*197-656*	*262-656*	*262-656*	*262-656*							*197-656*
M3	*197-492*	*197-427*	*197-656*	*262-656*	*262-656*	*262-656*							*197-591*
M4	*197-492*	*197-394*	*197-591*	*262-591*	*262-591*	*262-591*							*197-558*
M5	*197-492*	*197-394*	*197-591*	*262-591*	*262-591*	*262-591*							*197-558*
K1	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-492*
K2	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-492*
K3	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-492*
K4	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-427*
K5	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*							*164-328*
K6	*197-525*	*197-525*		*328-591*	*328-591*	*328-591*							*164-328*
K7	*197-525*	*197-525*		*328-591*	*328-591*	*328-591*							*164-328*
N1	*492-2625*										*984-4921*	*984-4921*	*656-2625*
N2	*492-2625*										*984-4921*	*984-4921*	*656-2625*
N3	*492-1640*										*656-2625*	*656-2625*	*656-2625*
N11	*492-1312*										*591-2625*	*591-2625*	*656-2625*
S1	*66-164*		*66-262*										*66-197*
S2	*66-164*		*66-262*										*66-197*
S3	*66-164*		*66-262*										*197-164*
S11	*66-164*		*66-262*										*66-164*
S12	*66-164*		*66-262*										*66-164*
S13	*66-164*		*66-262*										*66-164*
H3							*262-591*	*262-591*					
H5							*262-656*	*262-656*					
H7							*262-492*	*262-492*					
H8							*262-492*	*262-492*					
H11													
H12													
H21													
H31													

SMG = Seco Werkstoff-Gruppe V_c = m/min (sf/min) Alle Schnittdaten sind Startwerte

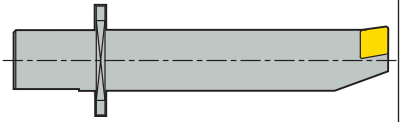
Wendeplatten-Spannschlüssel und -schrauben aller Ausdreh-Wendeplattenhalter, Werkzeuge und Kassetten

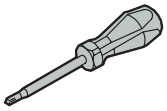




		Zubehör		Im Lieferumfang enthaltene Ersatzteile	
		Torx-Schraubendreher für Wendeplatten-Spannschraube*		Wendeplatten-Spannschraube	
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Schruppaus-dreh-Wendeplatten-halter	CP...0502	T07P-3	07	C02245-T07P	07
	CC...0602	T07P-3	07	C02504-T07P	07
	CC...09T3	T15P-3	15	C04008-T15P	15
	CC...1204	T15P-3	15	C05012-T15P	15
	CC...1605	T15P-3	15	C05012-T15P	15
	SC...0502	T07P-3	07	C02245-T07P	07
	SC...0602	T07P-3	07	C02504-T07P	07
	SC...09T3	T15P-3	15	C04008-T15P	15
	SC...1204	T15P-3	15	C05012-T15P	15
	SC...1505	T15P-3	15	C05012-T15P	15

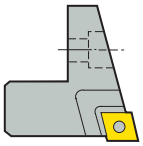
* Ein Torx-Schraubendreher wird mit jedem Schrupp-Ausdrehkopf geliefert.

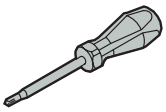




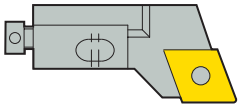
		Zubehör		Im Lieferumfang enthaltene Ersatzteile	
		Torx-Schraubendreher für Wendeplatten-Spannschraube*		Wendeplatten-Spannschraube	
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Werkzeug vom Typ Axiabore™	WB...0301...	T06P-3	06	C02035-T06P	06
	CC...0602...	T07P-3	07	C02504-T07P	07
	–	T15P-3	15	C04008-T15P	15

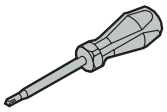
Ersatzteile für Wendeplattenhalter





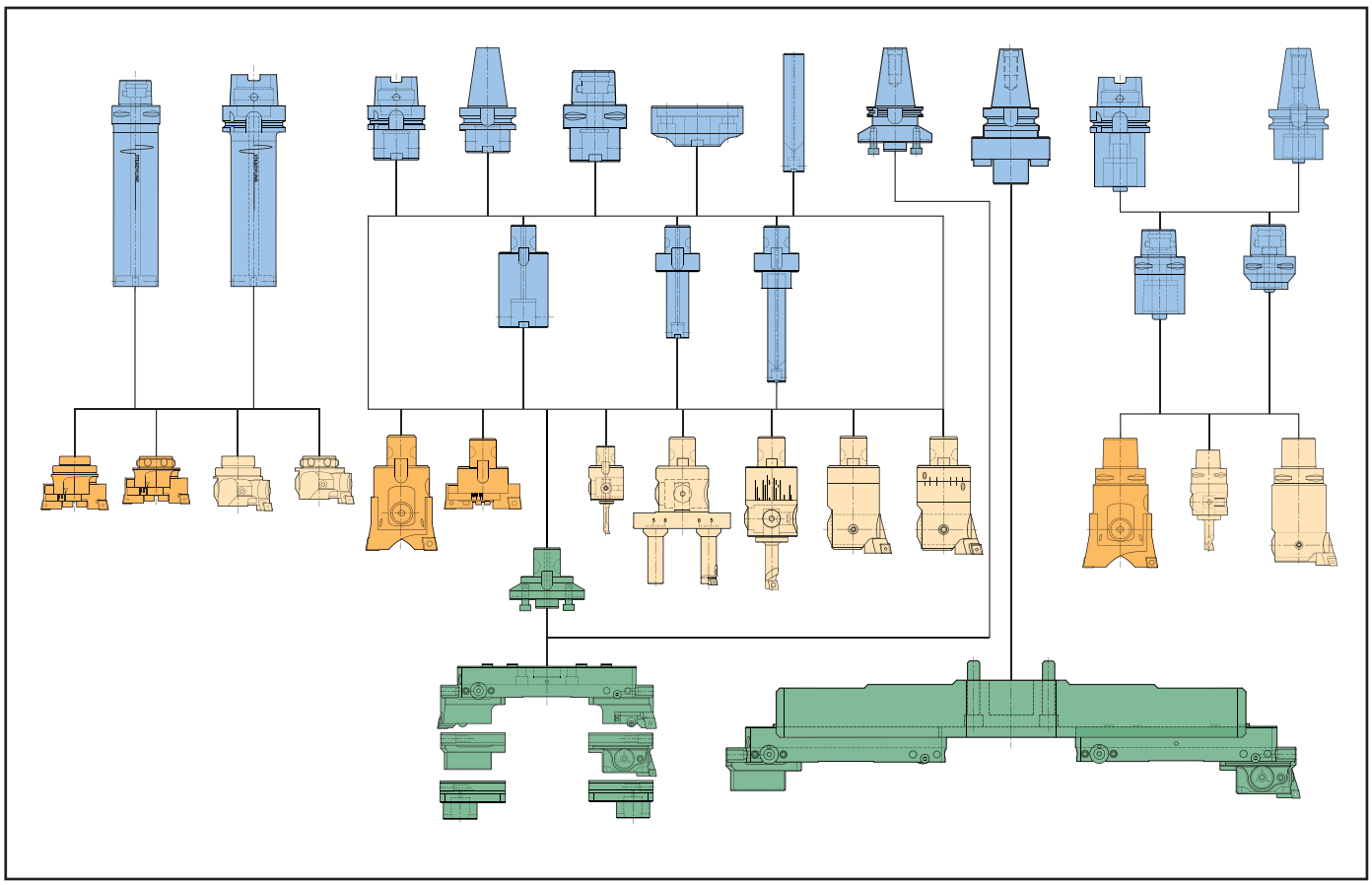
		Im Lieferumfang enthaltene Ersatzteile			
		Wendeplatten-Schlüssel		Schraube für WSP	
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Feinausdreh-Wendeplat-tenhalter, Fas-Wendeplattenhalter und Rückwärtssenk-Wende-plattenhalter	WB...0301...	T06P-2	06	C02035-T06P	06
	CC...0602...	T07P-3	07	C02504-T07P	07
	CC...09T3...	T15P-3	15	C04008-T15P	15
	TC...1102...	T07P-3	07	C02504-T07P	07





		Zubehör		Im Lieferumfang enthaltene Ersatzteile	
		Torx-Schraubendreher für Wendeplatten-Spannschraube*		Wendeplatten-Spannschraube	
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Kassetten	CC...16...	T15P-2	15	C05012-T15P	15
	SC...15...	T15P-2	15	C05012-T15P	15
	TC...16...	T15P-2	15	C03509-T15P	15
	TC...22...	T15P-2	15	C05012-T15P	15

Geeignete Halter für Ausdrehköpfe



Die Ausdrehköpfe verfügen maschinenseitig über Graflex®-, Seco Capto™-, GL- oder BA-Anschlüsse.

Die Ausdrehköpfe können auf jedem Maschinentyp mittels des geeigneten Graflex®-Adapters, Seco Capto™-Adapters oder einer schwingungsdämpfenden Steadyline®-Bohrstange verwendet werden.

Steadyline® Schwingungsdämpfung zum Ausdrehen
Ausdrehköpfe mit maschinenseitigem GL- oder BA-Anschluss eignen sich besonders zur Montage an Steadyline®-Bohrstangen mit maschinenseitigem HSK-T/A- und Seco Capto™-Anschlüssen. Dies ermöglicht Schruppen und Schlichten mit großen Auskraglängen wie 6 x D, 8 x D und 10 x D. Das schwingungsdämpfende Steadyline®-System ermöglicht stabile Bedingungen auch bei großen Auskraglängen.

Modulare Graflex® und Seco Capto™-Bohrstangen
Alle Bohrtiefen bis 6 x D können mithilfe der entsprechenden Graflex®-Zwischenelemente erreicht werden. Höchste Stabilität durch Auswahl des längsten und größten Zwischenteiles, dann Ergänzung durch kleinere Zwischenstücke.

Die Graflex® und Seco Capto™-Verbindungen ermöglichen eine ausgezeichnete Schneidenausrichtung nach ISO. Die Graflex®-Module werden von der Seite geklemmt.

Wählen Sie für Ausdrehköpfe mit maschinenseitigem GL-Anschluss mit Steadyline® die kürzeste Steadyline®-Bohrstange aus dem Katalog Werkzeug-Systeme. Diese Bohrstangen sind maschinenseitig mit HSK-T/A und Seco Capto™ verfügbar. Andere Spindelarten können mithilfe der kürzesten Seco Capto™-Adapter angeschlossen werden.
Für klassische Ausdrehköpfe (Stahl) verwenden Sie die klassischen Graflex® und Seco Capto™-Aufnahmen sowie Zwischenaufnahmen aus dem Seco Katalog Werkzeug-Systeme.
Für Brückenwerkzeuge, siehe Graflex®-Adapter und direkte Aufnahmen, siehe Seite 568.

Hinweis: Jumbo Brückenwerkzeuge können auf Fräseraufnahmen oder direkt frontseitig auf die Maschinenspindel montiert werden.

Graflex®

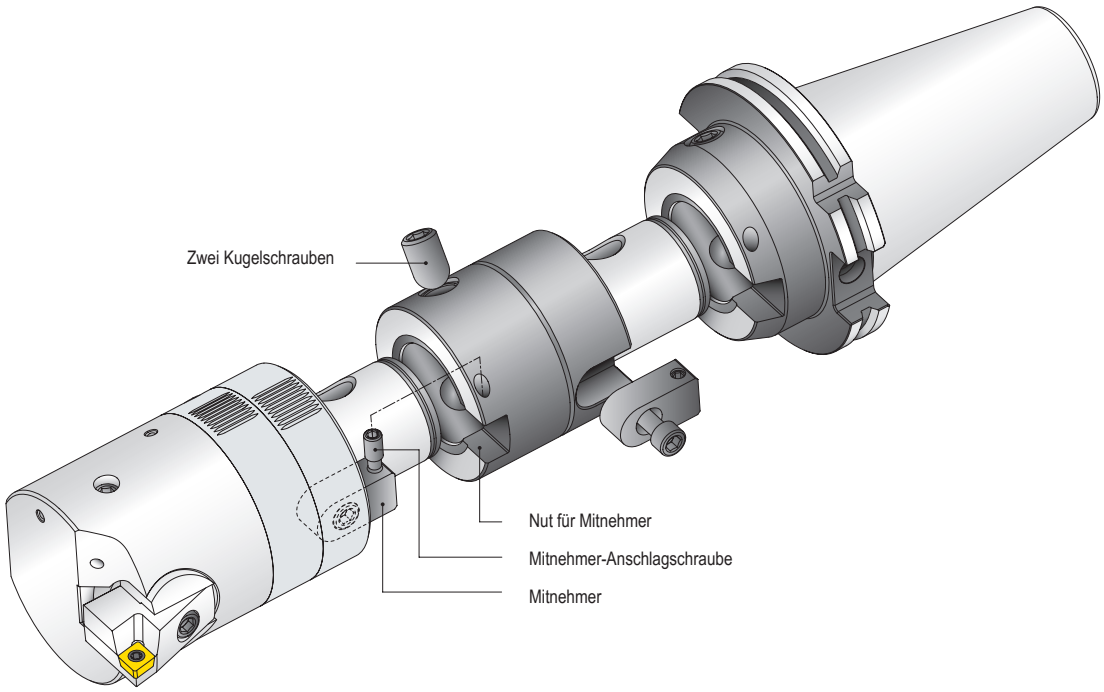
Graflex®-Aufnahmen sind verfügbar für Aufsteckfräser, Zwischenelemente, Werkzeughalter und Ausdrehköpfe, die schnell montiert werden können. Sie sind geeignet zum Fräsen, Bohren, Gewindeschneiden, Reiben und Ausdrehen. Graflex®-Module ermöglichen den Einsatz verschiedener Längen und Durchmesser und können durch ersetzen der Graflex®-Grundaufnahme in allen Maschinen verwendet werden.

- Exzellente Anschlussfestigkeit
- Große Anzahl an Modulen für hohe Flexibilität
- Für interne Kühlschmierstoffzufuhr geeignet
- Gute Wiederholgenauigkeit

Verriegelung für Graflex® G (Verwendung eines Mitnehmers mit einer Anschlagschraube):

Zum Ausspindeln ist die Klemmung der inneren Schraube des Mitnehmers nicht erforderlich, da das System selbstspannend ist.
Beachten Sie zum Schruppausdrehen bei Schwerzerspanung für Graflex®-Kugelschrauben das höchste angegebene Drehmoment.

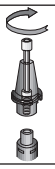
Ausführliche Hinweise für die Graflex® Verbindung finden Sie im Seco Katalog Werkzeug-Systeme



Für Seco Capto™ Anschlüsse Typ C bei Ausdrehköpfen müssen keine besonderen Maßnahmen beachtet werden. Für Ausdrehköpfe, beachten Sie die folgenden allgemeinen Hinweise.

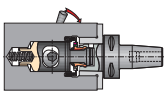
Drehmomente für Verbindungen mit Seco Capto™-Aufnahmen mit axialen Anzugsschrauben (Grundaufnahmen, Zwischenelemente).

Seco Capto™ Größe	Anzugsdrehmoment der Zentrumsschraube (Nm)	Anzugsdrehmoment der Zentrumsschraube (ft/lbs)
C3	40-50	30-37
C4	50-60	37-44
C5	90-100	66-74
C6	160-180	118-133
C8	160-180	118-133



Drehmomente für Verbindungen mit Seco Capto™-Aufnahmen mit Spanneinheiten, die durch seitliche Exzenterbolzen befestigt werden.

Seco Capto™ Größe	Anzugsdrehmoment der Nocke (Nm)	Anzugsdrehmoment der Nocke (ft/lbs)
C3	35	26
C4	50	37
C5	70	52
C6	90	66
C8	130	96

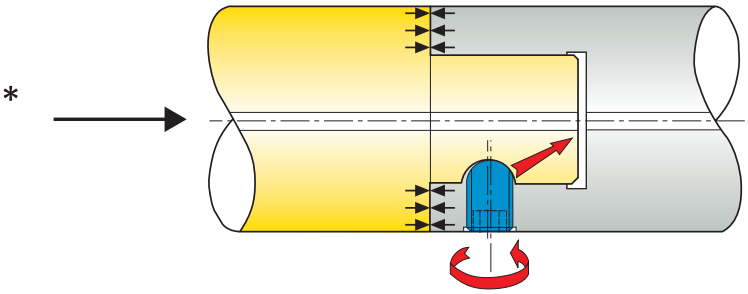


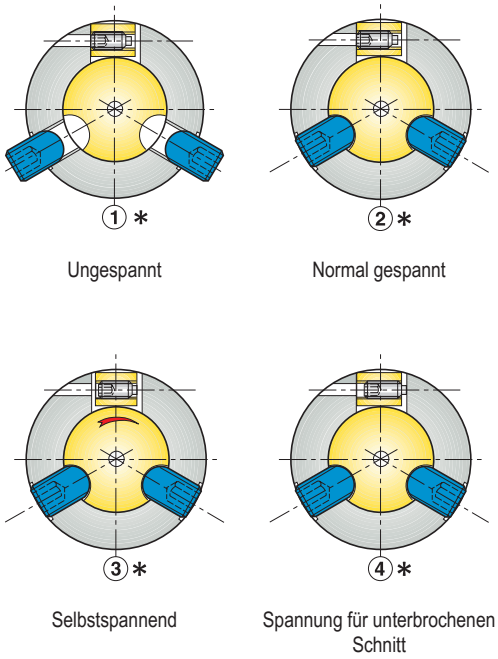
Die Seco Capto™-Verbindung verfügt über einen selbsthemmenden Kegel. Beim Einsatz des zentralen Anzugsbolzens lösen Sie den zentralen Bolzen, bis sich die Anlagefläche löst, wodurch die Kegelverbindung getrennt wird. Beim seitlichen Exzenteranzugssystem wird durch Lösen des Exzenterbolzens die Verbindung getrennt.

Modulares System Graflex® – Leitfaden

1. Montieren Sie das Graflex®-Element und die Module mithilfe der Zapfen zur einfachen Ausrichtung. Ziehen Sie die Kugelkopf-Feststellschrauben fest und achten Sie darauf, dass die linke Seite des Zapfens die linke Seite des Zapfenschlitzes berührt (Zeichnungen 1 und 2).
2. Große Drehmomente, z.B. beim Ausspindeln, können zu einer Mikrodrehbewegung des Zapfens im Verhältnis zur Bohrung führen, was eine Mikroverschiebung der Kontaktflächen der Kugelumlaufspindel verursacht, wodurch die Steifigkeit des Systems noch erhöht wird (Zeichnung 3).
3. Bei Arbeiten mit intermittierendem Schnitt, z. B. beim schweren Fräsen, kann die im Zapfen vorgesehene Blockierschraube angezogen werden, um Mikrodrehbewegungen zu vermeiden und eine Selbsthemmung zu verhindern (Zeichnung 4).

Montage des Graflex®-Systems





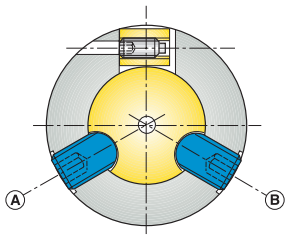
Ungespannt | Normal gespannt

Selbstspannend | Spannung für unterbrochenen Schnitt

* Die Zeichnungen 1, 2, 3 und 4 werden von vorne betrachtet, wie bei normalem Zusammenbau, z. B. bei Verwendung der Montagehilfe Tool Boy.

Verbesserte Montage des Graflex®-Systems

Linke Fläche

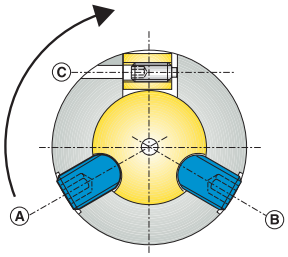


Normales Spannen für glatten Schnitt, z. B. Ausspindeln, leichtes Fräsen

5. Spannschraube A (niedrige Werte).
6. Spannschraube B (niedrige Werte).

1. Reinigen Sie die zu montierenden Teile und tragen Sie einen dünnen Oxidationsschutzfilm auf.
2. Die Teile so zusammensetzen, dass die linke Seite des Zapfens die linke Seite des Zapfenschlitzes berührt
3. Schraube A leicht anziehen
4. Schraube B leicht anziehen

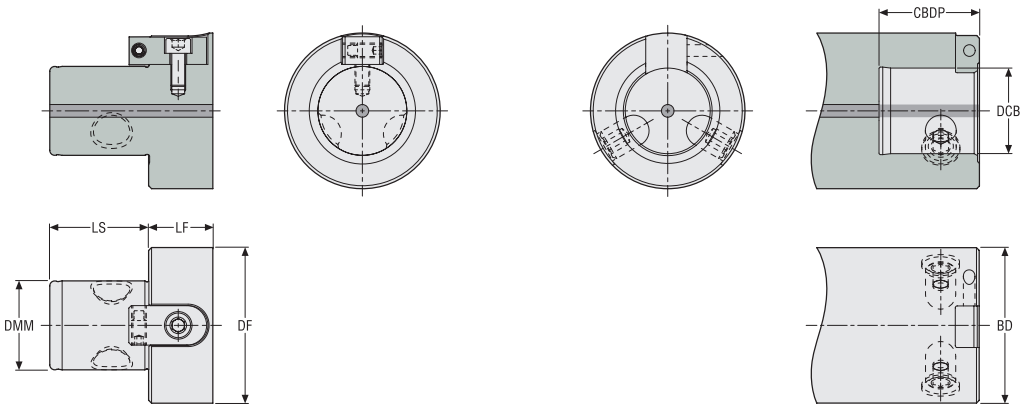
Linke Fläche



Spannen für Schnittunterbrechungen, z.B. unterbrochene Schnitte beim Ausspindeln, schwere Fräsbearbeitungen

5. Ziehen Sie die Klemmschraube C an.
6. Spannschraube A (hohe Werte).
7. Spannschraube B (hohe Werte).
8. Prüfen Sie Klemmschraube C erneut.

Graflex®, Normabmessungen



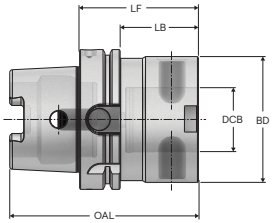
Maschinenseite	RFID-Bohrung*	DF	DMM	LS	LF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
G0	Nein	16 *0.630*	8 *0.315*	12 *0.472*	8 *0.315*
G1	Nein	20 *0.787*	11 *0.433*	13 *0.512*	9,5 *0.374*
G2	Nein	25 *0.984*	14 *0.551*	16 *0.630*	11 *0.433*
G3	Nein	32 *1.260*	18 *0.709*	20 *0.787*	14 *0.551*
G4	Nein	40 *1.575*	22 *0.866*	24 *0.945*	17 *0.669*
G5	Nein	50 *1.969*	28 *1.102*	30 *1.181*	20 *0.787*
G6	Nein	63 *2.480*	36 *1.417*	40 *1.575*	26 *1.024*
G7	Nein	90 *3.543*	46 *1.811*	50 *1.969*	26 *1.024*

Werkstückseite	RFID-Bohrung*	CBDP	DCB	BD
		mm *Zoll*	mm *Zoll*	mm *Zoll*
G0	Nein	16 *0.630*	8 *0.315*	12 *0.472*
G1	Nein	20 *0.787*	11 *0.433*	13 *0.512*
G2	Nein	25 *0.984*	14 *0.551*	16 *0.630*
G3	Nein	32 *1.260*	18 *0.709*	20 *0.787*
G4	Nein	40 *1.575*	22 *0.866*	24 *0.945*
G5	Nein	50 *1.969*	28 *1.102*	30 *1.181*
G6	Nein	63 *2.480*	36 *1.417*	40 *1.575*
G7	Nein	90 *3.543*	46 *1.811*	50 *1.969*

Hinweis: Diese maschinenseitigen und werkstückseitigen Abmessungen gelten für alle Halter auf den Produktseiten.
* Keine Bohrung für RFID-Datenträger

G 401 – Graflex®-Grundaufnahme

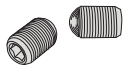
HSK-A/ ISO12164-1-HSK-A



—HSK-Verschlussstopfen, Kühlmittelrohre und Spannschlüssel siehe Seite(n) 625

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
EM93034012870	00086917	HSK-A50	G5	28,0 *1.102*	70,0 *2.756*	44,0 *1.732*	50,0 *1.969*	95,0 *3.740*	1	PB	0,9 *1.980*
EM93044011445	02469722	HSK-A63	G2	14,0 *0.551*	45,0 *1.772*	19,0 *0.748*	25,0 *0.984*	77,0 *3.031*	1	G6.3	0,7 *1.540*
EM93044011850	00086918	HSK-A63	G3	18,0 *0.709*	50,0 *1.969*	24,0 *0.945*	32,0 *1.260*	82,0 *3.228*	1	G6.3	0,8 *1.760*
EM93044012255	00088217	HSK-A63	G4	22,0 *0.866*	55,0 *2.165*	29,0 *1.142*	40,0 *1.575*	87,0 *3.425*	1	G6.3	0,9 *1.980*
EM93044012860	00086920	HSK-A63	G5	28,0 *1.102*	60,0 *2.362*	34,0 *1.339*	50,0 *1.969*	92,0 *3.622*	1	PB	1,0 *2.200*
EM930440128100	00086921	HSK-A63	G5	28,0 *1.102*	100,0 *3.937*	74,0 *2.913*	50,0 *1.969*	132,0 *5.197*	1	PB	1,6 *3.530*
EM930440128140	00086922	HSK-A63	G5	28,0 *1.102*	140,0 *5.512*	114,0 *4.488*	50,0 *1.969*	172,0 *6.772*	1	PB	2,18 *4.810*
EM93044013670	00086923	HSK-A63	G6	36,0 *1.417*	70,0 *2.756*	44,0 *1.732*	63,0 *2.480*	102,0 *4.016*	1	PB	1,3 *2.870*
EM930440136120	00086924	HSK-A63	G6	36,0 *1.417*	120,0 *4.724*	94,0 *3.701*	63,0 *2.480*	152,0 *5.984*	1	PB	2,38 *5.250*
EM93064011855	00086925	HSK-A100	G3	18,0 *0.709*	55,0 *2.165*	26,0 *1.024*	32,0 *1.260*	105,0 *4.134*	1	G6.3	2,2 *4.850*
EM93064012260	00086926	HSK-A100	G4	22,0 *0.866*	60,0 *2.362*	31,0 *1.220*	40,0 *1.575*	110,0 *4.331*	1	G6.3	2,3 *5.070*
EM93064012865	00086927	HSK-A100	G5	28,0 *1.102*	65,0 *2.559*	36,0 *1.417*	50,0 *1.969*	115,0 *4.528*	1	PB	2,4 *5.290*
EM930640128110	00086928	HSK-A100	G5	28,0 *1.102*	110,0 *4.331*	81,0 *3.189*	50,0 *1.969*	160,0 *6.299*	1	PB	3,1 *6.830*
EM930640128150	00086929	HSK-A100	G5	28,0 *1.102*	150,0 *5.906*	121,0 *4.764*	50,0 *1.969*	200,0 *7.874*	1	PB	3,7 *8.160*
EM93064013675	00083432	HSK-A100	G6	36,0 *1.417*	75,0 *2.953*	46,0 *1.811*	63,0 *2.480*	125,0 *4.921*	1	PB	2,8 *6.170*
EM930640136120	00086931	HSK-A100	G6	36,0 *1.417*	120,0 *4.724*	91,0 *3.583*	63,0 *2.480*	170,0 *6.693*	1	PB	3,9 *8.600*
EM930640136160	00086932	HSK-A100	G6	36,0 *1.417*	160,0 *6.299*	131,0 *5.157*	63,0 *2.480*	210,0 *8.268*	1	PB	4,8 *10.580*
EM93064014685	00074385	HSK-A100	G7	46,0 *1.811*	85,0 *3.346*	56,0 *2.205*	90,0 *3.543*	135,0 *5.315*	1	PB	4,0 *8.820*
EM930640146160	00086933	HSK-A100	G7	46,0 *1.811*	160,0 *6.299*	131,0 *5.157*	90,0 *3.543*	210,0 *8.268*	1	PB	7,67 *16.910*
HSKA125-G6-120	03229653	HSK-A125	G6	36,0 *1.417*	120,0 *4.724*	91,0 *3.583*	63,0 *2.480*	183,0 *7.205*	1	PB	5,1 *11.240*
HSKA125-G7-120	03229654	HSK-A125	G7	46,0 *1.811*	120,0 *4.724*	91,0 *3.583*	90,0 *3.543*	183,0 *7.205*	1	PB	7,1 *15.650*

Ersatzteile, im Lieferumfang enthalten

Für Größe	Schraube
	
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

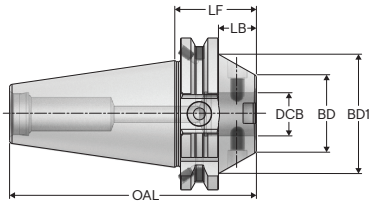
Zubehör

Für Größe	Spannschlüssel
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

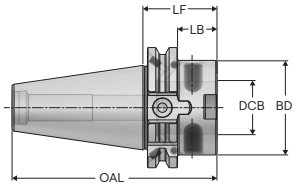
G 401 – Graflex®-Grundaufnahme

SA/SK/DIN 69871-ADB

Design 1



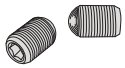
Design 2



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM34694011190	02503292	DIN40 ADB	G1	11,0 *0.433*	90,0 *3.543*	70,9 *2.791*	20,0 *0.787*	–	158,4 *6.236*	2	1	G6.3	1,0 *2.200*
EM34694011435	02469729	DIN40 ADB	G2	14,0 *0.551*	35,0 *1.378*	15,9 *0.626*	25,0 *0.984*	–	103,4 *4.071*	2	1	G6.3	0,83 *1.830*
EM34694011490	02503293	DIN40 ADB	G2	14,0 *0.551*	90,0 *3.543*	70,9 *2.791*	25,0 *0.984*	–	158,4 *6.236*	2	1	G6.3	1,1 *2.430*
EM34694011835	02420097	DIN40 ADB	G3	18,0 *0.709*	35,0 *1.378*	15,9 *0.626*	32,0 *1.260*	50,0 *1.969*	103,4 *4.071*	1	1	G6.3	1,0 *2.200*
EM346940118100	02503298	DIN40 ADB	G3	18,0 *0.709*	100,0 *3.937*	80,9 *3.185*	32,0 *1.260*	–	168,4 *6.630*	2	1	G6.3	1,3 *2.870*
EM34694012235	02503299	DIN40 ADB	G4	22,0 *0.866*	35,0 *1.378*	15,9 *0.626*	40,0 *1.575*	50,0 *1.969*	103,4 *4.071*	1	1	G6.3	0,92 *2.030*
EM346940122100	02503300	DIN40 ADB	G4	22,0 *0.866*	100,0 *3.937*	80,9 *3.185*	40,0 *1.575*	–	168,4 *6.630*	2	1	G6.3	1,5 *3.310*
EM34694012840	02458421	DIN40 ADB	G5	28,0 *1.102*	40,0 *1.575*	20,9 *0.823*	50,0 *1.969*	–	108,4 *4.268*	2	1	PB	1,0 *2.200*
EM34694012880	02503301	DIN40 ADB	G5	28,0 *1.102*	80,0 *3.150*	60,9 *2.398*	50,0 *1.969*	–	148,4 *5.843*	2	1	PB	1,5 *3.310*
EM346940128120	02503302	DIN40 ADB	G5	28,0 *1.102*	120,0 *4.724*	100,9 *3.972*	50,0 *1.969*	–	188,4 *7.417*	2	1	PB	2,1 *4.630*
EM34694013660	02503303	DIN40 ADB	G6	36,0 *1.417*	60,0 *2.362*	40,9 *1.610*	63,0 *2.480*	–	128,4 *5.055*	2	1	PB	1,3 *2.870*
EM346940136120	02503304	DIN40 ADB	G6	36,0 *1.417*	120,0 *4.724*	100,9 *3.972*	63,0 *2.480*	–	188,4 *7.417*	2	1	PB	2,7 *5.950*
EM347140114100	02503306	DIN50 ADB	G2	14,0 *0.551*	100,0 *3.937*	80,9 *3.185*	25,0 *0.984*	–	201,7 *7.941*	2	1	G6.3	2,9 *6.390*
EM34714011835	02503307	DIN50 ADB	G3	18,0 *0.709*	35,0 *1.378*	15,9 *0.626*	32,0 *1.260*	–	136,7 *5.382*	2	1	G6.3	2,67 *5.890*
EM347140118110	02503308	DIN50 ADB	G3	18,0 *0.709*	110,0 *4.331*	90,9 *3.579*	32,0 *1.260*	–	211,7 *8.335*	2	1	G6.3	3,1 *6.830*
EM34714012235	02503309	DIN50 ADB	G4	22,0 *0.866*	35,0 *1.378*	15,9 *0.626*	40,0 *1.575*	80,0 *3.150*	136,7 *5.382*	1	1	G6.3	2,88 *6.350*
EM347140122120	02503311	DIN50 ADB	G4	22,0 *0.866*	120,0 *4.724*	100,9 *3.972*	40,0 *1.575*	–	221,7 *8.728*	2	1	G6.3	3,4 *7.500*
EM34714012840	02503312	DIN50 ADB	G5	28,0 *1.102*	40,0 *1.575*	20,9 *0.823*	50,0 *1.969*	–	141,7 *5.579*	2	1	PB	2,75 *6.060*
EM347140128100	02503315	DIN50 ADB	G5	28,0 *1.102*	100,0 *3.937*	80,9 *3.185*	50,0 *1.969*	–	201,7 *7.941*	2	1	PB	3,56 *7.850*
EM347140128140	02503316	DIN50 ADB	G5	28,0 *1.102*	140,0 *5.512*	120,9 *4.760*	50,0 *1.969*	–	241,7 *9.516*	2	1	PB	4,08 *8.990*
EM34714013645	02503317	DIN50 ADB	G6	36,0 *1.417*	45,0 *1.772*	25,9 *1.020*	63,0 *2.480*	–	146,7 *5.776*	2	1	PB	2,9 *6.390*
EM347140136100	02503318	DIN50 ADB	G6	36,0 *1.417*	100,0 *3.937*	80,9 *3.185*	63,0 *2.480*	–	201,7 *7.941*	2	1	PB	4,1 *9.040*
EM347140136140	02503319	DIN50 ADB	G6	36,0 *1.417*	140,0 *5.512*	120,9 *4.760*	63,0 *2.480*	–	241,7 *9.516*	2	1	PB	5,1 *11.240*
EM34714014650	02503320	DIN50 ADB	G7	46,0 *1.811*	50,0 *1.969*	30,9 *1.217*	90,0 *3.543*	–	151,7 *5.972*	2	1	PB	3,3 *7.280*
EM347140146120	02503321	DIN50 ADB	G7	46,0 *1.811*	120,0 *4.724*	100,9 *3.972*	90,0 *3.543*	–	221,7 *8.728*	2	1	PB	6,5 *14.330*

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM347140146200	02503324	DIN50 ADB	G7	46,0 *1.811*	200,0 *7.874*	180,9 *7.122*	90,0 *3.543*	–	301,7 *11.878*	2	1	PB	10,4 *22.930*

Ersatzteile, im Lieferumfang enthalten

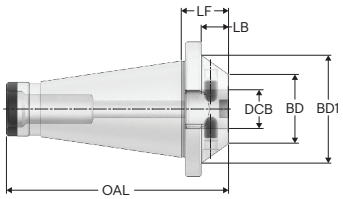
Für Größe	Schraube	Dichtschraube
		
DIN40/ G1	90F1	950A0406
DIN40/ G2	90F2	950A0406
DIN40/ G3	90F3	950A0406
DIN40/ G4	90F4	950A0406
DIN40/ G5	90F5	950A0406
DIN40/ G6	90F6	950A0406
DIN50/ G2	90F2	950A0606
DIN50/ G3	90F3	950A0606
DIN50/ G4	90F4	950A0606
DIN50/ G5	90F5	950A0606
DIN50/ G6	90F6	950A0606
DIN50/ G7	90F7	950A0606
EM34714014650	90F71	950A0606

Zubehör

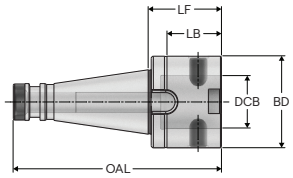
Für Größe	Spannschlüssel
DIN40/ G1	03H02
DIN40/ G2	03H025
DIN40/ G3	03H03
DIN40/ G4	03H04
DIN40/ G5	03H05
DIN40/ G6	03H06
DIN50/ G2	03H025
DIN50/ G3	03H03
DIN50/ G4	03H04
DIN50/ G5	03H05
DIN50/ G6	03H06
DIN50/ G7	03H10
EM34714014650	03H10

G 401 – Graflex®-Grundaufnahme
DIN 2080

Design 1

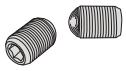


Design 2



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM00404013650	00076707	DIN(2080)40	G6	36,0 *1.417*	50,0 *1.969*	0,0 –	63,0 *2.480*	–	143,4 *5.646*	2	0	PB	1,3 *2.870*
EM00504012835	00076710	DIN(2080)50	G5	28,0 *1.102*	35,0 *1.378*	19,8 *0.780*	50,0 *1.969*	78,0 *3.071*	161,8 *6.370*	1	0	PB	2,94 *6.480*
EM00504013640	00076714	DIN(2080)50	G6	36,0 *1.417*	40,0 *1.575*	24,8 *0.976*	63,0 *2.480*	–	166,8 *6.567*	2	0	PB	2,9 *6.390*
EM00504014645	00076718	DIN(2080)50	G7	46,0 *1.811*	45,0 *1.772*	29,8 *1.173*	90,0 *3.543*	–	171,8 *6.764*	2	0	PB	3,34 *7.360*

Ersatzteile, im Lieferumfang enthalten

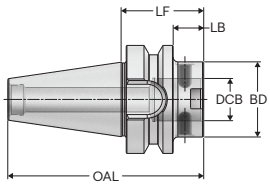
Für Größe	Schraube
	
G5	90F5
G6	90F6
G7	90F7

Zubehör

Für Größe	Spannschlüssel
G5	03H05
G6	03H06
G7	03H10

G 401 – Graflex®-Grundaufnahme

BT JIS B 6339-AD



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
EM40404011835	00056699	BT30 AD	G3	18,0 *0.709*	35,0 *1.378*	13,0 *0.512*	32,0 *1.260*	83,4 *3.283*	0	G6.3	0,5 *1.100*
EM40404012850	00056705	BT30 AD	G5	28,0 *1.102*	50,0 *1.969*	25,0 *0.984*	50,0 *1.969*	98,4 *3.874*	0	PB	0,7 *1.540*

Ersatzteile, im Lieferumfang enthalten

Für Größe	Schraube
EM40404011835	90F3
EM40404012850	90F5

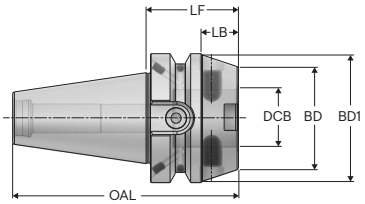
Zubehör

Für Größe	Spannschlüssel
EM40404011835	03H03
EM40404012850	03H05

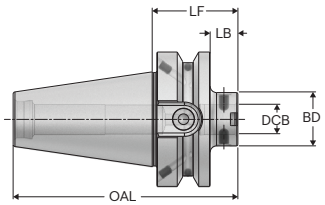
G 401 – Graflex®-Grundaufnahme

BT JIS B 6339-ADB

Design 1



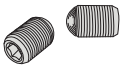
Design 2



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM34144011190	02503364	BT40 ADB	G1	11,0 *0.433*	90,0 *3.543*	63,0 *2.480*	20,0 *0.787*	–	155,4 *6.118*	2	1	G6.3	1,1 *2.430*
EM34144011440	02469725	BT40 ADB	G2	14,0 *0.551*	40,0 *1.575*	13,0 *0.512*	25,0 *0.984*	–	105,4 *4.150*	2	1	G6.3	0,98 *2.160*
EM34144011490	02503365	BT40 ADB	G2	14,0 *0.551*	90,0 *3.543*	63,0 *2.480*	25,0 *0.984*	–	155,4 *6.118*	2	1	G6.3	1,2 *2.650*
EM34144011840	02503366	BT40 ADB	G3	18,0 *0.709*	40,0 *1.575*	13,0 *0.512*	32,0 *1.260*	62,0 *2.441*	105,4 *4.150*	1	1	G6.3	1,07 *2.360*
EM341440118100	02503367	BT40 ADB	G3	18,0 *0.709*	100,0 *3.937*	73,0 *2.874*	32,0 *1.260*	–	165,4 *6.512*	2	1	G6.3	1,31 *2.890*
EM34144012245	02503368	BT40 ADB	G4	22,0 *0.866*	45,0 *1.772*	18,0 *0.709*	40,0 *1.575*	62,0 *2.441*	110,4 *4.346*	1	1	G6.3	1,2 *2.650*
EM341440122100	02503370	BT40 ADB	G4	22,0 *0.866*	100,0 *3.937*	73,0 *2.874*	40,0 *1.575*	–	165,4 *6.512*	2	1	G6.3	1,6 *3.530*
EM34144012845	02457989	BT40 ADB	G5	28,0 *1.102*	45,0 *1.772*	18,0 *0.709*	50,0 *1.969*	62,0 *2.441*	110,4 *4.346*	1	1	PB	1,2 *2.650*
EM34144012880	02503371	BT40 ADB	G5	28,0 *1.102*	80,0 *3.150*	53,0 *2.087*	50,0 *1.969*	–	145,4 *5.724*	2	1	PB	1,6 *3.530*
EM341440128120	02503372	BT40 ADB	G5	28,0 *1.102*	120,0 *4.724*	93,0 *3.661*	50,0 *1.969*	–	185,4 *7.299*	2	1	PB	2,2 *4.850*
EM34144013650	02503373	BT40 ADB	G6	36,0 *1.417*	50,0 *1.969*	0,0 –	63,0 *2.480*	–	115,4 *4.543*	2	0	PB	1,2 *2.650*
EM341440136120	02503374	BT40 ADB	G6	36,0 *1.417*	120,0 *4.724*	0,0 –	63,0 *2.480*	–	185,4 *7.299*	2	1	PB	2,8 *6.170*
EM341640114110	02503375	BT50 ADB	G2	14,0 *0.551*	110,0 *4.331*	72,0 *2.835*	25,0 *0.984*	–	211,8 *8.339*	2	1	G6.3	3,8 *8.380*
EM34164011845	02503376	BT50 ADB	G3	18,0 *0.709*	45,0 *1.772*	7,0 *0.276*	32,0 *1.260*	70,0 *2.756*	146,8 *5.780*	1	1	G6.3	3,6 *7.940*
EM341640118120	02503377	BT50 ADB	G3	18,0 *0.709*	120,0 *4.724*	82,0 *3.228*	32,0 *1.260*	–	221,8 *8.732*	2	1	G6.3	4,0 *8.820*
EM34164012250	02503378	BT50 ADB	G4	22,0 *0.866*	50,0 *1.969*	12,0 *0.472*	40,0 *1.575*	70,0 *2.756*	151,8 *5.976*	1	1	G6.3	3,7 *8.160*
EM341640122140	02503379	BT50 ADB	G4	22,0 *0.866*	140,0 *5.512*	102,0 *4.016*	40,0 *1.575*	–	241,8 *9.520*	2	1	G6.3	4,4 *9.700*
EM34164012855	02503380	BT50 ADB	G5	28,0 *1.102*	55,0 *2.165*	17,0 *0.669*	50,0 *1.969*	98,0 *3.858*	156,8 *6.173*	1	1	PB	4,0 *8.820*
EM341640128100	02503381	BT50 ADB	G5	28,0 *1.102*	100,0 *3.937*	62,0 *2.441*	50,0 *1.969*	–	201,8 *7.945*	2	1	PB	4,3 *9.480*
EM341640128140	02503382	BT50 ADB	G5	28,0 *1.102*	140,0 *5.512*	102,0 *4.016*	50,0 *1.969*	–	241,8 *9.520*	2	1	PB	4,9 *10.800*
EM34164013663	02503383	BT50 ADB	G6	36,0 *1.417*	63,0 *2.480*	25,0 *0.984*	63,0 *2.480*	98,0 *3.858*	164,8 *6.488*	1	1	PB	4,3 *9.480*
EM341640136100	02503384	BT50 ADB	G6	36,0 *1.417*	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	–	201,8 *7.945*	2	1	PB	4,7 *10.360*
EM341640136140	02503385	BT50 ADB	G6	36,0 *1.417*	140,0 *5.512*	102,0 *4.016*	63,0 *2.480*	–	241,8 *9.520*	2	1	PB	5,6 *12.350*
EM34164014665	02503386	BT50 ADB	G7	46,0 *1.811*	65,0 *2.559*	27,0 *1.063*	90,0 *3.543*	98,0 *3.858*	166,8 *6.567*	1	1	PB	4,4 *9.700*
EM341640146120	02503387	BT50 ADB	G7	46,0 *1.811*	120,0 *4.724*	82,0 *3.228*	90,0 *3.543*	–	221,8 *8.732*	2	1	PB	6,9 *15.210*

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM341640146200	02503388	BT50 ADB	G7	46,0 *1.811*	200,0 *7.874*	162,0 *6.378*	90,0 *3.543*	–	301,8 *11.882*	2	1	PB	10,7 *23.590*

Ersatzteile, im Lieferumfang enthalten

Für Größe	Schraube	Dichtschraube
		
BT40/ G1	90F1	950A0406
BT40/ G2	90F2	950A0406
BT40/ G3	90F3	950A0406
BT40/ G4	90F4	950A0406
BT40/ G5	90F5	950A0406
BT40/ G6	90F6	950A0406
BT50/ G2	90F2	950A0606
BT50/ G3	90F3	950A0606
BT50/ G4	90F4	950A0606
BT50/ G5	90F5	950A0606
BT50/ G6	90F6	950A0606
BT50/ G7	90F7	950A0606

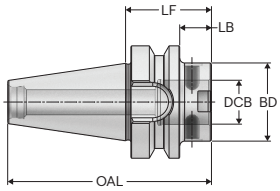
Zubehör

Für Größe	Spannschlüssel
BT40/ G1	03H02
BT40/ G2	03H025
BT40/ G3	03H03
BT40/ G4	03H04
BT40/ G5	03H05
BT40/ G6	03H06
BT50/ G2	03H025
BT50/ G3	03H03
BT50/ G4	03H04
BT50/ G5	03H05
BT50/ G6	03H06
BT50/ G7	03H10

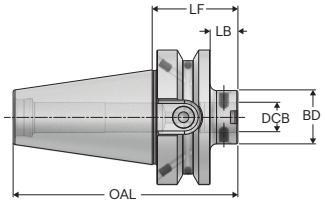
G 401 – Graflex®-Grundaufnahme

BT-Steilkegel-Aufnahmen-AD/ADB

Design 1

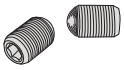


Design 2



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM40024011850	02998757	BT30 TF AD	G3	18,0 *0.709*	50,0 *1.969*	28,0 *1.102*	32,0 *1.260*	98,4 *3.874*	1	0	G6.3	0,6 *1.320*
EM40024012250	02998758	BT30 TF AD	G4	22,0 *0.866*	50,0 *1.969*	28,0 *1.102*	40,0 *1.575*	98,4 *3.874*	1	0	G6.3	0,6 *1.320*
EM321440122100	02998754	BT40 TF ADB	G4	22,0 *0.866*	100,0 *3.937*	73,0 *2.874*	40,0 *1.575*	165,4 *6.512*	2	1	G6.3	1,6 *3.530*
EM321440128120	02926006	BT40 TF ADB	G5	28,0 *1.102*	120,0 *4.724*	93,0 *3.661*	50,0 *1.969*	185,4 *7.299*	2	1	PB	2,2 *4.850*
EM321440136120	02998755	BT40 TF ADB	G6	36,0 *1.417*	120,0 *4.724*	93,0 *3.661*	63,0 *2.480*	185,4 *7.299*	2	1	PB	2,8 *6.170*
EM321640128140	02998756	BT50 TF ADB	G5	28,0 *1.102*	140,0 *5.512*	102,0 *4.016*	50,0 *1.969*	241,8 *9.520*	2	1	PB	4,9 *10.800*
EM321640136140	02926009	BT50 TF ADB	G6	36,0 *1.417*	140,0 *5.512*	102,0 *4.016*	63,0 *2.480*	241,8 *9.520*	2	1	PB	5,6 *12.350*
EM321640146200	02926010	BT50 TF ADB	G7	46,0 *1.811*	200,0 *7.874*	162,0 *6.378*	90,0 *3.543*	301,8 *11.882*	2	1	PB	10,8 *23.810*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Dichtschraube	Schraube
		
EM321440122100	950A0406	90F4
EM321440128120	950A0406	90F5
EM321440136120	950A0406	90F6
EM321640128140	950A0606	90F5
EM321640136140	950A0606	90F6
EM321640146200	950A0606	90F7
EM40024011850	–	90F3
EM40024012250	–	90F4

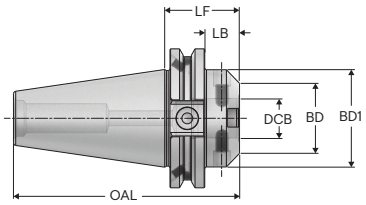
Zubehör

Spannschlüssel
03H03
03H04
03H04
03H05
03H06
03H05
03H06
03H10

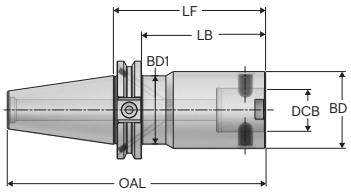
G 401 – Graflex®-Grundaufnahme

CAT / ASME B5.50-1994-ADB

Design 1

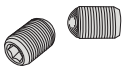


Design 2



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
EM25024011435	02469734	CAT40 ADB	G2	0.551	1.380	0.630	0.984	1.750	4.070	1	1	G6.3	2.120
EM25024011835	00056660	CAT40 ADB	G3	0.709	1.380	0.630	1.260	1.750	4.070	1	1	G6.3	2.200
EM25024012235	00056661	CAT40 ADB	G4	0.866	1.380	0.630	1.575	1.750	4.070	1	1	G6.3	1.980
EM25024012840	00056663	CAT40 ADB	G5	1.102	1.570	0.820	1.969	1.750	4.270	2	1	PB	1.980
EM250240128100	00056662	CAT40 ADB	G5	1.102	3.940	3.190	1.969	1.750	7.420	2	1	PB	3.970
EM25024013660	00056665	CAT40 ADB	G6	1.417	2.360	1.610	2.480	1.750	5.060	2	1	PB	2.870
EM25044011835	00056666	CAT50 ADB	G3	0.709	1.380	0.630	1.260	2.750	5.380	1	1	G6.3	6.830
EM25044012235	00056667	CAT50 ADB	G4	0.866	1.380	0.630	1.575	2.750	5.380	1	1	G6.3	6.610
EM25044012840	00056669	CAT50 ADB	G5	1.102	1.570	0.820	1.969	2.750	5.580	2	1	PB	6.610
EM250440128100	00056668	CAT50 ADB	G5	1.102	3.940	3.190	1.969	2.750	7.940	2	1	PB	8.380
EM25044013645	00056671	CAT50 ADB	G6	1.417	1.770	1.020	2.480	2.750	5.780	1	1	PB	6.610
EM250440136120	00056670	CAT50 ADB	G6	1.417	4.720	3.970	2.480	2.750	9.520	1	1	PB	10.360
EM25044014665	00056675	CAT50 ADB	G7	1.811	2.560	1.810	3.543	2.750	5.970	2	1	PB	8.380
EM250440146120	00056673	CAT50 ADB	G7	1.811	4.720	3.970	3.543	2.750	8.730	2	1	PB	13.890
EM250440146200	00056674	CAT50 ADB	G7	1.811	7.870	7.120	3.543	2.750	11.880	2	1	PB	22.270

Ersatzteile, im Lieferumfang enthalten

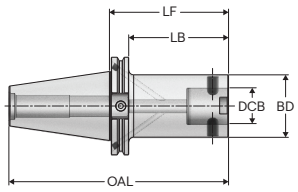
Für Größe	Dichtschraube	Schraube
		
CAT40/ G2	950A0406	90F2
CAT40/ G3	950A0406	90F3
CAT40/ G4	950A0406	90F4
CAT40/ G5	950A0406	90F5
CAT40/ G6	950A0406	90F6
CAT50/ G3	950A0606	90F3
CAT50/ G4	950A0606	90F4
CAT50/ G5	950A0606	90F5
CAT50/ G6	950A0606	90F6
CAT50/ G7	950A0606	90F7

Zubehör

Spannschlüssel
03H025
03H03
03H04
03H05
03H06
03H03
03H04
03H05
03H06
03H10

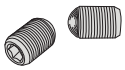
G 401 – Graflex®-Grundaufnahme

CAT TF / ASME B5.50-2009-ADB



Bezeichnung	Produktnummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Aus-wuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
EM26424011880	02998750	CAT40 TF ADB	G3	0.709	3.150	2.398	1.260	5.843	2	1	G6.3	2.650
EM26424012280	02998751	CAT40 TF ADB	G4	0.866	3.150	2.398	1.575	5.843	2	1	G6.3	3.090
EM264240128100	02998752	CAT40 TF ADB	G5	1.102	3.937	3.185	1.969	6.630	2	1	PB	4.190
EM264240136100	02998753	CAT40 TF ADB	G6	1.417	3.937	3.185	2.480	6.630	2	1	PB	5.290
EM264440122100	02964322	CAT50 TF ADB	G4	0.866	3.937	3.185	1.575	7.943	2	1	G6.3	7.280
EM264440128100	02964323	CAT50 TF ADB	G5	1.102	3.937	3.185	1.969	7.943	2	1	PB	7.940
EM264440136120	02926850	CAT50 TF ADB	G6	1.417	4.724	3.972	2.480	8.732	1	1	PB	10.140
EM264440146200	02926851	CAT50 TF ADB	G7	1.811	7.874	7.122	3.543	11.880	2	1	PB	22.710

Ersatzteile, im Lieferumfang enthalten

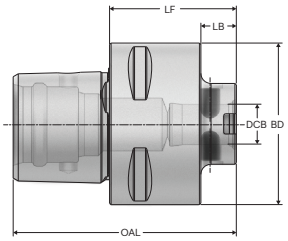
Für Größe	Dichtschraube	Schraube
		
EM26424011880	950A0406	90F3
EM26424012280	950A0406	90F4
EM264240128100	950A0406	90F5
EM264240136100	950A0406	90F6
EM264440122100	950A0606	90F4
EM264440128100	950A0606	90F5
EM264440136120	950A0606	90F6
EM264440146200	950A0606	90F7

Zubehör

Spannschlüssel
03H03
03H04
03H05
03H06
03H04
03H05
03H06
03H10

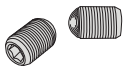
G 401 – Graflex®-Adapter

Seco Capto™



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-391.0401-08025	02532939	C3	G0	8,0 *0.315*	25,0 *0.984*	7,0 *0.276*	16,0 *0.630*	44,0 *1.732*	0	G6.3	0,2 *0.440*
C3-391.0401-11025	02532940	C3	G1	11,0 *0.433*	25,0 *0.984*	7,0 *0.276*	20,0 *0.787*	44,0 *1.732*	0	G6.3	0,14 *0.310*
C3-391.0401-14025	02532941	C3	G2	14,0 *0.551*	25,0 *0.984*	7,0 *0.276*	25,0 *0.984*	44,0 *1.732*	0	G6.3	0,2 *0.440*
C3-391.0401-18030	02532942	C3	G3	18,0 *0.709*	30,0 *1.181*	0,0 –	32,0 *1.260*	49,0 *1.929*	0	G6.3	0,16 *0.350*
C4-391.0401-18035	02532943	C4	G3	18,0 *0.709*	35,0 *1.378*	12,0 *0.472*	32,0 *1.260*	59,0 *2.323*	0	G6.3	0,4 *0.880*
C4-391.0401-22035	02532944	C4	G4	22,0 *0.866*	35,0 *1.378*	0,0 –	40,0 *1.575*	59,0 *2.323*	0	G6.3	0,31 *0.680*
C5-391.0401-14030	02532945	C5	G2	14,0 *0.551*	30,0 *1.181*	7,0 *0.276*	25,0 *0.984*	60,0 *2.362*	1	G6.3	0,47 *1.040*
C5-391.0401-18035	02532947	C5	G3	18,0 *0.709*	35,0 *1.378*	12,0 *0.472*	32,0 *1.260*	65,0 *2.559*	1	G6.3	0,5 *1.100*
C5-391.0401-22035	02532948	C5	G4	22,0 *0.866*	35,0 *1.378*	12,0 *0.472*	40,0 *1.575*	65,0 *2.559*	1	G6.3	0,5 *1.100*
C5-391.0401-28045	02532949	C5	G5	28,0 *1.102*	45,0 *1.772*	22,0 *0.866*	50,0 *1.969*	75,0 *2.953*	1	PB	0,7 *1.540*
C6-391.0401-18035	02532950	C6	G3	18,0 *0.709*	35,0 *1.378*	10,0 *0.394*	32,0 *1.260*	73,0 *2.874*	1	G6.3	0,9 *1.980*
C6-391.0401-22040	02532951	C6	G4	22,0 *0.866*	40,0 *1.575*	15,0 *0.591*	40,0 *1.575*	78,0 *3.071*	1	G6.3	0,9 *1.980*
C6-391.0401-28050	02532952	C6	G5	28,0 *1.102*	50,0 *1.969*	25,0 *0.984*	50,0 *1.969*	88,0 *3.465*	1	PB	1,1 *2.430*
C6-391.0401-36055	02532953	C6	G6	36,0 *1.417*	55,0 *2.165*	0,0 –	63,0 *2.480*	93,0 *3.661*	1	PB	1,2 *2.650*
C8-391.0401-28050	02532954	C8	G5	28,0 *1.102*	50,0 *1.969*	17,0 *0.669*	50,0 *1.969*	98,0 *3.858*	1	PB	2,0 *4.410*
C8-391.0401-36055	02532955	C8	G6	36,0 *1.417*	55,0 *2.165*	22,0 *0.866*	63,0 *2.480*	103,0 *4.055*	1	PB	2,1 *4.630*
C8-391.0401-46065	02532956	C8	G7	46,0 *1.811*	65,0 *2.559*	35,0 *1.378*	90,0 *3.543*	113,0 *4.449*	1	PB	2,8 *6.170*

Ersatzteile, im Lieferumfang enthalten

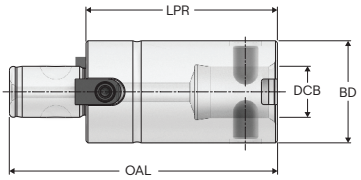
Für Halter	Schraube
	
G0	90F0
G1	90F1
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

Zubehör

Für Größe	Spannschlüssel
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

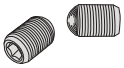
G 402 – Graflex®-Verlängerungen

Graflex®



Bezeichnung	Produktnummer	CTMS	CTWS	DCB	LPR	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M402000	00056752	G0	G0	8,0 *0.315*	30,0 *1.181*	16,0 *0.630*	42,0 *1.654*	0	PB	0,1 *0.220*
M402001	00056753	G0	G0	8,0 *0.315*	50,0 *1.969*	16,0 *0.630*	62,0 *2.441*	0	PB	0,1 *0.220*
M402110	00056754	G1	G1	11,0 *0.433*	30,0 *1.181*	20,0 *0.787*	43,0 *1.693*	0	PB	0,1 *0.220*
M402111	00056755	G1	G1	11,0 *0.433*	50,0 *1.969*	20,0 *0.787*	63,0 *2.480*	0	PB	0,2 *0.440*
M402220	00056756	G2	G2	14,0 *0.551*	30,0 *1.181*	25,0 *0.984*	46,0 *1.811*	0	PB	0,2 *0.440*
M402221	00056757	G2	G2	14,0 *0.551*	50,0 *1.969*	25,0 *0.984*	66,0 *2.598*	0	PB	0,2 *0.440*
M402330	00056758	G3	G3	18,0 *0.709*	40,0 *1.575*	32,0 *1.260*	60,0 *2.362*	0	PB	0,3 *0.660*
M402331	75056759	G3	G3	18,0 *0.709*	60,0 *2.362*	32,0 *1.260*	80,0 *3.150*	0	PB	0,4 *0.880*
M402440	00056760	G4	G4	22,0 *0.866*	40,0 *1.575*	40,0 *1.575*	64,0 *2.520*	0	PB	0,4 *0.880*
M402441	00056761	G4	G4	22,0 *0.866*	60,0 *2.362*	40,0 *1.575*	84,0 *3.307*	0	PB	0,6 *1.320*
M402444	02786252	G4	G4	22,0 *0.866*	200,0 *7.874*	40,0 *1.575*	224,0 *8.819*	0	PB	1,95 *4.300*
M402550	00056762	G5	G5	28,0 *1.102*	50,0 *1.969*	50,0 *1.969*	80,0 *3.150*	0	PB	0,8 *1.760*
M402551	00056763	G5	G5	28,0 *1.102*	75,0 *2.953*	50,0 *1.969*	105,0 *4.134*	0	PB	1,2 *2.650*
M402552	00056764	G5	G5	28,0 *1.102*	100,0 *3.937*	50,0 *1.969*	130,0 *5.118*	0	PB	1,5 *3.310*
M402554	02786254	G5	G5	28,0 *1.102*	250,0 *9.843*	50,0 *1.969*	280,0 *11.024*	0	PB	3,8 *8.380*
M402660	00056765	G6	G6	36,0 *1.417*	60,0 *2.362*	63,0 *2.480*	100,0 *3.937*	0	PB	1,4 *3.090*
M402661	00056766	G6	G6	36,0 *1.417*	90,0 *3.543*	63,0 *2.480*	130,0 *5.118*	0	PB	2,2 *4.850*
M402662	00056767	G6	G6	36,0 *1.417*	120,0 *4.724*	63,0 *2.480*	160,0 *6.299*	0	PB	2,9 *6.390*
M402664	02786255	G6	G6	36,0 *1.417*	300,0 *11.811*	63,0 *2.480*	340,0 *13.386*	0	PB	7,2 *15.870*
M402770	00056768	G7	G7	46,0 *1.811*	60,0 *2.362*	90,0 *3.543*	110,0 *4.331*	0	-	2,9 *6.390*
M402771	00056769	G7	G7	46,0 *1.811*	90,0 *3.543*	90,0 *3.543*	140,0 *5.512*	0	-	4,4 *9.700*
M402772	00056770	G7	G7	46,0 *1.811*	120,0 *4.724*	90,0 *3.543*	170,0 *6.693*	0	-	5,8 *12.790*
M402774	02786257	G7	G7	46,0 *1.811*	300,0 *11.811*	90,0 *3.543*	350,0 *13.780*	0	-	14,6 *32.190*

Ersatzteile, im Lieferumfang enthalten

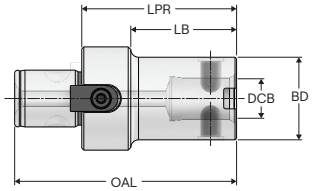
Für Größe	Mitnehmer	Schraube
		
G0	90M0	90F0
G1	90M1	90F1
G2	90M2	90F2
G3	90M3	90F3
G4	90M4	90F4
G5	90M5	90F5
G6	90M6	90F6
G7	90M7	90F7

Zubehör

Für Größe	Spannschlüssel
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

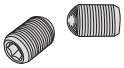
G 403 – Graflex®-Reduzierstücke

Graflex®



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LPR	LB	BD	OAL	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40310	00056771	G1	G0	8,0 *0.315*	30,0 *1.181*	22,0 *0.866*	16,0 *0.630*	43,0 *1.693*	0	PB	0,1 *0.220*
M40320	00056772	G2	G0	8,0 *0.315*	30,0 *1.181*	19,0 *0.748*	16,0 *0.630*	46,0 *1.811*	0	PB	0,1 *0.220*
M40321	00056773	G2	G1	11,0 *0.433*	30,0 *1.181*	19,0 *0.748*	20,0 *0.787*	46,0 *1.811*	0	PB	0,1 *0.220*
M40330	00056774	G3	G0	8,0 *0.315*	30,0 *1.181*	16,0 *0.630*	16,0 *0.630*	50,0 *1.969*	0	PB	0,2 *0.440*
M40331	00056775	G3	G1	11,0 *0.433*	30,0 *1.181*	16,0 *0.630*	20,0 *0.787*	50,0 *1.969*	0	PB	0,15 *0.330*
M40332	00056776	G3	G2	14,0 *0.551*	30,0 *1.181*	16,0 *0.630*	25,0 *0.984*	50,0 *1.969*	0	PB	0,2 *0.440*
M40341	00056778	G4	G1	11,0 *0.433*	30,0 *1.181*	13,0 *0.512*	20,0 *0.787*	54,0 *2.126*	0	PB	0,25 *0.550*
M40342	00056779	G4	G2	14,0 *0.551*	30,0 *1.181*	13,0 *0.512*	25,0 *0.984*	54,0 *2.126*	0	PB	0,3 *0.660*
M40343	00056780	G4	G3	18,0 *0.709*	30,0 *1.181*	13,0 *0.512*	32,0 *1.260*	54,0 *2.126*	0	PB	0,3 *0.660*
M40350	00056781	G5	G0	8,0 *0.315*	40,0 *1.575*	20,0 *0.787*	16,0 *0.630*	70,0 *2.756*	0	PB	0,47 *1.040*
M40351	00056783	G5	G1	11,0 *0.433*	40,0 *1.575*	20,0 *0.787*	20,0 *0.787*	70,0 *2.756*	0	PB	0,5 *1.100*
M40352	00056785	G5	G2	14,0 *0.551*	40,0 *1.575*	20,0 *0.787*	25,0 *0.984*	70,0 *2.756*	0	PB	0,5 *1.100*
M40353	00056787	G5	G3	18,0 *0.709*	40,0 *1.575*	20,0 *0.787*	32,0 *1.260*	70,0 *2.756*	0	PB	0,6 *1.320*
M40354	00056789	G5	G4	22,0 *0.866*	40,0 *1.575*	20,0 *0.787*	40,0 *1.575*	70,0 *2.756*	0	PB	0,6 *1.320*
M40363	00056797	G6	G3	18,0 *0.709*	40,0 *1.575*	14,0 *0.551*	32,0 *1.260*	80,0 *3.150*	0	PB	1,0 *2.200*
M40364	00056799	G6	G4	22,0 *0.866*	40,0 *1.575*	14,0 *0.551*	40,0 *1.575*	80,0 *3.150*	0	PB	1,0 *2.200*
M40365	00056807	G6	G5	28,0 *1.102*	45,0 *1.772*	19,0 *0.748*	50,0 *1.969*	85,0 *3.346*	0	PB	1,1 *2.430*
M40375	00056811	G7	G5	28,0 *1.102*	50,0 *1.969*	24,0 *0.945*	50,0 *1.969*	100,0 *3.937*	0	-	2,1 *4.630*
M40376	00056812	G7	G6	36,0 *1.417*	55,0 *2.165*	29,0 *1.142*	63,0 *2.480*	105,0 *4.134*	0	-	2,3 *5.070*

Ersatzteile, im Lieferumfang enthalten

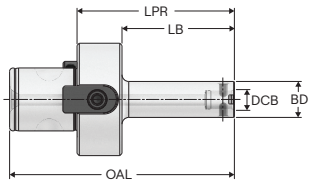
Für Größe	Mitnehmer	Schraube
		
M40310	90M1	90F0
M40320	90M2	90F0
M40321	90M2	90F1
M40330	90M3	90F0
M40331	90M3	90F1
M40332	90M3	90F2
M40341	90M4	90F1
M40342	90M4	90F2
M40343	90M4	90F3
M40350	90M5	90F0
M40351	90M5	90F1
M40352	90M5	90F2
M40353	90M5	90F3
M40354	90M5	90F4
M40363	90M6	90F3
M40364	90M6	90F4
M40365	90M6	90F5
M40375	90M7	90F5
M40376	90M7	90F6

Zubehör

Für Größe	Spannschlüssel
M40310	03H02
M40320	03H02
M40321	03H02
M40330	03H02
M40331	03H02
M40332	03H025
M40341	03H02
M40342	03H025
M40343	03H03
M40350	03H02
M40351	03H02
M40352	03H025
M40353	03H03
M40354	03H04
M40363	03H03
M40364	03H04
M40365	03H05
M40375	03H05
M40376	03H06

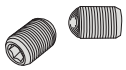
G 403 – Lange Graflex®-Reduzierstücke

Graflex®



Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LPR	LB	BD	OAL	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40350070	00056782	G5	G0	8,0 *0.315*	70,0 *2.756*	50,0 *1.969*	16,0 *0.630*	100,0 *3.937*	0	PB	0,6 *1.320*
M40351080	00056784	G5	G1	11,0 *0.433*	80,0 *3.150*	60,0 *2.362*	20,0 *0.787*	110,0 *4.331*	0	PB	0,6 *1.320*
M40352100	00056786	G5	G2	14,0 *0.551*	100,0 *3.937*	80,0 *3.150*	25,0 *0.984*	130,0 *5.118*	0	PB	0,8 *1.760*
M40353120	00056788	G5	G3	18,0 *0.709*	120,0 *4.724*	100,0 *3.937*	32,0 *1.260*	150,0 *5.906*	0	PB	1,1 *2.430*
M40354150	00056790	G5	G4	22,0 *0.866*	150,0 *5.906*	130,0 *5.118*	40,0 *1.575*	180,0 *7.087*	0	PB	1,7 *3.750*
M40361090	00056794	G6	G1	11,0 *0.433*	90,0 *3.543*	64,0 *2.520*	20,0 *0.787*	130,0 *5.118*	0	PB	1,08 *2.380*
M40362110	00056796	G6	G2	14,0 *0.551*	110,0 *4.331*	84,0 *3.307*	25,0 *0.984*	150,0 *5.906*	0	PB	1,3 *2.870*
M40363120	00056798	G6	G3	18,0 *0.709*	120,0 *4.724*	94,0 *3.701*	32,0 *1.260*	160,0 *6.299*	0	PB	1,5 *3.310*
M40364150	00056800	G6	G4	22,0 *0.866*	150,0 *5.906*	124,0 *4.882*	40,0 *1.575*	190,0 *7.480*	0	PB	2,1 *4.630*
M40365190	00056808	G6	G5	28,0 *1.102*	190,0 *7.480*	164,0 *6.457*	50,0 *1.969*	230,0 *9.055*	0	PB	3,3 *7.280*

Ersatzteile, im Lieferumfang enthalten

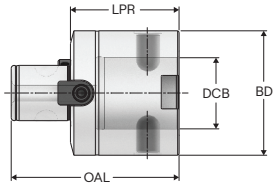
Für Größe	Mitnehmer	Schraube
		
M40350070	90M5	90F0
M40351080	90M5	90F1
M40352100	90M5	90F2
M40353120	90M5	90F3
M40354150	90M5	90F4
M40361090	90M6	90F1
M40362110	90M6	90F2
M40363120	90M6	90F3
M40364150	90M6	90F4
M40365190	90M6	90F5

Zubehör

Spannschlüssel
03H02
03H02
03H025
03H03
03H04
03H02
03H025
03H03
03H04
03H05

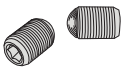
G 403 – Graflex®-Vergrößerer

Graflex®



Bezeichnung	Produktnummer	CTMS	CTWS	DCB	LPR	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40356	00056791	G5	G6	36,0 *1.417*	55,0 *2.165*	63,0 *2.480*	85,0 *3.346*	0	PB	1,1 *2.430*
M40367	00056810	G6	G7	46,0 *1.811*	80,0 *3.150*	90,0 *3.543*	120,0 *4.724*	0	PB	3,5 *7.720*

Ersatzteile, im Lieferumfang enthalten

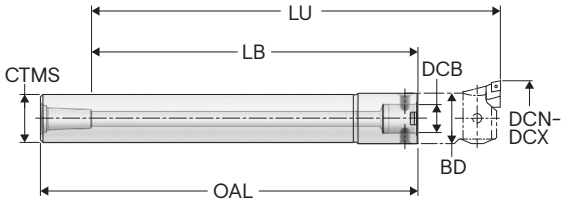
Für Halter	Mitnehmer	Schraube
		
M40356	90M5	90F6
M40367	90M6	90F7

Zubehör

Für Halter	Spannschlüssel
M40356	03H06
M40367	03H10

G 401 – Graflex®-Aufnahmen, Stahl

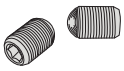
Zylindrisch



—Geeignet für Feinausdrehlänge bis LU mit eingebautem Ausdrehkopf Typ A780 oder A790
—Maschinenseitiger zylindrischer Schaft CTMS mit Toleranz h5, kompatibel mit Schrumpfaufnahmen.

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID-Bohrung	Aus-wuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M4011408	00086938	14	G0	8,0 *0.315*	15,0 *0.591*	18,5 *0.728*	120,0 *4.724*	14,0 *0.551*	110,0 *4.331*	75,0 *2.953*	0	G6.3	0,2 *0.440*
M4011608	00086935	16	G0	8,0 *0.315*	18,0 *0.709*	23,5 *0.925*	150,0 *5.906*	16,0 *0.630*	137,0 *5.394*	102,0 *4.016*	0	G6.3	0,3 *0.660*
M4012011	00086936	20	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	150,0 *5.906*	20,0 *0.787*	140,0 *5.512*	100,0 *3.937*	0	G6.3	0,33 *0.730*
M4012514	00086937	25	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	150,0 *5.906*	25,0 *0.984*	139,0 *5.472*	93,0 *3.661*	0	G6.3	0,6 *1.320*
M4013218	00086939	32	G3	18,0 *0.709*	39,0 *1.535*	51,0 *2.008*	150,0 *5.906*	32,0 *1.260*	155,0 *6.102*	90,0 *3.543*	0	G6.3	0,9 *1.980*

Ersatzteile, im Lieferumfang enthalten

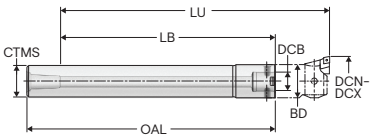
Für Halter	Schraube
	
M4011408	90F01
M4011608	90F0
M4012011	90F1
M4012514	90F2
M4013218	90F3

Zubehör

Für Halter	Spannschlüssel
M4011408	03H025
M4011608	03H02
M4012011	03H02
M4012514	03H025
M4013218	03H03

G 401 – Graflex®-Aufnahmen, Stahl

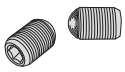
Zylindrisch



—Geeignet für Feinausdrehlänge bis LU mit eingebautem Ausdrehkopf Typ A780 oder A790
—Maschinenseitiger zylindrischer Schaft CTMS mit Toleranz h5, kompatibel mit Schrumpfaufnahmen.

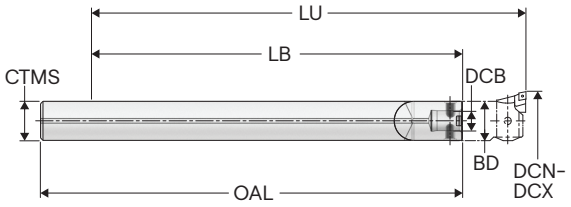
Bezeichnung	Produktnummer	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID-Bohrung	Auswuchtung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*			lbs
M40107511	00056741	0,750 in	G1	0.433	0.906	1.220	5.906	0.827	5.510	3.906	0	G6.3	0.660

Ersatzteile, im Lieferumfang enthalten

Für Größe	Schraube	Spannschlüssel
		
M40107511	90F1	03H02

G 401 – Graflex®-Aufnahmen, Hartmetall

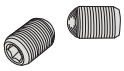
Zylindrisch



—Geeignet für Feinausdrehlänge bis LU mit eingebautem Ausdrehkopf Typ A780 oder A790
—CTMS Toleranz h5

Bezeichnung	Produktnummer	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID-Bohrung	Auswuchtung	Gewicht *Gewicht*
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M4011408C	00073004	14	G0	8,0 *0.315*	15,0 *0.591*	18,5 *0.728*	152,0 *5.984*	14,0 *0.551*	140,0 *5.512*	105,0 *4.134*	0	G6.3	0,3 *0.660*
M4011608C	00056747	16	G0	8,0 *0.315*	18,0 *0.709*	23,5 *0.925*	175,0 *6.890*	16,0 *0.630*	160,0 *6.299*	125,0 *4.921*	0	G6.3	0,5 *1.100*
M4012011C	00056749	20	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	212,0 *8.346*	20,0 *0.787*	200,0 *7.874*	160,0 *6.299*	0	G6.3	0,9 *1.980*
M4012514C	00056750	25	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	262,0 *10.315*	25,0 *0.984*	250,0 *9.843*	204,0 *8.031*	0	G6.3	1,71 *3.770*
M4013218C	00056751	32	G3	18,0 *0.709*	39,0 *1.535*	51,0 *2.008*	317,0 *12.480*	32,0 *1.260*	320,0 *12.598*	255,0 *10.039*	0	G6.3	3,44 *7.580*

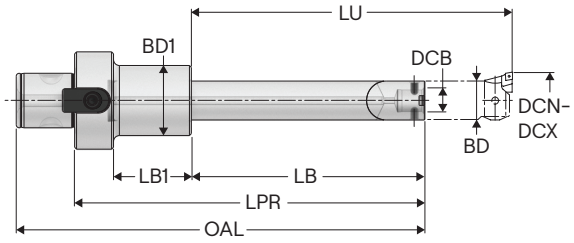
Ersatzteile, im Lieferumfang enthalten

Für Halter	Schraube
	
M4011408C	90F01
M4011608C	90F0
M4012011C	90F1
M4012514C	90F2
M4013218C	90F3

Zubehör

Für Halter	Spannschlüssel
M4011408C	03H025
M4011608C	03H02
M4012011C	03H02
M4012514C	03H025
M4013218C	03H03

G 403 – Extralange Graflex® Reduzierstücke, Hartmetall



—Die Verlängerung besteht aus Hartmetall
—Geeignet für Feinausdrehlänge bis LU mit eingebautem Ausdrehkopf Typ A780 oder A790

Bezeichnung	Produktnummer	CTMS	CTWS	DCB	DCN	DCX	OAL	LPR	BD	BD1	LU	LB	LB1	RFID-Bohrung	Auswuchtung	Gewicht *Gewicht*
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40350C150	00057604	G5	G0	8,0 *0.315*	18,0 *0.709*	23,5 *0.925*	180,0 *7.087*	150,0 *5.906*	16,0 *0.630*	32,0 *1.260*	130,0 *5.118*	95,0 *3.740*	35,0 *1.378*	0	PB	1,0 *2.200*
M40351C180	00056943	G5	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	210,0 *8.268*	180,0 *7.087*	20,0 *0.787*	36,0 *1.417*	160,0 *6.299*	120,0 *4.724*	40,0 *1.575*	0	PB	1,3 *2.870*
M40352C220	00057605	G5	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	250,0 *9.843*	220,0 *8.661*	25,0 *0.984*	41,0 *1.614*	200,0 *7.874*	155,0 *6.102*	45,0 *1.772*	0	PB	2,01 *4.430*

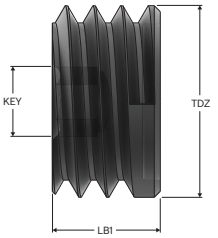
Ersatzteile, im Lieferumfang enthalten

Für Halter	Mitnehmer	Schraube
M40350C150	90M5	90F0
M40351C180	90M5	90F1
M40352C220	90M5	90F2

Zubehör

Für Halter	Spannschlüssel
M40350C150	03H02
M40351C180	03H02
M40352C220	03H025

HSK-Kühlmittelrohr, Süannschlüssel und Verschlussstopfen



—HSK-A-Seco Capto™-Aufnahmen werden mit einem speziellen Kühlmittelrohr als Ersatzteil geliefert und benötigen einen speziellen Schlüssel, siehe Produktseite(n) 632, 633-634

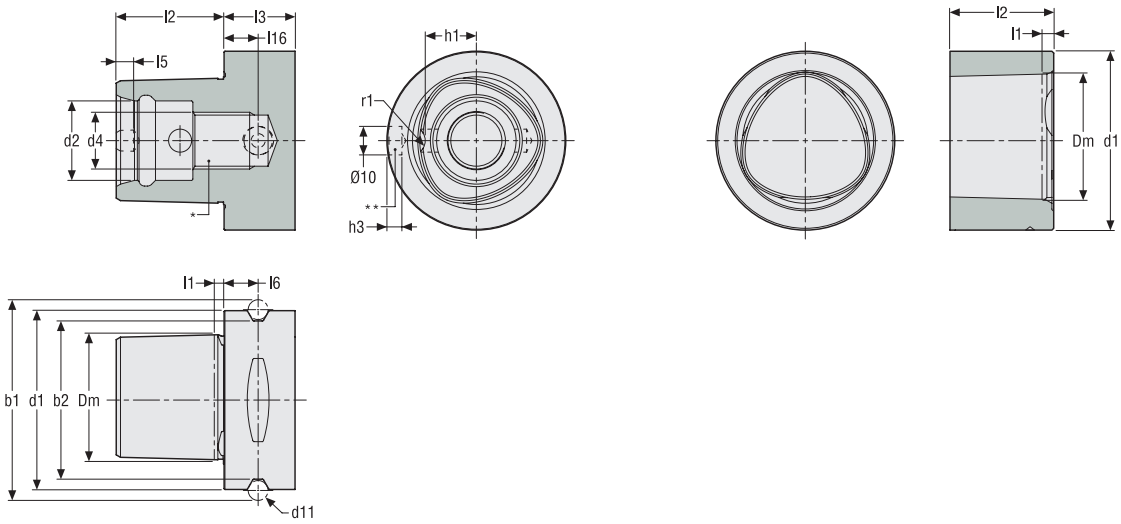
Beschreibung	Bezeichnung	Produktnummer	Für Aufnahmen HSK A und E	LB1	LB2	KEY	CNT	TDZ	BHTA°
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm		
Kühlmittelrohr (1)*	20E9301	00088814	HSK-A32 & HSK-E32	5,5 *0.217*	20,5 *0.807*	–	6	M10x1	1,0
	20E9302	00088815	HSK-A40 & HSK-E40	7,5 *0.295*	22,0 *0.866*	–	8	M12x1	1,0
	20E9303	00086740	HSK-A50 & HSK-E50	9,5 *0.374*	23,5 *0.925*	–	6	M16x1	1,0
	20E9304	00086741	HSK-A63 & HSK-E63	11,5 *0.453*	25,0 *0.984*	–	8	M18x1	1,0
	20E9306	00086742	HSK-A100 & HSK-E100	15,5 *0.610*	28,5 *1.122*	–	6	M24x1,5	1,0
	20E9307	00088816	HSK-A125	17,5 *0.689*	30,5 *1.201*	–	18	M30x1.5	1,0
Kühlmittelrohrspannschlüssel (2)	03E9301	00088811	HSK-A32 & HSK-E32	–	–	–	–	–	–
	03E9302	00088812	HSK-A40 & HSK-E40	–	–	–	–	–	–
	03E9303	00069969	HSK-A50 & HSK-E50	–	–	–	–	–	–
	03E9304	00069970	HSK-A63 & HSK-E63	–	–	–	–	–	–
	03E9305	00032296	HSK-A80 & HSK-E80	–	–	–	–	–	–
	03E9306	00084012	HSK-A100 & HSK-E100	–	–	–	–	–	–
	5680094-07	03248614	HSK-A125	–	–	–	–	–	–
Verschlussstopfen (3)	02E9301	00031588	HSK-A32 & HSK-E32	5,0 *0.197*	–	3,0 *0.118*	–	M10x1	–
	02E9302	00031593	HSK-A40 & HSK-E40	7,0 *0.276*	–	4,0 *0.157*	–	M12x1	–
	02E9303	00001002	HSK-A50 & HSK-E50	9,0 *0.354*	–	5,0 *0.197*	–	M16x1	–
	02E9304	00010101	HSK-A63 & HSK-E63	11,0 *0.433*	–	6,0 *0.236*	–	M18x1	–
	02E9306	00014002	HSK-A100 & HSK-E100	15,0 *0.591*	–	10,0 *0.394*	–	M24x1,5	–
	02E9307	00033649	HSK-A125	17,0 *0.669*	–	12,0 *0.472*	–	M30x1.5	–

Seco Capto™

Seco Capto™ ist ein modulares Schnellwechsel-Werkzeugsystem für alle Werkzeugmaschinen. Das modulare Seco Capto™ Werkzeugsystem verwendet PSC (Polygonale Schaft-) Kupplungen, gemäß ISO 26623 und verfügt über einen selbsthemmenden Kegel.

— Werkzeugaufnahmen, wie Schrumpfaufnahmen, Spannzangenfutter und Aufsteckfräser
— Seco Capto™ Basis-Aufnahmen mit Anschluss HSK, DIN, BT

Seco Capto™, Normabmessungen
ISO 26623-1-PSC/ ISO 26623-2-PSC



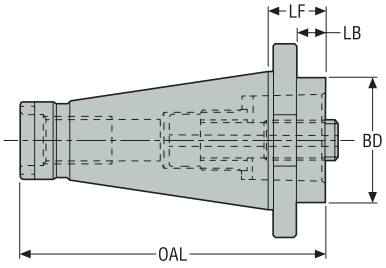
Maschinen-seite	RFID-Boh-rung**	d_1	d_2	d_4	d_{11}	Dm	b_1	b_2	l_1	l_2	$l_{3\,min}$	l_5	l_6	l_{16}	h_1	h_3	r_1
		mm *Zoll*	mm *Zoll*		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
C3	Nein**	32 *1.260*	15 *0.591*	M12	5 *0.197*	22 *0.866*	39 *1.535*	28,3 *1.114*	2,5 *0.098*	19 *0.748*	15 *0.591*	3,2 *0.126*	6 *0.236*	9 *0.354*	9 *0.354*	5,4 *0.213*	3 *0.118*
C4	Nein**	40 *1.575*	18 *0.709*	M14	5 *0.197*	28 *1.102*	46 *1.811*	35,3 *1.390*	2,5 *0.098*	24 *0.945*	20 *0.787*	4 *0.157*	8 *0.315*	12 *0.472*	11 *0.433*	5,2 *0.205*	3 *0.118*
C5	**	50 *1.969*	21 *0.827*	M16	7 *0.276*	35 *1.378*	59,3 *2.335*	44,4 *1.748*	3 *0.118*	30 *1.181*	20 *0.787*	5,3 *0.209*	10 *0.394*	12 *0.472*	14 *0.551*	5,1 *0.201*	4 *0.157*
C6	**	63 *2.480*	28 *1.102*	M20	7 *0.276*	44 *1.732*	70,7 *2.783*	55,8 *2.197*	3 *0.118*	38 *1.496*	22 *0.866*	6,2 *0.244*	12 *0.472*	12 *0.472*	18 *0.709*	5 *0.197*	5 *0.197*
C8	**	80 *3.150*	32 *1.260*	M20	7 *0.276*	55 *2.165*	86 *3.386*	71,1 *2.799*	3 *0.118*	48 *1.890*	30 *1.181*	8 *0.315*	12 *0.472*	12 *0.472*	22,2 *0.874*	4,9 *0.193*	6 *0.236*

Werkstückseite	RFID-Boh-rung**	$d_{1\,min}$	d_3	Dm	l_1	l_2	l_3	l_4
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
C3	Nein	32 *1.260*	2 *0.079*	22 *0.866*	2,3 *0.091*	18,4 *0.724*	16,5 *0.650*	9,4 *0.370*
C4	Nein	40 *1.575*	2,5 *0.098*	28 *1.102*	2,3 *0.091*	23,4 *0.921*	21 *0.827*	11,5 *0.453*
C5	Nein	50 *1.969*	3 *0.118*	35 *1.378*	2,8 *0.110*	29,4 *1.157*	26 *1.024*	14,5 *0.571*
C6	**	63 *2.480*	4 *0.157*	44 *1.732*	2,8 *0.110*	37,4 *1.472*	33,5 *1.319*	18,5 *0.728*
C8	**	80 *3.150*	5 *0.197*	55 *2.165*	2,8 *0.110*	47,4 *1.866*	43 *1.693*	22,8 *0.898*

Hinweis: Diese maschinenseitigen und werkstückseitigen Abmessungen gelten für alle Halter auf den Produktseiten.
* Die Maschinenseite von kurzen Seco Capto™ Verlängerungen kann nur von Spindeln mit Segment-Klemmung gehalten werden (nicht mittels Zentralschrauben-Klemmung). Die Maschinenseite von kurzen Seco Capto™ Reduzierstücken kann nur von Spindeln mit Segment-Klemmung gehalten werden (nicht mittels Zentralschrauben-Klemmung).
** Ob eine Bohrung für einen RFID-Datenträger vorhanden ist, können Sie der Spalte „RFID-Bohrung" auf den Produktseiten entnehmen: 1 = Bohrung für RFID-Datenträger erhältlich, falls erforderlich, kann ein Datenträger auf Anfrage montiert werden. Bitte anfragen.
0 = Eine Bohrung für einen RFID-Datenträger ist nicht verfügbar. Wenn erforderlich, kann eine Bohrung für einen RFID-Datenträger vorgenommen werden und ein Datenträger kann auf Anfrage montiert werden.

C 00 – DIN 2080-auf-Seco Capto™-Aufnahmen – ISO 26623-2

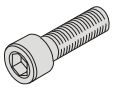
DIN 2080



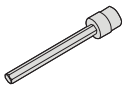
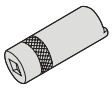
Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-390.00-40030	75039844	DIN(2080)40	C3	30,0 *1.181*	18,4 *0.724*	32,0 *1.260*	123,4 *4.858*	0	–	0,9 *1.980*
C4-390.00-40030	75039848	DIN(2080)40	C4	30,0 *1.181*	18,4 *0.724*	40,0 *1.575*	123,4 *4.858*	0	–	1,0 *2.200*
C4-390.00-40060	75039849	DIN(2080)40	C4	60,0 *2.362*	48,4 *1.906*	40,0 *1.575*	153,4 *6.039*	0	–	1,08 *2.380*
C5-390.00-40030	75039852	DIN(2080)40	C5	30,0 *1.181*	18,4 *0.724*	50,0 *1.969*	123,4 *4.858*	0	–	0,81 *1.790*
C6-390.00-40075	00048158	DIN(2080)40	C6	75,0 *2.953*	0,0 –	63,0 *2.480*	168,4 *6.630*	0	–	1,82 *4.010*
C3-390.00-50030	75039846	DIN(2080)50	C3	30,0 *1.181*	14,8 *0.583*	32,0 *1.260*	156,8 *6.173*	0	–	2,5 *5.510*
C3-390.00-50060	75039847	DIN(2080)50	C3	60,0 *2.362*	44,8 *1.764*	32,0 *1.260*	186,8 *7.354*	0	–	2,5 *5.510*
C4-390.00-50030	75039850	DIN(2080)50	C4	30,0 *1.181*	14,8 *0.583*	40,0 *1.575*	156,8 *6.173*	0	–	2,5 *5.510*
C4-390.00-50060	75039851	DIN(2080)50	C4	60,0 *2.362*	44,8 *1.764*	40,0 *1.575*	186,8 *7.354*	0	–	2,5 *5.510*
C5-390.00-50030	75039854	DIN(2080)50	C5	30,0 *1.181*	14,8 *0.583*	50,0 *1.969*	156,8 *6.173*	0	–	2,62 *5.780*
C5-390.00-50070	75039855	DIN(2080)50	C5	70,0 *2.756*	54,8 *2.157*	50,0 *1.969*	196,8 *7.748*	0	–	3,29 *7.250*
C6-390.00-50030	75039856	DIN(2080)50	C6	30,0 *1.181*	14,8 *0.583*	63,0 *2.480*	156,8 *6.173*	0	–	2,56 *5.640*
C6-390.00-50080	75039857	DIN(2080)50	C6	80,0 *3.150*	64,8 *2.551*	63,0 *2.480*	206,8 *8.142*	0	–	3,27 *7.210*
C8-390.00-50070	75039858	DIN(2080)50	C8	70,0 *2.756*	54,8 *2.157*	80,0 *3.150*	196,8 *7.748*	0	–	3,8 *8.380*
C8-390.00-50120	75039859	DIN(2080)50	C8	120,0 *4.724*	104,8 *4.126*	80,0 *3.150*	246,8 *9.717*	0	–	5,6 *12.350*

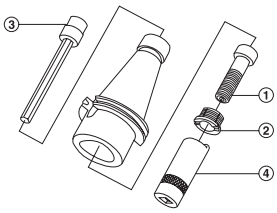
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrumsschraube	Sicherungsmutter
		
C3	5512063-10	5512091-04
C4	5512063-07	5512091-03
C5	5512063-08	5512091-01
C6-400	5512063-13	5512091-02
C6-500	5512063-09	5512091-02
C8	5512063-09	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C3	5680015-05	5680065-13
C4	5680015-05	5680065-10
C5	5680015-01	5680065-11
C6-400	5680015-01	5680065-12
C6-500	5680015-02	5680065-12
C8	5680015-02	5680065-12

Zubehör / Ersatzteile

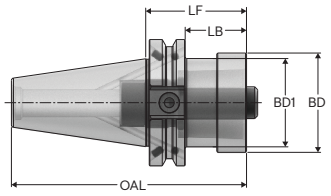


Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter

C 55/58 – CAT-auf-Seco Capto™-Aufnahmen

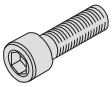
CAT / ASME B5.50-2009-ADB



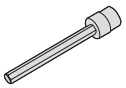
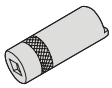
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuchtung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*				lbs
C3-A390B.45-40060	02925929	CAT40 ADB	C3	2.362	1.610	1.260	5.055	2	0	PB	2.200
C4-A390B.45-40030	02925932	CAT40 ADB	C4	1.181	0.429	1.575	3.874	2	0	PB	1.980
C4-A390B.45-40060	02925933	CAT40 ADB	C4	2.362	1.610	1.575	5.055	2	0	PB	2.430
C5-A390B.45-40040	02925935	CAT40 ADB	C5	1.575	0.823	1.969	4.268	2	0	PB	2.200
C5-A390B.45-40080	02925936	CAT40 ADB	C5	3.150	2.398	1.969	5.843	2	0	PB	3.310
C6-A390B.45-40085	02925939	CAT40 ADB	C6	3.346	1.378	2.480	6.039	2	0	PB	4.190
C3-A390B.45-50030	02925930	CAT50 ADB	C3	1.181	0.429	1.260	5.185	2	0	PB	6.390
C3-A390B.45-50060	02925931	CAT50 ADB	C3	2.362	1.610	1.260	6.366	2	0	PB	5.970
C4-A390B.45-50030	02925948	CAT50 ADB	C4	1.181	0.429	1.575	5.185	2	0	PB	5.780
C4-A390B.45-50060	02925934	CAT50 ADB	C4	2.362	1.610	1.969	6.366	2	0	PB	6.610
C5-A390B.45-50030	02925937	CAT50 ADB	C5	1.181	0.429	1.969	5.185	2	0	PB	5.510
C5-A390B.45-50070	02925938	CAT50 ADB	C5	2.756	2.004	1.969	6.760	2	0	PB	6.610
C6-A390B.45-50030	02925940	CAT50 ADB	C6	1.181	0.429	2.480	5.185	2	0	PB	5.510
C6-A390B.45-50080	02925941	CAT50 ADB	C6	3.150	2.398	2.480	7.154	2	0	PB	7.940
C8-A390B.45-50070	02925942	CAT50 ADB	C8	2.756	2.004	3.150	6.760	2	0	PB	7.940
C8-A390B.45-50120	02925943	CAT50 ADB	C8	4.724	3.972	3.150	8.728	2	0	PB	12.350

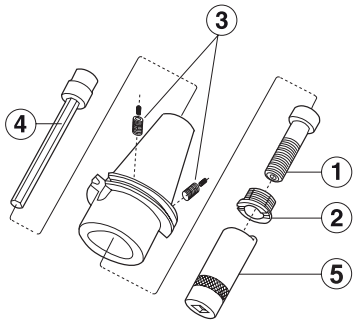
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrumsschraube	Dichtschraube	Sicherungsmutter	Dichtstopfen
				
CAT40/ C3	5512063-10	564301701	5512091-04	–
CAT40/ C4	5512063-07	564301701	5512091-03	–
CAT40/ C5	5512063-08	564301701	5512091-01	–
CAT40/ C6	5512063-13	564301701	5512091-02	–
CAT50/ C3	5512063-10	564301702	5512091-04	–
CAT50/ C4-50030	5512063-07	564301701	5512091-03	564301702
CAT50/ C4-50060	5512063-07	564301702	5512091-03	–
CAT50/ C5	5512063-08	564301702	5512091-01	–
CAT50/ C6	5512063-09	564301702	5512091-02	–
CAT50/ C8	5512063-09	564301702	5512091-02	–

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
CAT40/ C3	5680015-05	5680065-13
CAT40/ C4	5680015-05	5680065-10
CAT40/ C5	5680015-01	5680065-11
CAT40/ C6	5680015-01	5680065-12
CAT50/ C3	5680015-05	5680065-13
CAT50/ C4-50030	5680015-05	5680065-10
CAT50/ C4-50060	5680015-05	5680065-10
CAT50/ C5	5680015-01	5680065-11
CAT50/ C6	5680015-02	5680065-12
CAT50/ C8	5680015-02	5680065-12

Zubehör / Ersatzteile



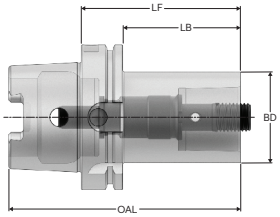
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter
3 = Dichtstopfen

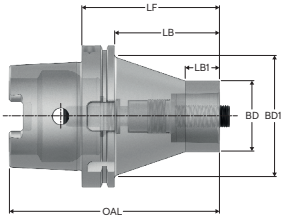
C 410 – HSK-A-Seco Capto™-Aufnahmen – ISO 26623-2

HSK-A/ ISO12164-1-HSK-A

Design 1



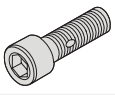
Design 2



Zubehör:
2 = Verlängerungsschlüssel
4 = Spannschlüssel
6 = Schlüssel für Kühlmittelrohr

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Abb.	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
HA10-C3-032-080	10197961	HSK-A100	C3	80,0 *3.150*	51,0 *2.008*	–	32,0 *1.260*	–	130,0 *5.118*	1	1	PB	2,5 *5.510*
HA06-C3-032-075	10197962	HSK-A63	C3	75,0 *2.953*	49,0 *1.929*	–	32,0 *1.260*	–	107,0 *4.213*	1	1	PB	0,9 *1.980*
HA10-C4-040-090	10197963	HSK-A100	C4	90,0 *3.543*	61,0 *2.402*	–	40,0 *1.575*	–	140,0 *5.512*	1	1	PB	2,5 *5.510*
HA06-C4-040-080	10197964	HSK-A63	C4	80,0 *3.150*	54,0 *2.126*	–	40,0 *1.575*	–	112,0 *4.409*	1	1	PB	1,1 *2.430*
HA10-C5-050-100	10197965	HSK-A100	C5	100,0 *3.937*	71,0 *2.795*	–	50,0 *1.969*	–	150,0 *5.906*	1	1	PB	2,9 *6.390*
HA06-C5-050-090	10197966	HSK-A63	C5	90,0 *3.543*	64,0 *2.520*	–	50,0 *1.969*	–	122,0 *4.803*	1	1	PB	1,3 *2.870*
HA10-C6-063-110	10197967	HSK-A100	C6	110,0 *4.331*	81,0 *3.189*	–	63,0 *2.480*	–	160,0 *6.299*	1	1	PB	3,6 *7.940*
HA10-C8-080-120	10197968	HSK-A100	C8	120,0 *4.724*	91,0 *3.583*	–	80,0 *3.150*	–	170,0 *6.693*	1	1	PB	4,8 *10.580*
HSKA125-C6-120	03229625	HSK-A125	C6	120,0 *4.724*	91,0 *3.583*	–	63,0 *2.480*	–	183,0 *7.205*	1	1	PB	5,2 *11.460*
HSKA125-C6-120-V	03229626	HSK-A125	C6	120,0 *4.724*	91,0 *3.583*	30,0 *1.181*	63,0 *2.480*	108,0 *4.252*	183,0 *7.205*	2	1	PB	6,4 *14.110*
HSKA125-C8-130	03229627	HSK-A125	C8	130,0 *5.118*	101,0 *3.976*	–	80,0 *3.150*	–	193,0 *7.598*	1	1	PB	6,5 *14.330*
HSKA125-C8-130-V	03229628	HSK-A125	C8	130,0 *5.118*	101,0 *3.976*	30,0 *1.181*	80,0 *3.150*	105,0 *4.134*	193,0 *7.598*	2	1	PB	7,8 *17.200*

Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrumsschraube	Kühlmittelrohr	Sicherungsmutter
			
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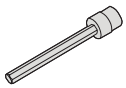
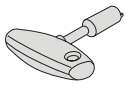
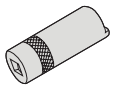
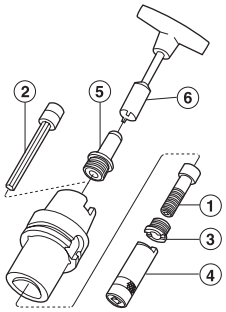
HA06-C4-040-080	5512067-02	5692020-04	5512091-03
HA06-C5-050-090	5512067-03	5692020-04	5512091-01
HA10-C3-032-080	5512067-01	5692020-06	5512091-04
HA10-C4-040-090	5512067-02	5692020-06	5512091-03
HA10-C5-050-100	5512067-03	5692020-06	5512091-01
HA10-C6-063-110	5512067-04	5692020-06	5512091-02
HA10-C8-080-120	5512067-04	5692020-06	5512091-02
HSKA125-C6-120	5512063-09	5692020-07	5512091-02
HSKA125-C6-120-V	5512063-09	5692020-07	5512091-02
HSKA125-C8-130	5512063-09	5692020-07	5512091-02
HSKA125-C8-130-V	5512063-09	5692020-07	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Schlüssel	Spannschlüssel
			
HA06-C3-032-075	5680015-05	5680094-04	5680065-13
HA06-C4-040-080	5680015-05	5680094-04	5680065-10
HA06-C5-050-090	5680015-01	5680094-04	5680065-11
HA10-C3-032-080	5680015-05	5680094-06	5680065-13
HA10-C4-040-090	5680015-05	5680094-06	5680065-10
HA10-C5-050-100	5680015-01	5680094-06	5680065-11
HA10-C6-063-110	5680015-02	5680094-06	5680065-12
HA10-C8-080-120	5680015-02	5680094-06	5680065-12
HSKA125-C6-120	5680015-02	5680094-07	5680065-12
HSKA125-C6-120-V	5680015-02	5680094-07	5680065-12
HSKA125-C8-130	5680015-02	5680094-07	5680065-12
HSKA125-C8-130-V	5680015-02	5680094-07	5680065-12

Zubehör / Ersatzteile



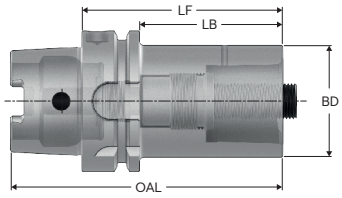
Zubehör:
2 = Verlängerungsschlüssel
4 = Spannschlüssel
6 = Schlüssel für Kühlmittelrohr

Ersatzteile:
1 = Zentrumschraube
3 = Sicherungsmutter
5 = Kühlmittelrohr*

*Ein spezielles Kühlmittelrohr wird zusammen mit den HSK-A-Seco Capto™-Aufnahmen geliefert.

C 411 – HSK-T auf Seco Capto™-Aufnahmen – ISO 26623-2

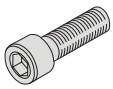
HSK-T/ ISO12164-3-HSK-T



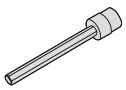
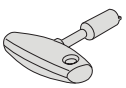
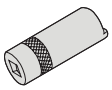
Zubehör:
2 = Verlängerungsschlüssel
4 = Spannschlüssel
6 = Schlüssel für Kühlmittelrohr

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C4-390.411-63080	02786511	HSK-T63	C4	80,0 *3.150*	54,0 *2.126*	40,0 *1.575*	112,0 *4.409*	1	–	1,1 *2.430*
C5-390.411-63090	02786520	HSK-T63	C5	90,0 *3.543*	64,0 *2.520*	50,0 *1.969*	122,0 *4.803*	1	–	1,5 *3.310*
C4-390.411-100090	02786519	HSK-T100	C4	90,0 *3.543*	61,0 *2.402*	40,0 *1.575*	140,0 *5.512*	1	–	2,6 *5.730*
C5-390.411-100100	02786521	HSK-T100	C5	100,0 *3.937*	71,0 *2.795*	50,0 *1.969*	150,0 *5.906*	1	–	3,0 *6.610*
C6-390.411-100110	02786522	HSK-T100	C6	110,0 *4.331*	81,0 *3.189*	63,0 *2.480*	160,0 *6.299*	1	–	3,6 *7.940*
C8-390.411-100120	02786523	HSK-T100	C8	120,0 *4.724*	91,0 *3.583*	80,0 *3.150*	170,0 *6.693*	1	–	4,8 *10.580*

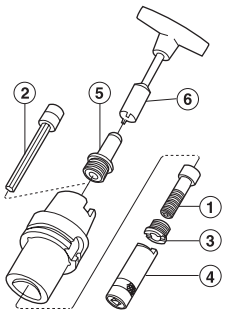
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrumsschraube	Kühlmittelrohr	Sicherungsmutter
			
C4-390.411-100090	5512063-07	20E9306	5512091-03
C4-390.411-63080	5512063-07	5692020-04	5512091-03
C5-390.411-100100	5512063-08	20E9306	5512091-01
C5-390.411-63090	5512063-08	5692020-04	5512091-01
C6-390.411-100110	5512063-09	5692020-06	5512091-02
C8-390.411-100120	5512063-09	5692020-06	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Schlüssel	Spannschlüssel
			
C4-390.411-100090	5680015-05	5680094-06	5680065-10
C4-390.411-63080	5680015-05	5680094-04	5680065-10
C5-390.411-100100	5680015-01	5680094-06	5680065-11
C5-390.411-63090	5680015-01	5680094-04	5680065-11
C6-390.411-100110	5680015-02	5680094-06	5680065-12
C8-390.411-100120	5680015-02	5680094-06	5680065-12

Zubehör / Ersatzteile



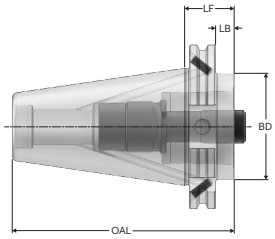
Zubehör:
2 = Verlängerungsschlüssel
4 = Spannschlüssel
6 = Schlüssel für Kühlmittelrohr

Ersatzteile:
1 = Zentrumschraube
3 = Sicherungsmutter
5 = Kühlmittelrohr*

*Ein spezielles Kühlmittelrohr wird zusammen mit den HSK-A-Seco Capto™-Aufnahmen geliefert.

C 140 – DIN-auf-Seco Capto™-Aufnahmen – ISO 26623-2

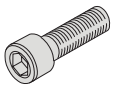
DIN 69871-ADB



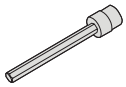
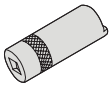
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-390B.140-40030	02924104	DIN40 ADB	C3	30,0 *1.181*	10,9 *0.429*	32,0 *1.260*	98,4 *3.874*	0	PB	0,8 *1.760*
C3-390B.140-40060	02924105	DIN40 ADB	C3	60,0 *2.362*	40,9 *1.610*	32,0 *1.260*	128,4 *5.055*	0	PB	0,9 *1.980*
C4-390B.140-40030	02924108	DIN40 ADB	C4	30,0 *1.181*	10,9 *0.429*	40,0 *1.575*	98,4 *3.874*	0	PB	0,8 *1.760*
C4-390B.140-40060	02924109	DIN40 ADB	C4	60,0 *2.362*	40,9 *1.610*	40,0 *1.575*	128,4 *5.055*	0	PB	1,1 *2.430*
C5-390B.140-40040	02924112	DIN40 ADB	C5	40,0 *1.575*	20,9 *0.823*	50,0 *1.969*	108,4 *4.268*	0	PB	0,9 *1.980*
C5-390B.140-40080	02924113	DIN40 ADB	C5	80,0 *3.150*	60,9 *2.398*	50,0 *1.969*	148,4 *5.843*	0	PB	1,5 *3.310*
C6-390B.140-40085	02924116	DIN40 ADB	C6	85,0 *3.346*	65,9 *2.594*	63,0 *2.480*	153,4 *6.039*	0	PB	1,8 *3.970*
C3-390B.140-50030	02924106	DIN50 ADB	C3	30,0 *1.181*	10,9 *0.429*	32,0 *1.260*	131,7 *5.185*	0	PB	2,6 *5.730*
C3-390B.140-50060	02924107	DIN50 ADB	C3	60,0 *2.362*	40,9 *1.610*	32,0 *1.260*	161,7 *6.366*	0	PB	2,7 *5.950*
C4-390B.140-50030	02924110	DIN50 ADB	C4	30,0 *1.181*	10,9 *0.429*	40,0 *1.575*	131,7 *5.185*	0	PB	2,6 *5.730*
C4-390B.140-50060	02924111	DIN50 ADB	C4	60,0 *2.362*	40,9 *1.610*	40,0 *1.575*	161,7 *6.366*	0	PB	2,8 *6.170*
C5-390B.140-50030	02924114	DIN50 ADB	C5	30,0 *1.181*	10,9 *0.429*	50,0 *1.969*	131,7 *5.185*	0	PB	2,6 *5.730*
C5-390B.140-50070	02924115	DIN50 ADB	C5	70,0 *2.756*	50,9 *2.004*	50,0 *1.969*	171,7 *6.760*	0	PB	3,1 *6.830*
C6-390B.140-50030	02924117	DIN50 ADB	C6	30,0 *1.181*	10,9 *0.429*	63,0 *2.480*	131,7 *5.185*	0	PB	2,4 *5.290*
C6-390B.140-50080	02924118	DIN50 ADB	C6	80,0 *3.150*	60,9 *2.398*	63,0 *2.480*	181,7 *7.154*	0	PB	3,6 *7.940*
C8-390B.140-50070	02924119	DIN50 ADB	C8	70,0 *2.756*	50,9 *2.004*	80,0 *3.150*	171,7 *6.760*	0	PB	3,7 *8.160*
C8-390B.140-50120	02924120	DIN50 ADB	C8	120,0 *4.724*	100,9 *3.972*	80,0 *3.150*	221,7 *8.728*	0	PB	5,5 *12.130*

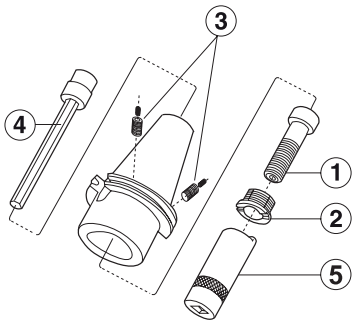
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Dichtschraube	Sicherungsmutter
			
C3-400	5512063-10	564301701	5512091-04
C3-500	5512063-10	564301702	5512091-04
C4-400	5512063-07	564301701	5512091-03
C4-500	5512063-07	564301702	5512091-03
C5-400	5512063-08	564301701	5512091-01
C5-500	5512063-08	564301702	5512091-01
C6-400	5512063-13	564301701	5512091-02
C6-500	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C3-400	5680015-05	5680065-13
C3-500	5680015-05	5680065-13
C4-400	5680015-05	5680065-10
C4-500	5680015-05	5680065-10
C5-400	5680015-01	5680065-11
C5-500	5680015-01	5680065-11
C6-400	5680015-01	5680065-12
C6-500	5680015-02	5680065-12
C8	5680015-02	5680065-12

Zubehör / Ersatzteile



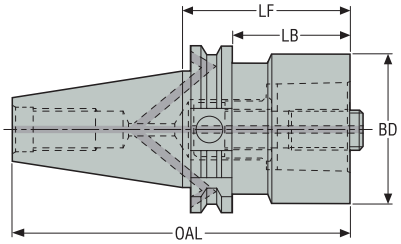
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter
3 = Dichtstopfen

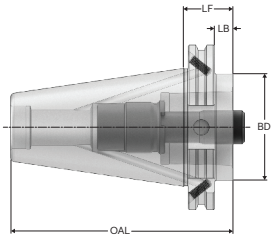
C 5191 – Seco Capto™-Grundaufnahmen – ISO 26623-2

DIN-Steilkegel-Aufnahmen-ADB

Design 1



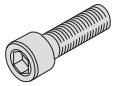
Design 2



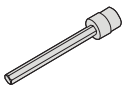
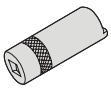
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
E316951915050	03030258	DIN40 TF ADB	C5	50,0 *1.969*	30,9 *1.217*	50,0 *1.969*	118,4 *4.661*	1	PB	1,1 *2.430*
E317151915070	03030264	DIN50 TF ADB	C5	70,0 *2.756*	50,9 *2.004*	50,0 *1.969*	171,7 *6.760*	1	PB	3,1 *6.830*
E317151916350	03030262	DIN50 TF ADB	C6	50,0 *1.969*	30,9 *1.217*	63,0 *2.480*	151,7 *5.972*	0	–	2,9 *6.390*
E3171519163100	03030265	DIN50 TF ADB	C6	100,0 *3.937*	80,9 *3.185*	63,0 *2.480*	201,7 *7.941*	1	PB	4,1 *9.040*
E317151918070	03030263	DIN50 TF ADB	C8	70,0 *2.756*	50,9 *2.004*	80,0 *3.150*	171,7 *6.760*	0	–	3,9 *8.600*
E3171519180120	03030266	DIN50 TF ADB	C8	120,0 *4.724*	100,9 *3.972*	80,0 *3.150*	221,7 *8.728*	0	–	5,6 *12.350*

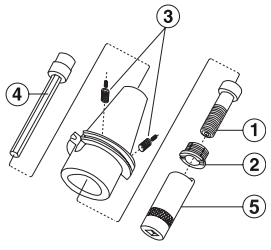
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Dichtschraube	Sicherungsmutter
			
DIN40 TF/ C5	5512063-08	564301701	5512091-01
DIN50 TF/ C5	5512063-08	564301702	5512091-01
DIN50 TF/ C6-C8	5512063-09	564301702	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
DIN40 TF/ C5	5680015-01	5680065-11
DIN50 TF/ C5	5680015-01	5680065-11
DIN50 TF/ C6-C8	5680015-02	5680065-12

Zubehör / Ersatzteile



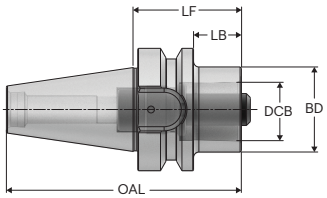
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter
3 = Dichtstopfen

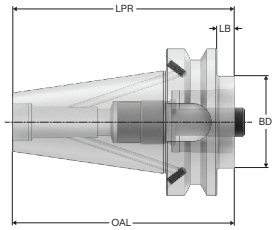
C 55/58 – BT-auf-Seco Capto™-Aufnahmen – ISO 26623-2

BT

Design 1



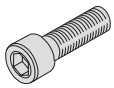
Design 2



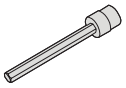
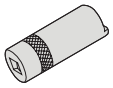
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-390.55-30030	75039807	BT30 AD	C3	30,0 *1.181*	8,0 *0.315*	32,0 *1.260*	78,4 *3.087*	0	PB	0,53 *1.170*
C3-390.55-30060	75039808	BT30 AD	C3	60,0 *2.362*	38,0 *1.496*	32,0 *1.260*	108,4 *4.268*	0	PB	0,73 *1.610*
C3-390B.55-40030	02925959	BT40 ADB	C3	30,0 *1.181*	3,0 *0.118*	32,0 *1.260*	95,4 *3.756*	0	PB	1,0 *2.200*
C3-390B.55-40060	02925960	BT40 ADB	C3	60,0 *2.362*	33,0 *1.299*	32,0 *1.260*	125,4 *4.937*	0	PB	1,1 *2.430*
C4-390B.55-40030	02925963	BT40 ADB	C4	30,0 *1.181*	3,0 *0.118*	40,0 *1.575*	95,4 *3.756*	0	PB	0,9 *1.980*
C4-390B.55-40060	02925964	BT40 ADB	C4	60,0 *2.362*	33,0 *1.299*	40,0 *1.575*	125,4 *4.937*	0	PB	1,2 *2.650*
C5-390B.55-40050	02925967	BT40 ADB	C5	50,0 *1.969*	23,0 *0.906*	50,0 *1.969*	115,4 *4.543*	0	PB	1,1 *2.430*
C5-390B.55-40090	02925968	BT40 ADB	C5	90,0 *3.543*	63,0 *2.480*	50,0 *1.969*	155,4 *6.118*	0	PB	1,7 *3.750*
C6-390B.55-40075	02925971	BT40 ADB	C6	75,0 *2.953*	54,6 *2.150*	63,0 *2.480*	140,4 *5.528*	0	PB	1,7 *3.750*
C3-390B.58-50040	02925961	BT50 ADB	C3	40,0 *1.575*	2,0 *0.079*	32,0 *1.260*	141,8 *5.583*	0	PB	3,5 *7.720*
C3-390B.58-50070	02925962	BT50 ADB	C3	70,0 *2.756*	32,0 *1.260*	32,0 *1.260*	171,8 *6.764*	0	PB	3,7 *8.160*
C4-390B.58-50040	02925965	BT50 ADB	C4	40,0 *1.575*	2,0 *0.079*	40,0 *1.575*	141,8 *5.583*	0	PB	3,5 *7.720*
C4-390B.58-50070	02925966	BT50 ADB	C4	70,0 *2.756*	32,0 *1.260*	40,0 *1.575*	171,8 *6.764*	0	PB	3,8 *8.380*
C5-390B.58-50040	02925969	BT50 ADB	C5	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	0	PB	3,4 *7.500*
C5-390B.58-50080	02925970	BT50 ADB	C5	80,0 *3.150*	42,0 *1.654*	50,0 *1.969*	181,8 *7.157*	0	PB	3,9 *8.600*
C6-390B.58-50050	02925972	BT50 ADB	C6	50,0 *1.969*	12,0 *0.472*	63,0 *2.480*	151,8 *5.976*	0	PB	3,5 *7.720*
C6-390B.58-50100	02925973	BT50 ADB	C6	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	201,8 *7.945*	0	PB	4,6 *10.140*
C8-390B.58-50070	02925974	BT50 ADB	C8	70,0 *2.756*	32,0 *1.260*	80,0 *3.150*	171,8 *6.764*	0	PB	4,0 *8.820*
C8-390B.58-50120	02925975	BT50 ADB	C8	120,0 *4.724*	82,0 *3.228*	80,0 *3.150*	221,8 *8.732*	0	PB	5,9 *13.010*

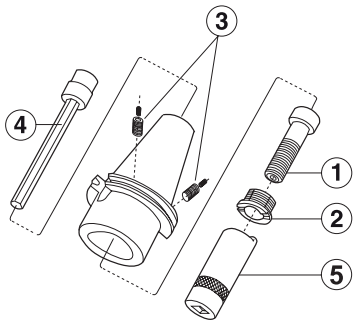
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Dichtschraube	Sicherungsmutter
			
C3-390.55	5512063-10	–	5512091-04
C3-390B.55	5512063-10	564301701	5512091-04
C3-390B.58	5512063-10	564301702	5512091-04
C4-390B.55	5512063-07	564301701	5512091-03
C4-390B.58	5512063-07	564301702	5512091-03
C5-390B.55	5512063-08	564301701	5512091-01
C5-390B.58	5512063-08	564301702	5512091-01
C6-390B.55	5512063-13	564301701	5512091-02
C6-390B.58	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C3-390.55	5680015-05	5680065-13
C3-390B.55	5680015-05	5680065-13
C3-390B.58	5680015-05	5680065-13
C4-390B.55	5680015-05	5680065-10
C4-390B.58	5680015-05	5680065-10
C5-390B.55	5680015-01	5680065-11
C5-390B.58	5680015-01	5680065-11
C6-390B.55	5680015-01	5680065-12
C6-390B.58	5680015-02	5680065-12
C8	5680015-02	5680065-12

Zubehör / Ersatzteile

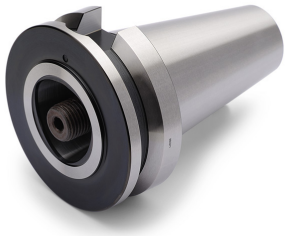


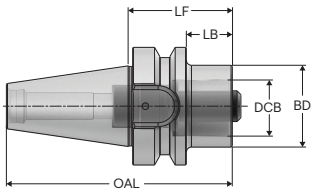
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 605 – BT-Mazak-auf-Seco Capto™-Aufnahmen – ISO 26623-2

BT Mazak



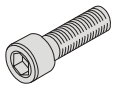


– Das Mazak-Design bedeutet, dass das Seco Capto™-Polygon im Vergleich zu herkömmlichen einfachen BT-Haltern um 90 ° gedreht ist
– Für Mazak E-Maschinen

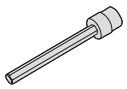
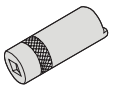
Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C5-390.605-40030	02606358	BT40 AD Mazak	C5	30,0 *1.181*	3,0 *0.118*	50,0 *1.969*	95,4 *3.756*	0	–	1,1 *2.430*
C6-390.605-50040	02606354	BT50 AD Mazak	C6	40,0 *1.575*	2,0 *0.079*	63,0 *2.480*	141,8 *5.583*	0	–	3,3 *7.280*
C8-390.605-50070	02646032	BT50 AD Mazak	C8	70,0 *2.756*	70,0 *2.756*	80,0 *3.150*	171,8 *6.764*	0	–	4,0 *8.820*

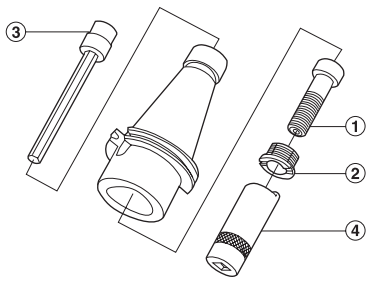
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Sicherungsmutter
		
C5	5512063-08	5512091-01
C6	5512063-09	5512091-02
C8	5512063-09	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C5	5680015-01	5680065-11
C6	5680015-02	5680065-12
C8	5680015-02	5680065-12

Zubehör / Ersatzteile



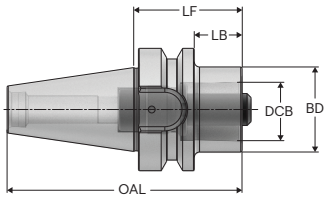
Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter

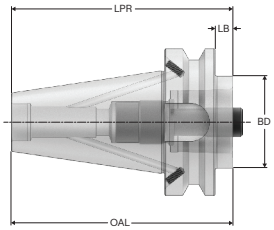
C 5191 – Seco Capto™-Grundaufnahmen – ISO 26623-2

BT-Steilkegel-Aufnahmen-AD/ADB

Design 1



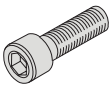
Design 2



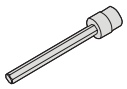
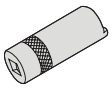
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
E400251913240	03030234	BT30 TF AD	C3	40,0 *1.575*	22,0 *0.866*	32,0 *1.260*	88,4 *3.480*	1	PB	0,454 *1.000*
E400251914060	03030235	BT30 TF AD	C4	60,0 *2.362*	22,0 *0.866*	40,0 *1.575*	108,4 *4.268*	1	PB	0,7 *1.540*
E311451914040	03030236	BT40 TF ADB	C4	40,0 *1.575*	13,0 *0.512*	40,0 *1.575*	105,4 *4.150*	0	PB	1,1 *2.430*
E311451915050	03030237	BT40 TF ADB	C5	50,0 *1.969*	23,0 *0.906*	50,0 *1.969*	115,4 *4.543*	0	PB	1,2 *2.650*
E311451916375	03030238	BT40 TF ADB	C6	75,0 *2.953*	48,0 *1.890*	63,0 *2.480*	140,4 *5.528*	0	PB	1,7 *3.750*
E311651914040	03030239	BT50 TF ADB	C4	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	1	PB	3,5 *7.720*
E311651915040	03030240	BT50 TF ADB	C5	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	0	PB	3,4 *7.500*
E311651916350	03030241	BT50 TF ADB	C6	50,0 *1.969*	12,0 *0.472*	63,0 *2.480*	151,8 *5.976*	0	PB	3,5 *7.720*
E3116519163100	03030242	BT50 TF ADB	C6	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	201,8 *7.945*	0	PB	4,8 *10.580*
E311651918070	03030243	BT50 TF ADB	C8	70,0 *2.756*	32,0 *1.260*	80,0 *3.150*	171,8 *6.764*	0	PB	4,0 *8.820*
E3116519180120	03030244	BT50 TF ADB	C8	120,0 *4.724*	82,0 *3.228*	80,0 *3.150*	121,8 *4.795*	1	PB	5,9 *13.010*

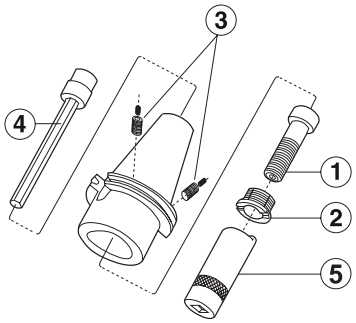
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Dichtschraube	Sicherungsmutter
			
BT30 TF/ C3	5512063-10	–	5512091-04
BT30 TF/ C4	5512063-07	–	5512091-03
BT40 TF/ C4	5512063-07	564301701	5512091-03
BT40 TF/ C5	5512063-08	564301701	5512091-01
BT40 TF/ C6	5512063-13	564301701	5512091-02
BT50 TF/ C4	5512063-07	564301702	5512091-03
BT50 TF/ C5	5512063-08	564301702	5512091-01
BT50 TF/ C6-C8	5512063-09	564301702	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
BT30 TF/ C3	5680015-05	5680065-13
BT30 TF/ C4	5680015-05	5680065-10
BT40 TF/ C4	5680015-05	5680065-10
BT40 TF/ C5	5680015-01	5680065-11
BT40 TF/ C6	5680015-01	5680065-12
BT50 TF/ C4	5680015-05	5680065-10
BT50 TF/ C5	5680015-01	5680065-11
BT50 TF/ C6-C8	5680015-02	5680065-12

Zubehör / Ersatzteile



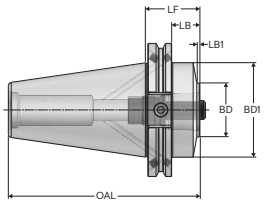
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter
3 = Dichtstopfen

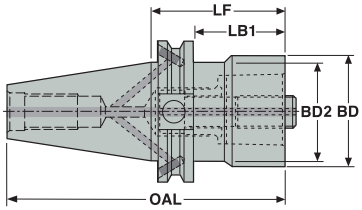
C 5191 – Seco Capto™-Grundaufnahmen

CAT Plananlage / ASME B5.50-1994-ADB

Design 1



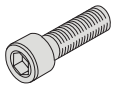
Design 2



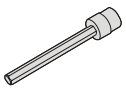
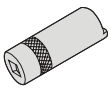
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Abb.	RFID-Bohrung	Auswuchtung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
E234251915050	03030247	CAT40 TF ADB	C5	1.969	1.220	1.220	1.969	1.750	4.660	2	1	PB	2.250
E234451914040	03030249	CAT50 TF ADB	C4	1.575	0.090	0.090	1.575	2.750	5.580	1	1	PB	6.830
E234451915040	03030250	CAT50 TF ADB	C5	1.575	0.090	0.090	1.969	2.750	5.580	1	0	-	6.610
E234451916340	03030251	CAT50 TF ADB	C6	1.575	0.120	0.120	2.480	2.750	5.580	1	0	-	6.170
E234451916390	03030252	CAT50 TF ADB	C6	3.543	2.085	2.085	2.480	2.750	7.543	1	0	-	8.600
E2344519180100	03030253	CAT50 TF ADB	C8	3.937	3.185	3.185	3.150	2.750	7.937	2	1	PB	10.140

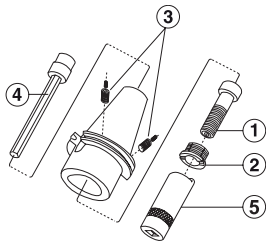
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Dichtschraube	Sicherungsmutter
			
CAT40/ C5	5512063-08	564301701	5512091-01
CAT50/ C4	5512063-07	564301702	5512091-03
CAT50/ C5	5512063-08	564301702	5512091-01
CAT50/ C6	5512063-09	564301702	5512091-02
CAT50/ C8	5512063-09	564301702	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
CAT40/ C5	5680015-01	5680065-11
CAT50/ C4	5680015-05	5680065-10
CAT50/ C5	5680015-01	5680065-11
CAT50/ C6	5680015-02	5680065-12
CAT50/ C8	5680015-02	5680065-12

Zubehör / Ersatzteile



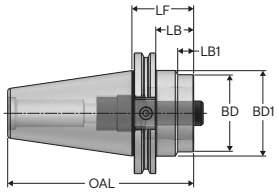
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 5191 – Seco Capto™-Grundaufnahmen

CAT TF Mazak™ e-Machine und Mori Seiki NT™ -Serie

Design 1

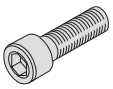


–90° rotiertes Polygon für präzise Kontrolle der Werkzeugschneide

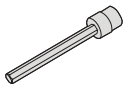
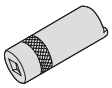
Zubehör:
4 = Verlängerungsschlüssel
5 = Spannschlüssel

Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
E947451916350	03030255	CAT50 TF AD Mazak	C6	1.969	0.510	0.510	2.480	2.750	5.960	1	0	PB	6.830

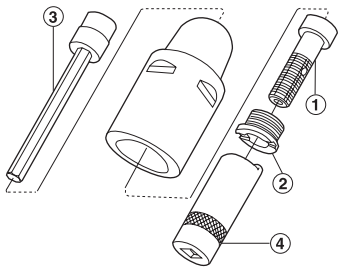
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Sicherungsmutter
		
E947451916350	5512063-09	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
E947451916350	5680015-02	5680065-12

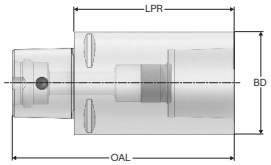
Zubehör / Ersatzteile



Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter

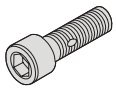
C 01 – Seco Capto™, Verlängerungen
ISO 26623-1



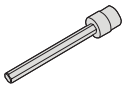
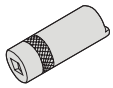
Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LPR	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-391.01-32060A	75039884	C3	C3	60,0 *2.362*	32,0 *1.260*	79,0 *3.110*	0	-	0,4 *0.880*
C3-391.01-32080A	00090847	C3	C3	80,0 *3.150*	32,0 *1.260*	99,0 *3.898*	0	-	0,5 *1.100*
C4-391.01-40060A	75039885	C4	C4	60,0 *2.362*	40,0 *1.575*	84,0 *3.307*	0	-	0,6 *1.320*
C4-391.01-40080A	02207391	C4	C4	80,0 *3.150*	40,0 *1.575*	104,0 *4.094*	0	-	0,8 *1.760*
C5-391.01-50080A	75039886	C5	C5	80,0 *3.150*	50,0 *1.969*	110,0 *4.331*	0	-	1,1 *2.430*
C5-391.01-50100A	00004773	C5	C5	100,0 *3.937*	50,0 *1.969*	130,0 *5.118*	0	-	1,4 *3.090*
C6-391.01-63100A	75039887	C6	C6	100,0 *3.937*	63,0 *2.480*	138,0 *5.433*	0	-	2,2 *4.850*
C6-391.01-63140A	00004840	C6	C6	140,0 *5.512*	63,0 *2.480*	178,0 *7.008*	0	-	3,1 *6.830*
C8-391.01-80100A	75039888	C8	C8	100,0 *3.937*	80,0 *3.150*	148,0 *5.827*	0	-	3,7 *8.160*
C8-391.01-80125A	00004841	C8	C8	125,0 *4.921*	80,0 *3.150*	173,0 *6.811*	0	-	4,6 *10.140*

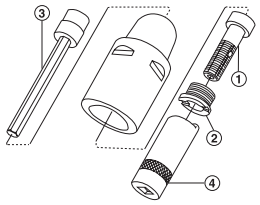
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Sicherungsmutter
		
C3	5512067-01	5512091-04
C4	5512067-02	5512091-03
C5	5512067-03	5512091-01
C6	5512067-04	5512091-02
C8	5512067-04	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C3	5680015-05	5680065-13
C4	5680015-05	5680065-10
C5	5680015-01	5680065-11
C6	5680015-02	5680065-12
C8	5680015-02	5680065-12

Zubehör / Ersatzteile



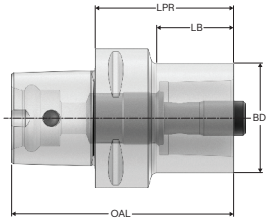
Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter

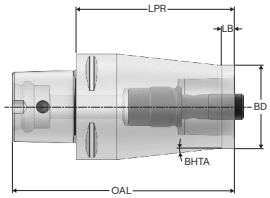
C 02 – Seco Capto™, Reduzierstücke

ISO 26623-1

Design 1



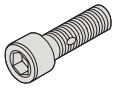
Design 2



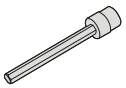
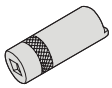
Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LPR	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C4-391.02-32055A	75039889	C4	C3	55,0 *2.165*	31,0 *1.220*	32,0 *1.260*	79,0 *3.110*	1	0	-	0,42 *0.930*
C4-391.02-32070A	02535687	C4	C3	70,0 *2.756*	–	32,0 *1.260*	94,0 *3.701*	2	0	-	0,56 *1.230*
C5-391.02-32060A	75039890	C5	C3	60,0 *2.362*	34,8 *1.370*	32,0 *1.260*	90,0 *3.543*	1	0	-	0,7 *1.540*
C5-391.02-40065A	75039891	C5	C4	65,0 *2.559*	40,0 *1.575*	40,0 *1.575*	95,0 *3.740*	1	0	-	0,8 *1.760*
C6-391.02-32070A	75039892	C6	C3	70,0 *2.756*	39,0 *1.535*	32,0 *1.260*	108,0 *4.252*	1	0	-	1,1 *2.430*
C6-391.02-40080A	75039893	C6	C4	80,0 *3.150*	51,4 *2.024*	40,0 *1.575*	118,0 *4.646*	1	0	-	1,2 *2.650*
C6-391.02-50080A	75039894	C6	C5	80,0 *3.150*	51,5 *2.028*	50,0 *1.969*	118,0 *4.646*	1	0	-	1,4 *3.090*
C6-391.02-50110A	02207400	C6	C5	110,0 *4.331*	12,0 *0.472*	50,0 *1.969*	148,0 *5.827*	2	0	-	2,2 *4.850*
C8-391.02-32060B	03080008	C8	C3	60,0 *2.362*	20,7 *0.815*	32,0 *1.260*	108,0 *4.252*	1	0	-	2,0 *4.410*
C8-391.02-40070B	03080009	C8	C4	70,0 *2.756*	31,4 *1.236*	40,0 *1.575*	118,0 *4.646*	1	0	-	2,1 *4.630*
C8-391.02-50080B	03080011	C8	C5	80,0 *3.150*	42,8 *1.685*	50,0 *1.969*	128,0 *5.039*	1	0	-	2,4 *5.290*
C8-391.02-63080B	02527212	C8	C6	80,0 *3.150*	44,5 *1.752*	63,0 *2.480*	128,0 *5.039*	1	0	-	2,6 *5.730*
C8-391.02-63120A	02207176	C8	C6	120,0 *4.724*	12,0 *0.472*	63,0 *2.480*	168,0 *6.614*	2	0	-	4,1 *9.040*

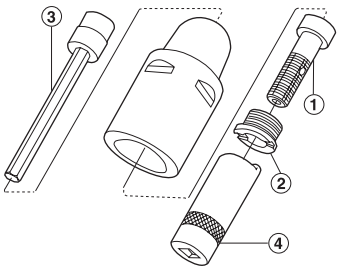
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Sicherungsmutter
		
C...-32	5512067-01	5512091-04
C...-40	5512067-02	5512091-03
C...-50	5512067-03	5512091-01
C...-63	5512067-04	5512091-02

Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C...-32	5680015-05	5680065-13
C...-40	5680015-05	5680065-10
C...-50	5680015-01	5680065-11
C...-63	5680015-02	5680065-12

Zubehör / Ersatzteile

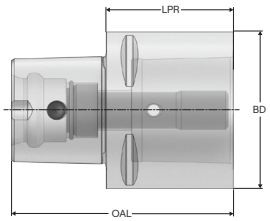


Zubehör:
3 = Verlängerungsschlüssel
4 = Spannschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsmutter

C01 Seco Capto™ Verlängerungen, kurze Version, nur für segmentäre Klemmung

ISO 26623-1

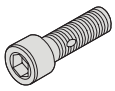


—Der maschinenseitige Anschluss kurzer Seco Capto™ Verlängerungen kann nur durch Spindeln mit Segment-Klemmvorrichtung (nicht mit Zentrierbolzen-verbindung) erfolgen.

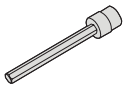
Zubehör:
3 = Verlängerungsschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LPR	BD	OAL	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-391.01-32035	02535685	C3	C3	35,0 *1.378*	32,0 *1.260*	54,0 *2.126*	0	–	0,3 *0.660*
C4-391.01-40040	02535686	C4	C4	40,0 *1.575*	40,0 *1.575*	64,0 *2.520*	0	–	0,4 *0.880*
C5-391.01-50050	02484934	C5	C5	50,0 *1.969*	50,0 *1.969*	80,0 *3.150*	0	–	0,7 *1.540*
C6-391.01-63060	02300834	C6	C6	60,0 *2.362*	63,0 *2.480*	98,0 *3.858*	0	–	1,3 *2.870*
C8-391.01-80065	02417041	C8	C8	65,0 *2.559*	80,0 *3.150*	113,0 *4.449*	0	–	2,4 *5.290*

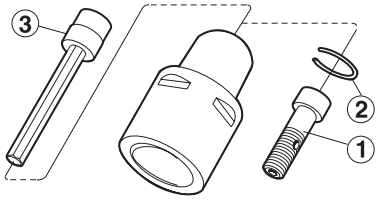
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrums-schraube	Seegerring
		
C3-391.01-32035	5512068-01	5545040-02
C4-391.01-40040	5512068-02	5545040-03
C5-391.01-50050	5512068-03	5545040-07
C6-391.01-63060	5512068-04	5545040-08
C8-391.01-80065	5512068-05	5545040-08

Zubehör

Für Halter	Verlängerungsschlüssel
	
C3-391.01-32035	5680015-05
C4-391.01-40040	5680015-05
C5-391.01-50050	5680015-05
C6-391.01-63060	5680015-02
C8-391.01-80065	5680015-02

Zubehör / Ersatzteile

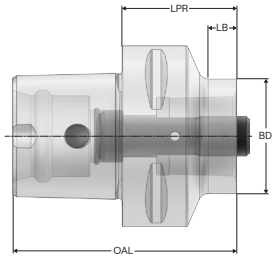


Zubehör:
3 = Verlängerungsschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsring

C02 Seco Capto™ Reduzierstücke, kurze Ausführung, nur für segmentäre Klemmung

ISO 26623-1

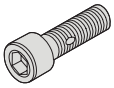


—Der maschinenseitige Anschluss kurzer Seco Capto™ Reduzierstücke kann nur durch Spindeln mit Segment-Klemmvorrichtung (nicht mit Zentrierbolzen-verbindung) erfolgen.
—* 108 ° Versatz maschinen- und werkstückseitig

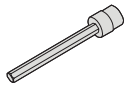
Zubehör:
3 = Verlängerungsschlüssel

Bezeichnung	Produktnummer	CTMS	CTWS	LPR	LB	BD	OAL	*	RFID-Bohrung	Auswuchtung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C5-391.02-32033A	03080025	C5	C3	33,0 *1.299*	5,0 *0.197*	32,0 *1.260*	63,0 *2.480*		0	PB	0,6 *1.320*
C5-391.02-40040A	03079983	C5	C4	40,0 *1.575*	15,0 *0.591*	40,0 *1.575*	70,0 *2.756*		0	–	0,6 *1.320*
C6-391.02-32032	02535690	C6	C3	32,0 *1.260*	6,0 *0.236*	32,0 *1.260*	70,0 *2.756*		0	–	0,85 *1.870*
C6-391.02-40040	02459467	C6	C4	40,0 *1.575*	11,0 *0.433*	40,0 *1.575*	78,0 *3.071*		0	–	0,9 *1.980*
C6-391.02-50050A	03080019	C6	C5	50,0 *1.969*	20,0 *0.787*	50,0 *1.969*	88,0 *3.465*		0	–	1,1 *2.430*
C8-391.02-50045A	03080010	C8	C5	45,0 *1.772*	5,0 *0.197*	50,0 *1.969*	93,0 *3.661*		0	–	1,9 *4.190*
C8-391.02-63055A	03080012	C8	C6	55,0 *2.165*	15,0 *0.591*	63,0 *2.480*	103,0 *4.055*		0	–	2,1 *4.630*
C8-391.02R-63055A	03080030	C8	C6	55,0 *2.165*	15,0 *0.591*	63,0 *2.480*	103,0 *4.055*	*	0	–	1,9 *4.190*

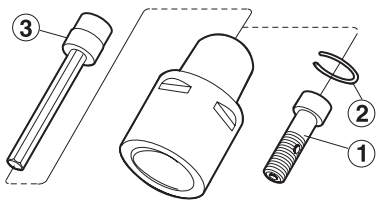
Ersatzteile, im Lieferumfang enthalten

Für Halter	Zentrumsschraube	Seegerring
		
C5-391.02-32033A	5512068-01	5545040-02
C5-391.02-40040A	5512068-06	5545040-07
C6-391.02-32032	5512068-01	5545040-02
C6-391.02-40040	5512068-02	5545040-03
C6-391.02-50050A	5512068-07	5545040-08
C8-391.02-50045A	5512068-08	5545040-08
C8-391.02-63055A	5512068-05	5545040-08
C8-391.02R-63055A	5512068-05	5545040-08

Zubehör

Verlängerungsschlüssel

5680015-05
5680015-05
5680015-05
5680015-05
5680015-01
5680015-01
5680015-02
5680015-02

Zubehör / Ersatzteile

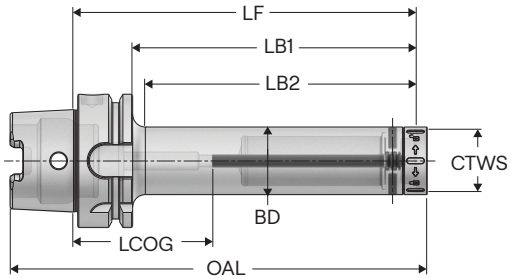


Zubehör:
3 = Verlängerungsschlüssel

Ersatzteile:
1 = Zentrumschraube
2 = Sicherungsring

GL – Steadyline®, HSK-T/A-GL-Aufnahmen

Körper-Durchmesser 25, 32, 40 und 50 mm/0,984, 1,260, 1,575 und 1,969 Zoll



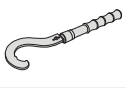
—Mit Schwingungsdämpfung, sofort einsatzbereit
—Mit Durchflusskühlmittel
—* Max. U/MIN nur bei Ausdrehung

Bezeichnung	Produkt-nummer	CTMS HSK-T/A	CTWS GL-Größe	BD	LF	LB1	LB2	OAL	LCOG	Max. U/min*	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
HSKTA63-GL25-130-K	03214283	HSK-T/A63	GL25	25,0 *0.984*	130,0 *5.118*	104,0 *4.094*	101,0 *3.976*	166,5 *6.555*	37,0 *1.457*	10000	1	–	1,4 *3.1*
HSKTA63-GL25-180-K	03214284	HSK-T/A63	GL25	25,0 *0.984*	180,0 *7.087*	154,0 *6.063*	151,0 *5.945*	216,5 *8.524*	57,7 *2.272*	8000	1	–	1,5 *3.3*
HSKTA63-GL25-230-K	03214285	HSK-T/A63	GL25	25,0 *0.984*	230,0 *9.055*	204,0 *8.031*	201,0 *7.913*	266,5 *10.492*	80,3 *3.161*	6000	1	–	1,5 *3.3*
E9374-D32-160-GL32	03029521	HSK-T/A63	GL32	32,0 *1.260*	160,0 *6.299*	134,0 *5.276*	128,0 *5.039*	197,4 *7.772*	58,92 *2.320*	10000	1	–	1,6 *3.5*
E9374-D32-224-GL32	03029522	HSK-T/A63	GL32	32,0 *1.260*	224,0 *8.819*	198,0 *7.795*	192,0 *7.559*	261,4 *10.291*	90,22 *3.552*	8000	1	–	2,0 *4.4*
E9374-D40-208-GL40	03029523	HSK-T/A63	GL40	40,0 *1.575*	208,0 *8.189*	182,0 *7.165*	176,0 *6.929*	246,4 *9.701*	92,78 *3.653*	8000	1	–	2,7 *6.0*
E9374-D40-288-GL40	03029524	HSK-T/A63	GL40	40,0 *1.575*	288,0 *11.339*	262,0 *10.315*	256,0 *10.079*	326,4 *12.850*	134,37 *5.290*	6000	1	–	3,5 *7.7*
E9374-D50-268-GL50	03029525	HSK-T/A63	GL50	50,0 *1.969*	268,0 *10.551*	242,0 *9.528*	240,5 *9.469*	307,4 *12.102*	131,8 *5.189*	6000	1	–	4,8 *10.6*
E9374-D50-368-GL50	03029526	HSK-T/A63	GL50	50,0 *1.969*	368,0 *14.488*	342,0 *13.465*	340,5 *13.406*	407,4 *16.039*	184,79 *7.275*	4000	1	–	6,4 *14.1*
E9376-D32-160-GL32	03029527	HSK-T/A100	GL32	32,0 *1.260*	160,0 *6.299*	131,0 *5.157*	125,0 *4.921*	215,4 *8.480*	32,87 *1.294*	10000	1	–	3,0 *6.6*
E9376-D32-224-GL32	03029528	HSK-T/A100	GL32	32,0 *1.260*	224,0 *8.819*	195,0 *7.677*	189,0 *7.441*	279,4 *11.000*	54,97 *2.164*	8000	1	–	3,4 *7.5*
E9376-D32-288-GL32	03029529	HSK-T/A100	GL32	32,0 *1.260*	288,0 *11.339*	259,0 *10.197*	253,0 *9.961*	343,4 *13.520*	80,51 *3.170*	6000	1	–	3,8 *8.4*
E9376-D40-208-GL40	03029530	HSK-T/A100	GL40	40,0 *1.575*	208,0 *8.189*	179,0 *7.047*	173,0 *6.811*	264,4 *10.409*	62,83 *2.474*	8000	1	–	4,1 *9.0*
E9376-D40-288-GL40	03029531	HSK-T/A100	GL40	40,0 *1.575*	288,0 *11.339*	259,0 *10.197*	253,0 *9.961*	344,4 *13.559*	98,31 *3.870*	6000	1	–	4,9 *10.8*
E9376-D40-368-GL40	03029532	HSK-T/A100	GL40	40,0 *1.575*	368,0 *14.488*	339,0 *13.346*	333,0 *13.110*	424,4 *16.709*	139,77 *5.503*	5000	1	–	5,8 *12.8*
E9376-D50-268-GL50	03029533	HSK-T/A100	GL50	50,0 *1.969*	268,0 *10.551*	239,0 *9.409*	234,0 *9.213*	325,4 *12.811*	104,26 *4.105*	6000	1	–	6,2 *13.7*
E9376-D50-368-GL50	03029534	HSK-T/A100	GL50	50,0 *1.969*	368,0 *14.488*	339,0 *13.346*	334,0 *13.150*	425,4 *16.748*	154,26 *6.073*	4000	1	–	7,8 *17.2*
E9376-D50-468-GL50	03029535	HSK-T/A100	GL50	50,0 *1.969*	468,0 *18.425*	439,0 *17.283*	434,0 *17.087*	525,4 *20.685*	211,61 *8.331*	2500	1	–	9,7 *21.4*

Ersatzteile, im Lieferumfang enthalten

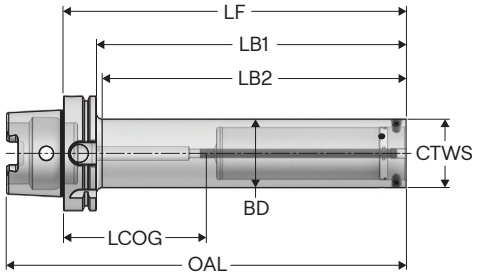
Für Größe	Spannschlüssel
GL25	SL25
GL32	SL32
GL40	SL40
GL50	SL50

Zubehör

Austauschbares Endstück	Drehmoment-schlüssel
	
SL00-25	SL00-25.250
SL00-32	SL00-32.250
SL00-40	SL00-40.350
SL00-50	SL00-50.550

BA – Steadyline®, HSK-T/A-BA-Aufnahmen

Körper-Durchmesser 60 und 80 mm/2,362 und 3,150 Zoll



- Mit Schwingungsdämpfung, sofort einsatzbereit
- Zur Aufnahme von BA-auf-GL-Adaptern mit GL-Köpfen zum Drehen
- Mit Durchflusskühlmittel
- * Max. U/MIN nur bei Ausdrehung

Bezeichnung	Produkt-nummer	CTMS HSK-T/A-Größe	CTWS BA Größe	BD	LF	LB1	LB2	OAL	LCOG	Max. U/min*	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
E9376-D60-301-BA060	03062828	HSK-T/A100	BA060	60,0 *2.362*	301,0 *11.850*	272,0 *10.709*	267,0 *10.512*	351,0 *13.819*	133,05 *5.238*	4000	1	PB	8,9 *19.6*
E9376-D60-421-BA060	03062829	HSK-T/A100	BA060	60,0 *2.362*	421,0 *16.575*	392,0 *15.433*	387,0 *15.236*	471,0 *18.543*	197,17 *7.763*	3000	1	PB	11,8 *26.0*
E9376-D60-541-BA060	03062830	HSK-T/A100	BA060	60,0 *2.362*	541,0 *21.299*	512,0 *20.157*	507,0 *19.961*	591,0 *23.268*	260,56 *10.258*	2000	1	PB	14,5 *32.0*
E9376-D80-421-BA080	03064109	HSK-T/A100	BA080	80,0 *3.150*	421,0 *16.575*	392,0 *15.433*	387,0 *15.236*	471,0 *18.543*	209,68 *8.255*	3000	1	PB	19,4 *42.8*
E9376-D80-581-BA080	03064111	HSK-T/A100	BA080	80,0 *3.150*	581,0 *22.874*	552,0 *21.732*	547,0 *21.535*	631,0 *24.843*	295,45 *11.632*	2000	1	PB	25,6 *56.4*

Ersatzteile, im Lieferumfang enthalten

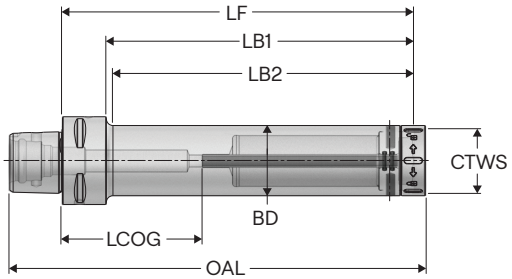
Für Größe	Befestigungsschraube
BA060	90FQ4
BA080	90FQ52

Zubehör

Für Größe	Spannschlüssel
BA060	03H04
BA080	03H05

GL – Steadyline®, GL-Aufnahmen

Körper-Durchmesser 25, 32, 40 und 50 mm/0,984, 1,260, 1,575 und 1,969 Zoll



—Mit Schwingungsdämpfung, sofort einsatzbereit
—Mit Durchflusskühlmittel
—* Max. U/MIN nur bei Ausdrehung

Bezeichnung	Produkt-nummer	CTMS Seco Capto™ Größe	CTWS GL-Größe	BD	LF	LB1	LB2	OAL	LCOG	Max. U/min*	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C4-D25-130-GL25	03214272	C4	GL25	25,0 *0.984*	130,0 *5.118*	110,0 *4.331*	107,0 *4.213*	158,5 *6.240*	51,8 *2.039*	10000	0	PB	0,9 *2.0*
C4-D25-180-GL25	03214273	C4	GL25	25,0 *0.984*	180,0 *7.087*	160,0 *6.299*	157,0 *6.181*	208,5 *8.209*	77,2 *3.039*	8000	0	PB	1,2 *2.7*
C4-D32-160-GL32	02807837	C4	GL32	32,0 *1.260*	160,0 *6.299*	140,0 *5.512*	137,0 *5.394*	189,4 *7.457*	74,73 *2.942*	10000	0	PB	1,4 *3.1*
C4-D32-224-GL32	02807838	C4	GL32	32,0 *1.260*	224,0 *8.819*	204,0 *8.031*	201,0 *7.913*	253,4 *9.976*	109,16 *4.298*	8000	0	PB	1,7 *3.8*
C5-D25-130-GL25	03214274	C5	GL25	25,0 *0.984*	130,0 *5.118*	110,0 *4.331*	107,0 *4.213*	164,5 *6.476*	41,8 *1.646*	10000	1	PB	1,1 *2.4*
C5-D25-180-GL25	03214275	C5	GL25	25,0 *0.984*	180,0 *7.087*	160,0 *6.299*	157,0 *6.181*	214,5 *8.445*	65,1 *2.563*	8000	1	PB	1,3 *2.9*
C5-D25-230-GL25	03214276	C5	GL25	25,0 *0.984*	230,0 *9.055*	210,0 *8.268*	207,0 *8.150*	264,5 *10.413*	89,8 *3.535*	6000	1	PB	1,5 *3.3*
C5-D32-160-GL32	02807840	C5	GL32	32,0 *1.260*	160,0 *6.299*	140,0 *5.512*	136,0 *5.354*	195,4 *7.693*	65,15 *2.565*	10000	1	PB	1,6 *3.5*
C5-D32-224-GL32	02807841	C5	GL32	32,0 *1.260*	224,0 *8.819*	204,0 *8.031*	200,0 *7.874*	259,4 *10.213*	98,47 *3.877*	8000	1	PB	2,0 *4.4*
C5-D32-288-GL32	02807842	C5	GL32	32,0 *1.260*	288,0 *11.339*	268,0 *10.551*	264,0 *10.394*	323,4 *12.732*	133,61 *5.260*	6000	1	PB	2,2 *4.9*
C5-D40-208-GL40	02807843	C5	GL40	40,0 *1.575*	208,0 *8.189*	188,0 *7.402*	184,0 *7.244*	244,4 *9.622*	98,32 *3.871*	8000	1	PB	2,8 *6.2*
C5-D40-288-GL40	02807844	C5	GL40	40,0 *1.575*	288,0 *11.339*	268,0 *10.551*	264,0 *10.394*	324,4 *12.772*	140,88 *5.546*	6000	1	PB	3,3 *7.3*
C6-D25-130-GL25	03214277	C6	GL25	25,0 *0.984*	130,0 *5.118*	105,0 *4.134*	102,0 *4.016*	172,5 *6.791*	30,4 *1.197*	10000	1	PB	1,6 *3.5*
C6-D25-180-GL25	03214278	C6	GL25	25,0 *0.984*	180,0 *7.087*	155,0 *6.102*	152,0 *5.984*	222,5 *8.760*	49,3 *1.941*	8000	1	PB	1,5 *3.3*
C6-D25-230-GL25	03214279	C6	GL25	25,0 *0.984*	230,0 *9.055*	205,0 *8.071*	202,0 *7.953*	272,5 *10.728*	70,2 *2.764*	6000	1	PB	1,7 *3.8*
C6-D32-160-GL32	02807846	C6	GL32	32,0 *1.260*	160,0 *6.299*	135,0 *5.315*	129,0 *5.079*	203,4 *8.008*	52,06 *2.050*	10000	1	PB	1,8 *4.0*
C6-D32-224-GL32	02807847	C6	GL32	32,0 *1.260*	224,0 *8.819*	199,0 *7.835*	193,0 *7.598*	267,4 *10.528*	82,17 *3.235*	8000	1	PB	2,2 *4.9*
C6-D32-288-GL32	02807848	C6	GL32	32,0 *1.260*	288,0 *11.339*	263,0 *10.354*	257,0 *10.118*	331,4 *13.047*	114,87 *4.522*	6000	1	PB	2,6 *5.7*
C6-D40-208-GL40	02807849	C6	GL40	40,0 *1.575*	208,0 *8.189*	183,0 *7.205*	177,0 *6.969*	252,4 *9.937*	86,42 *3.402*	8000	1	PB	2,9 *6.4*
C6-D40-288-GL40	02807850	C6	GL40	40,0 *1.575*	288,0 *11.339*	263,0 *10.354*	257,0 *10.118*	332,4 *13.087*	127,5 *5.020*	6000	1	PB	3,7 *8.2*
C6-D40-368-GL40	02807851	C6	GL40	40,0 *1.575*	368,0 *14.488*	343,0 *13.504*	337,0 *13.268*	412,4 *16.236*	173,14 *6.817*	5000	1	PB	4,6 *10.1*
C6-D50-268-GL50	02807852	C6	GL50	50,0 *1.969*	268,0 *10.551*	243,0 *9.567*	238,0 *9.370*	313,4 *12.339*	126,6 *4.984*	6000	1	PB	5,4 *11.9*
C6-D50-368-GL50	02807853	C6	GL50	50,0 *1.969*	368,0 *14.488*	343,0 *13.504*	338,0 *13.307*	413,4 *16.276*	179,44 *7.065*	4000	1	PB	6,6 *14.6*
C6-D50-468-GL50	02807854	C6	GL50	50,0 *1.969*	468,0 *18.425*	443,0 *17.441*	438,0 *17.244*	513,4 *20.213*	238,49 *9.389*	2500	1	PB	8,5 *18.7*

Bezeichnung	Produkt-nummer	CTMS Seco Capto™ Größe	CTWS GL-Größe	BD	LF	LB1	LB2	OAL	LCOG	Max. U/min*	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C8-D32-224-GL32	03029356	C8	GL32	32,0 *1.260*	224,0 *8.819*	191,0 *7.520*	181,0 *7.126*	277,4 *10.921*	58,17 *2.290*	8000	1	PB	3,2 *7.1*
C8-D32-288-GL32	03029357	C8	GL32	32,0 *1.260*	288,0 *11.339*	255,0 *10.039*	245,0 *9.646*	341,4 *13.441*	84,7 *3.335*	6000	1	PB	3,6 *7.9*
C8-D40-288-GL40	03029358	C8	GL40	40,0 *1.575*	288,0 *11.339*	255,0 *10.039*	245,0 *9.646*	342,4 *13.480*	102,14 *4.021*	6000	1	PB	4,7 *10.4*
C8-D40-368-GL40	03029359	C8	GL40	40,0 *1.575*	368,0 *14.488*	335,0 *13.189*	325,0 *12.795*	422,4 *16.630*	144,04 *5.671*	5000	1	PB	5,6 *12.4*
C8-D50-268-GL50	03029360	C8	GL50	50,0 *1.969*	268,0 *10.551*	235,0 *9.252*	225,0 *8.858*	323,4 *12.732*	107,59 *4.236*	6000	1	PB	5,9 *13.0*
C8-D50-368-GL50	03029361	C8	GL50	50,0 *1.969*	368,0 *14.488*	335,0 *13.189*	325,0 *12.795*	423,4 *16.669*	158,08 *6.224*	4000	1	PB	7,5 *16.5*
C8-D50-468-GL50	03029362	C8	GL50	50,0 *1.969*	468,0 *18.425*	435,0 *17.126*	425,0 *16.732*	523,4 *20.606*	215,6 *8.488*	2500	1	PB	9,4 *20.7*

Ersatzteile, im Lieferumfang enthalten

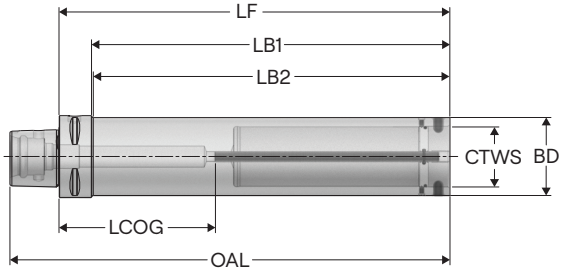
Für Größe	Spannschlüssel
GL25	SL25
GL32	SL32
GL40	SL40
GL50	SL50

Zubehör

Für Größe	Austauschbares Endstück	Drehmoment-schlüssel
GL25	SL00-25	SL00-25.250
GL32	SL00-32	SL00-32.250
GL40	SL00-40	SL00-40.350
GL50	SL00-50	SL00-50.550

BA – Steadyline®, BA-Aufnahmen

Körper-Durchmesser 60 und 80 mm/2,362 und 3,150 Zoll



—Mit Schwingungsdämpfung, sofort einsatzbereit
—Zur Aufnahme von BA-auf-GL-Adaptern mit GL-Köpfen zum Drehen
—Mit Durchflusskühlmittel
—* Max. U/MIN nur bei Ausdrehung

Bezeichnung	Produkt-nummer	CTMS Seco Capto™ Größe	CTWS BA-Größe	BD	LF	LB1	LB2	OAL	LCOG	Max. U/min*	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C6-D60-301-BA060	03062831	C6	BA060	60,0 *2.362*	301,0 *11.850*	276,0 *10.866*	273,0 *10.748*	339,0 *13.346*	151,74 *5.974*	4000	1	PB	7,8 *17.2*
C6-D60-421-BA060	03062832	C6	BA060	60,0 *2.362*	421,0 *16.575*	396,0 *15.591*	393,0 *15.472*	459,0 *18.071*	218,63 *8.607*	3000	1	PB	10,6 *23.4*
C8-D60-301-BA060	03062833	C8	BA060	60,0 *2.362*	301,0 *11.850*	268,0 *10.551*	263,0 *10.354*	349,0 *13.740*	137,04 *5.395*	4000	1	PB	8,6 *19.0*
C8-D60-421-BA060	03062834	C8	BA060	60,0 *2.362*	421,0 *16.575*	388,0 *15.276*	383,0 *15.079*	469,0 *18.465*	202,5 *7.972*	3000	1	PB	11,4 *25.1*
C8-D60-541-BA060	03062835	C8	BA060	60,0 *2.362*	541,0 *21.299*	508,0 *20.000*	503,0 *19.803*	589,0 *23.189*	266,78 *10.503*	2000	1	PB	14,0 *30.9*
C8-D80-421-BA080	03065829	C8	BA080	80,0 *3.150*	421,0 *16.575*	388,0 *15.276*	383,0 *15.079*	469,0 *18.465*	213,89 *8.421*	3000	1	PB	18,8 *41.5*
C8-D80-581-BA080	03065830	C8	BA080	80,0 *3.150*	581,0 *22.874*	548,0 *21.575*	543,0 *21.378*	629,0 *24.764*	300,38 *11.826*	2000	1	PB	25,1 *55.3*

Ersatzteile, im Lieferumfang enthalten

Für Größe	Befestigungsschraube
BA060	90FQ4
BA080	90FQ52

Zubehör

Für Größe	Spannschlüssel
BA060	03H04
BA080	03H05

ISO-Toleranztabelle

ISO-Toleranzen für Bohrungen (µm)														
Bohrung ∅ mm (Zoll)	**D10**	**E9**	**F7**	**F8**	**G7**	**G9**	**H5**	**H6**	**H7**	**H8**	**H9**	**H10**	**H11**	**H12**
≤ 3 *(0.118")*	+60 +20	+39 +14	+16 +6	+20 +6	+12 +2	+27 +2	+4 0	+6 0	+10 0	+14 0	+25 0	+40 0	+60 0	+100 0
3 ≥ 6 *(0.236")*	+78 +30	+50 +20	+22 +10	+28 +10	+16 +4	+34 +4	+5 0	+8 0	+12 0	+18 0	+30 0	+48 0	+75 0	+120 0
6 ≥ 10 *(0.394")*	+98 +40	+61 +25	+28 +13	+35 +13	+20 +5	+41 +5	+6 0	+9 0	+15 0	+22 0	+36 0	+58 0	+90 0	+150 0
10 ≥ 18 *(0.708")*	+120 +50	+75 +32	+34 +16	+43 +16	+24 +6	+49 +6	+8 0	+11 0	+18 0	+27 0	+43 0	+70 0	+110 0	+180 0
18 ≥ 30 *(1.181")*	+149 +65	+92 +40	+41 +20	+53 +20	+28 +7	+59 +7	+9 0	+13 0	+21 0	+33 0	+52 0	+84 0	+130 0	+210 0
30 ≥ 50 *(1.969")*	+180 +80	+112 +50	+50 +25	+64 +25	+34 +9	+71 +9	+11 0	+16 0	+25 0	+39 0	+62 0	+100 0	+160 0	+250 0
50 ≥ 65 *(2.559")*	+220 +100	+134 +60	+60 +30	+76 +30	+40 +10	–	+13 0	+19 0	+30 0	+46 0	+74 0	+120 0	+190 0	+300 0
65 ≥ 80 *(3.150")*														
80 ≥ 100 *(3.937")*	+260 +120	+159 +72	+71 +36	+90 +36	+47 +12	–	+15 0	+22 0	+35 0	+54 0	+87 0	+140 0	+220 0	+350 0
100 ≥ 120 *(4.724")*														
120 ≥ 140 *(5.512")*	+305 +145	+185 +85	+83 +43	+106 +43	+54 +14	–	+18 0	+25 0	+40 0	+63 0	+100 0	+160 0	+250 0	+400 0
140 ≥ 160 *(6.299")*														
160 ≥ 180 *(7.087")*														
180 ≥ 200 *(7.874")*	+355 +170	+215 +110	+96 +50	+122 +50	+61 +15	–	+20 0	+29 0	+46 0	+72 0	+115 0	+185 0	+290 0	+460 0
200 ≥ 225 *(8.858")*														
225 ≥ 250 *(9.843")*														
250 ≥ 280 *(11.0236")*	+400 +190	+240 +110	+108 +56	+137 +56	+69 +17	–	+23 0	+32 0	+52 0	+81 0	+130 0	210 0	+320 0	+520 0
280 ≥ 315 *(12.402")*														
315 ≥ 355 *(13.976")*	+440 +210	+265 +125	+119 +62	+151 +62	+75 +18	–	+25 0	+36 0	+57 0	+89 0	+140 0	+230 0	+360 0	+570 0
355 ≥ 400 *(15.748")*														

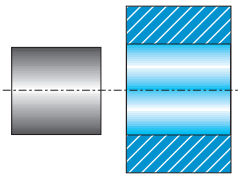
ISO-Toleranztabelle

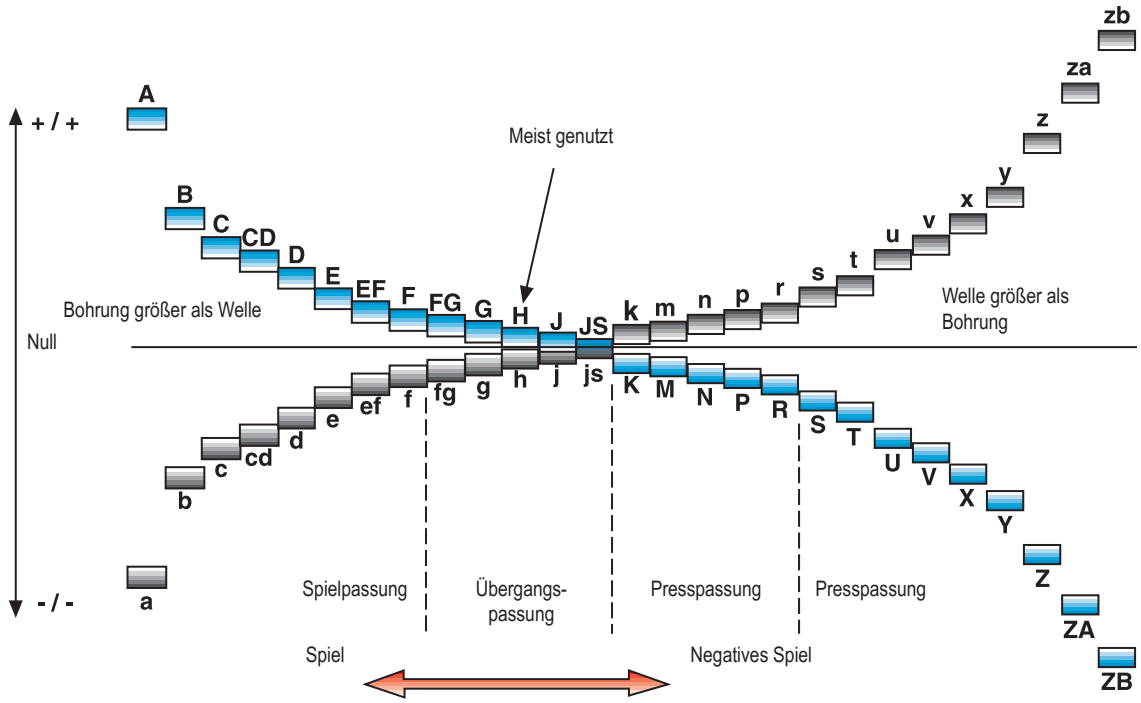
ISO-Toleranzen für Bohrungen (µm)												
Bohrung ∅ mm (Zoll)	**H13**	**JS7**	**JS9**	**K6**	**K7**	**M6**	**M7**	**N7**	**N9**	**P7**	**P9**	**R7**
≤ 3 *(0.118")*	+140 0	+/-5	+/-12,5	0 -6	0 -10	-2 -8	-2 -12	-4 -14	-4 -29	-6 -16	-6 -31	-10 -20
3 ≥ 6 *(0.236")*	+180 0	+/-6	+/-15	+2 -6	+3 -9	-1 -9	0 -12	-4 -16	0 -30	-8 -20	-12 -42	-11 -23
6 ≥ 10 *(0.394")*	+220 0	+/-7,5	+/-18	+2 -7	+5 -10	-3 -12	0 -15	-4 -19	0 -36	-9 -24	-15 -51	-13 -28
10 ≥ 18 *(0.708")*	+270 0	+/-9	+/-21,5	+2 -9	+6 -12	-4 -15	0 -18	-5 -23	0 -43	-11 -29	-18 -61	-16 -34
18 ≥ 30 *(1.181")*	+330 0	+/-10,5	+/-26	+2 -11	+6 -15	-4 -17	0 -21	-7 -28	0 -52	-14 -35	-22 -74	-20 -41
30 ≥ 50 *(1.969")*	+390 0	+/-12,5	+/-31	+3 -13	+7 -18	-4 -20	0 -25	-8 -33	0 -62	-17 -42	-26 -88	-25 -50
50 ≥ 65 *(2.559")*	+460 0	+/-15	+/-37	+4 -15	+9 -21	-5 -24	0 -30	-9 -39	0 -74	-21 -51	-32 -106	-30 -62
65 ≥ 80 *(3.150")*												
80 ≥ 100 *(3.937")*	+260 +120	+159 +72	+71 +36	+90 +36	+47 +12	–	+22 0	+35 0	+54 0	+87 0	+140 0	+350 0
100 ≥ 120 *(4.724")*												
120 ≥ 140 *(5.512")*	+305 +145	+185 +85	+83 +43	+106 +43	+54 +14	–	+25 0	+40 0	+63 0	+100 0	+160 0	+400 0
140 ≥ 160 *(6.299")*												
160 ≥ 180 *(7.087")*												
180 ≥ 200 *(7.874")*	+355 +170	+215 +110	+96 +50	+122 +50	+61 +15	–	+29 0	+46 0	+72 0	+115 0	+185 0	+460 0
200 ≥ 225 *(8.858")*												
225 ≥ 250 *(9.843")*												
250 ≥ 280 *(11.0236")*	+400 +190	+240 +110	+108 +56	+137 +56	+69 +17	–	+32 0	+52 0	+81 0	+130 0	210 0	+520 0
280 ≥ 315 *(12.402")*												
315 ≥ 355 *(13.976")*	+440 +210	+265 +125	+119 +62	+151 +62	+75 +18	–	+36 0	+57 0	+89 0	+140 0	+230 0	+570 0
355 ≥ 400 *(15.748")*												

ISO Standard Toleranzen – Bohrungen und Wellen

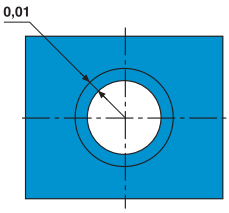
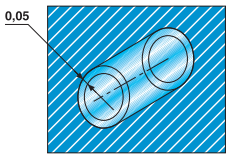
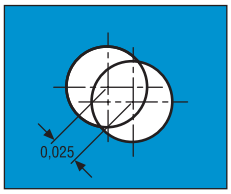
Die Position der Wellentoleranz wird mit **kleinen Buchstaben** bezeichnet.

Die Position der Bohrungstoleranz wird mit **GROSSBUCHSTABEN** bezeichnet.





Geometrische Toleranzen

	Zeichnungssymbol	Toleranzbereich
Zirkularität	0,01 mm *(0.0004")*	
Zylindrizität	0,05 mm *(0.0020")*	
Positionierung	0,05 mm *(0.0020")*	

Stahl, ferritische und martensitisch rostfreie Stähle

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
P1	Automatenstähle mit niedrigem Kohlenstoffgehalt	360 < R_m < 880	11 SMn30 R_m = 385 N/mm²	1500	0,14
P2	Niedrig legierte ferritische Stähle mit C < 0,25%wt Niedrig legierte normale Baustähle	320 < R_m < 600	S235JRG2 R_m = 420 N/mm²	1600	0,23
P3	Ferritische und ferritisch/perlitische Stähle mit C < 0,25%wt schweißbare Baustähle Einsatzstähle	430 < R_m < 610	16 MnCr 5 R_m = 550 N/mm²	1800	0,14
P4	Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungs-stähle	520 < R_m < 1200	C 45E R_m = 660 N/mm²	2000	0,15
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²	2020	0,18
P6	Niedrig legierte härtbare Stähle mit C > 0,67%wt Niedrig legierte Feder- und Lagerstähle	520 < R_m < 1200	C 100S R_m = 600 N/mm²	2100	0,17
P7	Härtbare Stähle mit C > 0,67%wt Feder- und Lagerstähle	600 < R_m < 1200	100 Cr 6 R_m = 650 N/mm²	2160	0,17
P8	Werkzeugstähle Schnellarbeitsstähle (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm²	2400	0,20
P11	Ferritische und martensitische Stähle	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm²	2000	0,15
P12	Martensitaushärtbares und lösungsbehandeltes Rostfrei	500 < R_m < 1200	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm²	2100	0,17

Austenitisch rostfreie Stähle

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
M1	Leicht schneidendes Rostfrei		X 10 CrNiS 18 9	1700	0,14
M2	Niedrig legierte austenitische rostfreie Stähle		X 5 CrNi 18 10	1920	0,18
M3	Legierte austenitische rostfreie Stähle		X 2 CrNiMo 18 14 3	2070	0,17
M4	Hoch legierte rostfreie Stähle (Austenit und Duplex)		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Austenit und Duplex, sehr schwierig zerspanbar		X 2 CrNiMoN 25 7 4	2510	0,13

Guss

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
K1	Grauguss (GCI)		EN-GJL-250	930	0,32
K2	Vermikularguss (CGI)		EN-GJV-400	1000	0,35
K3	Temperguss (MCI)		EN-GJMB-550-4	1050	0,37
K4	Sphäroguss, Kugelgrafit-guss (SGI)		EN-GJS-500-7	1160	0,37
K5	Wärmebehandelter Kugelgrafitguss (ADI)		EN-GJS-1000-5	0	
K6	Austenitischer Guss mit Lamellengrafit		EN-GJLA-XNiCuCr15-6-2	0	
K7	Austenitischer Sphäroguss		EN-GJSA-XNiMn23-4	0	

Nicht-Eisen-Metalle

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
N1	Aluminiumlegierungen, Si < 9%		AW-7075	0	
N2	Aluminiumlegierungen, 9% < Si < 16%		AC-44200 Si = 12%	0	
N3	Aluminiumlegierungen, Si >16%		AlSi17Cu5	0	
N11	Kupferlegierungen		CW614N	740	0,26

Superlegierungen und Titan

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
S1	Superlegierungen auf Fe-Basis		Discalloy	0	
S2	Superlegierungen auf Co-Basis		Stellite 21	0	
S3	Superlegierungen auf Ni-Basis		Inconel 718	2530	0,21
S11	Titan, niedrig legiert, (α)		Ti	0	
S12	Titan, mittlere Legierung, (α+β)		TiAl6V4	1500	0,24
S13	Titan, hoch legiert, (nahe β und β)		Ti10V2Fe3Al	0	

Harte Werkstoffe

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
H3	Einsatzstahl gehärtet	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Vergütungsstähle Lagerstähle	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Werkzeugstähle Schnellarbeitsstähle (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Martensitische, rostfreie Stähle	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Martensitausgehärtetes und lösungsbehandeltes Rostfrei	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Manganstahl	23 < HRC < 64	X 120 Mn 12 50 HRC	0	
H31	Weißhartguss	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC	0	

Andere Werkstoffe

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
PM1	Niedrig legierte Pulvermet-all-Werkstoffe		F-0008 Fe-0.7C	0	
PM2	PM-Werkstofflegierungen im mittleren Bereich		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C	0	
PM3	Hoch legierte PM-Werkstof-fe Werkstoffe für Abgasven-tilsitze, etc.			0	
HF1	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Legierungen auf Eisen-Basis			0	
HF2	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Kobalt- und Nickel-basis-Legierungen			0	
CC1	Gesintertes Wolfram-Hartmetall		G50	0	

Kunststoffe und Composite

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
TS1	Duroplaste		Urea Formaldehyde (UF)	0	
TS2	Duroplastische Kohlenstoff-faser-Verbundwerkstoffe		T300 T700 T800 HTA-S IMA - Epoxy (M21)...	0	
TS3	Duroplastische Glasfaser-Verbundwerkstoffe		Epoxy - HX..(42..)/E-Glas (7781...)...	0	
TS4	Duroplastische Aramidfaser-Verbundwerkstoffe		Kevlar 49	0	
TP1	Thermoplastische Polymere		Polycarbonat (PC)	0	
TP2	Thermoplastische Kohlenstofffaser-Verbun-dwerkstoffe		PPS/PEEK - T300..	0	
TP3	Thermoplastische Glasfaser-Verbundwerkstof-fe		PPS/PEEK - E-Glas oder A-Glas...	0	
TP4	Thermoplastische Aramidfaser-Verbundwerk-stoffe			0	

Graphit

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
GR1	Graphit		R 8500	0	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	AF 34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	AF 37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3,5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4,5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCr 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCr 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
	1213				geglüht	
	12 L 13				geglüht	
	1108				geglüht	
	11 L 08				geglüht	
					geglüht	
	1140	40			geglüht	
	1146				geglüht	
	1215				geglüht	
	12 L 14				geglüht	
		16D			geglüht	
	ASTM Grade 58	18kp	11 378		geglüht	
	ASTM Grade 70	St14kP	11 448		geglüht	
	1010	10			geglüht	
F.1110	1015	15			geglüht	
	1020, 1023	20	12 024		geglüht	
		17G1S	11 523		geglüht	
F.1511	1015	15			geglüht	
F.1120	1025	25			geglüht	
					geglüht	
	A204 Grade A		15 020		geglüht	
	4520				geglüht	
	3310, 9314	20X2H4A	16 420		geglüht	
	4320		16 220		geglüht	
					geglüht	
F.1516	5115	12KHN2	14 220		geglüht	
		18HG			geglüht	
	5120	20KH	14 221		geglüht	
	5120 H	20KH			geglüht	
	A182-F11, A182-F12	12KHM	15 121		geglüht	
	A387 Grade 12 Cl. 2				geglüht	
F.155	A182-F22	12KH8	15 313		geglüht	
F.1130	1035	35	12 040		geglüht	
F.5110	1045	45	12 050		geglüht	
	1040	40	12 041		geglüht	
F.1150	1055	55			geglüht	
	1060	60	12 061		geglüht	
	1039	40G			geglüht	
	1330	30G2			geglüht	
F.1135	1035	35			geglüht	
F.1140	1045	45	12 050		geglüht	
F.1150	1064	60			geglüht	
	1060	60			geglüht	
F.144	9255	55S2			geglüht	
F.1250	4135	35KHM			geglüht	
F.5241	S1	5KHV2S			geglüht	
	L6	5KHNV			geglüht	
	5045				geglüht	
	3135				vergütet	
	3435				geglüht	
	9840				vergütet	
F.1280	4340	38H2N2MA	16 343		geglüht	
	5132	35KH			vergütet	
	5140	40H	14 140		vergütet	
F.1251	4130	20KHM	15 130		vergütet	
F.1252	4142, 4140	38HM	15 142		geglüht	
F.1252	4142, 4140	38HM	15 142		vergütet	
					vergütet	
F.143	6150	50KHFA	15 260		vergütet	
F.1740	A355 Cl. A				geglüht	
F.5103	1070	70			geglüht	
F.5117	1095				geglüht	
F.5118	W1	U10A			geglüht	
		U10			geglüht	
	W1	U13			geglüht	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 CrNiMoAl 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
F.520L	L2	11KHF			geglüht	
F.5220	O1	9KHVG			geglüht	
	O2	9G2F			geglüht	
F.5230	52100	SHKH15	14 109		geglüht	
F.5212	D3	KH12			geglüht	
	H11	4KH5MFS			geglüht	
F.5318	H13	4KH5MF1S			geglüht	
F.5227	A2	9KH5VF			geglüht	
	H10	3KH3M3F			geglüht	
F.5213		KH12			geglüht	
		KH12MF			geglüht	
F.520.S	L6	5KHNM			geglüht	
F.5613	M35	R6M5K5			geglüht	
	M42	R2AM9K5			geglüht	
	T4	R18K5F2			geglüht	
F.5603	M2	R6M5			geglüht	
	M7				geglüht	
	T1	R18			geglüht	
	403	08KH13			geglüht	ferritisch
F.3401	410, -15	12KH13, 08KH13			geglüht	martensitisch
F.3113	430	12KH17			geglüht	ferritisch
F.5261	420	20KH13	17 022		geglüht	martensitisch
F.3404	420	40KH13			geglüht	martensitisch
	440 A				geglüht	martensitisch
	440 B	95KH18			geglüht	martensitisch
	440 C	95KH18			geglüht	martensitisch
	A182 F6NM			F6NM	geglüht	martensitisch
	446	15KH28			geglüht	ferritisch
	XM-13			PH 13-8 Mo	lösungsgeglüht	austenitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H1150	martensitisch
	XM-12			15-5-PH	lösungsgeglüht	martensitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H1025	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H1150	martensitisch
	630			17-4-PH	lösungsgeglüht	martensitisch
	631	09KH17N7YU1		17-7-PH	lösungsgeglüht	austenitisch/ferritisch
	AMS 6515			Marage 350	lösungsgeglüht	martensitisch
	AMS 6521			Marage 300	lösungsgeglüht	martensitisch
	AMS 6514			Marage 300, Vascomax C300	lösungsgeglüht	martensitisch
	AMS 6512			Marage 250	lösungsgeglüht	martensitisch
	AMS 6512			Marage 250, Vascomax C250	lösungsgeglüht	martensitisch
F.3508	303	12KH19N9			geglüht	austenitisch
F.3504	304 L	03KH18N11			geglüht	austenitisch
F.3504	304	08KH18N10	17 240		geglüht	austenitisch
F.3534	316	08KH17H13M2T	17 346		geglüht	austenitisch
F.3524	347	08KH18N12B			geglüht	austenitisch
F.3517	301	07KH16N6			geglüht	austenitisch
	302	12KH18N9			geglüht	austenitisch
F.3533	316 L	03KH17N14M3	17 349		geglüht	austenitisch
	316 LN	03KH16N15M3			geglüht	austenitisch
F.3541	304 LN	03KH18N11			geglüht	austenitisch
	317	08KH17H15M3T			geglüht	austenitisch
				253 MA	geglüht	austenitisch
	310 S	12KH25N20			geglüht	austenitisch
	329 LN			SAF 2205	geglüht	Duplex
				3RE60	geglüht	Duplex
	904L				geglüht	Super Austenit
	329				geglüht	Duplex
	660			A286	lösungsgeglüht	austenitisch
				254 SMO	geglüht	Super Austenit
				654 SMO	geglüht	Super Austenit
				Alloy 800	geglüht	austenitisch
	F 53			SAF 2507	geglüht	Super Duplex

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
K4	EN-GJS-350-22	0.7033	0.7033	DMM=-35,3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
	EN-GJS-400-18	0.7043	0.7043	DMM=-40,3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
K5										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
N1	AW-1050A	Al99.5	3.0255	Al99.5	-51050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
	A48 25 B	Sc 15	422 415			Grauguss (GCI)
	A48 30 B	Sc 20	422 420			Grauguss (GCI)
	A48 35 B	Sc 25	422 425			Grauguss (GCI)
	A48 50 B	Sc 35				Grauguss (GCI)
	G 3500					Grauguss (GCI)
	Grade 350					Vermikularguss (CGI)
	Grade 400					Vermikularguss (CGI)
	Grade 400-15					Vermikularguss (CGI)
	Grade 450					Vermikularguss (CGI)
	Grade 500					Vermikularguss (CGI)
	A220 60004				geglüht	Temperguss (MCI)
						Sphäroguss (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Sphäroguss (SGI)
	60-40-18	Vc 42-12				Sphäroguss (SGI)
FGE 50-7	A536 80-55-06	Vc 50-2	422 305			Sphäroguss (SGI)
FGE 60-2	A476 80-60-03	Vc 60-2	422 306			Sphäroguss (SGI)
FGE 70-2	A536 100-70-03	Vc 70-2				Sphäroguss (SGI)
	1600/1300					wärmebehandelter Kugelgrafitguss (ADI)
	1050/700/7					wärmebehandelter Kugelgrafitguss (ADI)
	1200/850/4					wärmebehandelter Kugelgrafitguss (ADI)
	1400/1100/1					wärmebehandelter Kugelgrafitguss (ADI)
	850/550/10					wärmebehandelter Kugelgrafitguss (ADI)
	A436 Type 2			Ni-Resist 2		austenitischer Guss mit Lamellengrafit
	A436 Type 3			Ni-Resist 3		austenitischer Guss mit Lamellengrafit
	A436 Type 1			Ni-Resist 1		austenitischer Guss mit Lamellengrafit
				Nodumag		austenitischer Sphäroguss
	A436 Type D-2			Ni-Resist D-2		austenitischer Sphäroguss
	A439 Type D-2M			Ni-Resist D-2M		austenitischer Sphäroguss
	A436 Type D-3			Ni-Resist D-3		austenitischer Sphäroguss
	A439 Type D-5			Ni-Resist D-5		austenitischer Sphäroguss
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
				Discalloy	ausscheidungsgehärtet	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel -750	lösungsgeglüht	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	technisch rein	Ti (α)
	AMS 4919			Ti 6-2-4-2	geglüht	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	geglüht	Ti (α+β)
	AMS 4920, Grd 5	VT6		Ti 6Al-4V	geglüht	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	geglüht	Ti (β)
F.1516	5115	12KHN2	14 220		einsatzgehärtet	
F.5103	1070	70			vergütet	
F.5107	1078, 1080	75			vergütet	
F.5117	1095				vergütet	
F.5118	W1	U10A			vergütet	
	S1	5KHV2SF			vergütet	
	5155				vergütet	
F.1252	4142, 4140	38HM	15 142		vergütet	
F.520L	L2	11KHF			vergütet	
F.5220	O1	9KHVG			vergütet	
	O2	9G2F			vergütet	
F.5230	52100	SHKH15	14 109		vergütet	
F.5318	H13	4KH5MF1S			vergütet	
F.5227	A2	9KH5VF			vergütet	
F.5211	D2	KH12MF			vergütet	
F.5213		KH12			vergütet	
		KH12MF			vergütet	
F.520.S	L6	5KHNM			vergütet	
F.5613	M35	R6M5K5			vergütet	
	M42	R2AM9K5			vergütet	
	T1	R18			vergütet	
F.5261	420	20KH13	17 022		vergütet	martensitisch
	440 A				vergütet	martensitisch
	440 B	95KH18			vergütet	martensitisch
	440 C	95KH18			vergütet	martensitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H900	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H1025	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H900	martensitisch
	AMS 5528	09KH17N7YU1		17-7-PH	ausscheidungsgehärtet TH1050	martensitisch
	632			PH 15-7 Mo	ausscheidungsgehärtet TH1050	martensitisch
	660			A286	ausscheidungsgehärtet	austenitisch
	AMS 6512			Marage 250	ausscheidungsgehärtet	martensitisch
	AMS 6521			Marage 300	ausscheidungsgehärtet	martensitisch
	AMS 6521			Marage 300	ausscheidungsgehärtet	martensitisch
	AMS 6515			Marage 350	ausscheidungsgehärtet	martensitisch
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		Weißhartguss
	A532 IA (NiCr-HC)			Ni-Hard 1		Weißhartguss
	A532 ID (Ni-HiCr)			Ni-Hard 4		Weißhartguss

Hartmetallwerkzeuge und Trägerwerkzeuge für Wendeschneidplatten

Hartmetall-Wendeschneidplatten und Hartmetall-Trägerwerkzeuge von Seco Tools sind in dem für folgende Richtlinien bestimmten Produktprogramm nicht enthalten. Seco Tools kann dennoch die folgende Erklärung abgeben:
Diese Produkte erfüllen alle Anforderungen der RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment = Einschränkungen der Verwendung gewisser gefährlicher Substanzen in elektronischer und elektrischer Ausrüstung), WEEE (Waste Electrical & Electronic Equipment = Entsorgung elektrischer und elektronischer Ausrüstung) sowie ELV (End of Life Vehicles = Altfahrzeuge).
Unsere Produkte enthalten keinerlei Stoffe wie Quecksilber, Blei, sechswertiges Chrom, Cadmium, CFC, HCFC, schwer entflammbare Stoffe oder Lösungen in höheren Konzentrationen als gesetzlich vorgegeben.

Nachschleifen
Nass- oder Trockenschleifbearbeitungen können potenziell gefährliche Stäube oder Verunreinigungen freisetzen, die Haut-, Augen-, Nasen- oder Kehlkopfreizungen hervorrufen und zu Lungenschäden oder -krankheiten führen können. Um Verletzungen vorzubeugen, sind geeignete Sicherheitsvorkehrungen zu treffen und Schutzvorrichtungen einzusetzen.

Entsorgung
Seco Tools erklärt sich bereit, Wendeschneidplatten und Vollhartmetallwerkzeuge zur Wiederaufbereitung zurückzukaufen. Wendeschneidplatten sollten von anderem Metallschrott (Stahl, Aluminium, Kupfer etc.) getrennt werden.
Unser gesamtes Verpackungsmaterial kann wiederaufbereitet werden.

CBN- und PKD-Wendeschneidplatten

Wendeschneidplatten von Seco Tools sind in dem für folgende Richtlinien bestimmten Produktprogramm nicht enthalten. Seco Tools kann dennoch die folgende Erklärung abgeben:
Diese Produkte erfüllen alle Anforderungen der RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment = Einschränkungen der Verwendung gewisser gefährlicher Substanzen in elektronischer und elektrischer Ausrüstung), WEEE (Waste Electrical & Electronic Equipment = Entsorgung elektrischer und elektronischer Ausrüstung) sowie ELV (End of Life Vehicles = Altfahrzeuge).
Unsere Produkte enthalten keinerlei Stoffe wie Quecksilber, Blei, sechswertiges Chrom, Cadmium, CFC, HCFC, schwer entflammbare Stoffe oder Lösungen in höheren Konzentrationen als gesetzlich vorgegeben.

Nachschleifen
Nass- oder Trockenschleifbearbeitungen können potenziell gefährliche Stäube oder Verunreinigungen freisetzen, die Haut-, Augen-, Nasen- oder Kehlkopfreizungen hervorrufen und zu Lungenschäden oder -krankheiten führen können. Um Verletzungen vorzubeugen, sind geeignete Sicherheitsvorkehrungen zu treffen und Schutzvorrichtungen einzusetzen.

Entsorgung
Seco Tools erklärt sich bereit, gebrauchte CBN- und PCD-bestückte Wendeschneidplatten zur Wiederaufbereitung zurückzukaufen.
Wendeschneidplatten sollten von anderem Metallschrott (Stahl, Aluminium, Kupfer etc.) getrennt werden. Full-Face-CBN-Wendeschneidplatten können als Bodenaufschüttungsmaterial eingesetzt werden.
Unser gesamtes Verpackungsmaterial kann wiederaufbereitet werden.

Brünierte Trägerwerkzeuge für Wendeschneidplatten

Trägerwerkzeuge für Wendeschneidplatten von Seco Tools sind in dem für folgende Richtlinien bestimmten Produktprogramm nicht enthalten. Seco Tools kann dennoch die folgende Erklärung abgeben:
Diese Produkte erfüllen alle Anforderungen der RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment = Einschränkungen der Verwendung gewisser gefährlicher Substanzen in elektronischer und elektrischer Ausrüstung), WEEE (Waste Electrical & Electronic Equipment = Entsorgung elektrischer und elektronischer Ausrüstung) sowie ELV (End of Life Vehicles = Altfahrzeuge).
Unsere Produkte enthalten keinerlei Stoffe wie Quecksilber, Blei, sechswertiges Chrom, Cadmium, CFC, HCFC, schwer entflammbare Stoffe oder Lösungen in höheren Konzentrationen als gesetzlich vorgegeben.

Entsorgung
Trägerwerkzeuge können zusammen mit normalen Stahlabfällen (wie Spänen und anderem Schrott) der Wiederaufbereitung zugeführt werden.
Unser gesamtes Verpackungsmaterial kann wiederaufbereitet werden.

Wendeschneidplatten aus Cermet

Wendeschneidplatten von Seco Tools sind in dem für folgende Richtlinien bestimmten Produktprogramm nicht enthalten. Seco Tools kann dennoch die folgende Erklärung abgeben:
Diese Produkte erfüllen alle Anforderungen der RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment = Einschränkungen der Verwendung gewisser gefährlicher Substanzen in elektronischer und elektrischer Ausrüstung), WEEE (Waste Electrical & Electronic Equipment = Entsorgung elektrischer und elektronischer Ausrüstung) sowie ELV (End of Life Vehicles = Altfahrzeuge).
Wendeschneidplatten C15M enthalten Nickel, das bei Hautkontakt freigesetzt wird. Die freigesetzte Nickelmenge ist höher als in der Norm SS-EN 1811 (Referenztestverfahren bezgl. Nickelfreisetzung bei Produkten, die für direkten und dauerhaften Hautkontakt bestimmt sind) angegeben. Diese Norm gilt für Produkte, die für direkten und dauerhaften Hautkontakt bestimmt sind; daher ist sie nicht für Cermet-Wendeschneidplatten anzuwenden. Personen, die bekannterweise allergische Reaktionen auf Nickel zeigen, sollten beim Umgang mit Cermet-Wendeschneidplatten Schutzhandschuhe tragen.

Nachschleifen
Nass- oder Trockenschleifbearbeitungen können potenziell gefährliche Stäube oder Verunreinigungen freisetzen, die Haut-, Augen-, Nasen- oder Kehlkopfreizungen hervorrufen und zu Lungenschäden oder -krankheiten führen können. Um Verletzungen vorzubeugen, sind geeignete Sicherheitsvorkehrungen zu treffen und Schutzvorrichtungen einzusetzen.

Entsorgung
Verschlissene Wendeschneidplatten können wiederaufbereitet werden. Wendeschneidplatten sollten von anderem Metallschrott (Stahl, Aluminium, Kupfer etc.) getrennt werden.
Unser gesamtes Verpackungsmaterial kann wiederaufbereitet werden.

Nickel-beschichtete Trägerwerkzeuge

Trägerwerkzeuge für Wendeschneidplatten von Seco Tools sind in dem für folgende Richtlinien bestimmten Produktprogramm nicht enthalten. Seco Tools kann dennoch die folgende Erklärung abgeben:
Diese Produkte erfüllen alle Anforderungen der RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment = Einschränkungen der Verwendung gewisser gefährlicher Substanzen in elektronischer und elektrischer Ausrüstung), WEEE (Waste Electrical & Electronic Equipment = Entsorgung elektrischer und elektronischer Ausrüstung) sowie ELV (End of Life Vehicles = Altfahrzeuge).
Unsere Produkte enthalten keinerlei Stoffe wie Quecksilber, Blei, sechswertiges Chrom, Cadmium, CFC, HCFC, schwer entflammbare Stoffe oder Lösungen in höheren Konzentrationen als gesetzlich vorgegeben.
Trägerwerkzeuge für Wendeschneidplatten enthalten Nickel, das bei Hautkontakt freigesetzt wird. Die freigesetzte Nickelmenge ist nicht höher als in der Norm SS-EN 1811 (Referenztestverfahren bezgl. Nickelfreisetzung bei Produkten, die für direkten und dauerhaften Hautkontakt bestimmt sind) angegeben.
Diese Norm gilt für Produkte, die für direkten und dauerhaften Hautkontakt bestimmt sind; daher ist sie nicht für Trägerwerkzeuge für Wendeschneidplatten anzuwenden.
Personen, die bekannterweise allergische Reaktionen auf Nickel zeigen, sollten beim Umgang mit Nickelbeschichteten Trägerwerkzeugen für Wendeschneidplatten Schutzhandschuhe tragen.

Entsorgung
Trägerwerkzeuge können zusammen mit normalen Stahlabfällen (wie Spänen und anderem Schrott) der Wiederaufbereitung zugeführt werden.
Unser gesamtes Verpackungsmaterial kann wiederaufbereitet werden.

Weitere Legierungsbestandteile

Beschichtung	Hartmetall											Beschichtung						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
CP20	■				■				■			■			■			
CP200	■				■	■			■			■	■		■			
CP300	■	■	■	■	■				■			■	■		■			
CP500	■				■	■			■			■	■		■			
CP600	■				■	■			■			■	■		■			
C15M	■	■	■	■	■		■	■	■	■								
CF	■		■		■		■	■	■									
CM	■		■		■		■	■	■									
DP2000	■		■	■	■				■			■	■	■	■	■		
DP2501	■	■	■	■	■				■	■		■	■	■	■	■		
DP3000	■	■	■	■	■				■	■		■	■	■	■	■		
DS2050	■				■	■			■			■	■		■			■
DS4050	■				■	■			■			■	■		■			■
F15M	■				■	■			■			■	■		■			
F25M	■	■	■	■	■				■			■	■		■			
F30M	■				■	■			■			■	■		■			
F40M	■				■	■			■			■	■		■			
HX	■		■		■				■									
H02	■		■		■	■			■									
H15	■				■	■			■									
H25	■				■	■			■									
KX	■				■	■			■									
MH1000	■				■	■			■			■	■		■			
MH1051	■				■	■			■			■	■		■		■	
MK1500	■		■		■				■			■	■	■	■	■		
MK1501	■		■		■				■			■	■	■	■	■		
MK2050	■		■		■	■			■			■	■		■		■	
MM4500	■				■	■			■			■	■	■	■	■		
MP1501	■		■	■	■				■			■	■	■	■	■		
MP2050	■				■						■	■	■		■		■	
MP2051	■				■	■			■			■	■		■		■	
MP2501	■		■	■	■				■			■	■	■	■	■		
MP3000	■				■	■			■			■	■		■			
MP3501	■		■	■	■				■			■	■	■	■	■		
MS2500	■		■	■	■				■			■	■	■	■	■		
MS2050	■				■	■			■			■	■		■			■
RX1500	■		■		■		■	■	■			■	■		■			
RX2000	■		■		■	■			■			■	■		■			
RM2020	■				■				■			■						
RM2090	■				■	■			■			■	■				■	
RN2010	■				■	■			■									
RS2090	■				■	■			■			■	■				■	
T350M	■		■	■	■				■			■	■	■	■	■		
T25M	■		■	■	■				■			■		■	■			
TGH1050	■				■	■			■			■	■		■		■	
TGK1500	■		■		■				■			■	■	■	■	■		
TGP25	■	■	■	■	■				■			■	■	■	■	■		
TGP35	■		■	■	■				■			■	■	■	■	■		
TGP45	■		■	■	■				■			■	■	■	■	■		
TGS2050	■				■	■			■			■	■		■		■	
TH1000	■				■	■			■			■	■		■		■	
TH1500	■				■	■			■			■	■	■	■	■		
TK0501	■				■	■			■			■	■	■	■	■		
TK1501	■		■		■	■			■			■	■	■	■	■		
TM1501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TM2000	■	■	■	■	■				■	■		■	■	■	■	■		
TM2501	■	■	■	■	■				■	■		■	■	■	■	■		

Beschichtung	Hartmetall											Beschichtung						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
TM3501	■				■				■			■	■	■	■	■		
TM4000	■	■	■	■	■				■	■		■	■	■	■	■		
TP0501	■	■	■	■	■	■			■			■	■	■	■	■		
TP1020	■	■	■	■	■				■	■								
TP1030	■	■	■	■	■				■	■		■	■		■		■	
TP1501	■	■	■	■	■				■	■		■	■	■	■	■		
TP25	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP200	■	■	■	■	■				■	■		■	■	■	■	■		
TP2501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP3501	■	■	■	■	■				■	■		■	■	■	■	■		
TP40	■		■	■	■				■			■		■	■			
TS2000	■				■	■			■			■	■		■			
TS2050	■				■	■			■			■	■		■		■	
TS2500	■		■		■				■			■	■		■			
TTP2050	■				■	■			■			■	■		■		■	
T250D	■				■	■			■			■	■		■			
T400D	■				■	■			■			■	■		■			
T100R	■		■		■	■			■			■	■		■			
T60M	■	■	■	■	■				■			■	■		■			
883	■		■		■				■									
890	■				■	■			■									

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