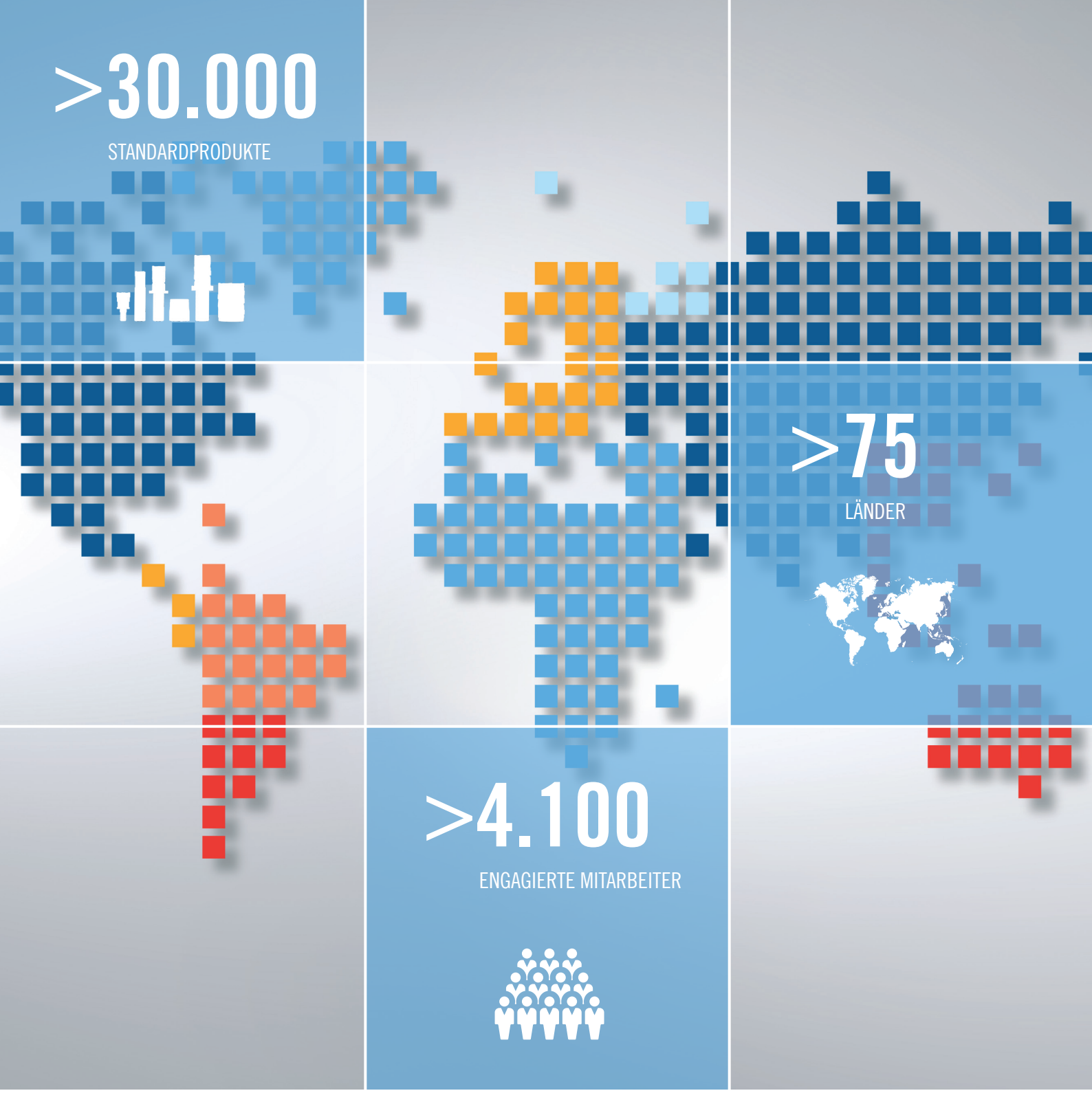
KATALOG &
TECHNISCHER
GUIDE 2022



BOHRUNGS-BEARBEITUNG

SECO



EXZELLENTE ZERSPANUNGSLÖSUNGEN

Seco ist einer der weltweit führenden Anbieter von effizienten Zerspanungslösungen. Basierend auf umfassendem Know-how und praktischer Erfahrung optimiert Seco gemeinsam mit seinen Kunden die vielfältigen Prozesse in der spanenden Fertigung. Das Angebot umfasst leistungsstarke Präzisionswerkzeuge für alle Technologien sowie ergänzende Service- und Dienstleistungen: vom Lagermanagement über Maschinenausrüstung, digitales Datenmanagement und Webanwendungen bis hin zur Prozessanalyse der gesamten Fertigung.

www.secotools.com

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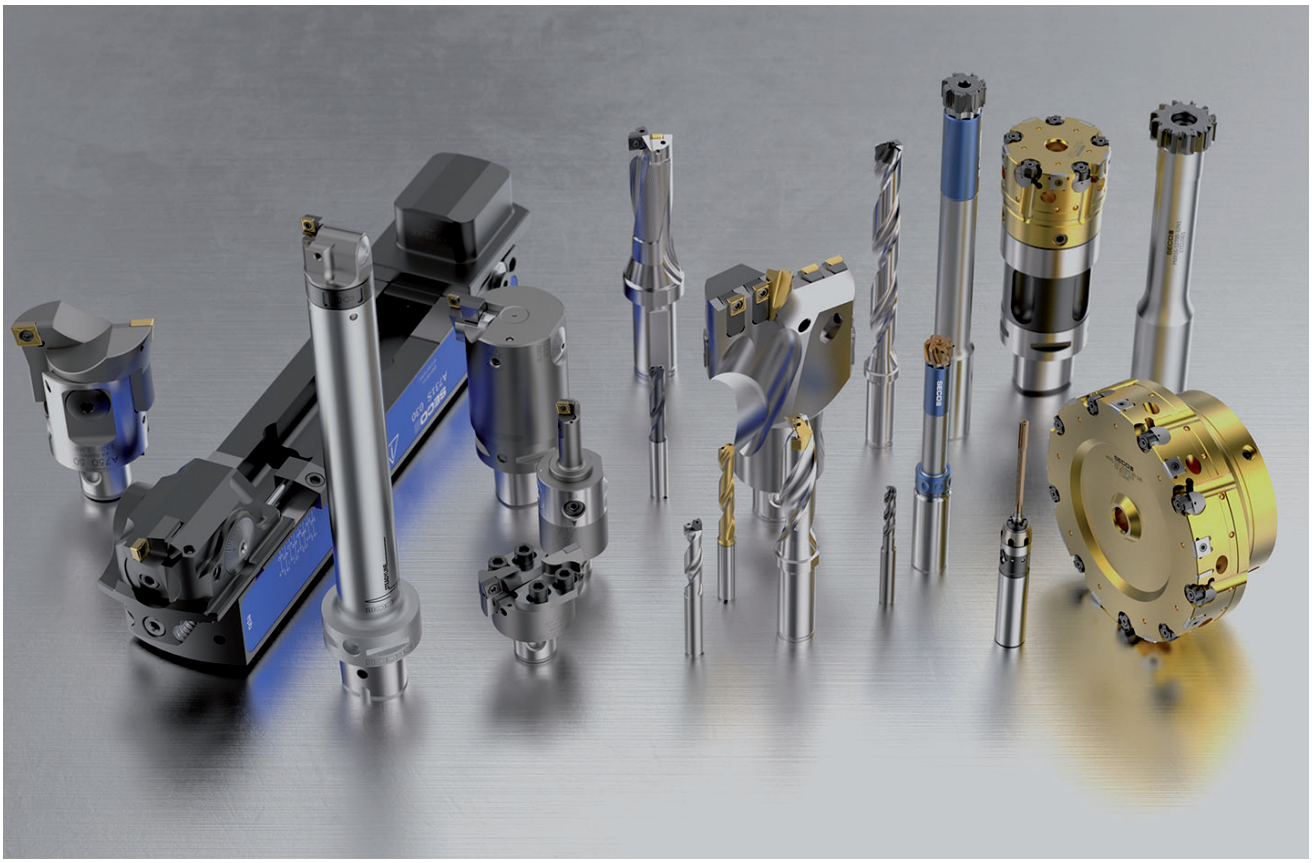
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Herausforderungen meistern

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 Gewinden 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			Gewinden		
	Seco Universal Seco Feedmax™	Crownloc® Crownloc® Plus	Perfomax®	Precimaster™ Plus	Nanofix™	Bifix®	Xfix™	Schruppausdrehen	Feinausdrehen	Threadmaster™	Threadmaster™ Taps		Gewindefräsen 396.18/.19/.20
Seite(n)	25-173	174-227	228-323	329-367	368-397	398-424	425-465	555-576	577-622	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")*	–	Folgt der Vorbohrung	Folgt der Vorbohrung	–
	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	–
Gewinde-form	–	–	–	–	–	–	–	–	–	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

Positionierungsgenauigkeit
Seco Feedmax, A750 Schruppausdrehköpfe und das gesamte Programm der Feinausdrehköpfe sind die Lösungen, die bei der Bohrungsbearbeitung die höchste Positionierungsgenauigkeit bieten.

Bohrungsgeometrie
Alle Seco Werkzeuge zum Bohren, Reiben und Ausdrehen erzielen hervorragende Bohrungsgeometrien wie Zylindrizität, Rundheit und Geradheit. Ausdrehköpfe erzielen hinsichtlich Geradheit die besten Ergebnisse.

Oberflächengüte
Für eine glatte Bohrungsoberfläche sind Seco Feedmax und Bifix die erste Wahl. Alle Feinausdrehköpfe sind hier ebenfalls einsetzbar

TCTR = Gewindetoleranzklasse

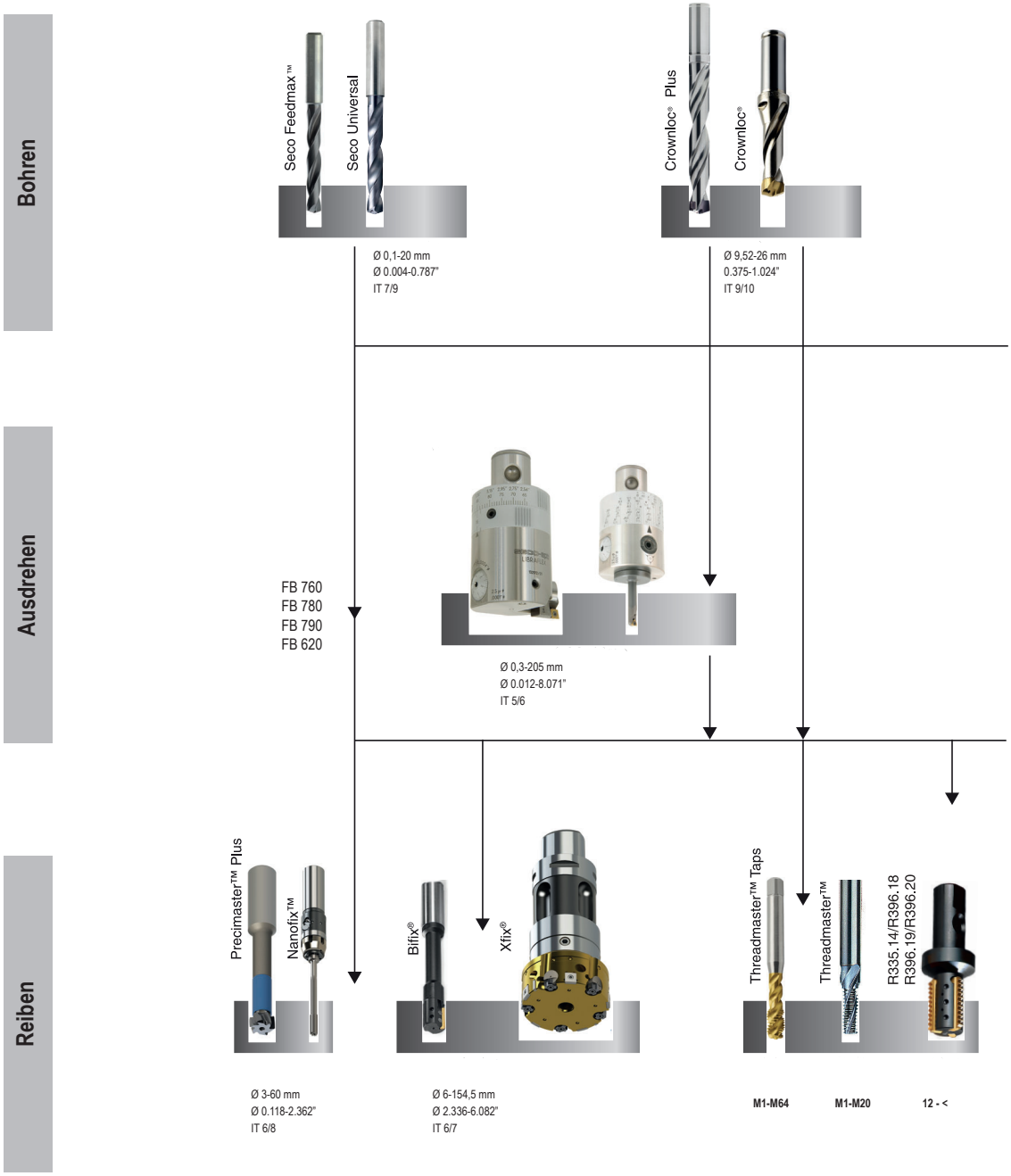
IT = Bohrungstoleranz

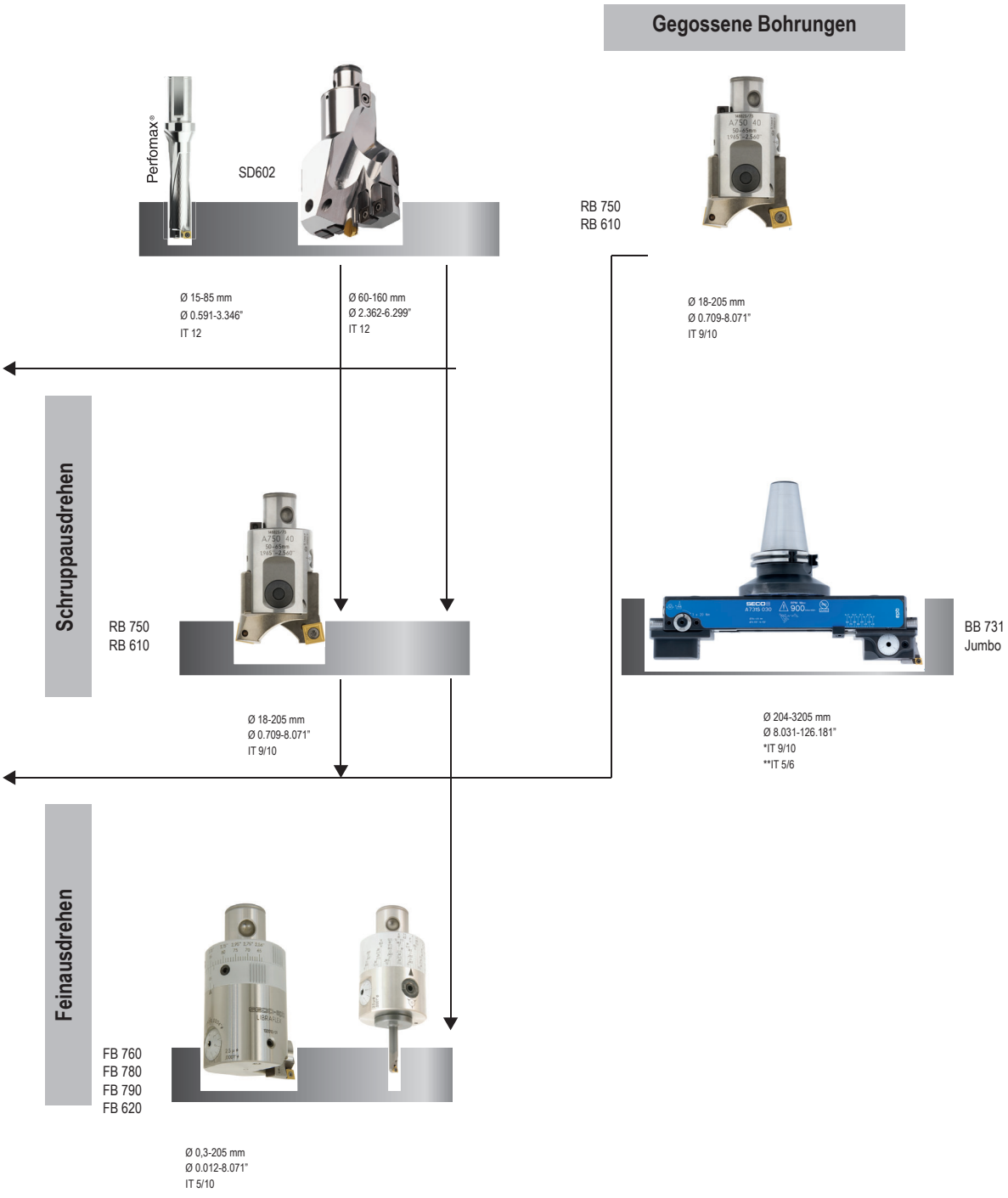
Werkzeugauswahl

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 Semi-Schlichten eingesetzt, 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. Metrische und UN-Versionen sind nur für Innengewinde verfügbar. 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

BOHREN



PERFOMAX®
STÄRKE, STABILITÄT & PRÄZISION

Perfomax® Wendeplattenbohrer sind die erste Wahl für Bohrungen mit großen Durchmessern. Die Bohrer eignen sich für hohe Schnittgeschwindigkeiten und hohe Vorschübe, da sie ein starkes, steifes Design mit einer großen Auswahl an Schneidstoffen verbinden.



ERWEITERTES PROGRAMM
- 2 x D, 3 x D, 4 x D und 5 x D
- Verfügbar mit gängigen Schaft-typen
- Durchmesserbereich von 15 bis 160 mm (.590 - 6.299")

EXZELLENTE BOHRERKÖRPER
- Neues Spankammerdesign
- Wellenartige Struktur in der Spankammer
- Polierter Bohrerkörper
- Lasergehärtet

OPTIMIERTE SORTEN UND GEOMETRIEN FÜR VERSCHIEDENE WERKSTOFFE FÜR LANGE, BERECHENBARE STANDZEITEN
- Quadratische Wendeschneid-platten mit vier Schneidkanten
- Starkes Design
- Für hohe Vorschübe geeignet

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

SMG - Einführung

Als Beispiel werden die Referenzwerkstoffe EN C45E für SMG P4 und EN 42 CrMo 4 für die beiden SMG P5 und SMG H5 in den nachstehenden Tabellen dargestellt.
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 Basis für SMG ist eine Klassifizierung von Werkstoffen, die hauptsächlich auf ihrer entsprechenden Art der Bearbeitbarkeit basiert; auch Werkstoffe wie Composite sind darin eingeschlossen. 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 662-673.

SMG	Bezeichnung	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/ mm^2
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/ mm^2

SMG	Bezeichnung	Eigenschaften	Referenz
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 R_m = 700 N/ mm^2

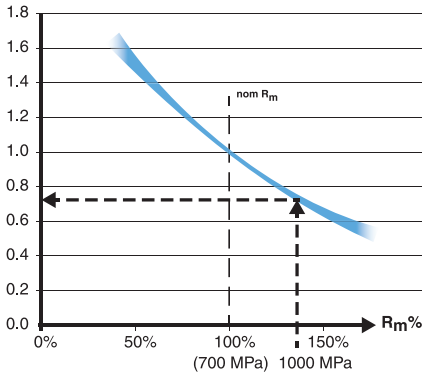
Mit besonderem Fokus auf EN 42 CrMo 4 in lösungsgeglühtem Zustand kann die Bruchfestigkeit R_m typischerweise zwischen R_m = 630 N/mm2 und R_m = 780 N/ mm2 liegen und bietet damit einen Referenzbereich für SMG P5.

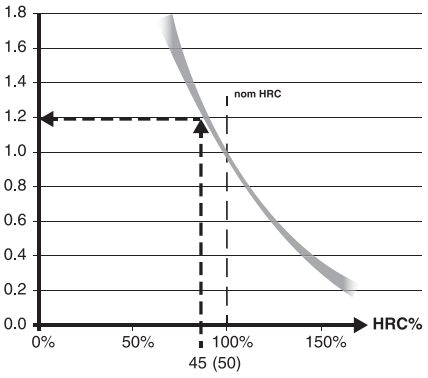
Im geglühten Zustand kann die Bruchfestigkeit Rm typischerweise zwischen R_m = 900 N/mm2 und R_m = 1100 N/mm2 liegen, gehört damit aber immer noch zu SMG P5. Bei einer Härte von mehr als R_m = 1200 N/ mm2 gehört sie zu SMG H5.

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). Hier stellen wir fest, dass bei der SMG P5 die nominelle Schnittgeschwindigkeit für ein bestimmtes Produkt bei einer gewissen Bearbeitung v_c = 280 m/min beträgt.
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) 662-673, weitere Schnittdatenempfehlungen auf den entsprechenden Katalogseiten.
Darüber hinaus finden Sie weitere geeignete Werkzeuge zur Schnittdatenberechnung auf www.secotools.com

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 radiale Eingriffsbreite
CEDC	Schneidenanzahl
CHA	Winkel der Querbohrung
CHW	Fasenbreite
CNT	Gewindegröße des Kühlmitteleinlasses
CW	Schnitttiefe/Stechbreite
CZC	Code Anschlussgröße
D1	Durchmesser Befestigungsbohrung
DC	Werkzeugdurchmesser
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 der Wendeschneidplatte
INSL	Länge der Wendeschneidplatte
KRINS	Einstellwinkel
L	Schneidenlänge
LB	Körperlänge
LB1	Körperlänge 1
LCF	Spannutenlänge
LE	Effektive Schneidenlänge
LF	Funktionale Länge
LFS	Sekundäre Funktionale Länge
LH	Kopflänge
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

Hochleistungs- und Universal-Lösungen

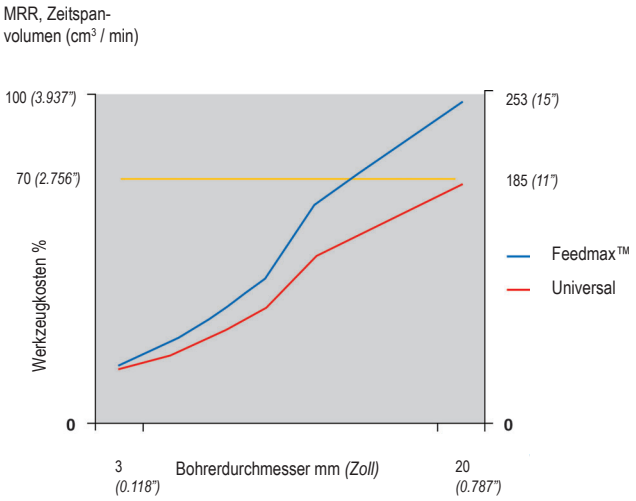
Was benötigen Sie in Ihren Anwendungen zum VHM-Bohren?

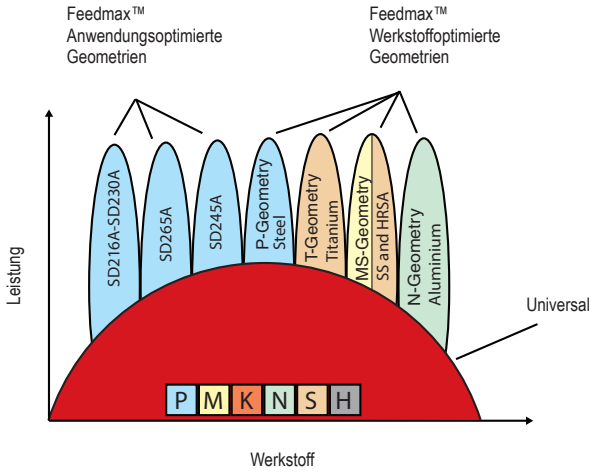
Universal – vielseitiger Vollhartmetallbohrer für allgemeine Bearbeitungen

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.

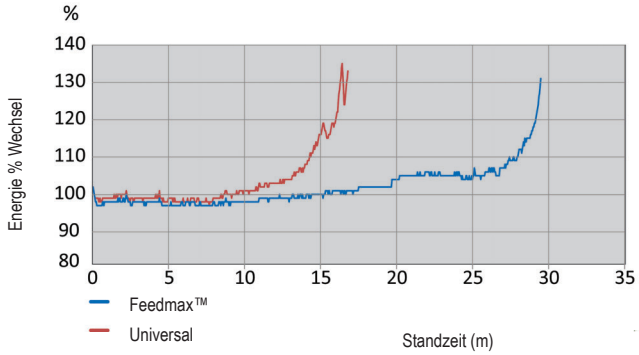
Feedmax™ – produktiver Hochleistungs-Vollhartmetallbohrer

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.





Standzeit, niedrigere Schnittdaten

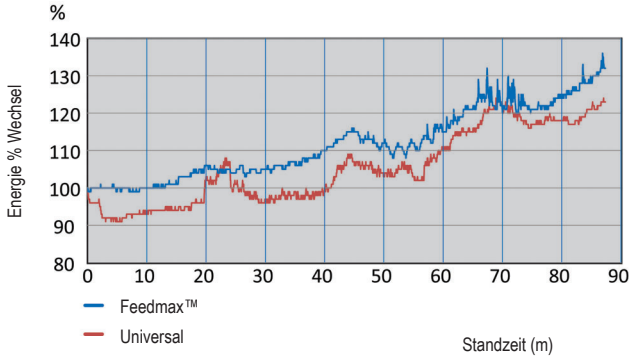


Die erste Bohrung dient als Referenzbohrung, 100% basierend auf der Spindelleistung
Schnittdaten
v_c = 90 m/min
f = 0,15 mm/U

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

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

Standzeit, hohe Schnittdaten

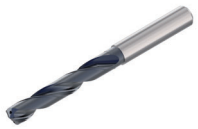


Die erste Bohrung dient als Referenzbohrung, 100% basierend auf der Spindelleistung
Schnittdaten
v_c = 160 m/min
f = 0,24 mm/U

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

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

Programmübersicht

Universal	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz (1)	Oberflächengüte (2)
SD1103  Seite(n) 26, 27, 28, 29, 30, 31	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) 32, 33, 34, 35, 36, 37	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) 38, 39, 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, 50	3-20 mm *(0.118-0.787")*	~ 8 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD1112A  Seite(n) 51, 52, 53, 54	3-20 mm *(0.118-0.787")*	~ 12 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*

1) Je nach verwendetem Werkstoff und verwendeten Schnittdaten kann es zu Abweichungen kommen.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können die Oberflächengüte beeinträchtigen.

Programmübersicht

Feedmax™	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz (1)	Oberflächengüte (2)
SD203A-P  Seite(n) 56, 57, 58, 59, 60, 61, 62	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) 63, 64, 65, 66, 67, 68, 69, 70	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) 71, 72	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) 73, 74, 75	3-20 mm *(0.118-0.787")*	~ 7 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD216A  Seite(n) 76	3-12 mm *(0.118-0.472")*	~ 16 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD230A  Seite(n) 77	4-10 mm *(0.157-0.393")*	~ 30 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*

1) Je nach verwendetem Werkstoff und verwendeten Schnittdaten kann es zu Abweichungen kommen.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können die Oberflächengüte beeinträchtigen.

Programmübersicht

Feedmax™	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz (1)	Oberflächengüte (2)
SD245A  Seite(n) 79, 80	5-14 mm *(0.196-0.551")*	~ 5 x D	m7	IT 8	Ra 1-2 µm *(Ra 39-79 µin)*
SD265A  Seite(n) 82	6-16 mm *(0.236-0.630")*	~ 5 x D	js6	IT 7	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-MS  Seite(n) 89, 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  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 Superlegierungen  Seite(n) 98, 99, 100	3-20 mm *(0.098-0.551")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-M Superlegierungen  Seite(n) 101, 102, 103	3-20 mm *(0.098-0.551")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*

1) Je nach verwendetem Werkstoff und verwendeten Schnittdaten kann es zu Abweichungen kommen.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können die Oberflächengüte beeinträchtigen.

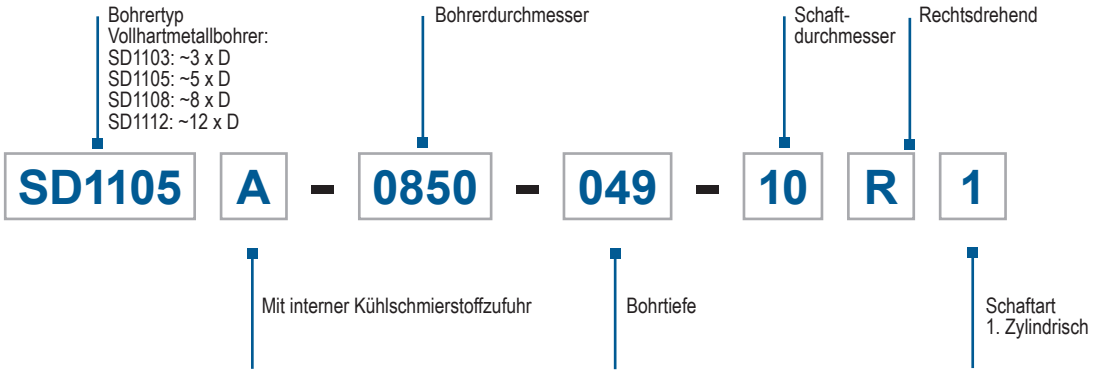
Programmübersicht

Feedmax™	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungs-toleranz (1)	Oberflächengüte (2)
SD203A-T, SD205A-T  Seite(n) 104, 105	3-20 mm *(0.118-0.787")*	~ 3 x D, ~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-N  Seite(n) 112, 113	3-20 mm *(0.118-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-C1, -C2  Seite(n) 114-116	3.2-12.7 mm *(0.125-0.500")*	~ 5 x D	m7	IT 9	–
SD203-CX1, -CX2, SD205-CX31  Seite(n) 94, 95, 96, 97	3.26-9.53 mm *(0.128-0.375")*	~ 5 x D	m7	IT 9	–
SD22  Seite(n) 118, 119, 120, 121, 122, 123, 124	0.1-2.0 mm *(0.004-0.079")*	~ 2 x D	0,005/0 mm (+0.0002"/0)	–	–
SD26  Seite(n) 125, 126, 127, 128, 129, 130, 131	0.1-2.0 mm *(0.004-0.079")*	~ 6 x D	0-0,04 mm (0/-0.0016")	–	–

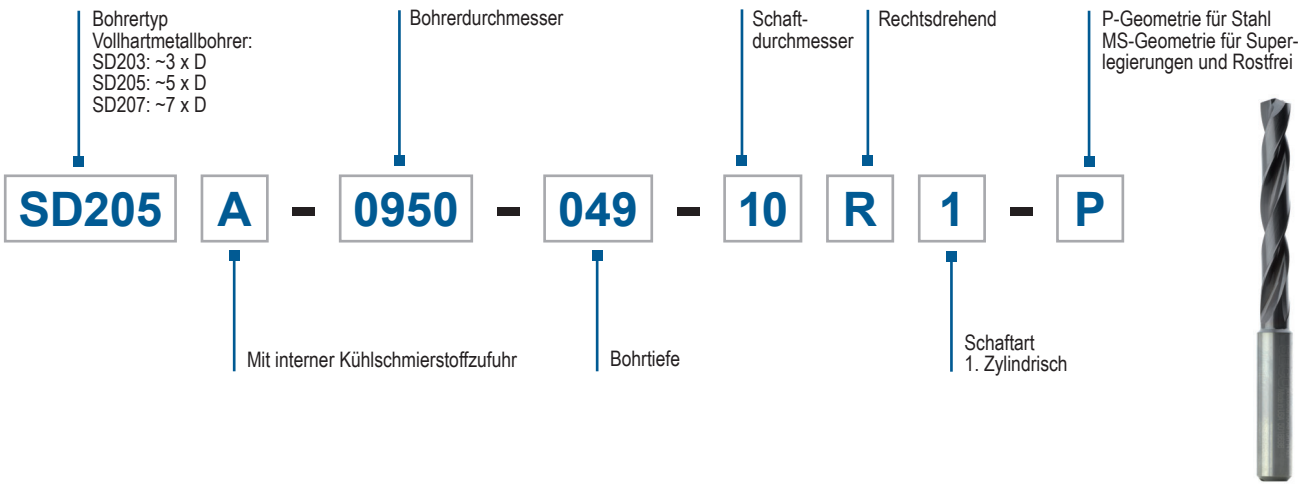
1) Je nach verwendetem Werkstoff und verwendeten Schnittdaten kann es zu Abweichungen kommen.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können die Oberflächengüte beeinträchtigen.

Code-Schlüssel

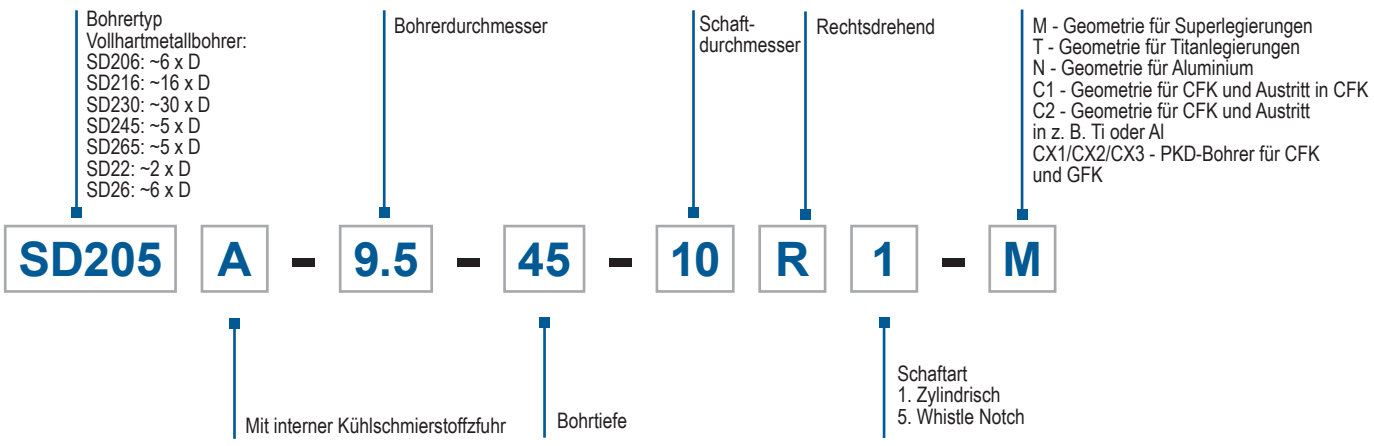
Universal



Feedmax™



Feedmax™



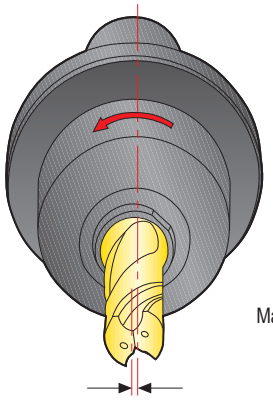
Einstellung

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 für Standzeit und Bohrungsqualität. Vorher den Zustand von Maschinenspindel und Aufspannvorrichtung prüfen, um die bestmöglichen Bearbeitungsbedingungen zu ermöglichen. Instabile Bedingungen können zu Werkzeugbruch führen.

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

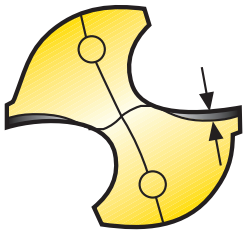
Empfehlungen für Werkzeugaufnahmen



Max. 0,04 mm (0.0016”)

Verwenden Sie die folgenden Aufnahmen für beste Ergebnisse:
Typ 5603 - Schrumpfaufnahmen, Typ DIN
Typ 5834 - Hydro-Dehnspannfutter
Typ 5672 - Hochpräzisionsspannzangenfutter
Weitere Informationen finden Sie im Seco Katalog Werkzeug-Systeme.

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)



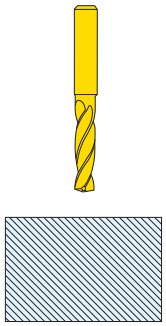
Hochpräzisionsspannzangenfutter
(Für zylindrische Aufnahmen, nur -R1 Schäfte verwenden)



Bearbeitungsverfahren

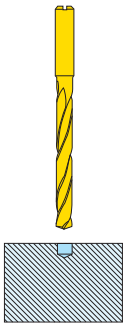
Empfehlungen für Werkzeugaufnahmen

3-15 x D



Es ist keine Zentrierbohrung oder reduzierter Eintrittsvorschub erforderlich.

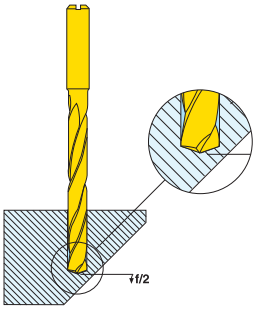
> 16 x D



Zentrierbohren mit einem kurzen Seco Feedmax ist erforderlich.

Winkelige Austrittsflächen

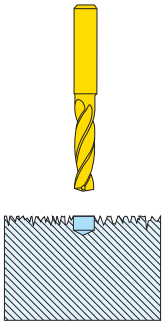
Vorschub ist am Bohrungsaustritt um 50% zu reduzieren



Oder SD245A Bohrer verwenden.

Ungleichmäßiger/winkeliger Eintritt

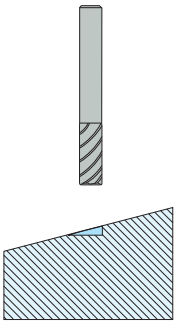
Bei ungleichmäßigen oder winkeligen Eintrittsflächen eine entsprechende Vorbearbeitung wählen.



Gleichmäßige Eintrittsfläche

Zentrierbohren mit einem kurzen Seco Feedmax.

Vorbearbeitungs-alternativen

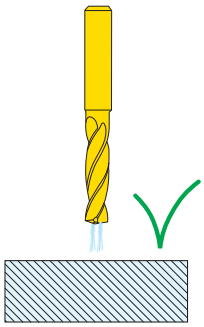


Winkeliger Bohrungseintritt

Fräsen einer ebenen Fläche mit einem Seco Vollhartmetallfräser.

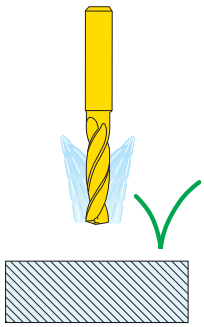
Empfehlungen für Kühlschmierstoffe

1.



Erste Wahl

2.



≤ 5 x D

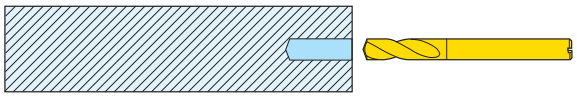
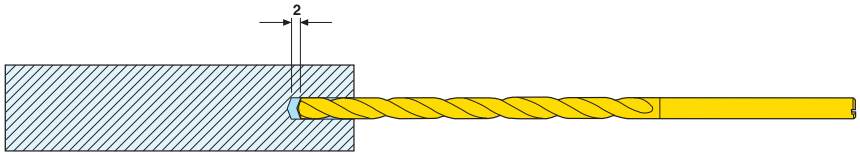
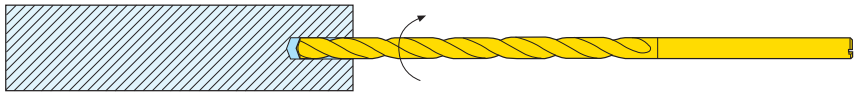
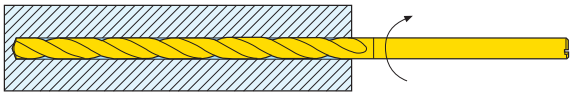
1. Kühlmitteldruck*
Minimaler Kühlschmierstoffdruck von 10 bar bei ≤ 5 x D
Minimaler Kühlschmierstoffdruck von 30 bar bei > 5 x D
Minimaler Kühlschmierstoffdruck von 40 bar bei > 16 x D

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

* Bei niedrigerem Kühlschmierstoffdruck sind die Schnittdaten entsprechend anzugleichen.

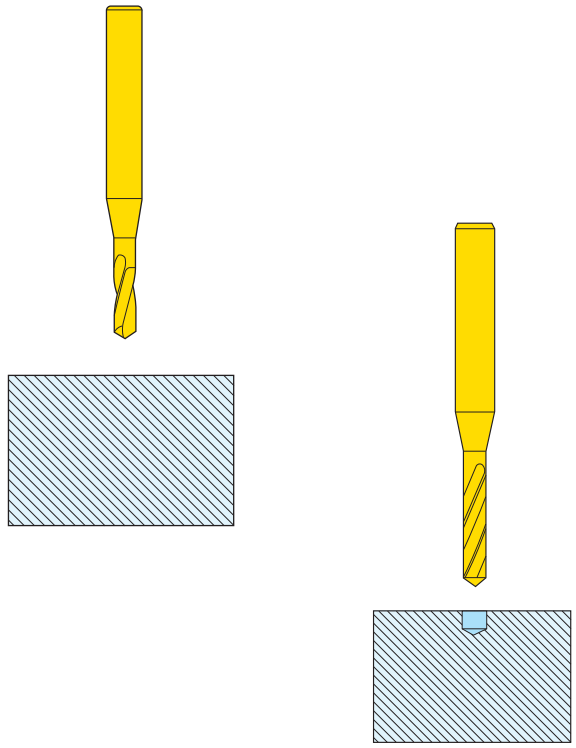
Bearbeitungsverfahren

SD216A (16 x D) bis SD230A (30 x D) - SCHRITT FÜR SCHRITT

1. 	1. Zentrierbohrung von 2-3 x D herstellen. Standard-bohrer mit demselben Durchmesser einsetzen, d. h. SD203A oder SD1103 (mit 140° Spitzenwinkel)
2. 	2. Den Bohrer bei stillstehender Spindel oder geringer Drehzahl (500) in das Werkstück einführen. 2 mm vor dem Ende der Zentrierbohrungstiefe anhalten.
3. 	3. Maschinenspindel und Kühlmittel in Betrieb setzen, beim Bohren die Schnittdatenempfehlungen beachten (kein Tieflochbohren.)
4. 	4. Wenn die volle Tiefe erreicht ist, die Spindel anhalten und den Bohrer herausziehen.

Bearbeitungsverfahren - Mikro-Bohrer

Zentrierbohrung



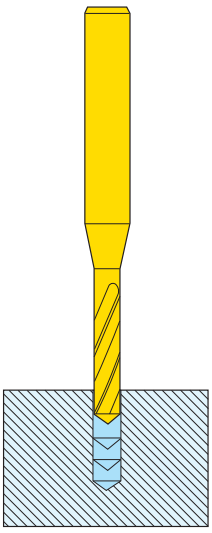
SD22

Für eine optimale Bohrungstoleranz und Positionierungsgenauigkeit einen SD22-Zentrierbohrer desselben Durchmessers verwenden.

SD26

Bei Bohrerdurchmessern unter 1 mm (0.039”) wird der Einsatz eines Zentrierbohrers empfohlen.

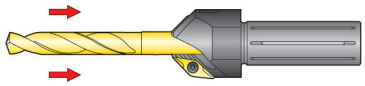
Tiefbohren



Für langspanende Werkstoffe sollte ein Tiefbohrzyklus eingesetzt werden. Einsatz jeweils 1 x D Bohrtiefe.

Montagehinweise für Fasringe

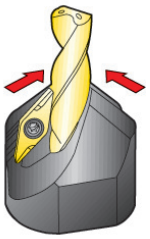
1.



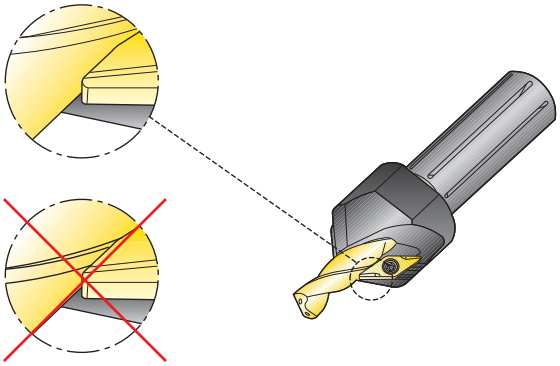
2.

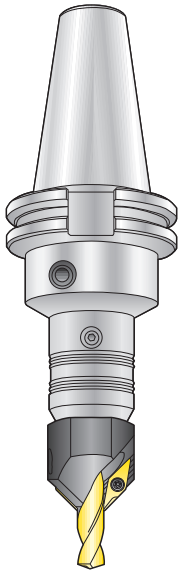


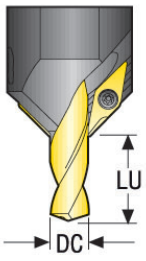
3.



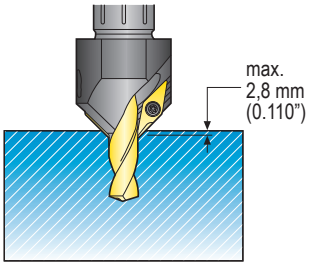
4.







Maximale Fastiefe



Bohrdurchmesser 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.



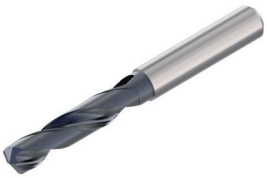
Seco Universal

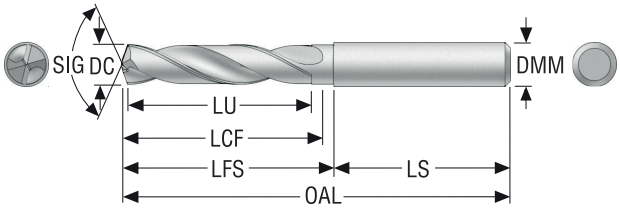
Seco Universal Vollhartmetallbohrer sind kosteneffiziente und vielseitige Lösungen für kleine bis mittlere Serien. Sie eignen sich für viele Anwendungen in allen Branchen.

- Vielzweck-, 4-Facetten-Spitzengeometrie für exzellente Zentrierung
- Hochverschleißfeste TiAlN-Beschichtung für lange Standzeit
- Kann in Kombination mit Threadmaster™ Taps und Precimaster™ Plus für vorbereitende Bearbeitungen genutzt werden

SD1103

Bohrtiefe ca. 3 x D





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Externe Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 142
- Zwischendurchmesser siehe Custom Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	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
SD1103-0357-014-06R1 *SD_DRILL_9/64_3XD*	02898982	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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
SD1103-0755-029-08R1 *SD_DRILL_7.55MM_3XD*	02899036	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	IT9
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
SD1103-0770-029-08R1 *SD_DRILL_7.7MM_3XD*	02899038	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
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

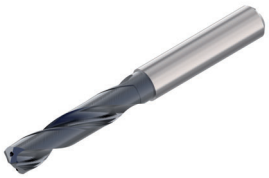
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-0930-035-10R1 *SD_DRILL_9.3MM_3XD*	02899060	9,3 *0.366*	35,0 *1.378*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	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
SD1103-0955-035-10R1 *SD_DRILL_9.55MM_3XD*	02899064	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
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
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
SD1103-1151-040-12R1 *SD_DRILL_29/64_3XD*	02899086	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
SD1103-1155-040-12R1 *SD_DRILL_11.55MM_3XD*	02899087	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	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

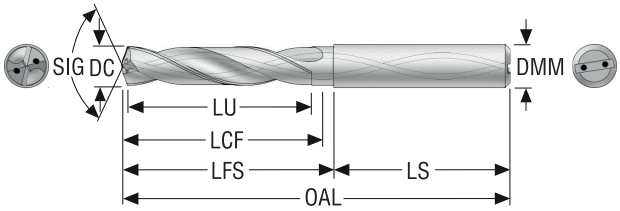
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103-1190-040-12R1 *SD_DRILL_11.9MM_3XD*	02899091	11,9 *0.469*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103-1191-040-12R1 *SD_DRILL_15/32_3XD*	02899092	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	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
SD1103-1230-043-14R1 *SD_DRILL_31/64_3XD*	02899096	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
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
SD1103-1290-043-14R1 *SD_DRILL_12.9MM_3XD*	02899103	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
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
SD1103-1340-043-14R1 *SD_DRILL_13.4MM_3XD*	02899108	13,4 *0.528*	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
SD1103-1370-043-14R1 *SD_DRILL_13.7MM_3XD*	02899112	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
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
SD1103-1390-043-14R1 *SD_DRILL_35/64_3XD*	02899114	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
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
SD1103-1429-045-16R1 *SD_DRILL_9/16_3XD*	02899117	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
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
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
SD1103-1480-045-16R1 *SD_DRILL_14.8MM_3XD*	02899122	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
SD1103-1530-045-16R1 *SD_DRILL_15.3MM_3XD*	02899125	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
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
SD1103-1570-045-16R1 *SD_DRILL_15.7MM_3XD*	02899127	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
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
SD1103-1900-055-20R1 *SD_DRILL_19.0MM_3XD*	02899136	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
SD1103-1905-055-20R1 *SD_DRILL_3/4_3XD*	02899137	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
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





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 143
- Zwischendurchmesser siehe Custom Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	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-0325-014-06R1 *SD_DRILL_3.25MM_3XD_A*	02898248	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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
SD1103A-0755-029-08R1 *SD_DRILL_7.55MM_3XD_A*	02898306	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	IT9
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-0890-035-10R1 *SD_DRILL_8.9MM_3XD_A*	02898323	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
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-0913-035-10R1 *SD_DRILL_23/64_3XD_A*	02898326	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
SD1103A-0920-035-10R1 *SD_DRILL_9.2MM_3XD_A*	02898327	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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-0992-035-10R1 *SD_DRILL_25/64_3XD_A*	02898337	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
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
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-1155-040-12R1 *SD_DRILL_11.55MM_3XD_A*	02898355	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	IT9
SD1103A-1160-040-12R1 *SD_DRILL_11.6MM_3XD_A*	02898356	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
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

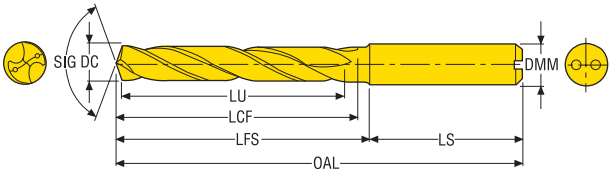
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1103A-1190-040-12R1 *SD_DRILL_11.9MM_3XD_A*	02898359	11,9 *0.469*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*	140°	TiAlN	IT9
SD1103A-1191-040-12R1 *SD_DRILL_15/32_3XD_A*	02898360	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	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-1240-043-14R1 *SD_DRILL_12.4MM_3XD_A*	02898365	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
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-1275-043-14R1 *SD_DRILL_12.75MM_3XD_A*	02898369	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
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-1340-043-14R1 *SD_DRILL_13.4MM_3XD_A*	02898376	13,4 *0.528*	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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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-1950-055-20R1 *SD_DRILL_19.5MM_3XD_A*	02898405	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
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





- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 144
- Zwischendurchmesser siehe Custom Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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-0755-043-08R1 *SD_DRILL_7.55MM_5XD_A*	02897907	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	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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-1151-056-12R1 *SD_DRILL_29/64_5XD_A*	02897959	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	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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-1330-060-14R1 *SD_DRILL_13.3MM_5XD_A*	02897982	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	IT9
SD1105A-1340-060-14R1 *SD_DRILL_13.4MM_5XD_A*	02897983	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	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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-1440-063-16R1 *SD_DRILL_14.4MM_5XD_A*	02897995	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	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-1460-063-16R1 *SD_DRILL_14.6MM_5XD_A*	02897997	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	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-1475-063-16R1 *SD_DRILL_14.75MM_5XD_A*	02897999	14,75 *0.581*	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-1540-063-16R1 *SD_DRILL_15.4MM_5XD_A*	02898006	15,4 *0.606*	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-1630-071-18R1 *SD_DRILL_16.3MM_5XD_A*	02898016	16,3 *0.642*	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-1640-071-18R1 *SD_DRILL_16.4MM_5XD_A*	02898017	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	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-1660-071-18R1 *SD_DRILL_16.6MM_5XD_A*	02898019	16,6 *0.654*	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
SD1105A-1690-071-18R1 *SD_DRILL_16.9MM_5XD_A*	02898023	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	IT9

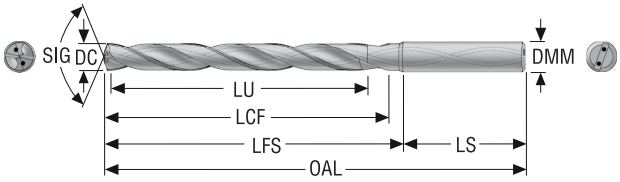
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-1700-071-18R1 *SD_DRILL_17.0MM_5XD_A*	02898024	17,0 *0.669*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	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-1740-071-18R1 *SD_DRILL_17.4MM_5XD_A*	02898028	17,4 *0.685*	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-1760-071-18R1 *SD_DRILL_17.6MM_5XD_A*	02898030	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	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-1780-071-18R1 *SD_DRILL_17.8MM_5XD_A*	02898032	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	IT9
SD1105A-1790-071-18R1 *SD_DRILL_17.9MM_5XD_A*	02898033	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	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-1810-077-20R1 *SD_DRILL_18.1MM_5XD_A*	02898035	18,1 *0.713*	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-1820-077-20R1 *SD_DRILL_18.2MM_5XD_A*	02898036	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	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-1840-077-20R1 *SD_DRILL_18.4MM_5XD_A*	02898038	18,4 *0.724*	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-1890-077-20R1 *SD_DRILL_18.9MM_5XD_A*	02898043	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	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-1905-077-20R1 *SD_DRILL_3/4_5XD_A*	02898045	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	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-1920-077-20R1 *SD_DRILL_19.2MM_5XD_A*	02898047	19,2 *0.756*	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-1940-077-20R1 *SD_DRILL_19.4MM_5XD_A*	02898049	19,4 *0.764*	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-1960-077-20R1 *SD_DRILL_19.6MM_5XD_A*	02898051	19,6 *0.772*	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1105A-1990-077-20R1 *SD_DRILL_19.9MM_5XD_A*	02898054	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	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





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 145
- Zwischendurchmesser siehe Custom Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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

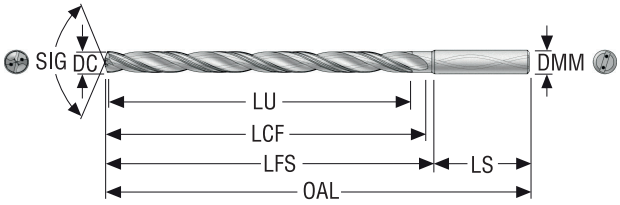
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1108A-0714-064-08R1 *SD_DRILL_9/32_8XD_A*	03323688	7,144 *0.281*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	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
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-0833-080-10R1 *SD_DRILL_21/64_8XD_A*	03323693	8,334 *0.328*	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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
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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 146
- Zwischendurchmesser siehe Custom Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	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-0357-048-06R1 *SD_DRILL_9/64_12XD_A*	03323705	3,572 *0.141*	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-0437-056-06R1 *SD_DRILL_11/64_12XD_A*	03323707	4,366 *0.172*	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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-0480-074-06R1 *SD_DRILL_4.8MM_12XD_A*	03295103	4,8 *0.189*	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
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-0540-074-06R1 *SD_DRILL_5.4MM_12XD_A*	03295109	5,4 *0.213*	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-0556-074-06R1 *SD_DRILL_7/32_12XD_A*	03295111	5,556 *0.219*	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-0570-074-06R1 *SD_DRILL_5.7MM_12XD_A*	03295113	5,7 *0.224*	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-0590-074-06R1 *SD_DRILL_5.9MM_12XD_A*	03295115	5,9 *0.232*	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-0630-098-08R1 *SD_DRILL_6.3MM_12XD_A*	03295119	6,3 *0.248*	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-0640-098-08R1 *SD_DRILL_6.4MM_12XD_A*	03295121	6,4 *0.252*	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-0710-098-08R1 *SD_DRILL_7.1MM_12XD_A*	03295128	7,1 *0.280*	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
SD1112A-0730-098-08R1 *SD_DRILL_7.3MM_12XD_A*	03323712	7,3 *0.287*	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-0870-123-10R1 *SD_DRILL_8.7MM_12XD_A*	03295141	8,7 *0.343*	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-0913-123-10R1 *SD_DRILL_23/64_12XD_A*	03323716	9,128 *0.359*	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
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-0970-123-10R1 *SD_DRILL_9.7MM_12XD_A*	03295146	9,7 *0.382*	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-1072-140-12R1 *SD_DRILL_27/64_12XD_A*	03323720	10,716 *0.422*	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM	Spitzen-winkel	Beschichtung	Bohrungs-toleranz
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			
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-1170-140-12R1 *SD_DRILL_11.7MM_12XD_A*	03295156	11,7 *0.461*	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-1180-140-12R1 *SD_DRILL_11.8MM_12XD_A*	03295157	11,8 *0.465*	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-1191-140-12R1 *SD_DRILL_15/32_12XD_A*	03323723	11,906 *0.469*	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-1220-168-14R1 *SD_DRILL_12.2MM_12XD_A*	03295159	12,2 *0.480*	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-1230-168-14R1 *SD_DRILL_31/64_12XD_A*	03295160	12,3 *0.484*	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-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-1349-168-14R1 *SD_DRILL_17/32_12XD_A*	03323724	13,494 *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-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-1450-192-16R1 *SD_DRILL_14.5MM_12XD_A*	03295167	14,5 *0.571*	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-1550-192-16R1 *SD_DRILL_15.5MM_12XD_A*	03295169	15,5 *0.610*	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-1588-192-16R1 *SD_DRILL_5/8_12XD_A*	03295170	15,875 *0.625*	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
SD1112A-2000-238-20R1 *SD_DRILL_20.0MM_12XD_A*	03295177	20,0 *0.787*	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

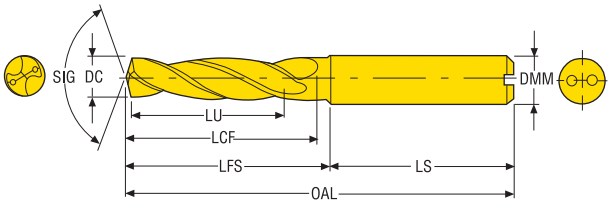
Die Feedmax -P-Bohrer bieten eine hohe Produktivität und geringe Kosten pro Bohrung durch eine einzigartige Kombination von Hartmetall, Beschichtung und Geometrie.

- 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





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 147-163
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

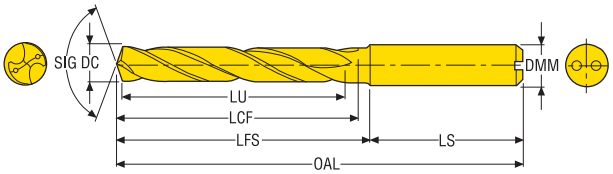
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-1080-040-12R1-P	03046008	10,8 *0.425*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*
SD203A-1090-040-12R1-P	03046009	10,9 *0.429*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0 *0.472*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-1340-043-14R1-P	03046034	13,4 *0.528*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD203A-1475-045-16R1-P	03046044	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*
SD203A-1480-045-16R1-P	03046045	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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*

SD205A-P

Bohrtiefe ca. 5 x D – Metrisch





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 149-165
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

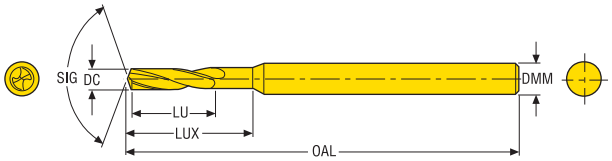
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD205A-1300-060-14R1-P	03046252	13,0 *0.512*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*
SD205A-1310-060-14R1-P	03046253	13,1 *0.516*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*
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*
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*
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*
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*
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*
SD205A-1355-060-14R1-P	03138158	13,55 *0.533*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD205A-1475-063-16R1-P	03046270	14,75 *0.581*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD205A-1540-063-16R1-P	03046277	15,4 *0.606*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD205A-1630-071-18R1-P	03046287	16,3 *0.642*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*
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*
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*
SD205A-1660-071-18R1-P	03046290	16,6 *0.654*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD205A-1740-071-18R1-P	03046300	17,4 *0.685*	71,0 *2.795*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*
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*
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*
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*
SD205A-1770-071-18R1-P	03046303	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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
SD205A-1810-077-20R1-P	03046307	18,1 *0.713*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
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*
SD205A-1830-077-20R1-P	03046309	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*
SD205A-1840-077-20R1-P	03046310	18,4 *0.724*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
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*
SD205A-1860-077-20R1-P	03046312	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*
SD205A-1870-077-20R1-P	03046313	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*
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*
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*
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*
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*
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*
SD205A-1920-077-20R1-P	03046318	19,2 *0.756*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
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*
SD205A-1940-077-20R1-P	03046320	19,4 *0.764*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
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*
SD205A-1960-077-20R1-P	03046322	19,6 *0.772*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
SD205A-1970-077-20R1-P	03046323	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*
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*
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*
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*

SD206

Bohrtiefe ca. 6 x D





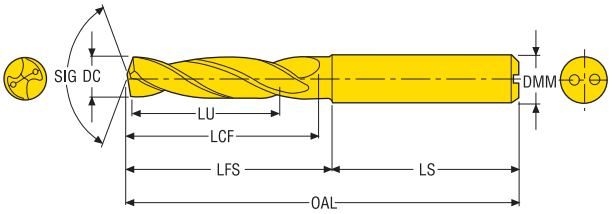
- Zylinderschaft
- Externe Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN
- Bohrungstoleranz: IT9
- Schnittdaten, siehe Seite(n) 151

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

SD206A

Bohrtiefe ca. 6 x D



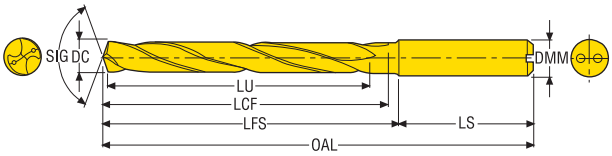


- Zylinderschaft
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN
- Bohrungstoleranz: IT9
- Schnittdaten, siehe Seite(n) 152

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

SD207A-P

Bohrtiefe ca. 7 x D – Metrisch





- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN
- Bohrungstoleranz: IT9
- Schnittdaten, siehe Seite(n) 153
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

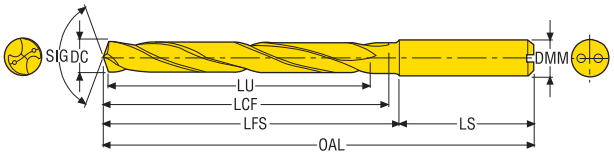
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD207A-0870-062-10R1-P	03046411	8,7 *0.343*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*
SD207A-0880-062-10R1-P	03046408	8,8 *0.346*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

SD216A

Bohrtiefe ca. 16 x D



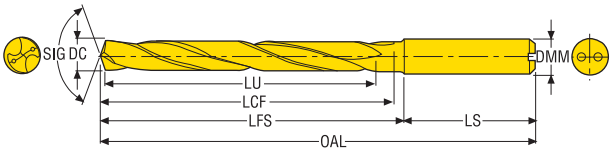


- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 136°
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT9
- Schnittdaten, siehe Seite(n) 154
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD216A-3.0-50-4R1	02712383	3,0 *0.118*	50,0 *1.969*	88,0 *3.465*	61,0 *2.402*	27,0 *1.063*	56,0 *2.205*	4,0 *0.157*
SD216A-3.5-60-4R1	02712384	3,5 *0.138*	60,0 *2.362*	99,0 *3.898*	72,0 *2.835*	27,0 *1.063*	67,0 *2.638*	4,0 *0.157*
SD216A-4.0-60-4R1	02712385	4,0 *0.157*	60,0 *2.362*	99,0 *3.898*	72,0 *2.835*	27,0 *1.063*	67,0 *2.638*	4,0 *0.157*
SD216A-4.5-70-6R1	02712386	4,5 *0.177*	70,0 *2.756*	117,0 *4.606*	81,0 *3.189*	36,0 *1.417*	79,0 *3.110*	6,0 *0.236*
SD216A-5.0-90-6R1	02637529	5,0 *0.197*	90,0 *3.543*	142,0 *5.591*	106,0 *4.173*	36,0 *1.417*	103,0 *4.055*	6,0 *0.236*
SD216A-5.5-90-6R1	02637530	5,5 *0.217*	90,0 *3.543*	142,0 *5.591*	106,0 *4.173*	36,0 *1.417*	103,0 *4.055*	6,0 *0.236*
SD216A-6.0-90-6R1	02637531	6,0 *0.236*	90,0 *3.543*	142,0 *5.591*	106,0 *4.173*	36,0 *1.417*	103,0 *4.055*	6,0 *0.236*
SD216A-6.35-120-8R1	02656536	6,35 *0.250*	120,0 *4.724*	177,0 *6.969*	141,0 *5.551*	36,0 *1.417*	137,0 *5.394*	8,0 *0.315*
SD216A-6.5-120-8R1	02637532	6,5 *0.256*	120,0 *4.724*	177,0 *6.969*	141,0 *5.551*	36,0 *1.417*	137,0 *5.394*	8,0 *0.315*
SD216A-7.0-120-8R1	02637533	7,0 *0.276*	120,0 *4.724*	177,0 *6.969*	141,0 *5.551*	36,0 *1.417*	137,0 *5.394*	8,0 *0.315*
SD216A-7.5-120-8R1	02637534	7,5 *0.295*	120,0 *4.724*	177,0 *6.969*	141,0 *5.551*	36,0 *1.417*	137,0 *5.394*	8,0 *0.315*
SD216A-8.0-120-8R1	02637536	8,0 *0.315*	120,0 *4.724*	177,0 *6.969*	141,0 *5.551*	36,0 *1.417*	137,0 *5.394*	8,0 *0.315*
SD216A-8.5-150-10R1	02637539	8,5 *0.335*	150,0 *5.906*	216,0 *8.504*	176,0 *6.929*	40,0 *1.575*	172,0 *6.772*	10,0 *0.394*
SD216A-9.0-150-10R1	02637540	9,0 *0.354*	150,0 *5.906*	216,0 *8.504*	176,0 *6.929*	40,0 *1.575*	172,0 *6.772*	10,0 *0.394*
SD216A-9.5-150-10R1	02637541	9,5 *0.374*	150,0 *5.906*	216,0 *8.504*	176,0 *6.929*	40,0 *1.575*	172,0 *6.772*	10,0 *0.394*
SD216A-9.52-150-10R1	02656537	9,52 *0.375*	150,0 *5.906*	216,0 *8.504*	176,0 *6.929*	40,0 *1.575*	172,0 *6.772*	10,0 *0.394*
SD216A-10.0-150-10R1	02637542	10,0 *0.394*	150,0 *5.906*	216,0 *8.504*	176,0 *6.929*	40,0 *1.575*	172,0 *6.772*	10,0 *0.394*
SD216A-10.5-180-12R1	02637543	10,5 *0.413*	180,0 *7.087*	256,0 *10.079*	211,0 *8.307*	45,0 *1.772*	207,0 *8.150*	12,0 *0.472*
SD216A-11.0-180-12R1	02637544	11,0 *0.433*	180,0 *7.087*	256,0 *10.079*	211,0 *8.307*	45,0 *1.772*	207,0 *8.150*	12,0 *0.472*
SD216A-11.5-180-12R1	02637545	11,5 *0.453*	180,0 *7.087*	256,0 *10.079*	211,0 *8.307*	45,0 *1.772*	207,0 *8.150*	12,0 *0.472*
SD216A-12.0-180-12R1	02637546	12,0 *0.472*	180,0 *7.087*	256,0 *10.079*	211,0 *8.307*	45,0 *1.772*	207,0 *8.150*	12,0 *0.472*

SD230A

Bohrtiefe ca. 30 x D





- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 136°
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT9
- Schnittdaten, siehe Seite(n) 155
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD230A-4.0-112-4R1	02712361	4,0 *0.157*	112,0 *4.409*	151,0 *5.945*	124,0 *4.882*	27,0 *1.063*	119,0 *4.685*	4,0 *0.157*
SD230A-4.5-135-6R1	02712362	4,5 *0.177*	135,0 *5.315*	185,0 *7.283*	149,0 *5.866*	36,0 *1.417*	145,0 *5.709*	6,0 *0.236*
SD230A-5.0-170-6R1	02712363	5,0 *0.197*	170,0 *6.693*	220,0 *8.661*	184,0 *7.244*	36,0 *1.417*	180,0 *7.087*	6,0 *0.236*
SD230A-5.5-170-6R1	02712364	5,5 *0.217*	170,0 *6.693*	220,0 *8.661*	184,0 *7.244*	36,0 *1.417*	180,0 *7.087*	6,0 *0.236*
SD230A-6.0-170-6R1	02712365	6,0 *0.236*	170,0 *6.693*	220,0 *8.661*	184,0 *7.244*	36,0 *1.417*	180,0 *7.087*	6,0 *0.236*
SD230A-02500-886-0315R1	02712366	6,35 *0.250*	225,0 *8.858*	279,0 *10.984*	243,0 *9.567*	36,0 *1.417*	239,0 *9.409*	8,0 *0.315*
SD230A-6.5-225-8R1	02712367	6,5 *0.256*	225,0 *8.858*	279,0 *10.984*	243,0 *9.567*	36,0 *1.417*	239,0 *9.409*	8,0 *0.315*
SD230A-7.0-225-8R1	02712370	7,0 *0.276*	225,0 *8.858*	279,0 *10.984*	243,0 *9.567*	36,0 *1.417*	239,0 *9.409*	8,0 *0.315*
SD230A-7.5-225-8R1	02712371	7,5 *0.295*	225,0 *8.858*	279,0 *10.984*	243,0 *9.567*	36,0 *1.417*	239,0 *9.409*	8,0 *0.315*
SD230A-03125-886-0315R1	02712374	7,938 *0.313*	225,0 *8.858*	279,0 *10.984*	243,0 *9.567*	36,0 *1.417*	239,0 *9.409*	8,0 *0.315*
SD230A-8.0-225-8R1	02712376	8,0 *0.315*	225,0 *8.858*	279,0 *10.984*	243,0 *9.567*	36,0 *1.417*	239,0 *9.409*	8,0 *0.315*
SD230A-8.5-285-10R1	02712378	8,5 *0.335*	285,0 *11.220*	346,0 *13.622*	306,0 *12.047*	40,0 *1.575*	302,0 *11.890*	10,0 *0.394*
SD230A-9.0-285-10R1	02712379	9,0 *0.354*	285,0 *11.220*	346,0 *13.622*	306,0 *12.047*	40,0 *1.575*	302,0 *11.890*	10,0 *0.394*
SD230A-9.5-285-10R1	02712380	9,5 *0.374*	285,0 *11.220*	346,0 *13.622*	306,0 *12.047*	40,0 *1.575*	302,0 *11.890*	10,0 *0.394*
SD230A-03750-1122-0394R1	02712381	9,525 *0.375*	285,0 *11.220*	346,0 *13.622*	306,0 *12.047*	40,0 *1.575*	302,0 *11.890*	10,0 *0.394*
SD230A-10.0-285-10R1	02712382	10,0 *0.394*	285,0 *11.220*	346,0 *13.622*	306,0 *12.047*	40,0 *1.575*	302,0 *11.890*	10,0 *0.394*



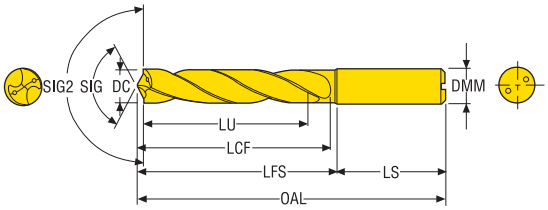
Feedmax™ SD245A

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





- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°/180°
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8
- Schnittdaten, siehe Seite(n) 156
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
SD245A-02500-138-0315R1	02691686	6,35 *0.2500*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD245A-11.0-56-12R1	02561860	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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
SD245A-05312-232-0551R1	02691709	13,494 *0.5312*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*
SD245A-13.5-59-14R1	02691710	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*
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*



Feedmax™ SD265A

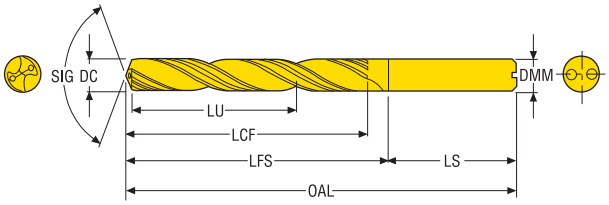
Die Hochpräzisionsbohrer SD265A IT 7 stehen für höchste Genauigkeit. Darüber hinaus kann ein Bohrer SD265A Vorbearbeitungen vereinfachen. Dank der folgenden Merkmale kann die Bohrung in einem Durchgang gefertigt werden:

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

SD265A

Bohrtiefe ca. 5 x D





- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT7
- Schnittdaten, siehe Seite(n) 157
- Zwischendurchmesser siehe My Design.
- Passstift Standard ANSI / ASME B18.8.2-1995.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*



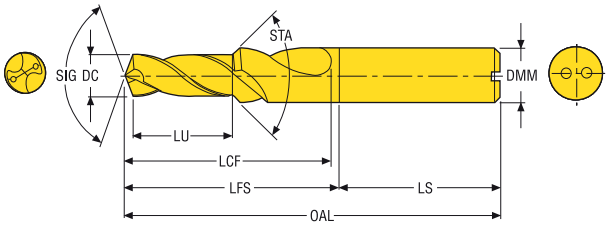
Feedmax™ – Fasbohrer

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° inkludierter Winkel)

Fasbohrer – Gewinde M4 - M16

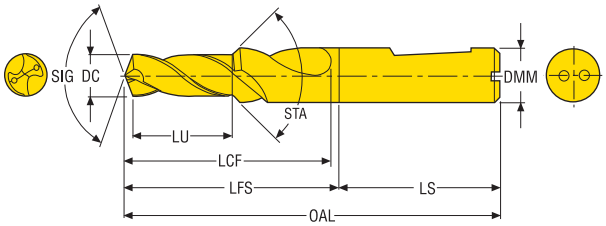




- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8-9
- Faswinkel = 90°
- Schnittdaten, siehe Seite(n) 147, 148

Bezeichnung	Produkt-nummer	Geschnittenes Gewinde	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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-C45-14.5-38.5-18R1	02500356	Feingewinde Metrisch	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*

Fasbohrer – Gewinde M4 - M16





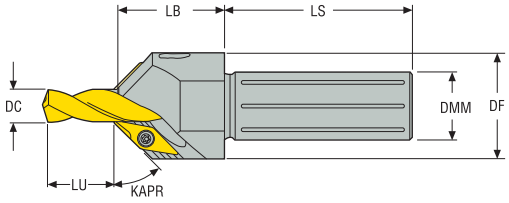
- Whistle Notch Schaft DIN 6537B
- Mit interner Kühlschmierstoffzufuhr
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8-9
- Faswinkel = 90°
- Schnittdaten, siehe Seite(n) 147, 148

Bezeichnung	Produkt-nummer	Geschnittenes Gewinde	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Metrisch	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 Seco Universal und Feedmax

Metrisch

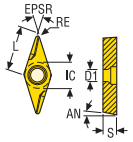




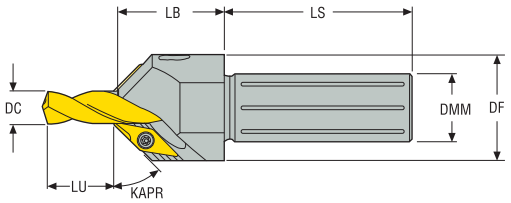
Bezeichnung	Produkt-nummer	DC	Bohrtiefe LU 3 x D LU (min-max)	Bohrtiefe LU 5 x D LU (min-max)	Bohrtiefe LU 7 x D LU (min-max)	Max. Fastiefe	LB	DF	LS	DMM	KAPR°
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
SD200-C45-6R1	02510275	4,01-6,1	4,0-17,0	10,0-27,0	30,0-45,0	2,8	25,0	21,0	41,0	12,0	45,0
SD200-C45-8R1	02510278	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	45,0
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	45,0
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	45,0
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	45,0
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	45,0

Ersatzteile

Bohrerdurchmesser (mm)	Schlüssel	Schraube	Spannschlüssel	Klemmschraube	Kassette
					
	Wendeplatte	Wendeplatte	Fasring	Fasring	Fasring
4,00 - 16,00	T07P-2	C02205-T07P	H1.5-2D	SH3040	SD200-3x7.3

	Toleranzen: mm	Größe	IC mm	L mm	S mm	D1 mm	RE mm
	IC = ±0,025 S = ±0,07 RE = ±0,10	C45	5,556	9,000	2,500	2,900	0,200
		Sorte: T400D					
		Bezeichnung: SD200-C45					
		Produktnummer: 02510325					

Fasringe für Seco Universal und Feedmax

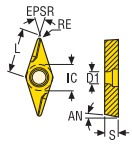




Bezeichnung	Produkt-nummer	DC	Bohrtiefe LU 3 x D LU (min-max)	5 x D LU (min-max)	7 x D LU (min-max)	Max. Fastiefe	DF	LB	LS	DMM	KAPR°
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	
SD200-C45-6-500R1	02510287	0.158-0.240	0.157-0.669	0.394-1.063	1.181-1.772	0.110	0.827	0.984	1.614	0.500	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

Bohrerdurchmesser (Zoll)	Schlüssel	Schraube	Spannschlüssel	Kassette
				
	Wendeplatte	Wendeplatte	Fasring	Fasring
0.1574 - 0.6299	T07P-2	C02205-T07P	H1.5-2D	SD200-3x7.3



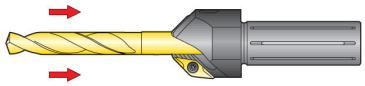
Toleranzen:
Zoll

IC = ±0.001
S = ±0.0027
RE = ±0.004

Größe	IC Zoll	L Zoll	S Zoll	D1 Zoll	RE Zoll
C45	0.2187	0.3543	0.0984	0.1141	0.0078
Sorte: T400D					
Bezeichnung: SD200-C45					
Produktnummer: 02510325					

Montagehinweise für Fasringe

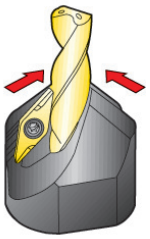
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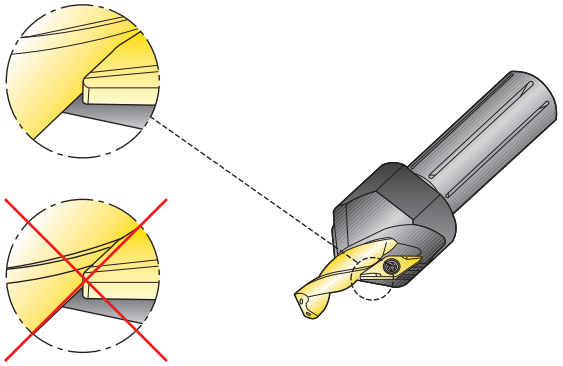
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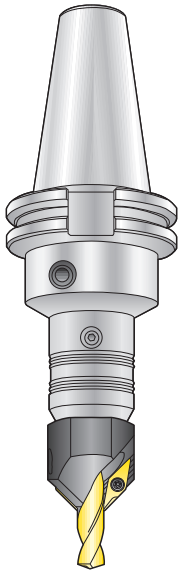


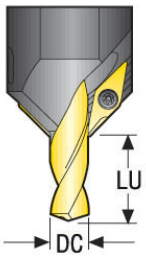
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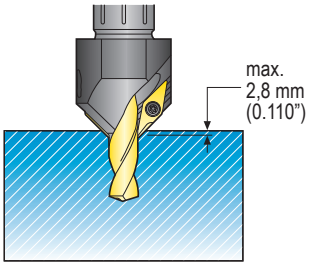
4.







Maximale Fastiefe

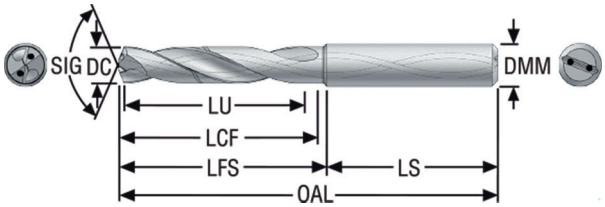


Bohrdurchmesser DC		LU Bohrtiefe (min.-max.) SD1103 / SD203A		SD1105 / SD205A		SD207A	
mm		mm	*Zoll*	mm	*Zoll*	mm	*Zoll*
4,00-4,75	*.157-.187*	4-17	*.157-.669*	10-27	*.394-1.063*	30-45	*1.181-1.772*
4,76-6,00	*.187-.236*	6-20	*.236-.787*	18-32	*.709-1.260*	30-45	*1.181-1.772*
6,01-8,00	*.241-.315*	15-27	*.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





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN +NbN
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 158-159
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

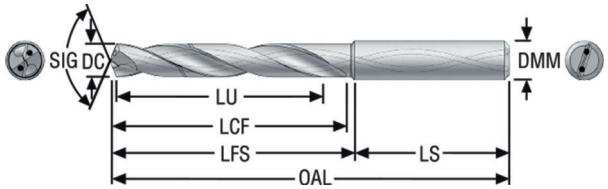
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-0970-031-10R1-MS	10004161	9,7 *0.382*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*
SD203A-0980-031-10R1-MS	10004162	9,8 *0.386*	31,0 *1.220*	89,0 *3.504*	49,0 *1.929*	40,0 *1.575*	47,0 *1.850*	10,0 *0.394*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

SD205A, -MS

Bohrtiefe ca. 5 x D





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN +NbN
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 160-161
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

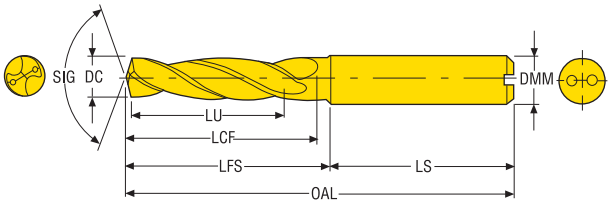
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD205A-0720-040-08R1-MS	10004239	7,2 *0.283*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*
SD205A-0750-040-08R1-MS	10004240	7,5 *0.295*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD205A-1930-077-20R1-MS	10004305	19,3 *0.760*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
SD205A-1950-077-20R1-MS	10004306	19,5 *0.768*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*
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*

SD203A, -M

Bohrtiefe ca. 3 x D – Metrisch





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 147, 148
- Zwischendurchmesser siehe My Design.

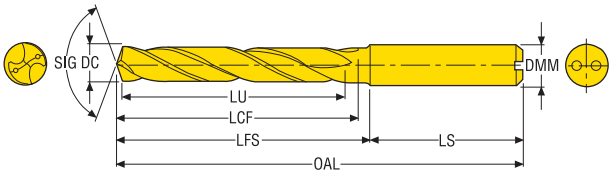
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-3.0-14-6R1-M	02569995	3,0 *0.118*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*
SD203A-3.1-14-6R1-M	02570998	3,1 *0.122*	14,0 *0.551*	62,0 *2.441*	26,0 *1.024*	36,0 *1.417*	20,0 *0.787*	6,0 *0.236*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

SD205A, -M

Bohrtiefe ca. 5 x D





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Beschichtung: TiAlN + TiN
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 149, 150
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

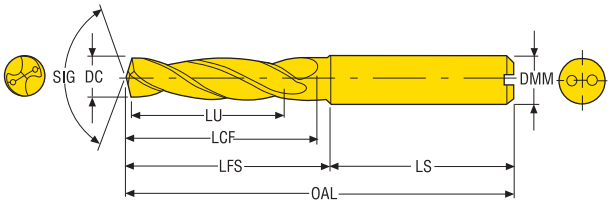
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD205A-5.9-32-6R1-M	02539334	5,9 *0.232*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*
SD205A-6.0-32-6R1-M	02450035	6,0 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
SD205A-12.9-56-14R1-M	02592729	12,9 *0.508*	56,0 *2.205*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*
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*
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*
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*
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*
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*
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*
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*
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*

SD203A, -T

Bohrtiefe ca. 3 x D





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Unbeschichtet
- Bohrungstoleranz: IT8-9
- Schnittdaten - www.secotools.com
- Zwischendurchmesser siehe My Design.

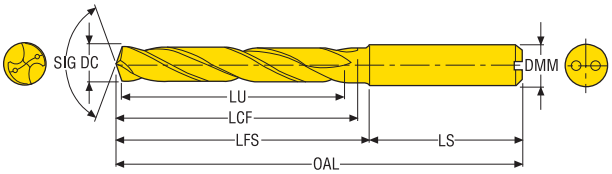
Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-01875-079-0236R1-T	02569147	4,763 *0.188*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*
SD203A-5.0-20-6R1-T	02523021	5,0 *0.197*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD203A-8.8-29-10R1-T	02569153	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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-11.5-33-12R1-T	02567385	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*
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*

SD205A, -T

Bohrtiefe ca. 5 x D



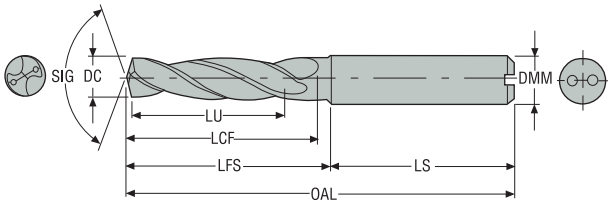


- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- Unbeschichtet
- Bohrungstoleranz: IT8-9
- Schnittdaten - www.secotools.com
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*

SD203A, -N

Bohrtiefe ca. 3 x D





- Zylinderschaft DIN 6537A
- Toleranz DC m7
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°
- DLC-beschichtet
- Bohrungstoleranz: IT8-9
- Schnittdaten, siehe Seite(n) 147, 148
- Zwischendurchmesser siehe Custom Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
SD203A-03125-106-0315R1-N	02691570	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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LFS	LS	LCF	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

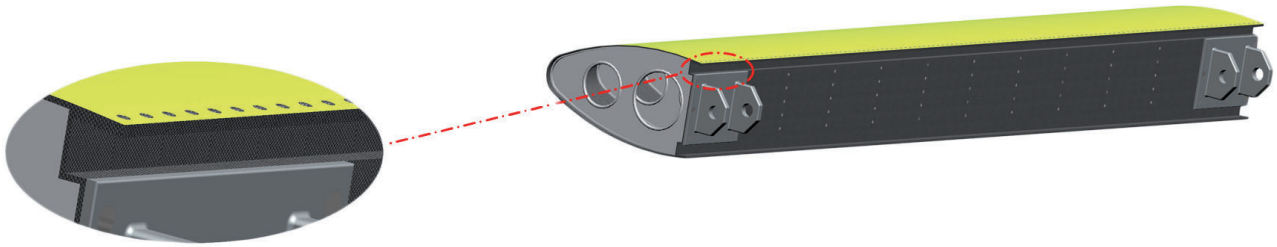


Bohrungsbearbeitung von Composite-Werkstoffen

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

- Die flache Geometrie der Bohrerspitze des C2 und CX2 eignet sich zur Bearbeitung von Verbundwerkstoffen mit Aluminium- oder Titanschichten.
- Die PKD-Bohrer CX1 und CX2 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.

Bohren von Composite-Werkstoffen



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
CX1





Sandwich-Werkstoff
(Austritt in Al/Ti)

Geometrie
CX2



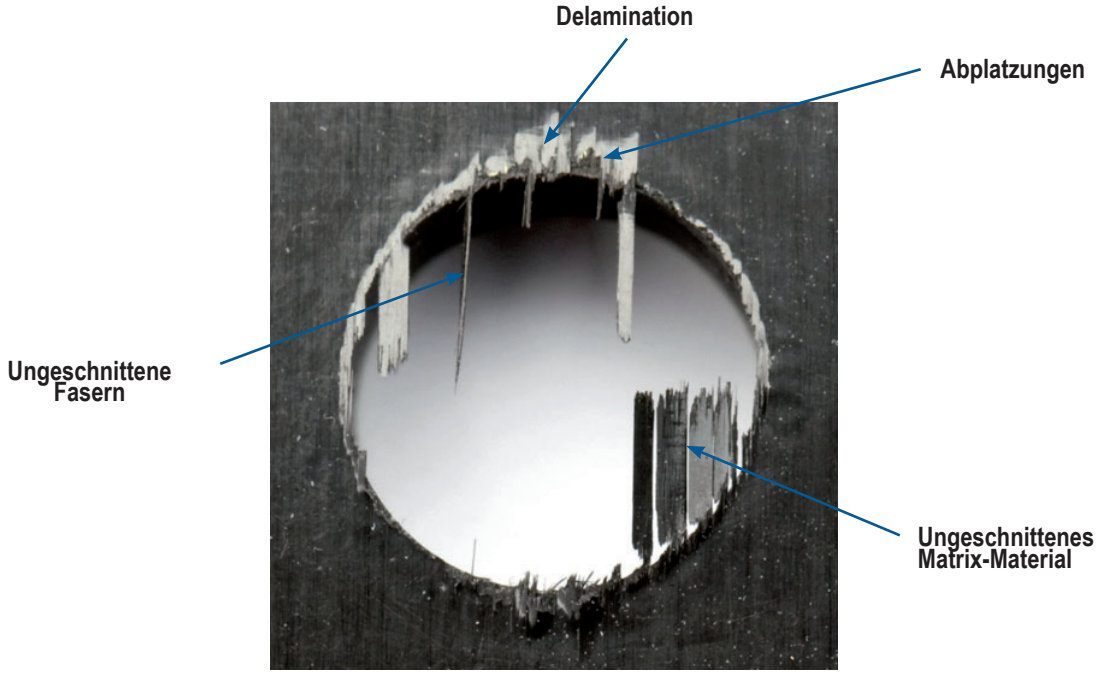


Geometrie PKD CX31:
Universalgeometrie sowohl für glatte CFK/GFK als auch für Sandwich-Werkstoffe



CFRP = Kohlenstofffaserverstärkter Kunststoff
GFRP = Glasfaserverstärkter Kunststoff

Winkelige Austrittsflächen

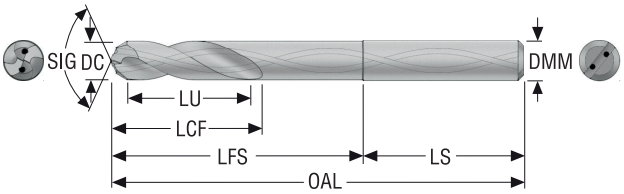


Herausforderung:	Delamination (ziehender / schiebender Schnitt)	Abplatzungen	Ungeschnittene Fasern	Ungeschnittenes Matrix-Material
Lösung:	**Ziehender Schnitt** ▪ Werkzeuge mit negativer Geometrie einsetzen ▪ Vorschub/Umdrehung reduzieren **Schiebender Schnitt** ▪ Vorschub/Umdrehung reduzieren	▪ Positive 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



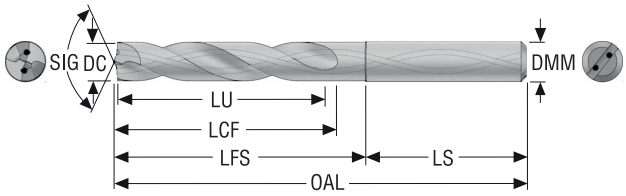


- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 60°/130°
- DURA-Diamantbeschichtung
- Schnittdaten, siehe Seite(n) 149, 150

Bezeichnung	Produkt-nummer	Gewünschte Bohrungstoleranz		DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*

SD205A-C2

Bohrtiefe ca. 5 x D





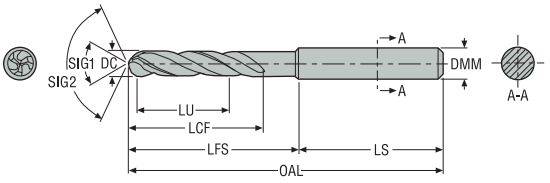
- Zylinderschaft DIN 6537A
- Mit interner Kühlschmierstoffzufuhr
- Spitzenwinkel: 140°/180°
- DURA-Diamantbeschichtung
- Schnittdaten, siehe Seite(n) 149, 150

Bezeichnung	Produkt-nummer	Gewünschte Bohrungstoleranz		DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*

SD203-CX1

Bohrtiefe ca. 3 x D



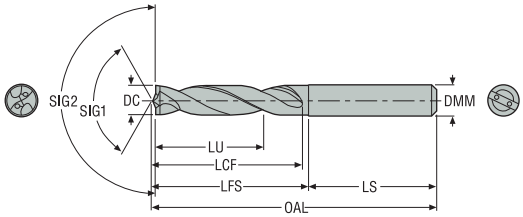


- Zylinderschaft DIN 6537A
- PKD-Schneidkanten
- Spitzenwinkel: 60°/130°
- Schnittdaten, siehe Seite(n) 147, 148

Bezeichnung	Produkt-nummer	Gewünschte Bohrungstoleranz		DC	LU	OAL	LFS	LS	LCF	DMM
		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*
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*
SD203-4.83-20-6R1-CX1	02827925	4,805/4,855	0.1891/0.1911	4,83 *0.190*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*
SD203-6.06-21-6R1-CX1	02827926	6,035/6,085	0.2375/0.2395	6,06 *0.239*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*
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*
SD203-7.94-27-8R1-CX1	02827928	7,913/7,963	0.3115/0.3135	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*
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*

SD203A-CX2

Bohrtiefe ca. 3 x D





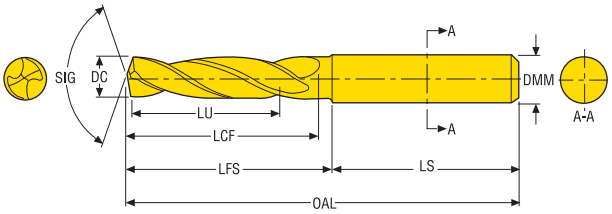
- Zylinderschaft DIN 6537A
- PKD-Schneidkanten
- Spitzenwinkel 120°/180°
- Schnittdaten, siehe Seite(n) 149, 150

Bezeichnung	Produkt-nummer	Gewünschte Bohrungstoleranz		DC	LU	OAL	LFS	LS	LCF	DMM
		mm	*Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD203A-3.26-14-6R1-CX2	02827930	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*	20,0 *0.787*	6,0 *0.236*
SD203A-4.17-17-6R1-CX2	02827931	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*	24,0 *0.945*	6,0 *0.236*
SD203A-4.83-20-6R1-CX2	02827932	4,805/4,855	0.1891/0.1911	4,83 *0.190*	20,0 *0.787*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*
SD203A-6.06-21-6R1-CX2	02827933	6,035/6,085	0.2375/0.2395	6,06 *0.239*	21,0 *0.827*	66,0 *2.598*	30,0 *1.181*	36,0 *1.417*	28,0 *1.102*	6,0 *0.236*
SD203A-6.36-23-8R1-CX2	02827934	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*
SD203A-7.94-27-8R1-CX2	02827935	7,913/7,963	0.3115/0.3135	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*
SD203A-9.53-31-10R1-CX2	02827936	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*

SD205-CX31

Bohrtiefe ca. 5 x D





- Zylinderschaft DIN 6537A
- PKD-Schneidkanten
- Spitzenwinkel: 120°
- Schnittdaten, siehe Seite(n) 149

Bezeichnung	Produkt-nummer	Gewünschte Bohrungstoleranz		DC	LU	OAL	LFS	LS	LCF	DMM
		mm	*Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD205-4.10-26-6R1-CX31	02780522	4,075/4,125	0.1604/0.1624	4,1 *0.161*	26,0 *1.024*	74,0 *2.913*	38,0 *1.496*	36,0 *1.417*	37,0 *1.457*	6,0 *0.236*
SD205-4.78-31-6R1-CX31	02780523	4,755/4,805	0.1872/0.1891	4,78 *0.188*	31,0 *1.220*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*
SD205-6.00-31-6R1-CX31	02780524	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*
SD205-6.38-34-8R1-CX31	02780525	6,350/6,401	0.2500/0.2520	6,38 *0.251*	34,0 *1.339*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*
SD205-7.963-40-8R1-CX31	02780527	7,938/7,988	0.3125/0.3144	7,963 *0.314*	40,0 *1.575*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*



Mikrobohren

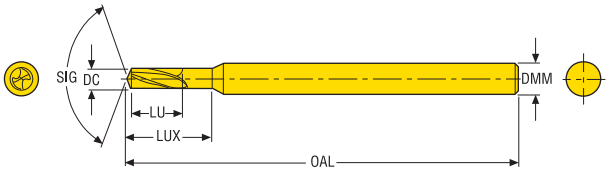
Zum Mikrobohren bietet Seco Tools ein Spektrum an speziellen Werkzeugen an, inklusive der kleinen Vollhartmetallbohrer-Reihe SD22 und SD26.

- 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)





- Zylinderschaft
- Externe Kühlschmierstoffzufuhr
- Spitzenwinkel: 130°
- Unbeschichtet
- Schnittdaten, siehe Seite(n) 169-173

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

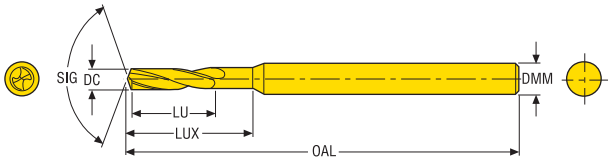
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD22-1.24-2.48-3R1	02730553	1,24 *0.049*	2,48 *0.098*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*
SD22-1.25-2.50-3R1	02730554	1,25 *0.049*	2,5 *0.098*	38,0 *1.496*	4,2 *0.165*	3,0 *0.118*
SD22-1.26-2.52-3R1	02730555	1,26 *0.050*	2,52 *0.099*	38,0 *1.496*	4,3 *0.169*	3,0 *0.118*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

SD26

Bohrtiefe ca. 6 x D





- Zylinderschaft
- Externe Kühlschmierstoffzufuhr
- Spitzenwinkel: 130°
- Unbeschichtet
- Schnittdaten, siehe Seite(n) 169-173

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

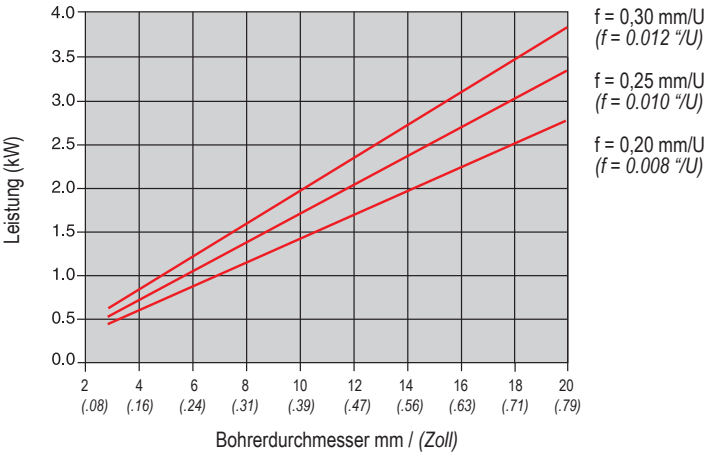
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD26-1.24-8.20-3R1	02730717	1,24 *0.049*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*
SD26-1.25-8.20-3R1	02730718	1,25 *0.049*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*
SD26-1.26-8.20-3R1	02730719	1,26 *0.050*	8,2 *0.323*	38,0 *1.496*	10,0 *0.394*	3,0 *0.118*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

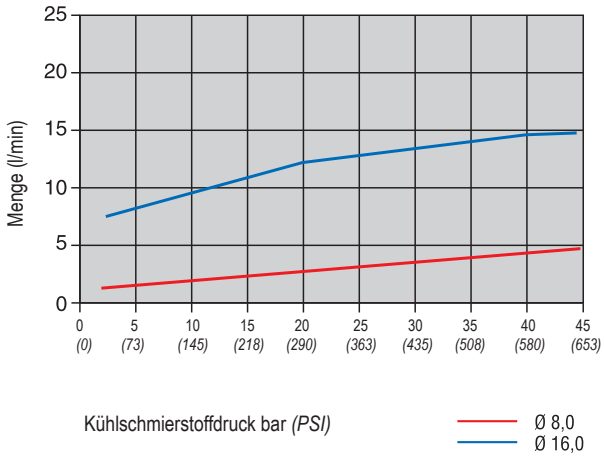
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	DMM
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD26-1.86-11.20-3R1	02730773	1,86 *0.073*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*
SD26-1.87-11.20-3R1	02730774	1,87 *0.074*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*
SD26-1.88-11.20-3R1	02730775	1,88 *0.074*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*
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*

Bearbeitungsparameter

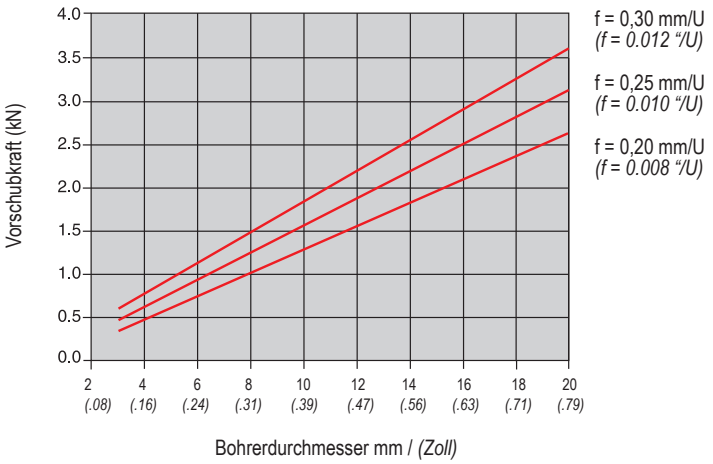
Leistungsbedarf



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, SD216A, SD230A IT8–9/R_a 1–3*					
Bohrerdurchmesser DC (mm)	IT9 Toleranz (mm)	IT10 Toleranz (mm)	Bohrerdurchmesser DC *(Zoll)*	IT9 Toleranz *(Zoll)*	IT10 Toleranz *(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

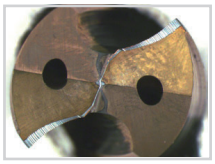
- Aufspannung:
  - Max. Rundlauffehler 0,04 TIR
  - Max. Rundlauffehler bei SD216A innerhalb von 0,04 TIR

- Spanabfuhr:
  - Schnittdaten

- Kühlung:
  - Druck
  - Durchfluss
  - Konzentration

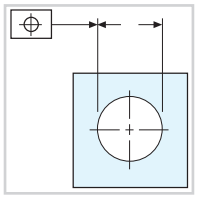
Freiflächenverschleiß

- Schnittgeschwindigkeit senken.
- Kühlmittelkonzentration erhöhen.



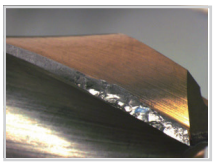
Durchmesser außer Toleranz

- Vorschub/U erhöhen.
- Reibbearbeitung einsetzen, siehe Seite 328
- Ausdrehbearbeitung einsetzen, siehe Seite 492-493



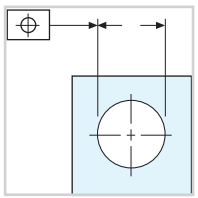
Fasenverschleiß

- Schnittgeschwindigkeit senken.
- Kühlmittelkonzentration erhöhen.



Mittenversatz der Bohrung

- Vorschub/U im Eintritt reduzieren.
- Vorschub/U reduzieren.
- Ausdrehbearbeitung einsetzen, siehe Seite 492-493
- Bei rauen, harten oder schrägen Oberflächen den Vorschub beim Ein- und Austritt um 30-50% reduzieren.
- Mit einem Zentrierbohrer mit 140° vorzentrieren.



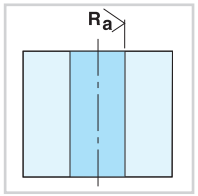
Ausbrüche/Querschneide

- Vorschub/U beim Eintritt senken
- Vorschub/U senken
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 492-493



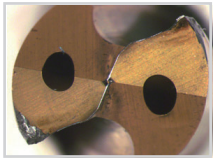
Geringe Oberflächengüte

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



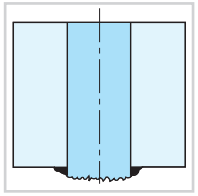
Ausbrüche/Ecke, Schneidkante

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



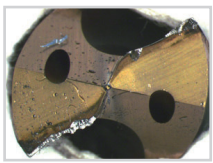
Gratbildung bei Bohreraustritt

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



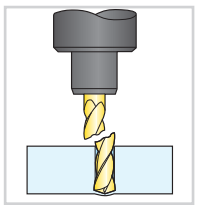
Aufbauschneide

- 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

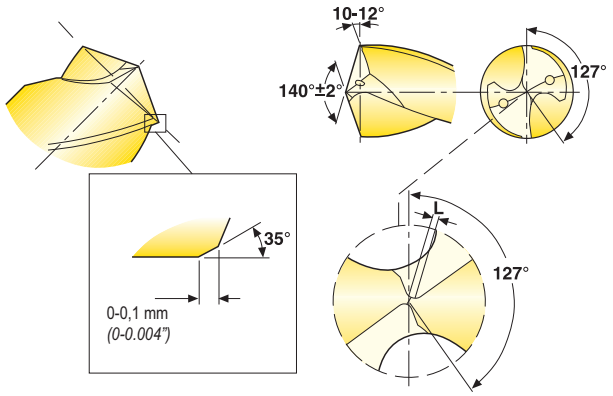


Nachschliff der Vollhartmetallbohrer für SD1103, SD1103A, SD1105A, SD1108A, SD1112A und SD230A

Einzelheiten
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.

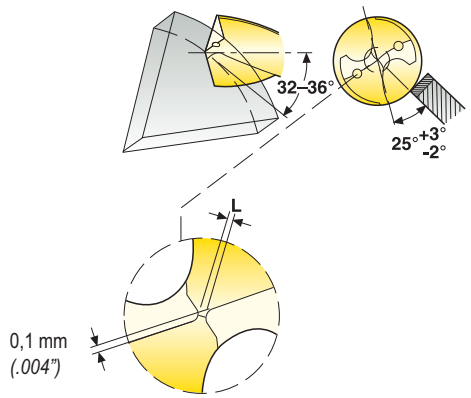
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff



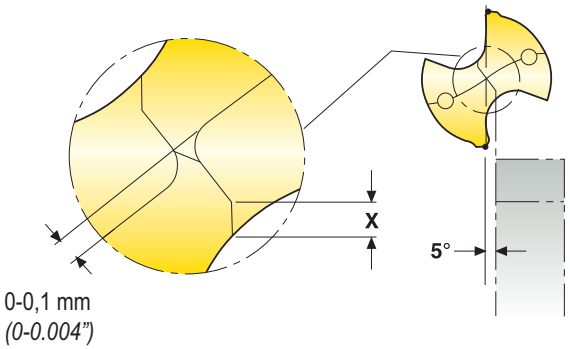
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



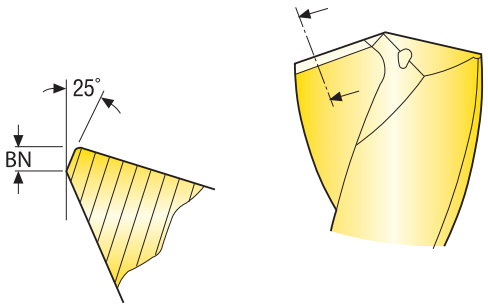
Bohrerdurchmesser DC mm	L mm	Bohrerdurchmesser DC *Zoll*	L *Zoll*
2-10	0,1-0,3	*0.079-0.394*	*0.004-0.012*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Abflachung der Fläche X



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

4. Schneidkantenausführung



Werkstoff	BN			
	Bohrer-durchmesser ≤ 10 mm	Bohrer-durchmesser > 10 mm	Bohrer-durchmesser ≤ 0.394 *Zoll*	Bohrer-durchmesser > 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*

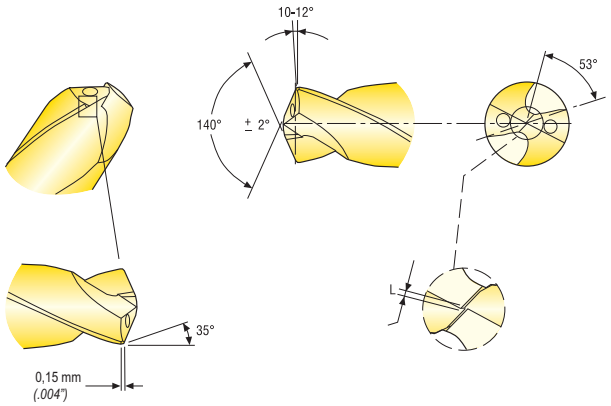
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

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

Einzelheiten
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.

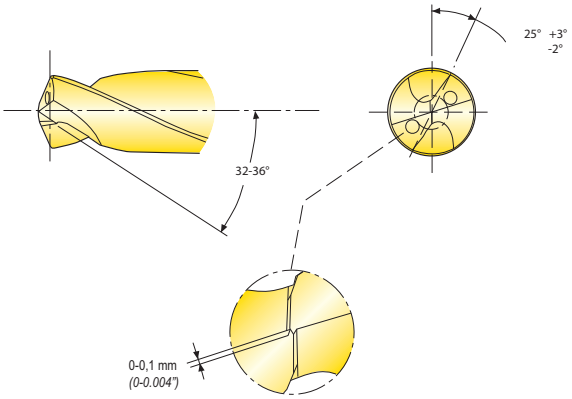
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff



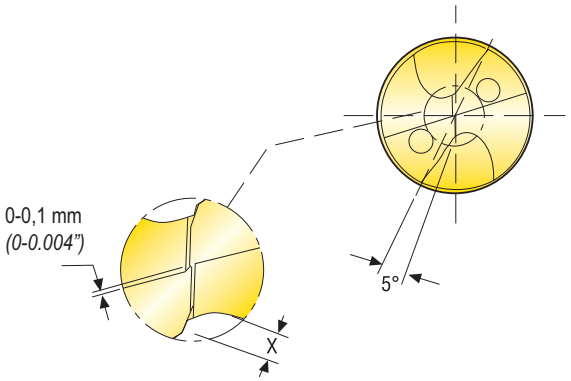
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



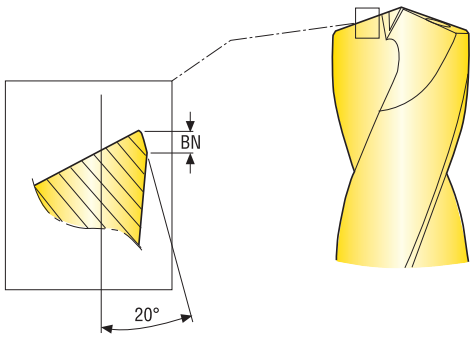
Bohrerdurchmesser DC mm	L mm	Bohrerdurchmesser DC *Zoll*	L *Zoll*
2-10	0,1-0,3	*0.079-0.394*	*0.004-0.012*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Abflachung der Fläche X



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

4. Schneidkantenausführung



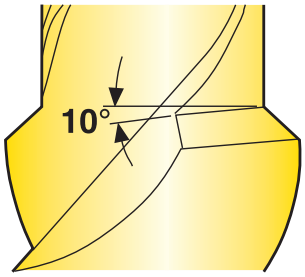
Werkstoff	BN			
	Bohrer-durchmesser ≤ 10 mm	Bohrer-durchmesser > 10 mm	Bohrer-durchmesser ≤ 0.394 *Zoll*	Bohrer-durchmesser > 0.394 *Zoll*
Stahl	0,05	0,10	*0.002*	*0.004*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,10	*0.002*	*0.004*

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

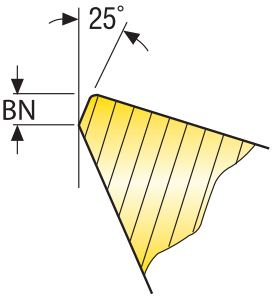
Nachschliff für Fasbohrer

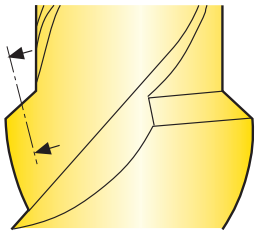
Es gelten die gleichen Anweisungen wie für SD203, SD203A, SD205A und SD207A, ausgenommen für die Fase.

1. Fasen-Ausführung



2. Schneidkantenpräparation, Fase





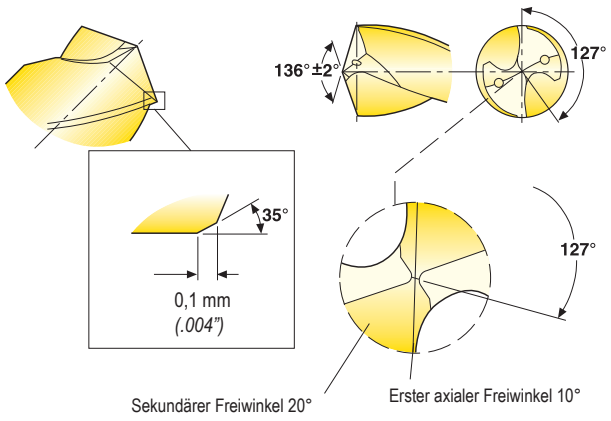
Werkstoff	BN			
	Bohrer-durchmesser ≤ 10 mm	Bohrer-durchmesser > 10 mm	Bohrer-durchmesser ≤ 0.394 *Zoll*	Bohrer-durchmesser > 0.394 *Zoll*
Stahl	0,05	0,10	*0.002*	*0.004*
Rostfrei	0,05	0,05	*0.002*	*0.002*
Guss	0,05	0,10	*0.002*	*0.004*

Nachschliff der Vollhartmetallbohrer für SD212A, SD216A, SD220A, SD225A, SD230A und SD230A

Einzelheiten
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.

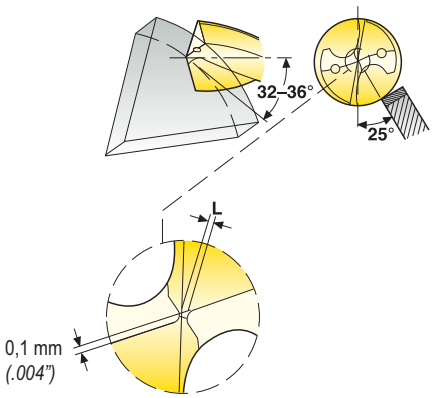
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff



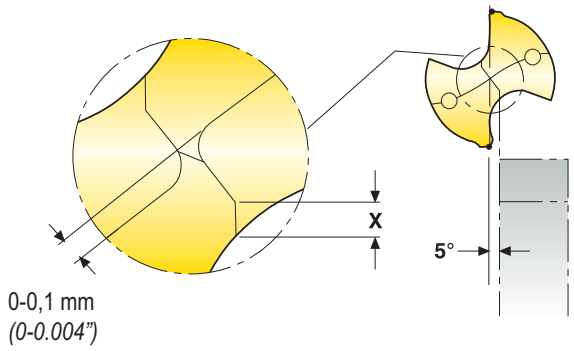
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



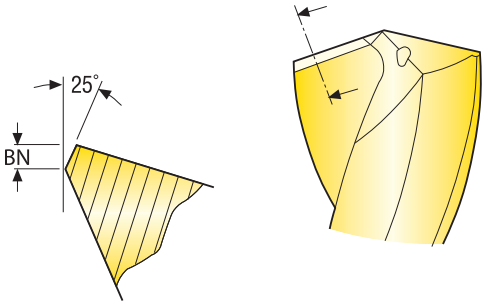
Bohrerdurchmesser DC mm	L mm	Bohrerdurchmesser DC *Zoll*	L *Zoll*
2-10	0,2	*0.079-0.394*	*0.008*
10-20	0,4	*0.394-0.787*	*0.016*

3. Abflachung der Fläche X



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

4. Schneidkantenausführung



Werkstoff	BN			
	Bohrer-durchmesser ≤ 10 mm	Bohrer-durchmesser > 10 mm	Bohrer-durchmesser ≤ 0.394 *Zoll*	Bohrer-durchmesser > 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*

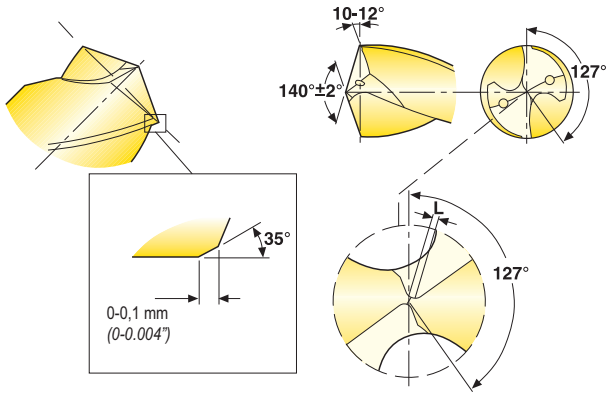
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Nachschliff für SD265A

Einzelheiten
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.

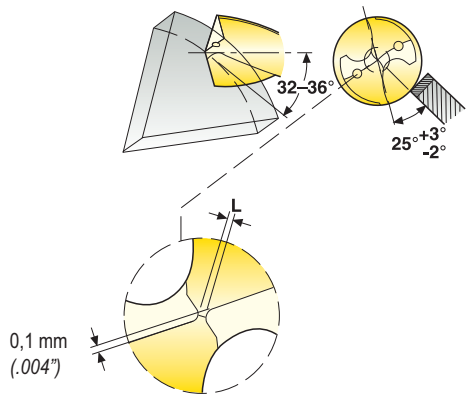
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff



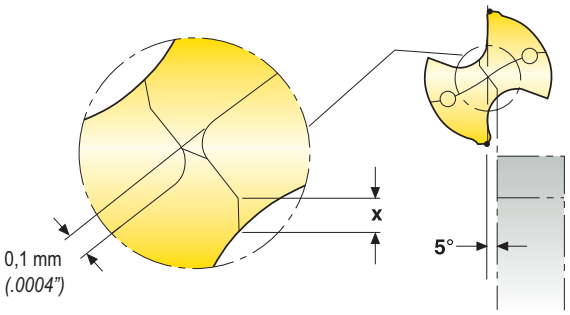
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

2. Ausspitzung der Querschneide



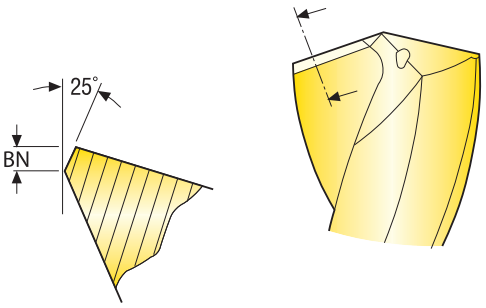
Bohrerdurchmesser DC mm	L mm	Bohrerdurchmesser DC *Zoll*	L *Zoll*
2-10	0,2	*0.079-0.394*	*0.008*
10-20	0,4	*0.394-0.787*	*0.016*

3. Abflachung der Fläche X



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

4. Schneidkantenausführung



Werkstoff	BN			
	Bohrer-durchmesser ≤ 10 mm	Bohrer-durchmesser > 10 mm	Bohrer-durchmesser ≤ 0.394 *Zoll*	Bohrer-durchmesser > 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*

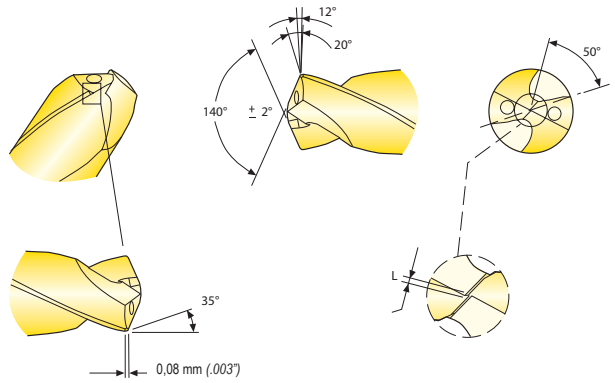
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Nachschliff für -MS-Geometrie

Einzelheiten
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.

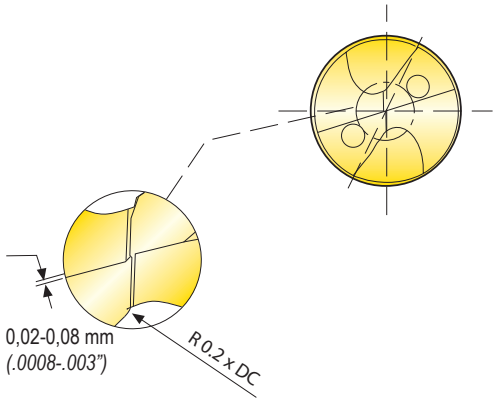
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff

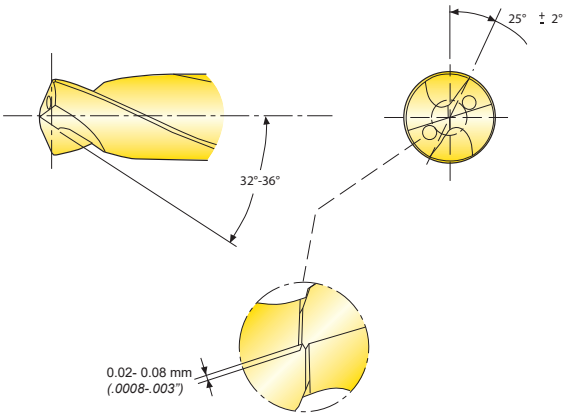


Hauptschneiden-Differenz (axiale Abweichung) maximal 0,02 mm *(0.008")*

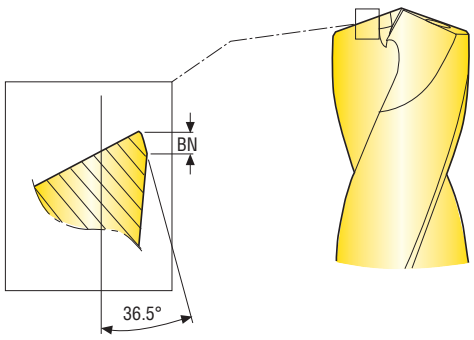
2. Schleifen des Radius R



3. Ausspitzung der Querschneide



4. Schneidkantenausführung



Bohrerdurchmesser DC mm	BN mm	Bohrerdurchmesser 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*

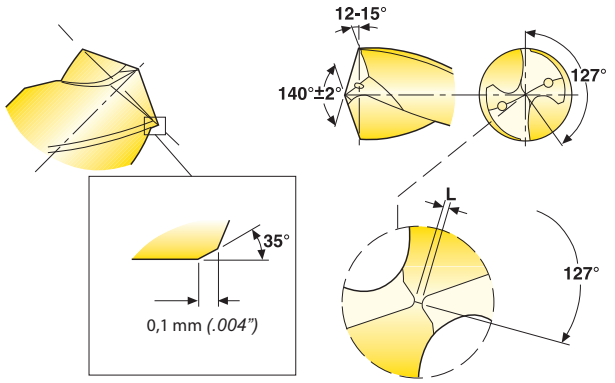
Der maximale Freiflächenverschleiß vor dem Nachschleifen ist 0,1-0,3 mm *(0.004-0.012")* gemessen an der breitesten Stelle.

Nachschliff der Vollhartmetallbohrer mit M- und T-Geometrie

Einzelheiten
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.

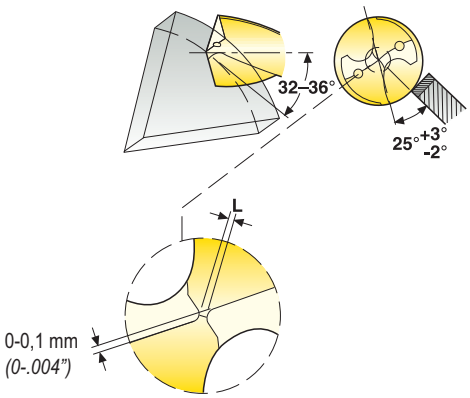
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff



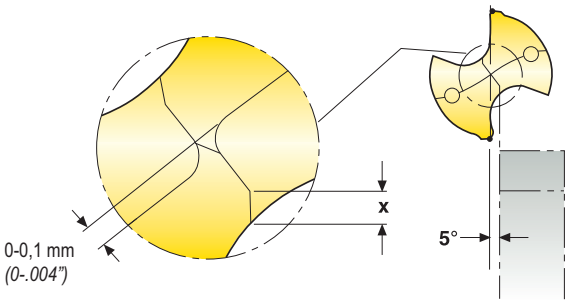
Hauptschneiden-Differenz (axiale Abweichung) maximal 0,01 mm *(0.0004")*

2. Ausspitzung der Querschneide

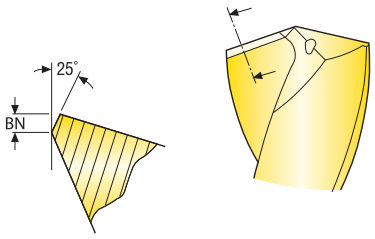


Bohrerdurchmesser DC mm	L mm	Bohrerdurchmesser DC *Zoll*	L *Zoll*
3-6	0,1-0,2	*0.118-0.236*	*0.004-0.008*
6-10	0,13-0,27	*0.236-0.394*	*0.005-0.011*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Abflachung der Fläche X



4. Schneidkantenausführung



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.

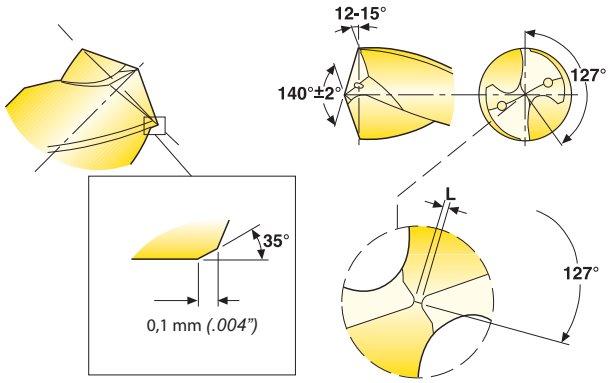
Nachschliff für N-Geometrie

Allgemein:
X = 0,08 x Bohrerdurchmesser DC

Einzelheiten
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.

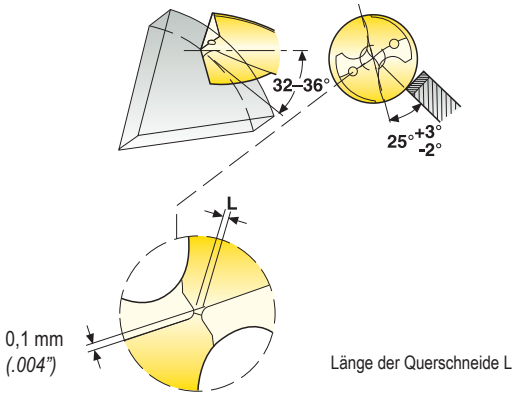
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. Hinterschliff



Hauptschneiden-Differenz (axiale Abweichung) maximal 0,01 mm *(0.0004")*

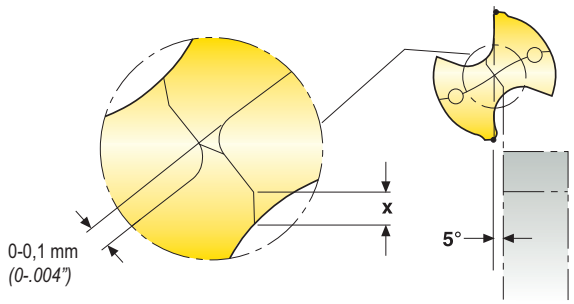
2. Ausspitzung der Querschneide



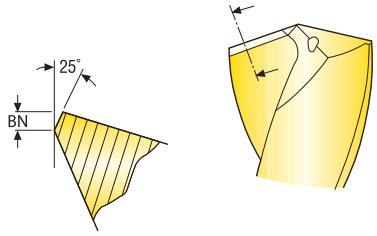
Länge der Querschneide L

Bohrerdurchmesser DC mm	L mm	Bohrerdurchmesser 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. Abflachung der Fläche X



4. Schneidkantenausführung



BN = 0,01-0,02 mm *(0.004-0.008")*

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

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

SMG	f										v_c
	Ø3,00 *Ø 0.118*	Ø4,00 *Ø 0.157*	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*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f										v_c
	Ø3,00 *Ø 0.118*	Ø4,00 *Ø 0.157*	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*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f										v_c
	Ø3,00 *Ø 0.118*	Ø4,00 *Ø 0.157*	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*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f										v_c
	Ø3,00 *Ø 0.118*	Ø4,00 *Ø 0.157*	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*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bei Bohrungsbearbeitung in Rostfrei mit 8 x D und 12 x D ist eine vorbereitende Bearbeitung eventuell erforderlich.

SD112 – Durchmesser 3-20 mm / *0.118-0.787 Zoll*

SMG	f										v_c
	Ø3,00 *Ø 0.118*	Ø4,00 *Ø 0.157*	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*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bei Bohrungsbearbeitung in Rostfrei mit 8 x D und 12 x D ist eine vorbereitende Bearbeitung eventuell erforderlich.

SD203A – Durchmesser 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*	
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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD203A – Durchmesser 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*	
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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD205A – Durchmesser 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*	
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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD205A – Durchmesser 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*	
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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG		f			v_c
		Ø0,70 *Ø 0.0276*	Ø1,00 *Ø 0.0394*	Ø2,00 *Ø 0,0787*	
P1	P	0,080	0,090	0,11	140
	P	*0.0032*	*0.0036*	*0.0044*	*460*
P2	P	0,085	0,090	0,12	140
	P	*0.0034*	*0.0036*	*0.0048*	*460*
P3	P	0,080	0,085	0,11	120
	P	*0.0032*	*0.0034*	*0.0044*	*395*
P4	P	0,080	0,085	0,11	105
	P	*0.0032*	*0.0034*	*0.0044*	*345*
P5	P	0,075	0,085	0,11	100
	P	*0.0030*	*0.0034*	*0.0044*	*330*
P6	P	0,075	0,080	0,10	110
	P	*0.0030*	*0.0032*	*0.0040*	*360*
P7	P	0,075	0,080	0,10	105
	P	*0.0030*	*0.0032*	*0.0040*	*345*
P8	P	0,080	0,085	0,11	100
	P	*0.0032*	*0.0034*	*0.0044*	*330*
P11	P	0,075	0,080	0,10	105
	P	*0.0030*	*0.0032*	*0.0040*	*345*
P12	P	0,050	0,055	0,070	60
	P	*0.0020*	*0.0022*	*0.0028*	*195*
K1	P	0,085	0,090	0,12	100
	P	*0.0034*	*0.0036*	*0.0048*	*330*
K2	P	0,075	0,085	0,11	85
	P	*0.0030*	*0.0034*	*0.0044*	*280*
K3	P	0,075	0,085	0,11	75
	P	*0.0030*	*0.0034*	*0.0044*	*245*
K4	P	0,075	0,085	0,11	70
	P	*0.0030*	*0.0034*	*0.0044*	*230*
K5	P	0,070	0,075	0,095	42
	P	*0.0028*	*0.0030*	*0.0038*	*140*

SMG = Seco Werkstoff-Gruppe f = mm/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG		f			v_c
		Ø1,00 *Ø 0.0394*	Ø1,50 *Ø 0.0591*	Ø2,00 *Ø 0.0787*	
P1	P	0,090	0,10	0,11	175
	P	*0.0036*	*0.0040*	*0.0044*	*570*
P2	P	0,090	0,10	0,12	170
	P	*0.0036*	*0.0040*	*0.0048*	*560*
P3	P	0,085	0,10	0,11	145
	P	*0.0034*	*0.0040*	*0.0044*	*475*
P4	P	0,085	0,095	0,11	130
	P	*0.0034*	*0.0038*	*0.0044*	*425*
P5	P	0,085	0,095	0,11	125
	P	*0.0034*	*0.0038*	*0.0044*	*410*
P6	P	0,080	0,095	0,10	140
	P	*0.0032*	*0.0038*	*0.0040*	*460*
P7	P	0,080	0,095	0,10	130
	P	*0.0032*	*0.0038*	*0.0040*	*425*
P8	P	0,085	0,10	0,11	125
	P	*0.0034*	*0.0040*	*0.0044*	*410*
P11	P	0,080	0,095	0,10	125
	P	*0.0032*	*0.0038*	*0.0040*	*410*
P12	P	0,055	0,065	0,070	75
	P	*0.0022*	*0.0026*	*0.0028*	*245*
M1	P	0,055	0,065	0,075	95
	P	*0.0022*	*0.0026*	*0.0030*	*310*
M2	P	0,050	0,060	0,070	75
	P	*0.0020*	*0.0024*	*0.0028*	*245*
M3	P	0,042	0,048	0,055	60
	P	*0.0017*	*0.0019*	*0.0022*	*195*
M4	P	0,036	0,042	0,048	43
	P	*0.0014*	*0.0017*	*0.0019*	*140*
M5	P	0,036	0,042	0,048	36
	P	*0.0014*	*0.0017*	*0.0019*	*120*
K1	P	0,095	0,11	0,12	115
	P	*0.0038*	*0.0044*	*0.0048*	*375*
K2	P	0,085	0,10	0,11	100
	P	*0.0034*	*0.0040*	*0.0044*	*330*
K3	P	0,085	0,10	0,11	85
	P	*0.0034*	*0.0040*	*0.0044*	*280*
K4	P	0,085	0,10	0,11	80
	P	*0.0034*	*0.0040*	*0.0044*	*260*
K5	P	0,075	0,090	0,10	47
	P	*0.0030*	*0.0036*	*0.0040*	*155*
N2	P	0,10	0,12	0,13	190
	P	*0.0040*	*0.0048*	*0.0050*	*620*
N3	P	0,10	0,12	0,13	125
	P	*0.0040*	*0.0048*	*0.0050*	*410*

SMG = Seco Werkstoff-Gruppe f = mm/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD207A – Durchmesser 3-20 mm / *0.118-0.787 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*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD216A – Durchmesser 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	125
	P	*0.0050*	*0.0070*	*0.0080*	*0.010*	*0.012*	*0.013*	*0.014*	*410*
P2	P	0,14	0,18	0,20	0,26	0,30	0,34	0,36	120
	P	*0.0055*	*0.0070*	*0.0080*	*0.010*	*0.012*	*0.013*	*0.014*	*395*
P3	P	0,13	0,17	0,20	0,24	0,28	0,32	0,34	105
	P	*0.0050*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.013*	*0.013*	*345*
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	0,34	90
	P	*0.0050*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*0.013*	*295*
P5	P	0,12	0,17	0,19	0,24	0,28	0,30	0,34	85
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*0.013*	*280*
P6	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	95
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*0.013*	*310*
P7	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	90
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*0.013*	*295*
P8	P	0,13	0,17	0,20	0,24	0,28	0,32	0,34	85
	P	*0.0050*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.013*	*0.013*	*280*
P11	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	90
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*0.013*	*295*
P12	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	55
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*180*
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	0,28	65
	P	*0.0038*	*0.0050*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*0.011*	*215*
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	0,25	55
	P	*0.0034*	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.010*	*180*
M3	P	0,070	0,095	0,11	0,14	0,16	0,18	0,20	41
	P	*0.0028*	*0.0038*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*0.0080*	*135*
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	0,18	31
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*100*
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	0,18	25
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*0.0070*	*80*
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*
N2	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	135
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.018*	*445*
N3	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	90
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*0.018*	*295*
H3	P	0,055	0,075	0,085	0,10	0,12	0,14	0,15	22
	P	*0.0022*	*0.0030*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*70*
H5	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	40
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*130*
H7	P	0,055	0,075	0,085	0,10	0,12	0,14	0,15	22
	P	*0.0022*	*0.0030*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*70*
H8	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	40
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*130*
H11	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	50
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*165*
H12	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	31
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*100*
H21	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	40
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*130*

SMG = Seco Werkstoff-Gruppe f = mm/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD230A – Durchmesser 3-12 mm / *0.118-0.472 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*	
P1	P	0,13	0,18	0,20	0,25	0,30	0,32	90
	P	*0.0050*	*0.0070*	*0.0080*	*0.010*	*0.012*	*0.013*	*295*
P2	P	0,14	0,18	0,20	0,26	0,30	0,34	90
	P	*0.0055*	*0.0070*	*0.0080*	*0.010*	*0.012*	*0.013*	*295*
P3	P	0,13	0,17	0,20	0,24	0,28	0,32	75
	P	*0.0050*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.013*	*245*
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	70
	P	*0.0050*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*230*
P5	P	0,12	0,17	0,19	0,24	0,28	0,30	65
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.011*	*0.012*	*215*
P6	P	0,12	0,17	0,19	0,24	0,26	0,30	75
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*245*
P7	P	0,12	0,17	0,19	0,24	0,26	0,30	70
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*230*
P8	P	0,13	0,17	0,20	0,24	0,28	0,32	65
	P	*0.0050*	*0.0065*	*0.0080*	*0.0095*	*0.011*	*0.013*	*215*
P11	P	0,12	0,17	0,19	0,24	0,26	0,30	65
	P	*0.0048*	*0.0065*	*0.0075*	*0.0095*	*0.010*	*0.012*	*215*
P12	P	0,085	0,11	0,13	0,16	0,18	0,20	39
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*130*
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	50
	P	*0.0038*	*0.0050*	*0.0060*	*0.0075*	*0.0085*	*0.010*	*165*
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	40
	P	*0.0034*	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*130*
M3	P	0,070	0,095	0,11	0,14	0,16	0,18	30
	P	*0.0028*	*0.0038*	*0.0044*	*0.0055*	*0.0065*	*0.0070*	*100*
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	23
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*75*
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	19
	P	*0.0024*	*0.0034*	*0.0038*	*0.0048*	*0.0055*	*0.0065*	*60*
K1	P	0,15	0,22	0,24	0,30	0,36	0,40	60
	P	*0.0060*	*0.0085*	*0.0095*	*0.012*	*0.014*	*0.016*	*195*
K2	P	0,14	0,19	0,22	0,28	0,32	0,36	50
	P	*0.0055*	*0.0075*	*0.0085*	*0.011*	*0.013*	*0.014*	*165*
K3	P	0,14	0,19	0,22	0,28	0,32	0,36	44
	P	*0.0055*	*0.0075*	*0.0085*	*0.011*	*0.013*	*0.014*	*145*
K4	P	0,14	0,19	0,22	0,28	0,32	0,36	42
	P	*0.0055*	*0.0075*	*0.0085*	*0.011*	*0.013*	*0.014*	*140*
K5	P	0,12	0,17	0,20	0,25	0,30	0,32	25
	P	*0.0048*	*0.0065*	*0.0080*	*0.010*	*0.012*	*0.013*	*80*
N2	P	0,16	0,22	0,26	0,32	0,38	0,42	100
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*330*
N3	P	0,16	0,22	0,26	0,32	0,38	0,42	65
	P	*0.0065*	*0.0085*	*0.010*	*0.013*	*0.015*	*0.017*	*215*
H3	P	0,055	0,075	0,085	0,10	0,12	0,14	16
	P	*0.0022*	*0.0030*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*50*
H5	P	0,085	0,11	0,13	0,16	0,18	0,20	30
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*100*
H7	P	0,055	0,075	0,085	0,10	0,12	0,14	16
	P	*0.0022*	*0.0030*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*50*
H8	P	0,065	0,085	0,10	0,12	0,14	0,16	30
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*100*
H11	P	0,085	0,11	0,13	0,16	0,18	0,20	39
	P	*0.0034*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*130*
H12	P	0,065	0,085	0,10	0,12	0,14	0,16	24
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*80*
H21	P	0,065	0,085	0,10	0,12	0,14	0,16	30
	P	*0.0026*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*100*

SMG = Seco Werkstoff-Gruppe f = mm/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG		f							v_c
		Ø4,00 *Ø 0.157*	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*	Ø16,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG		f							v_c
		Ø4,00 *Ø 0.157*	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*	Ø16,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD203A -MS Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD203A -MS Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD205A -MS Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD205A -MS Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD203A – Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bei Bohrungsbearbeitung in Rostfrei mit 8 x D und 12 x D ist eine vorbereitende Bearbeitung eventuell erforderlich.

SD203A – Durchmesser 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 *M*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	150 *490*
P12	M *M*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	0,24 *0.0095*	90 *295*
M1	M *M*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*	110 *360*
M2	M *M*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	0,30 *0.012*	90 *295*
M3	M *M*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*	70 *230*
M4	M *M*	0,14 *0.0055*	0,16 *0.0065*	0,17 *0.0065*	0,19 *0.0075*	0,20 *0.0080*	0,20 *0.0080*	50 *165*
M5	M *M*	0,14 *0.0055*	0,16 *0.0065*	0,17 *0.0065*	0,19 *0.0075*	0,20 *0.0080*	0,20 *0.0080*	42 *140*
N1	M *M*	0,38 *0.015*	0,42 *0.017*	0,46 *0.018*	0,50 *0.020*	0,55 *0.022*	0,55 *0.022*	345 *1125*
N2	M *M*	0,38 *0.015*	0,42 *0.017*	0,46 *0.018*	0,50 *0.020*	0,55 *0.022*	0,55 *0.022*	225 *740*
N3	M *M*	0,38 *0.015*	0,42 *0.017*	0,46 *0.018*	0,50 *0.020*	0,55 *0.022*	0,55 *0.022*	150 *490*
N11	M *M*	0,38 *0.015*	0,42 *0.017*	0,46 *0.018*	0,50 *0.020*	0,55 *0.022*	0,55 *0.022*	285 *940*
S1	M *M*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,19 *0.0075*	39 *130*
S2	M *M*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,19 *0.0075*	28 *90*
S3	M *M*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,16 *0.0065*	0,17 *0.0065*	0,19 *0.0075*	28 *90*
S11	M *M*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	70 *230*
S12	M *M*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	0,26 *0.010*	55 *180*
S13	M *M*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	0,22 *0.0085*	43 *140*

SMG = Seco Werkstoff-Gruppe f = mm/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bei Bohrungsbearbeitung in Rostfrei mit 8 x D und 12 x D ist eine vorbereitende Bearbeitung eventuell erforderlich.

SD205A – Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bei Bohrungsbearbeitung in Rostfrei mit 8 x D und 12 x D ist eine vorbereitende Bearbeitung eventuell erforderlich.

SD205A – Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bei Bohrungsbearbeitung in Rostfrei mit 8 x D und 12 x D ist eine vorbereitende Bearbeitung eventuell erforderlich.

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

SMG		f						v_c
		Ø3,00 *Ø 0.118*	Ø5,00 *Ø 0.197*	Ø7,00 *Ø 0.276*	Ø9,00 *Ø 0.354*	Ø11,00 *Ø 0.433*	Ø13,00 *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 – Durchmesser 3-13 mm / *0.118-0.512 Zoll*

SMG		f						v_c
		Ø3,00 *Ø 0.118*	Ø5,00 *Ø 0.197*	Ø7,00 *Ø 0.276*	Ø9,00 *Ø 0.354*	Ø11,00 *Ø 0.433*	Ø13,00 *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*

SMG = Seco Werkstoff-Gruppe
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten abhängig von Werkstoff auf der Austrittsseite. N1-N3 und S11-S13 für Bearbeitungen in Sandwich-Werkstoffen
N1-N3 = Alu
S11-S13 = Ti
TS/TP = Composite

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

SMG		f				v_c
		Ø3,00 *Ø 0.118*	Ø5,00 *Ø 0.197*	Ø7,00 *Ø 0.276*	Ø9,00 *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*

SD203A-CX2 – Durchmesser 3-9 mm / *0.118-0.354 Zoll*

SMG		f				v_c
		Ø3,00 *Ø 0.118*	Ø5,00 *Ø 0.197*	Ø7,00 *Ø 0.276*	Ø9,00 *Ø 0.354*	
N1	CX2 *CX2*	0,048 *0.0019*	0,050 *0.0020*	0,055 *0.0022*	0,060 *0.0024*	185 *610*
N2	CX2 *CX2*	0,048 *0.0019*	0,050 *0.0020*	0,055 *0.0022*	0,060 *0.0024*	120 *395*
N3	CX2 *CX2*	0,048 *0.0019*	0,050 *0.0020*	0,055 *0.0022*	0,060 *0.0024*	80 *260*
S11	CX2 *CX2*	0,019 *0.00075*	0,020 *0.00080*	0,024 *0.00095*	0,025 *0.0010*	16 *50*
S12	CX2 *CX2*	0,019 *0.00075*	0,020 *0.00080*	0,024 *0.00095*	0,025 *0.0010*	12 *39*
S13	CX2 *CX2*	0,017 *0.00065*	0,018 *0.00070*	0,020 *0.00080*	0,022 *0.00085*	9 *30*

SMG = Seco Werkstoff-Gruppe
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten abhängig von Werkstoff auf der Austrittsseite. N1-N3 und S11-S13 für Bearbeitungen in Sandwich-Werkstoffen
N1-N3 = Alu
S11-S13 = Ti
TS/TP = Composite

SD205-CX31 – Durchmesser 4-8 mm / *0.157-0.315 Zoll*

SMG		f					v_c
		Ø4,00 *Ø 0.157*	Ø5,00 *Ø 0.197*	Ø6,00 *Ø 0.236*	Ø7,00 *Ø 0.276*	Ø8,00 *Ø 0.315*	
N1	CX31 *CX31*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	155 *510*
N2	CX31 *CX31*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	100 *330*
N3	CX31 *CX31*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	65 *215*
S11	CX31 *CX31*	0,040 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	0,070 *0.0028*	16 *50*
S12	CX31 *CX31*	0,040 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	0,070 *0.0028*	12 *39*
S13	CX31 *CX31*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	9 *30*
TS2	CX31 *CX31*	0,080 *0.0032*	0,085 *0.0034*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	125 *410*
TS3	CX31 *CX31*	0,080 *0.0032*	0,085 *0.0034*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	100 *330*
TP2	CX31 *CX31*	0,080 *0.0032*	0,085 *0.0034*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	125 *410*
TP3	CX31 *CX31*	0,080 *0.0032*	0,085 *0.0034*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*	100 *330*

SMG = Seco Werkstoff-Gruppe
f = mm/U
v_c = m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten abhängig von Werkstoff auf der Austrittsseite. N1-N3 und S11-S13 für Bearbeitungen in Sandwich-Werkstoffen
N1-N3 = Alu
S11-S13 = Ti
TS/TP = Composite

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

SMG	f			v_c
	Ø0,10 *Ø 0.0039*	Ø0,20 *Ø 0.0079*	Ø0,30 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f		v_c
	Ø0,40 *Ø 0.0157*	Ø0,50 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f			v_c
	Ø0,60 *Ø 0.0236*	Ø0,70 *Ø 0.0276*	Ø0,80 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f			v_c
	Ø0,90 *Ø 0.0354*	Ø1,00 *Ø 0.0394*	Ø1,10 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

SMG	f					v_c
	Ø1,20 *Ø 0.0472*	Ø1,40 *Ø 0.0551*	Ø1,60 *Ø 0.0630*	Ø1,80 *Ø 0.0709*	Ø2,00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.



Seco 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®	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz (1)	Oberflächengüte (2)
SD101  Seite(n) 178-179	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) 180-181	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) 182-183	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) 184-185	12,00-25,99 mm *(0.472-1.023")*	~ 7 x D	k7	IT 10	Ra 1-4 µm *(Ra 39-157 µin)*
Fasbohrer  Seite(n) 193	12.00-19,99 mm *(0.472-0.787")*	–	–	–	–

1) Je nach verwendetem Werkstoff und verwendeten Schnittdaten kann es zu Abweichungen kommen.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können die Oberflächengüte beeinträchtigen.

Code-Schlüssel

Code-Schlüssel Bohrerkörper

Metrisch

Bohrertyp SD101: 1,5 x D SD103: 3 x D SD105: 5 x D SD107: 7 x D	Min./max. Durchmesser Krone	Bohrtiefe	Aufnahme-durchmesser	Aufsteck-fräser rechts-drehend	Schaftart 1. Zylindrisch 7. ISO 9766
SD103	14.00/14.99	50	16	R	7

Zoll

50	0750	R	7



Code-Schlüssel Kronen

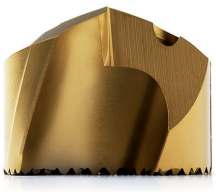
Bohrerdurchmesser	Geometrie P = Stahl M = Rostfrei K = Guss
SD100 – 14.00	P

Geometrien

P-Geometrie
Universelle Geometrie, erste Wahl für Stahl



M-Geometrie
Erste Wahl für Rostfrei, gehärteten Stahl und Superlegierungen



K-Geometrie
- Erste Wahl für Guss



Montagehinweise

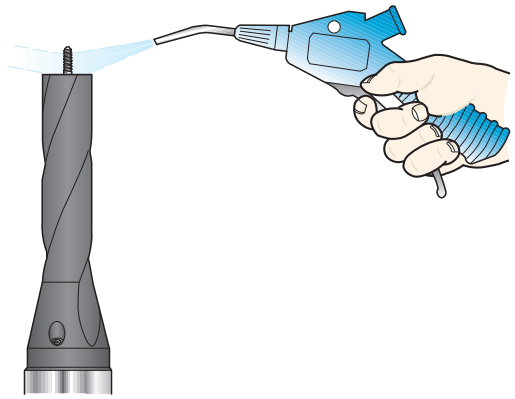
1. Kontaktfläche des Bohrerkörpers sorgfältig mit Pressluft reinigen.
2. Die Zugstange muss komplett herausschauen.
3. Neue Krone auf die Zugstange setzen und bis zum Ende des Gewindes aufschrauben.

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.

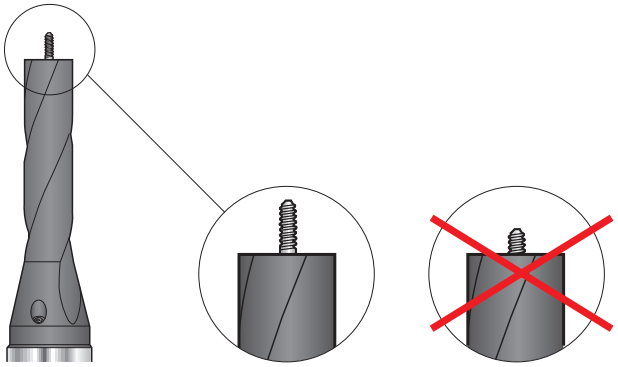
Stabilität
Stabilität ist entscheidend für Standzeit und Bohrungsqualität. Vorher den Zustand von Maschinenspindel und Aufspannvorrichtung prüfen, um die bestmöglichen Bearbeitungsbedingungen zu ermöglichen. Instabile Bedingungen können zu Werkzeugbruch führen.

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.

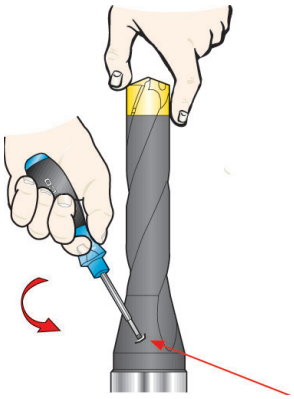
1.



2.

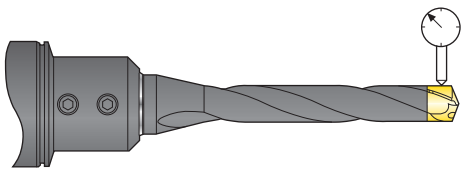


3.



Bohrerdurchmesser DC mm	M_c Nm	Bohrerdurchmesser 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.

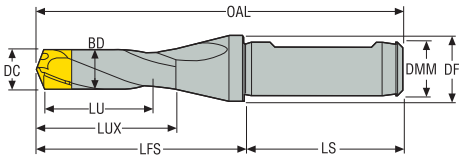


Weldon

SD101

Bohrtiefe ca. 1,5 x D – Schaft (metrisch)





- SD101 -R7 Schaft
- Mit interner Kühlschmierstoffzufuhr
- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Schnittdaten, siehe Seite(n) 196

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

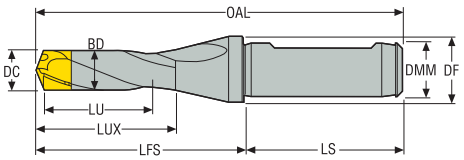
Bohrerdurchmesser (mm)	Spannschlüssel	Befestigungs-schraube	Satz Ersatzteile
			
12,00-13,99	H1.5-2D	MP6SS3X12	SD101-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD101-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD101-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD101-SP-8.0

Zubehör

Ersatzklinge	Drehmomentschlüssel
	
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD101 -R7 Schaft

Bohrtiefe ca. 1,5 x D – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 196

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

Ersatzteile

Bohrerdurchmesser (Zoll)	Spannschlüssel	Befestigungs-schraube	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

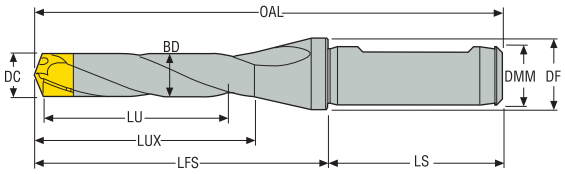
Zubehör

Ersatzklinge	Drehmomentschlüssel
	
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD103

Bohrtiefe ca. 3 x D – Schaft (metrisch)





- SD103 -R7 Schaft
- Mit interner Kühlschmierstoffzufuhr
- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Schnittdaten, siehe Seite(n) 197

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

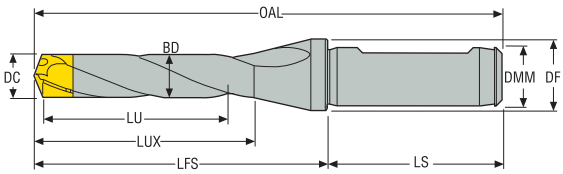
Bohrerdurchmesser (mm)	Spannschlüssel	Befestigungs-schraube	Satz Ersatzteile
			
10,00-11,99	H1.5-2D	MP6SS3X12	SD103-SP-4.0
12,00-13,99	H1.5-2D	MP6SS3X12	SD103-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD103-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD103-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD103-SP-8.0

Zubehör

Ersatzklinge	Drehmomentschlüssel
	
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 Schaft

Bohrtiefe ca. 3 x D – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 197

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

Ersatzteile

Bohrerdurchmesser (Zoll)	Spannschlüssel	Befestigungs-schraube	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

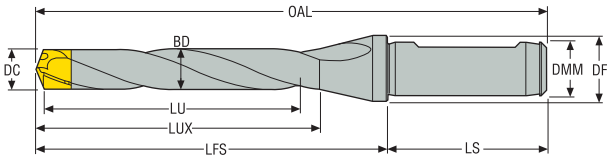
Zubehör

Ersatzklinge	Drehmomentschlüssel
	
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

Bohrtiefe ca. 5 x D – Schaft (metrisch)





- SD105 -R7 Schaft
- Mit interner Kühlschmierstoffzufuhr
- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Schnittdaten, siehe Seite(n) 198

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

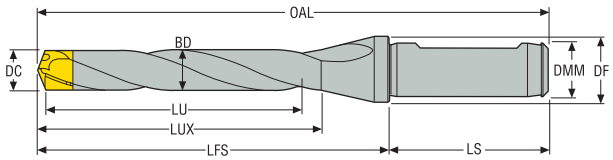
Bohrerdurchmesser (mm)	Spannschlüssel	Befestigungs-schraube	Satz Ersatzteile
			
10,00-11,99	H1.5-2D	MP6SS3X12	SD105-SP-4.0
12,00-13,99	H1.5-2D	MP6SS3X12	SD105-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD105-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD105-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD105-SP-8.0

Zubehör

Ersatzklinge	Drehmomentschlüssel
	
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 Schaft

Bohrtiefe ca. 5 x D – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 198

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

Ersatzteile

Bohrerdurchmesser (Zoll)	Spannschlüssel	Befestigungs-schraube	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

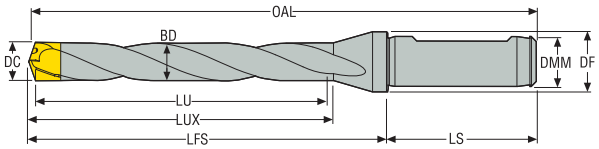
Zubehör

Ersatzklinge	Drehmomentschlüssel
	
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

Bohrtiefe ca. 7 x D – Schaft (metrisch)





- SD107 -R7 Schaft
- Mit interner Kühlschmierstoffzufuhr
- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Schnittdaten, siehe Seite(n) 199

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

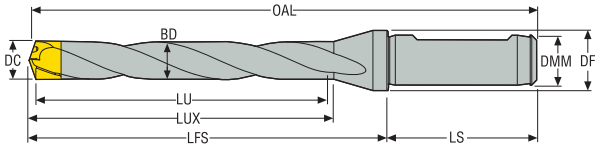
Bohrerdurchmesser (mm)	Spannschlüssel	Befestigungs-schraube	Satz Ersatzteile
			
12,00-13,99	H1.5-2D	MP6SS3X12	SD107-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD107-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD107-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD107-SP-8.0

Zubehör

Ersatzklinge	Drehmomentschlüssel
	
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD107 -R7 Schaft

Bohrtiefe ca. 7 x D – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 199

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

Ersatzteile

Bohrerdurchmesser (Zoll)	Spannschlüssel	Befestigungs-schraube	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

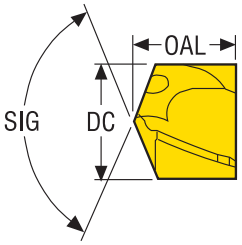
Zubehör

Bohrerdurchmesser (Zoll)	Ersatzklinge	Drehmoment-schlüssel
		
0.472-0.551	H00-1.5	H00-1509
0.551-0.669	H00-2.0	H00-2020
0.669-0.787	H00-2.5	H00-2530
0.787-1.023	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*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	Zoll	mm	Zoll
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
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

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	Zoll	mm	Zoll
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
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

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	Zoll	mm	Zoll
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
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

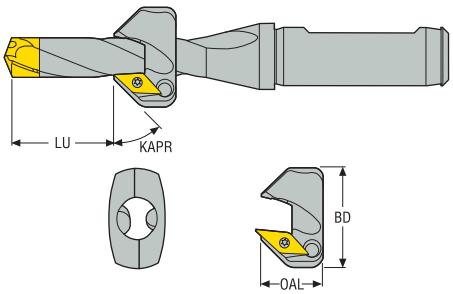
Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
SD100-18.80-K	00059693	–	–	■	18,8	*0.740*	14,4	*0.567*
SD100-18.80-M	00059692	–	■	–	18,8	*0.740*	14,4	*0.567*
SD100-18.80-P	00059691	■	–	–	18,0	*0.709*	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*
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*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
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*
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*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	K-Geometrie für Guss	DC		OAL	
					mm	*Zoll*	mm	*Zoll*
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



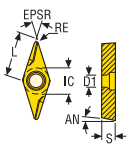


Bezeichnung	Produkt-nummer	Für Bohrer	Bohrtiefe LU								Max. Fastiefe	OAL	BD
			SD101 (min-max)		SD103 (min-max)		SD105 (min-max)		SD107 (min-max)				
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
SD100-C45-12.00/12.49	00014922	SD10x-12.00/12.49	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	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	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	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	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	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	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	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	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*

Ersatzteile

Bohrerdurchmesser (mm)	Schraube		Schlüssel	Spannschlüssel
				
	Wendeplatte	Fasring	Wendeplatte	Fasring
SD100-12.00–16.99	C02205-T07P	C04011-T15P	T07P-2	T15P-2
SD100-17.00–19.99	C02205-T07P	C05012-T15P	T07P-2	T15P-2

Wendeschneidplatte



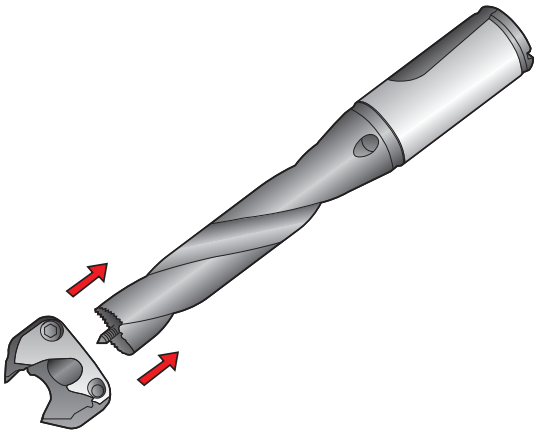
Toleranzen:
mm/*Zoll*

IC = ±0,025/*0.0009842"*
S = ±0,07/*0.0027559"*
RE = ±0,10/*0.0039370"*

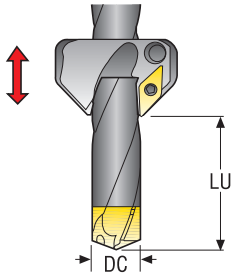
Größe	IC mm/*Zoll*	L mm/*Zoll*	S mm/*Zoll*	D1 mm/*Zoll*	RE mm/*Zoll*
09	**5,556**/*0.2187"*	**9,0**/*0.2187"*	**2,5**/*0.0984"*	**2,9**/*0.1141"*	**0,2**/*0.0078"*
Sorte:T400D					
Bezeichnung: VCGX090202-D1					
Produktnummer: 00014948					

Montagehinweis/Fasring

1. Fasring auf dem Bohrerschaft befestigen, ohne Faswendeplatte oder Bohrkrone.

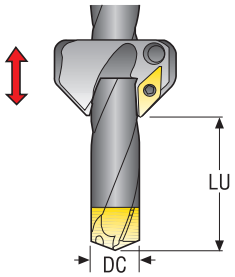


2.1 Fasring so eng wie möglich am Schaft befestigen.



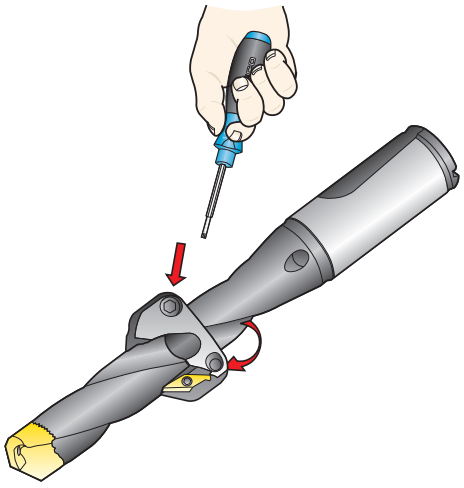
DC		LU Bohrtiefe (min.-max.)			
		SD101		SD103	
mm	*Zoll*	mm	*Zoll*	mm	*Zoll*
12	*.472*	12-13	*.472-.512*	12-28	*.472-1.102*
12,5	*.492*	12-14	*.472-.551*	12-29	*.472-1.142*
13	*.512*	13-14	*.512-.551*	13-29	*.512-1.142*
14	*.551*	14-20	*.551-.787*	14-40	*.551-1.575*
15	*.591*	14-21	*.551-.827*	14-41	*.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*

4. Beide Schrauben gemäß obiger Tabelle anziehen.



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

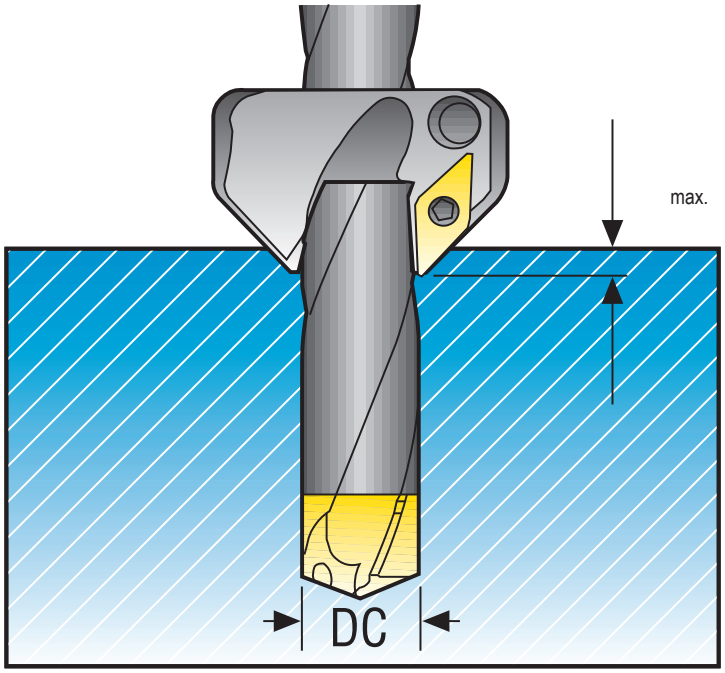
Fasringe

Die für Crownloc® empfohlenen Schnittgeschwindigkeiten und Vorschübe auf Seiten 196-199 müssen auch zum Fasen eingesetzt werden.

Herausforderung

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 – Durchmesser 10-26 mm / *0.394-1.024 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*	Ø22.00 *Ø 0.866*	Ø24.00 *Ø 0.945*	Ø26.00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD103 – Durchmesser 10-26 mm / *0.394-1.024 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*	Ø22.00 *Ø 0.866*	Ø24.00 *Ø 0.945*	Ø26.00 *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	*0.0080*	*0.0095*	*0.010*	*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	*0.0080*	*0.0095*	*0.010*	*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*	*0.010*	*0.010*	*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*	*0.010*	*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	85
	P	*0.0075*	*0.0085*	*0.0095*	*0.010*	*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	*0.0070*	*0.0085*	*0.0095*	*0.010*	*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	*0.0070*	*0.0085*	*0.0095*	*0.010*	*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*	*0.010*	*0.010*	*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	*0.0070*	*0.0085*	*0.0095*	*0.010*	*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	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*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*	*0.0060*	*0.0060*	*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	*0.0050*	*0.0050*	*0.0055*	*0.0055*	*0.0060*	*0.0060*	*0.0060*	*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	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*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*	*0.0040*	*0.0040*	*0.0040*	*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*	*0.0040*	*0.0040*	*0.0040*	*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	*0.010*	*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	*0.010*	*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	65
	K	*0.010*	*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*	*0.010*	*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	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*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	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*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	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*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	*0.0070*	*0.0075*	*0.0075*	*0.0080*	*0.0080*	*0.0080*	*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*	*0.0040*	*0.0040*	*0.0040*	*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*	*0.0040*	*0.0040*	*0.0040*	*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*	*0.0040*	*0.0040*	*0.0040*	*75*
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	60
	M	*0.0040*	*0.0044*	*0.0044*	*0.0044*	*0.0048*	*0.0048*	*0.0048*	*0.0048*	*0.0050*	*195*
S12	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*
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*	*0.0040*	*0.0040*	*0.0040*	*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*	*0.0050*	*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	46
	P	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*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*	*0.0050*	*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	46
	P	*0.0038*	*0.0044*	*0.0048*	*0.0050*	*0.0055*	*0.0060*	*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	*0.0050*	*0.0060*	*0.0065*	*0.0070*	*0.0075*	*0.0080*	*0.0080*	*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*	*0.0050*	*0.0055*	*0.0060*	*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*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*0.0065*	*0.0065*	*150*

SMG = Seco Werkstoff-Gruppe f = mm/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD105 – Durchmesser 10-26 mm / *0.394-1.024 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*	Ø22.00 *Ø 0.866*	Ø24.00 *Ø 0.945*	Ø26.00 *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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

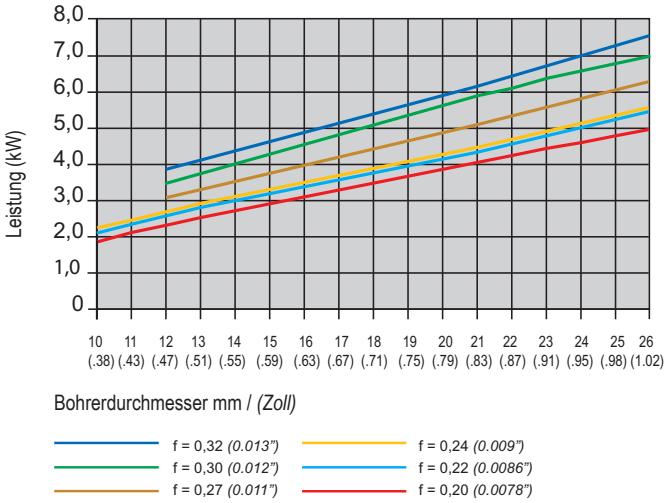
SMG		f								v_c
		Ø12.00 *Ø 0.472*	Ø14.00 *Ø 0.551*	Ø16.00 *Ø 0.630*	Ø18.00 *Ø 0.709*	Ø20.00 *Ø 0.787*	Ø22.00 *Ø 0.866*	Ø24.00 *Ø 0.945*	Ø26.00 *Ø 1.024*	
P1	P	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	110
	P	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*360*
P2	P	0,24	0,26	0,28	0,30	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

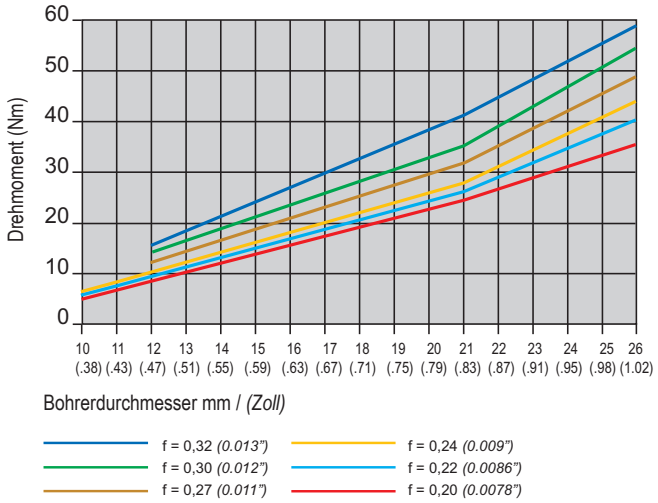
Bearbeitungsparameter

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 SFM)*.

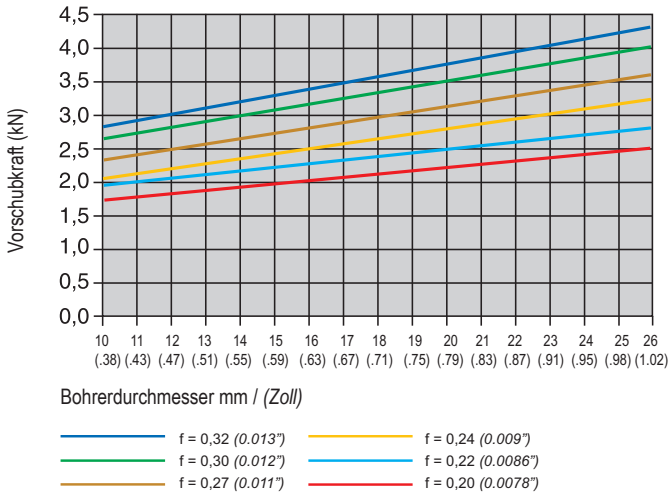
Leistungsbedarf



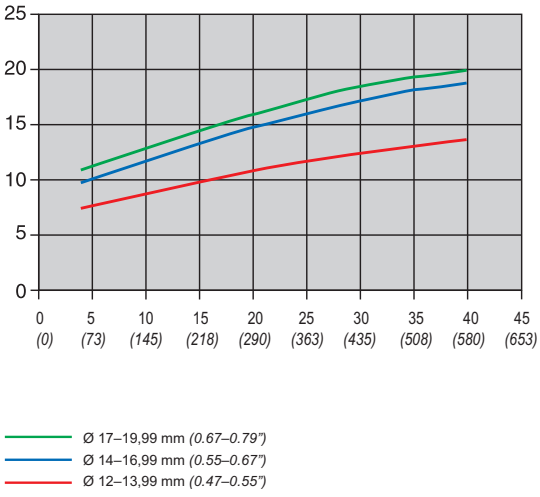
Drehmoment



Vorschubkraft



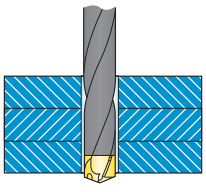
Kühlmittelmenge und Druck



Empfohlene Kühlschmierstoffmenge: Dx1 l/min
Mindest-Kühlschmierstoffmenge: D/2 l/min
D = Bohrerdurchmesser
Minimaler Kühlschmierstoffdruck von 10 bar *(145 PSI)* bei 3 x D.
Minimaler Kühlschmierstoffdruck von 20 bar *(290 PSI)* bei 3 x D.
Minimaler Kühlschmierstoffdruck 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*, *Ra 39-157 µin**					
Bohrerdurchmesser DC (mm)	**IT9 Toleranz (mm)**	**IT10 Toleranz (mm)**	**Bohrerdurchmesser DC** *(Zoll)*	**IT9 Toleranz** *(Zoll)*	**IT10 Toleranz** *(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. Für bestmögliche Bohrungsqualität immer den kürzest möglichen Bohrer einsetzen.

Herausforderungen – Einsatzhinweise:

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

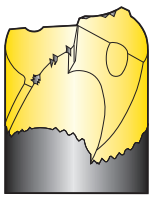
- Aufspannung:
  - Max. Rundlauffehler 0,06 TIR

- Spanabfuhr:
  - Schnittdaten

- Kühlung:
  - Druck
  - Durchfluss
  - Konzentration

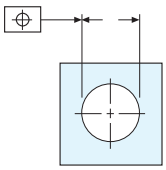
Schneidenausbrüche

- 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.



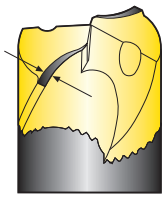
Durchmesser außer Toleranz

- Vorschub/U erhöhen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 15-18.
- Reibbearbeitung einsetzen, siehe Seite(n) 328.
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 492-493



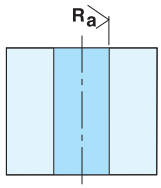
Schneller Freiflächenverschleiß

- Eingesetzte Geometrie prüfen.
- Schnittgeschwindigkeit reduzieren.



Geringe Oberflächengüte

- Vorschub/U reduzieren.
- Schnittgeschwindigkeit erhöhen.
- Eingesetzte Geometrie prüfen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 15-18.
- Reibbearbeitung einsetzen, siehe Seite(n) 328.



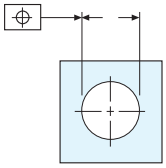
Spanflächenverschleiß

- Vorschub/U senken
- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen



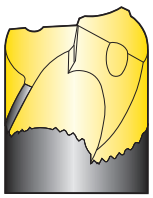
Mittenversatz der Bohrung

- 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) 15-18.
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 492-493



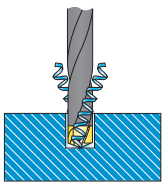
Verschleiß der Führungsfase

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



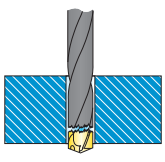
Spänestau durch lange Späne

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



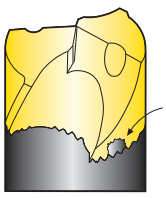
Bruch bei Bohreraustritt

- 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 Hochtemperaturlegierungen, Titan, Titanlegierungen und Rostfrei.

Programmübersicht

Crownloc® Plus	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz (1)	Oberflächengüte (2)
SD403  Seite(n) 206-209	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) 210-213	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) 214-217	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 verwendetem Werkstoff und verwendeten Schnittdaten kann es zu Abweichungen kommen.
2) Bohrtiefe, Schnittdaten, Kühlmitteldruck und Werkstoff können die Oberflächengüte beeinträchtigen.

Code-Schlüssel

Crownloc® Plus Bohrerkörper

Metrisch

Bohrertyp SD403: 3 x D SD405: 5 x D SD408: 8 x D	Min./max. Durchmesser Krone	Bohrtiefe	Aufnahme-durchmesser	Aufsteck-fräser rechts-drehend	Schaftart 1. Zylindrisch 7. ISO 9766
SD403	14.00/14.99	45	16	R	7



Zoll

45	0750	R	7		

Code-Schlüssel Kronen

Bohrerdurchmesser	Geometrie P = Stahl M = Rostfrei
SD400 – 14.00	– P



Geometrien

P-Geometrie
Universelle Geometrie, erste Wahl für Stahl



M-Geometrie
Erste Wahl für Rostfrei, gehärteten Stahl und Superlegierungen



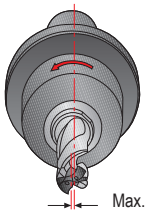
Montagehinweise

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

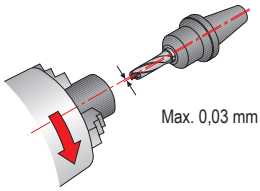
Bei rotierendem Einsatz darf die maximale Rundlaufabweichung (TIR) nicht mehr als 0,06 mm *(0.002")* betragen, gemessen am eingespannten Bohrer.
Rundlauf des Bohrers im montierten Zustand messen.



Max. 0,06 mm *(.002")*

3. Statischer Einsatz

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



Max. 0,03 mm *(.001")*

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 Aufnahmen Typ ERHP 5672, Hochpräzisionsspannzangenfutter, einsetzen.
Weitere Informationen, siehe Katalog Werkzeug-Systeme.



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



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



Weldon

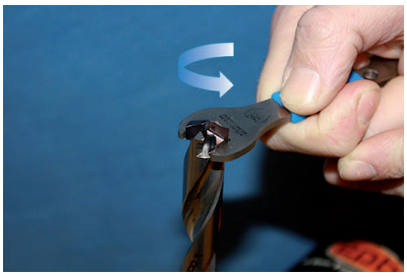
1.

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



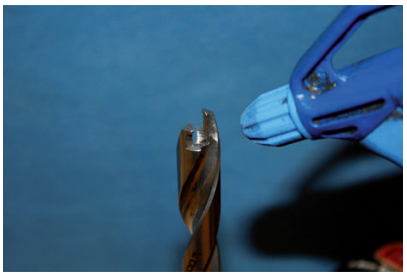
2.

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



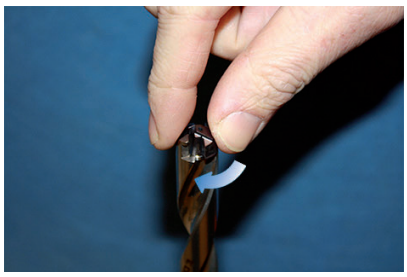
3.

Vor Montage der neuen Krone die Kontaktflächen reinigen.



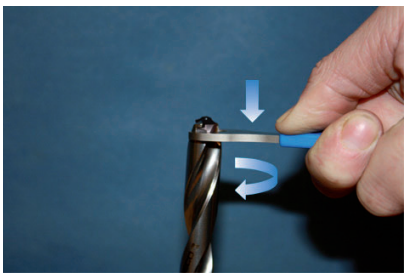
4.

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



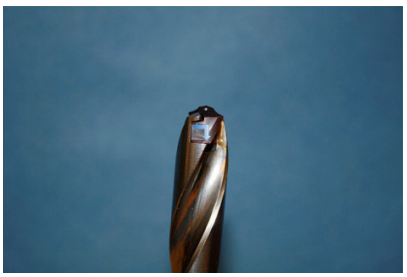
5.

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



6.

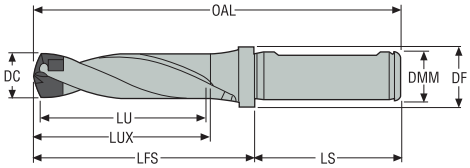
Bei Einsatz der Krone im Bohrerkörper muss voller Kontakt zwischen den Kontaktflächen des Bohrerkörpers und der Krone bestehen, siehe Abbildung.



SD403 – R7

Bohrtiefe ca. 3 x D – Schaft (metrisch)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 222

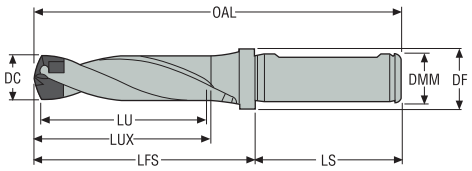
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD403-12.00/12.49-38-16R7	02622894	12,0-12,49	38,0	106,2	46,2	58,2	48,0	16,0	20,0
SD403-12.50/12.99-39-16R7	02622895	12,5-12,99	39,0	108,0	47,5	60,0	48,0	16,0	20,0
SD403-13.00/13.99-42-16R7	02622896	13,0-13,99	42,0	111,9	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

Bohrerdurchmesser (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 – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 222

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

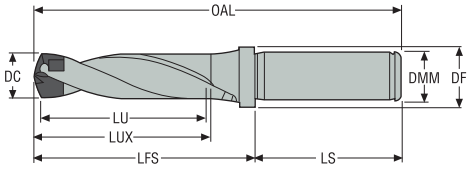
Ersatzteile

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 – Schaft (metrisch)





- Zylinderschaft (R1) passend zu den Aufnahmen: 5834 und 5672
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 222

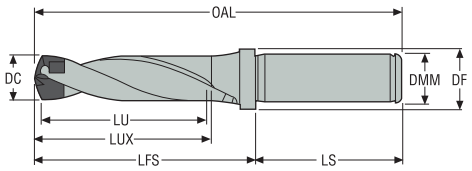
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD403-12.00/12.49-38-16R1	02622920	12,0-12,49	38,0	106,2	46,2	58,2	48,0	16,0	20,0
SD403-12.50/12.99-39-16R1	02622921	12,5-12,99	39,0	108,0	47,5	60,0	48,0	16,0	20,0
SD403-13.00/13.99-42-16R1	02622922	13,0-13,99	42,0	111,9	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

Bohrerdurchmesser (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 – Schaft (Zoll)





- Zylinderschaft (R1) passend zu den Aufnahmen: 5834 und 5672
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 222

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

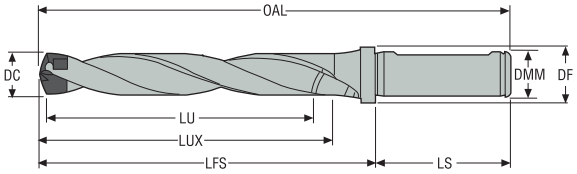
Ersatzteile

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 – Schaft (metrisch)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 223

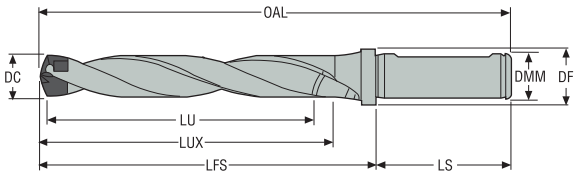
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD405-12.00/12.49-63-16R7	02623554	12,0-12,49	63,0	131,2	71,2	83,2	48,0	16,0	20,0
SD405-12.50/12.99-65-16R7	02623555	12,5-12,99	65,0	134,0	73,5	86,0	48,0	16,0	20,0
SD405-13.00/13.99-70-16R7	02623556	13,0-13,99	70,0	139,9	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

Bohrerdurchmesser (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 – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 223

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

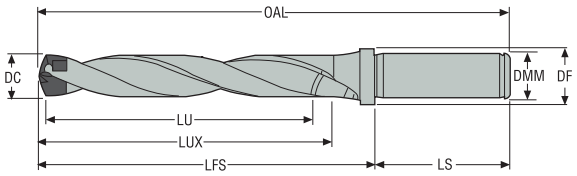
Ersatzteile

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 – Schaft (metrisch)





- Zylinderschaft (R1) passend zu den Aufnahmen: 5834 und 5672
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 223

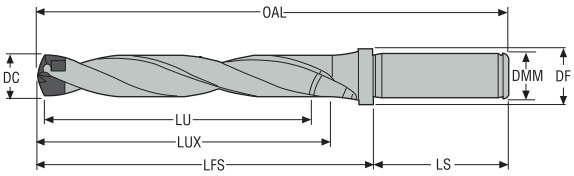
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD405-12.00/12.49-63-16R1	02623570	12,0-12,49	63,0	131,2	71,2	83,2	48,0	16,0	20,0
SD405-12.50/12.99-65-16R1	02623571	12,5-12,99	65,0	134,0	73,5	86,0	48,0	16,0	20,0
SD405-13.00/13.99-70-16R1	02623572	13,0-13,99	70,0	139,9	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

Bohrerdurchmesser (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 – Schaft (Zoll)





- Zylinderschaft (R1) passend zu den Aufnahmen: 5834 und 5672
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 223

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

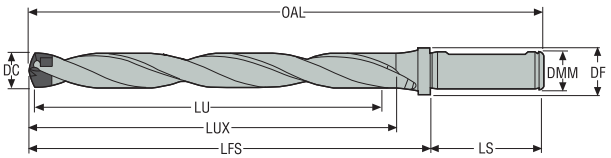
Ersatzteile

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 – Schaft (metrisch)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 224

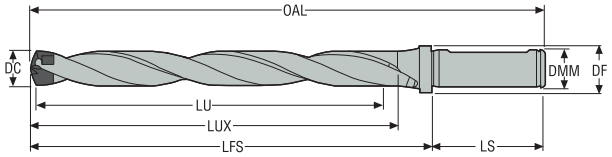
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD408-12.00/12.49-100-16R7	02623615	12,0-12,49	100,0	168,2	108,2	120,2	48,0	16,0	20,0
SD408-12.50/12.99-104-16R7	02623616	12,5-12,99	104,0	173,0	112,5	125,0	48,0	16,0	20,0
SD408-13.00/13.99-112-16R7	02623617	13,0-13,99	112,0	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

Bohrerdurchmesser (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 – Schaft (Zoll)





- ISO9766 passt zu Aufnahmen: Weldon 1835B, ISO 5414, DIN 60880
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 224

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

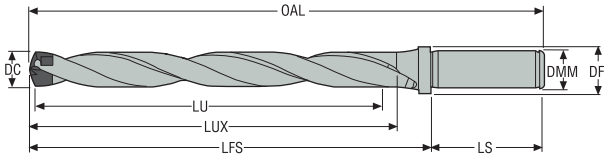
Ersatzteile

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 – Schaft (metrisch)





- Zylinderschaft (R1) passend zu den Aufnahmen: 5834 und 5672
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 224

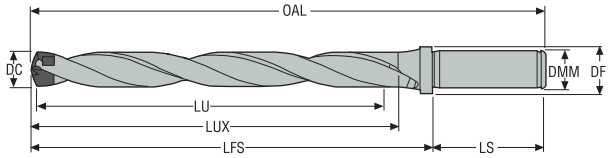
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD408-12.00/12.49-100-16R1	02623627	12,0-12,49	100,0	168,2	108,2	120,2	48,0	16,0	20,0
SD408-12.50/12.99-104-16R1	02623628	12,5-12,99	104,0	173,0	112,5	125,0	48,0	16,0	20,0
SD408-13.00/13.99-112-16R1	02623629	13,0-13,99	112,0	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

Bohrerdurchmesser (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 – Schaft (Zoll)





- Zylinderschaft (R1) passend zu den Aufnahmen: 5834 und 5672
- Mit interner Kühlschmierstoffzufuhr
- Schnittdaten, siehe Seite(n) 224

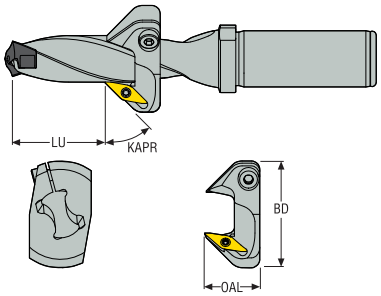
Bezeichnung	Produkt-nummer	Max Bohrtiefe	Bohrer-durchmesser DC	LU	DF	OAL	LS	LFS	LUX	DMM
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*
SD408-12.00/12.49-100-0625R1	02623651	3.937	0.472-0.492	3.937	0.787	6.622	1.890	4.732	4.260	0.625
SD408-12.50/12.99-104-0625R1	02623652	4.094	0.492-0.511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

Ersatzteile

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

Fasringe



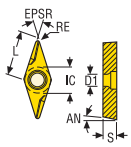


Bezeichnung	Produkt-nummer	Für Bohrer	Bohrtiefe LU SD403 (min-max)		SD405 (min-max)		SD408 (min-max)		Max. Fastiefe	OAL	BD	KAPR°
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	
SD400-C45-12.00/12.49	02846075	SD40x-12.00/12.49	6,0 *0.236*	22,0 *0.866*	6,0 *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

Ersatzteile

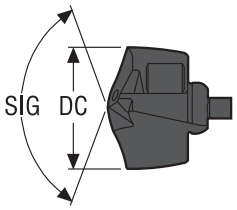
Bohrerdurchmesser (mm)	Schlüssel	Schraube	Spannschlüssel	Spannschlüssel	Klemmschraube 1	Klemmschraube 2
						
SD400-C45...	T07P-2	C02505-T07P	2SMS795	3SMS795	MC6S4X8	P6SS4X8

Wendeschneidplatte

	Toleranzen: mm/*Zoll*	Größe	IC mm/*Zoll*	L mm/*Zoll*	S mm/*Zoll*	D1 mm/*Zoll*	RE mm/*Zoll*
	IC = ±0,025/*0.0009842"* S = ±0,07/*0.0027559"* RE = ±0,10/*0.0039370"*	**09**	**5,556**/*0.2187"*	**9,0**/*0.2187"*	**2,5**/*0.0984"*	**2,9**/*0.1141"*	**0,2**/*0.0078"*
		Sorte: T400D					
		Bezeichnung: VCGX090202-D1					
		Produktnummer: 00014948					

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-M	02826212	–	■	12,41	*0.489*
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-M	02826216	–	■	12,9	*0.508*
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-M	02826221	–	■	13,7	*0.539*
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*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
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*
SD400-14.68-M	02826228	–	■	14,68	*0.578*
SD400-14.68-P	02634595	■	–	14,68	*0.578*
SD400-14.70-M	02826229	–	■	14,7	*0.579*
SD400-14.70-P	02634596	■	–	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-M	02826231	–	■	14,9	*0.587*
SD400-14.90-P	02634598	■	–	14,9	*0.587*
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-M	02826238	–	■	15,8	*0.622*
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*
SD400-16.27-P	02635960	■	–	16,27	*0.641*
SD400-16.40-P	02635962	■	–	16,4	*0.646*
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-M	02826245	–	■	16,8	*0.661*
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*
SD400-17.065-P	02635972	■	–	17,065	*0.672*
SD400-17.10-P	02635973	■	–	17,1	*0.673*

Bezeichnung	Produktnummer	P-Geometrie für Stahl	M-Geometrie für Rostfrei und Superlegierungen	DC	
				mm	*Zoll*
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*
SD400-17.80-P	02635978	■	–	17,8	*0.701*
SD400-17.859-M	02826252	–	■	17,86	*0.703*
SD400-17.859-P	02635979	■	–	17,859	*0.703*
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*
SD400-18.256-P	02635984	■	–	18,256	*0.719*
SD400-18.50-M	02826256	–	■	18,5	*0.728*
SD400-18.50-P	02635985	■	–	18,5	*0.728*
SD400-18.653-M	02826257	–	■	18,65	*0.734*
SD400-18.653-P	02635986	■	–	18,653	*0.734*
SD400-18.70-M	02826258	–	■	18,7	*0.736*
SD400-18.70-P	02635987	■	–	18,7	*0.736*
SD400-18.80-M	02826259	–	■	18,8	*0.740*
SD400-18.80-P	02635988	■	–	18,8	*0.740*
SD400-18.90-M	02826260	–	■	18,9	*0.744*
SD400-18.90-P	02635989	■	–	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*
SD400-19.25-M	02925410	–	■	19,25	*0.758*
SD400-19.447-M	02826264	–	■	19,45	*0.766*
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-M	02826266	–	■	19,7	*0.776*
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.**

SD403 – Durchmesser 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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD405 – Durchmesser 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	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

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

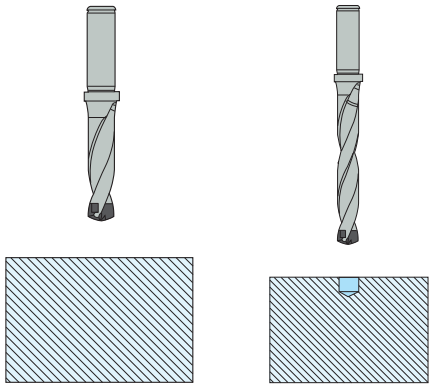
SMG		f					v_c
		Ø12,00 *Ø 0.472*	Ø14,00 *Ø 0.551*	Ø16,00 *Ø 0.630*	Ø18,00 *Ø 0.709*	Ø20,00 *Ø 0.787*	
P1	P	0,30	0,32	0,34	0,36	0,36	100
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*330*
P2	P	0,30	0,32	0,34	0,36	0,38	100
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*330*
P3	P	0,28	0,30	0,32	0,34	0,36	85
	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/rev (IPR) V_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

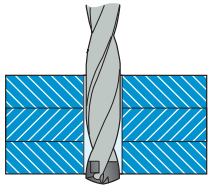
Anwendungsinformationen

Anwendungsinformationen

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



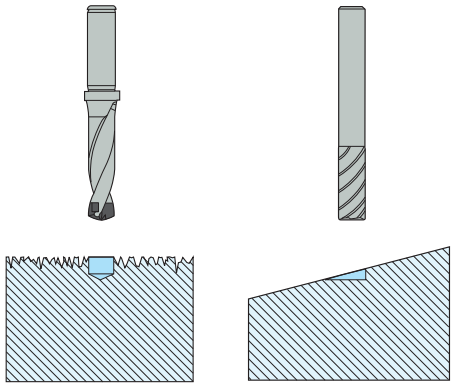
Plattenpakete
Das Bohren von Plattenpaketen ist möglich, vorausgesetzt, es gibt keine Zwischenräume zwischen den Platten und die Aufspannung ist sehr stabil. Zwischenräume können die Spanabfuhr behindern und den Bohrer dabei beschädigen.



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



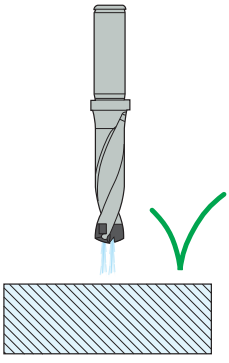
Ungleichmäßige Eintrittsflächen

Winkeliger Bohrungseintritt

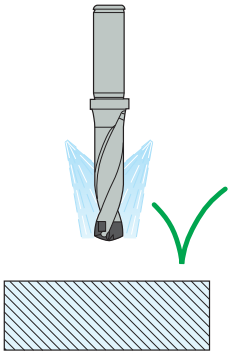
Fräsen einer ebenen Fläche mit einem Seco Vollhartmetallfräser.

Kühlung

Kühlschmierstoffdruck
Minimaler Kühlschmierstoffdruck von 10 bar (145 PSI) bei ≤ 3 x D
Minimaler Kühlschmierstoffdruck von 30 bar (435 PSI) bei > 3 x D

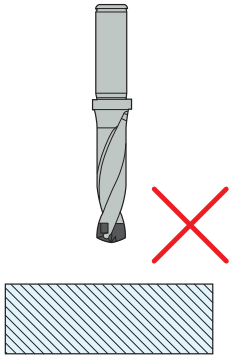


Erste Wahl



<3 x D

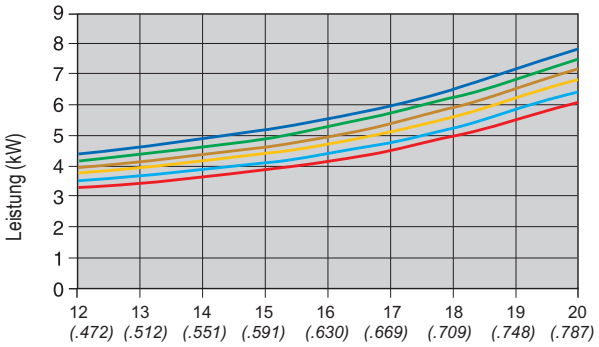
Kühlschmierstoffmischung
Wir empfehlen für diese Bearbeitung allgemein eine Kühlschmierstoffkonzentration von 6 bis 8%. Bei hochlegierten und rostfreien Stählen empfehlen wir eine Kühlschmierstoffkonzentration von 10%



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 SFM)*.

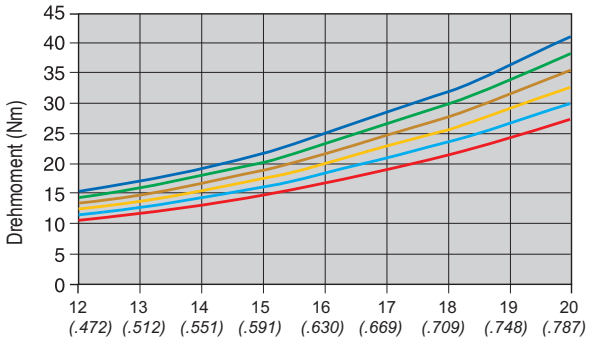
Leistungsbedarf



Bohrerdurchmesser mm / *(Zoll)*

f = 0,32 *(0.013")*
f = 0,30 *(0.012")*
f = 0,27 *(0.011")*
f = 0,24 *(0.009")*
f = 0,22 *(0.0086")*
f = 0,20 *(0.0078")*

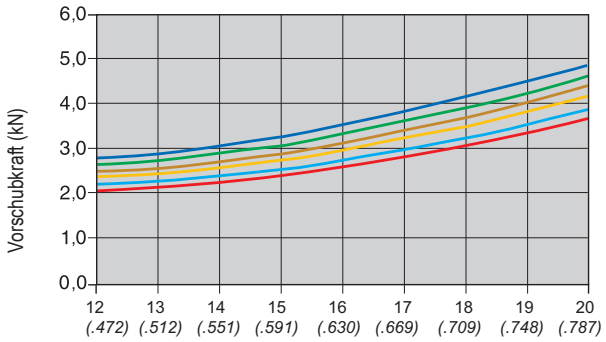
Drehmoment



Bohrerdurchmesser mm / *(Zoll)*

f = 0,32 *(0.013")*
f = 0,30 *(0.012")*
f = 0,27 *(0.011")*
f = 0,24 *(0.009")*
f = 0,22 *(0.0086")*
f = 0,20 *(0.0078")*

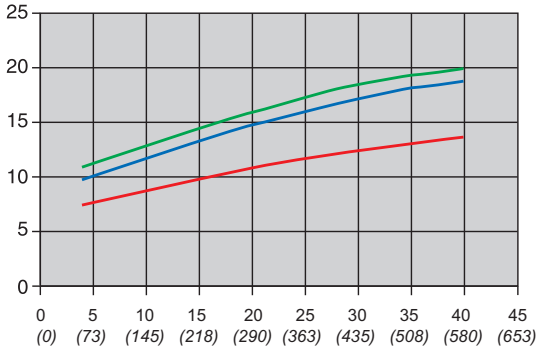
Vorschubkraft



Bohrerdurchmesser mm / *(Zoll)*

f = 0,32 *(0.013")*
f = 0,30 *(0.012")*
f = 0,27 *(0.011")*
f = 0,24 *(0.009")*
f = 0,22 *(0.0086")*
f = 0,20 *(0.0078")*

Kühlmittelmenge und Druck



Ø 17–19,99 mm *(0.67–0.79")*
Ø 14–16,99 mm *(0.55–0.67")*
Ø 12–13,99 mm *(0.47–0.55")*

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

SD403, SD405 und SD408 IT9-10 / R_a 1-4*, *Ra 39-157 µin**					
Bohrerdurchmesser DC (mm)	**IT9 Toleranz (mm)**	**IT10 Toleranz (mm)**	**Bohrerdurchmesser DC** *(Zoll)*	**IT9 Toleranz** *(Zoll)*	**IT10 Toleranz** *(Zoll)*
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 kürzest möglichen Bohrer einsetzen.

Herausforderungen – Einsatzhinweise:

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

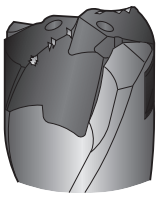
- Aufspannung:
  - Max. Rundlauffehler 0,06 TIR

- Spanabfuhr:
  - Schnittdaten

- Kühlung:
  - Druck
  - Durchfluss
  - Konzentration

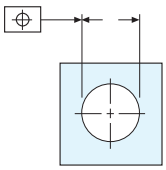
Schneidenausbrüche

- 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.



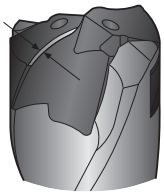
Durchmesser außer Toleranz

- Vorschub/U erhöhen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 15-18.
- Reibbearbeitung einsetzen, siehe Seite(n) 328.
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 492-493.



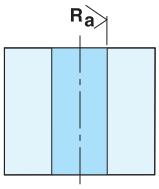
Schneller Freiflächenverschleiß

- Eingesetzte Geometrie prüfen.
- Schnittgeschwindigkeit reduzieren.



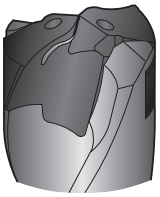
Geringe Oberflächengüte

- Vorschub/U reduzieren.
- Schnittgeschwindigkeit erhöhen.
- Eingesetzte Geometrie prüfen.
- Seco Feedmax-Bohrer einsetzen, siehe Seite(n) 15-18.
- Reibbearbeitung einsetzen, siehe Seite(n) 328



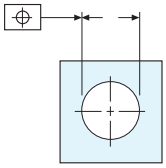
Spanflächenverschleiß

- Vorschub/U senken
- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen



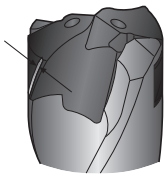
Mittenversatz der Bohrung

- 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) 15-18.
- Ausdrehbearbeitung einsetzen, siehe Seite(n) 492-493



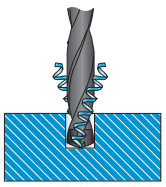
Verschleiß der Führungsfase

- 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

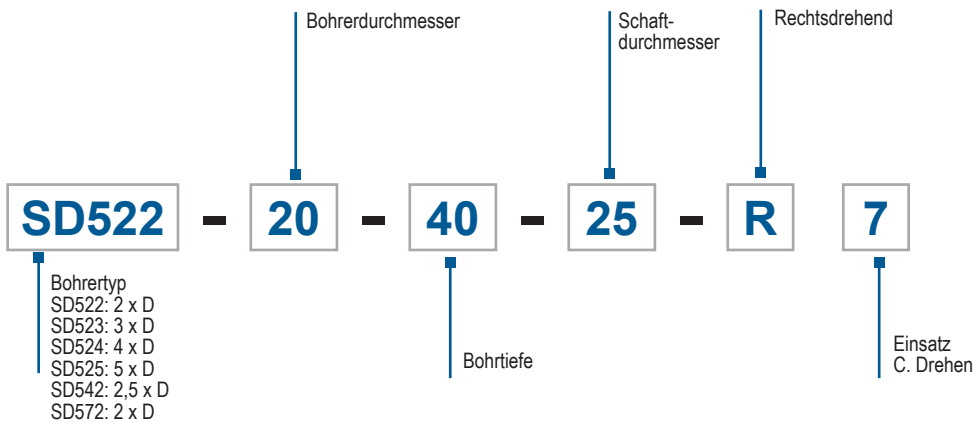
Perfomax®	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz
SD522  Seite(n) 242, 243, 244-242, 243, 244	15-59 mm *(0.594-2.375“)*	~ 2 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+ 0/+ 0.008”)*
SD523  Seite(n) 245, 246, 247, 248-261, 262, 263	15-59 mm *(0.594-2.375“)*	~ 3 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,3 mm *(+ 0/+ 0.012”)*
SD524  Seite(n) 264, 265, 266-276, 277	17-59 mm *(0,594-2.375“)*	~ 4 x D	+/- 0,1 mm *(+/- 0.004”)*	+ 0,4 mm *(+ 0/+ 0.016”)*
SD525  Seite(n) 278, 279-280	19-45 mm *(0,750-2.000“)*	~ 5 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,5 mm *(+ 0/+ 0.020”)*
SD542  Seite(n) 281-282	60-85 mm *(2.250-3.500“)*	~ 2.5 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+ 0/+ 0.008”)*

Programmübersicht

Perfomax®	Durchmesserbereich	Bohrtiefe	Toleranz Bohrdurchmesser	Bohrungstoleranz
SD572  Seite(n) 283, 284-283, 284	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) 287-291	60-160 mm *(2.5“-4.000“)*	~ 1-10 x D	+/- 0,2 mm *(+/- 0.008”)*	–

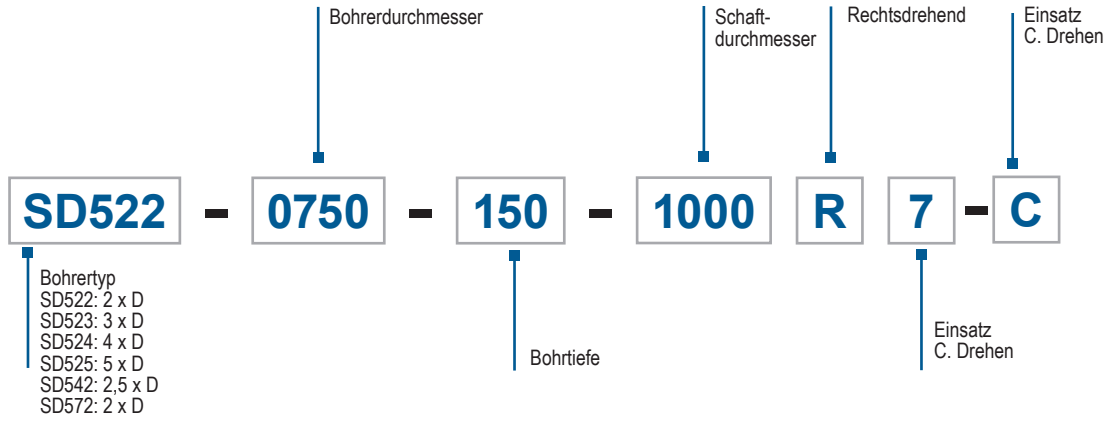
Code Schlüssel – Wendeplatten-Bohrer

Metrisch

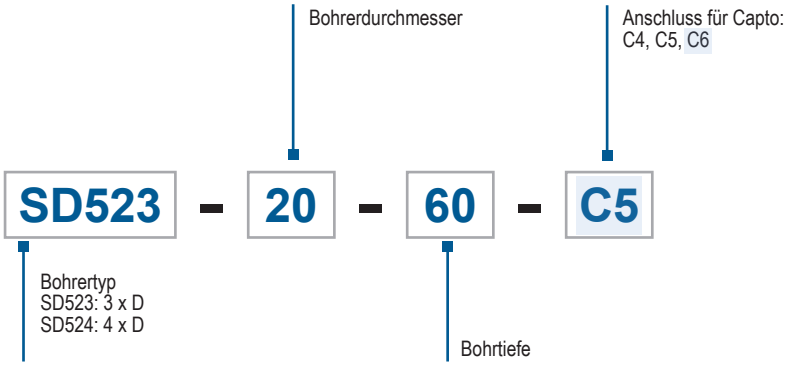




Zoll



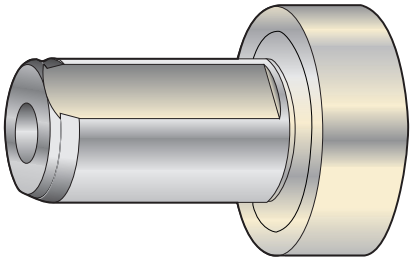
Capto™



Aufnahmen

Aufnahmen

-R7

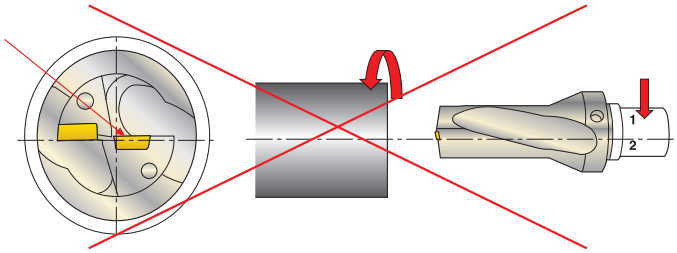


ISO 9766
Universell einsetzbar, passend für viele Aufnahmen:

- Weldon 1835B
- ISO 5414
- DIN 69880

Interne Kühlschmierstoffzufuhr

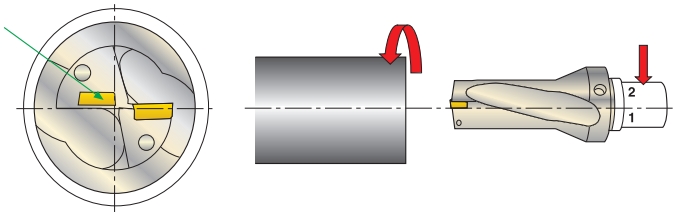
R7 und R7-C



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

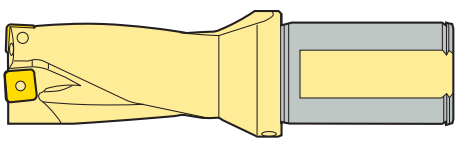
Statischer Einsatz:

- 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.

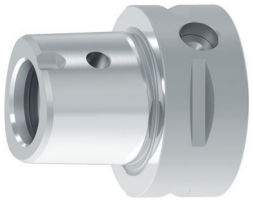


ANMERKUNG:

- 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.

Aufnahmen

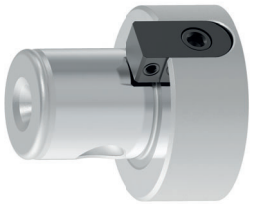
Seco-Capto™



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 µm

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

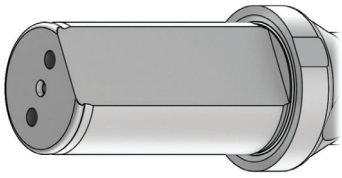
ABS 50 (kompatibel)



- 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

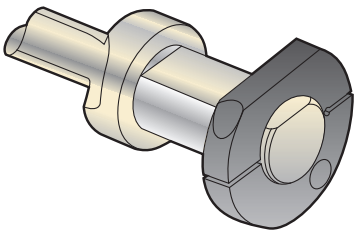
ANMERKUNG:
Der Kühlmittelring muss separat bestellt werden.

Zubehör – Kühlring

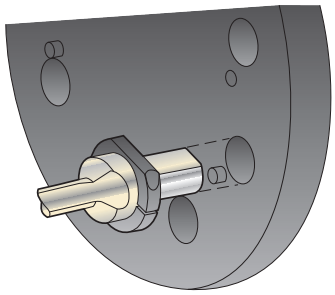
VDI 30			
Bohrtiefe	Bohrdurchmesser		Zubehör Kühlring
	mm	*Zoll*	
2 x D	15-31	*0.591-1.220*	SDA5-30R8
3 x D	15-31	*0.591-1.220*	SDA5-30R8
4 x D	17-31	*0.669-1.220*	SDA5-30R8
5 x D	19-31	*0.748-1.220*	SDA5-30R8

VDI 40					
Bohrtiefe	Bohrdurchmesser		Stopfen	Klemm-schraube	Zubehör Kühlring
	mm	*Zoll*			
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

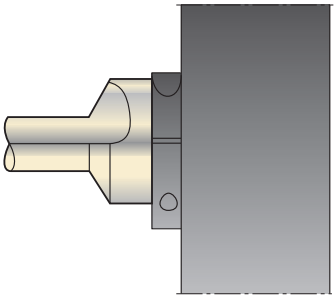
1. Ring über den Schaft schieben. Schraube nicht festziehen.



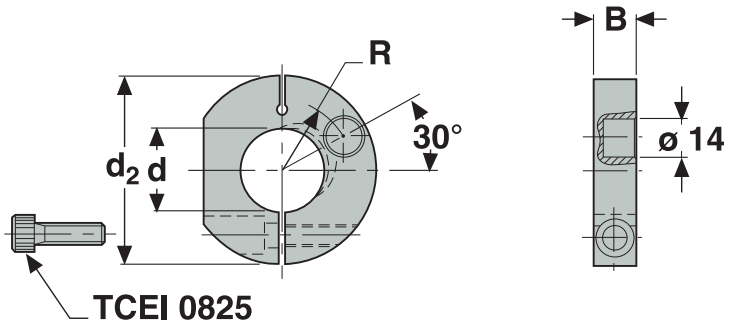
2. Bohrer in die Revolverscheibe montieren.



3. Ringschraube fest anziehen.

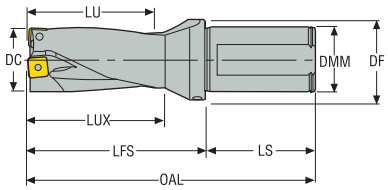


Kühlmittelring



SD522

Bohrtiefe ca. 2 x D





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 304, 305
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-22-44-25R7	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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-43-86-40R7	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*
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

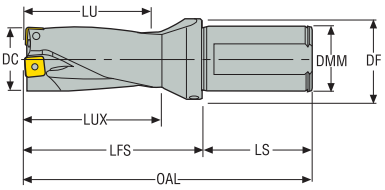
Zubehör

Bohrerdurchmesser (mm)	Drehmomentschlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD522

Bohrtiefe ca. 2 x D – Zoll





- ISO 9766 Schaft, R7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 304, 305
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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

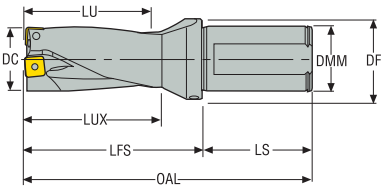
Bohrerdurchmesser (Zoll)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787	C02205-T07P	C02205-T07P	T07P-2
0.812-0.827	C02205-T07P	C02205-T07P	T07P-2
0.875	C02506-T08P	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.062	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
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

Bohrerdurchmesser (Zoll)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
0.594-0.687	T00-07P09	T00-07P	8 in/lbs
0.709-0.766	T00-07P09	T00-07P	8 in/lbs
0.787	T00-07P09	T00-07P	8 in/lbs
0.812-0.827	T00-07P09	T00-07P	8 in/lbs
0.875	T00-08P12	T00-08P	10.6 in/lbs
0.906-1.000	T00-08P12	T00-08P	10.6 in/lbs
1.032-1.062	T00-09P20	T00-09P	17.7 in/lbs
1.125-1.187	T00-09P20	T00-09P	17.7 in/lbs
1.250-1.500	T00-15P30	T00-15P	26.6 in/lbs
1.625	T00-15P30	T00-15P	26.6 in/lbs
1.750-2.375	T00-15P30	T00-15P	26.6 in/lbs

SD522

Bohrtiefe ca. 2 x D – Zoll





- ISO 9766 Schaft, R7-C
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 304-305
- Zwischendurchmesser siehe My Design.
- Für statischen Einsatz

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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

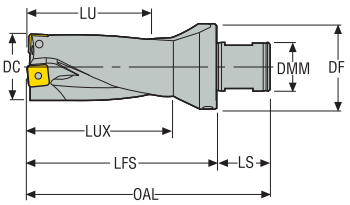
Zubehör

Bohrerdurchmesser (Zoll)	Schlauchadapter	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Stopfen	Drehmomentschlüssel
						
0.625	1310	C02245-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.687	1310	C02245-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.750	1310	C02205-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.812	1310	C02205-T07P	C02205-T07P	T07P-2	R1/4	T00-07P09
0.875	1310	C02506-T08P	C02506-T08P	T08P-2	R1/4	T00-08P12
0.937-1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4	T00-08P12
1.062	1310	C03007-T09P	C03007-T09P	T09P-2	R1/4	T00-09P20
1.125-1.187	1310	C03007-T09P	C03009-T09P	T09P-2	R1/4	T00-09P20
1.250-1.500	1310	C03508-T15P	C03508-T15P	T15P-2D	R1/4	T00-15P30
1.750-2.375	1310	C04011-T15P	C05012-T15P	T15P-2D	R1/4	T00-15P35

SD522

Bohrtiefe ca. 2 x D





- ABS 50 kompatibler Schaft, R2
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 304, 305
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD522-28.59-58-50R2	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*
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*	50,0 *1.969*	50,0 *1.969*	SPGX1504	SCGX120408	0,5 *0.020*	0,41 *0.016*

Ersatzteile

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

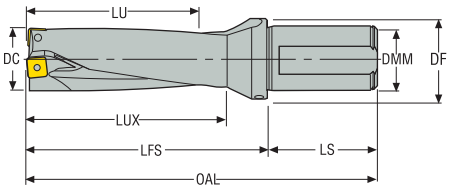
Zubehör

Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD523

Bohrtiefe ca. 3 x D





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-20.5-62-25R7	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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-35.5-107-40R7	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*
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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-58-174-40R7	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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

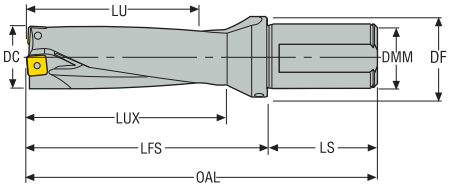
Zubehör

Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD523

Bohrtiefe ca. 3 x D – Zoll





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

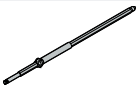
Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		Zoll	*Zoll*	***Zoll***	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide	*Zoll -*	*Zoll +*
SD523-0562-169-1000R7	03080485	0.562	1.686	5.117	1.883	2.867	2.250	1.000	1.378	SPGX0502	SCGX050204	0.011	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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		Zoll	*Zoll*	***Zoll***	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide	*Zoll -*	*Zoll +*
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
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

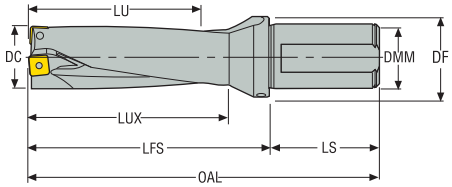
Bohrerdurchmesser (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel
			
0.562-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787-0.827	C02205-T07P	C02205-T07P	T07P-2
0.875	C02506-T08P	C02506-T08P	T08P-2
0.906	C02507-T08P	C03007-T08P	T08P-2
0.922	C02506-T08P	C03007-T08P	T08P-2
0.937-1.000	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)	Ersatzklinge	Drehmomentspanner
		
0.562-0.687	T00-07P	T00-07P09
0.709-0.766	–	T00-07P09
0.787-0.827	–	T00-07P09
0.875	–	T00-08P12
0.906	–	T00-08P12
0.922	–	T00-08P12
0.937-1.000	–	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





- ISO 9766 Schaft, R7-C
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.
- Für statischen Einsatz

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide	*Zoll -*	*Zoll +*
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
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

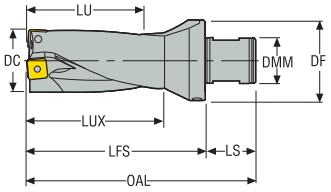
Bohrerdurchmesser (Zoll)	Schlauchadapter	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Stopfen
					
0.594-0.687	1310	C02245-T07P	C02245-T07P	T07P-2	R1/4
0.709-0.766	1310	C02205-T07P	C02245-T07P	T07P-2	R1/4
0.787-0.827	1310	C02205-T07P	C02205-T07P	T07P-2	R1/4
0.875	1310	C02506-T08P	C02506-T08P	T08P-2	R1/4
0.906-0.922	1310	C02506-T08P	C03007-T08P	T08P-2	R1/4
0.937-1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.032-1.109	1310	C03007-T09P	C03007-T09P	T09P-2	R1/4
1.125-1.187	1310	C03007-T09P	C03009-T09P	T09P-2	R1/4
1.250-1.562	1310	C03508-T15P	C03508-T15P	T15P-2D	R1/4
1.625-1.687	1310	C03508-T15P	C05012-T15P	T15P-2D	R1/4
1.750-2.375	1310	C04011-T15P	C05012-T15P	T15P-2D	R1/4

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
0.906-0.922	T00-08P12
0.937-1.000	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





- ABS 50 kompatibler Schaft, -2
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
SD523-28.59-86-50R2	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*
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

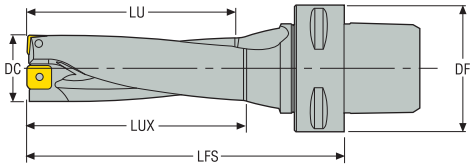
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD523

Bohrtiefe ca. 3 x D





- Seco-Capto™ C4-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

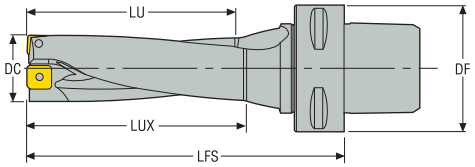
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD523

Bohrtiefe ca. 3 x D





- Seco-Capto™ C5-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
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*
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

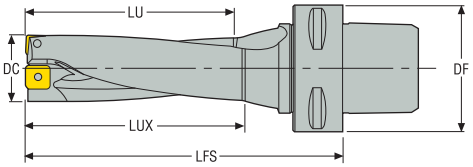
Zubehör

Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD523

Bohrtiefe ca. 3 x D





- Seco-Capto™ C6-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Innen	
		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*

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte		Innen	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide	mm - *Zoll -*	mm + *Zoll +*
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*
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

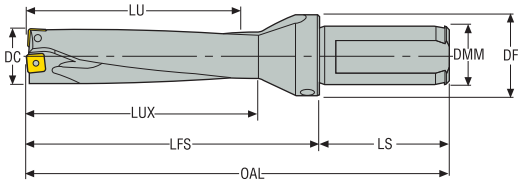
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD524

Bohrtiefe ca. 4 x D





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.

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

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
SD524-36-144-40R7	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
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

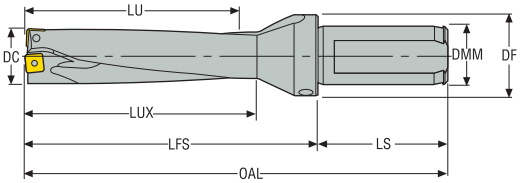
Zubehör

Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD524

Bohrtiefe ca. 4 x D – Zoll





- ISO 9766 Schaft, R7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.

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

Bezeichnung	Produkt-nummer	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD524-2062-825-1500R7	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
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

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

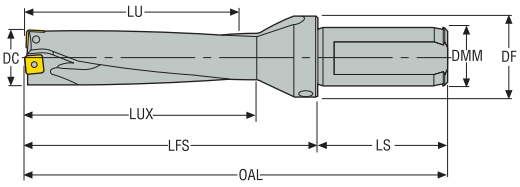
Zubehör

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

Torque wrench including blade.

SD524

Bohrtiefe ca. 4 x D – Zoll





- ISO 9766 Schaft, R7-C
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.
- Für statischen Einsatz

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

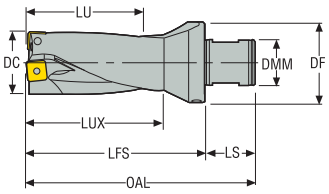
Zubehör

Bohrerdurchmesser (Zoll)	Schlauchadapter	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Stopfen	Drehmomentschlüssel
						
0.625-0.687	1310	C02245-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.750	1310	C02205-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.812	1310	C02205-T07P	C02205-T07P	T07P-2	R1/4	T00-07P09
0.875	1310	C02506-T08P	C02506-T08P	T08P-2	R1/4	T00-08P12
0.937-1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4	T00-08P12
1.062	1310	C03007-T09P	C03007-T09P	T09P-2	R1/4	T00-09P20
1.125-1.187	1310	C03007-T09P	C03009-T09P	T09P-2	R1/4	T00-09P20
1.250-1.375	1310	C03508-T15P	C03508-T15P	T15P-2D	R1/4	T00-15P30
1.750-2.375	1310	C04011-T15P	C05012-T15P	T15P-2D	R1/4	T00-15P35

SD524

Bohrtiefe ca. 4 x D





- ABS 50 kompatibler Schaft, -2
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.

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

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
SD524-31.75-127-50R2	03080359	31,75 *1.250*	127,0 *5.000*	188,0 *7.402*	132,0 *5.197*	157,0 *6.181*	31,0 *1.220*	50,0 *1.969*	50,0 *1.969*	SPGX11T3	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
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

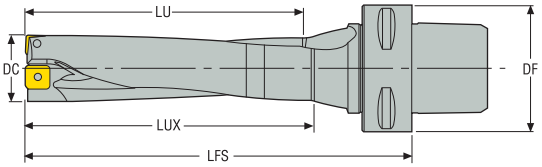
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD524

Bohrtiefe ca. 4 x D





- Seco-Capto™ C4-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.

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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

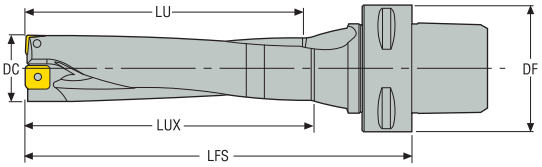
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD524

Bohrtiefe ca. 4 x D





- Seco-Capto™ C5-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.

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

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
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
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

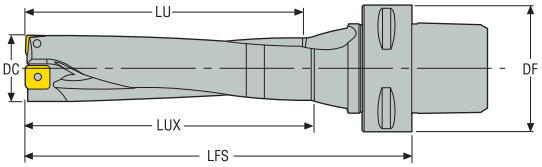
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD524

Bohrtiefe ca. 4 x D





- Seco-Capto™ C6-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 308, 309
- Zwischendurchmesser siehe My Design.

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

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	Zentrums-schneide	Peripherie-schneide
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
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

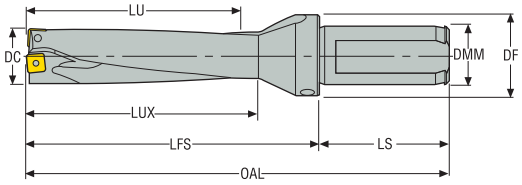
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD525

Bohrtiefe ca. 5 x D





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 310, 311
- Zwischendurchmesser siehe My Design.

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

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
SD525-40-200-40R7	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
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

Bohrerdurchmesser (mm)	Schraube		Schlüssel
			
	Zentrumsschneide	Peripherieschneide	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Zubehör

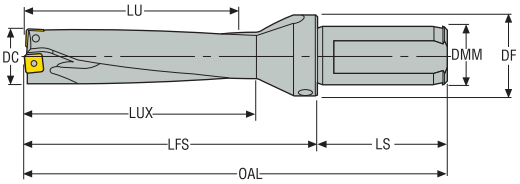
Bohrerdurchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD525

Bohrtiefe ca. 5 x D – Zoll





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 306-307
- Zwischendurchmesser siehe My Design.

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

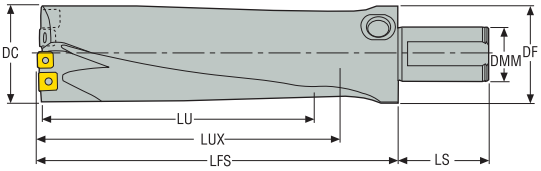
Ersatzteile

Zubehör

Bohrerdurchmesser (Zoll)	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Drehmomentschlüssel
				
0.750	C02205-T07P	C02245-T07P	T07P-2	T00-07P09
0.812	C02205-T07P	C02205-T07P	T07P-2	T00-07P09
0.875	C02506-T08P	C02506-T08P	T08P-2	T00-08P12
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2	T00-08P12
1.062	C03007-T09P	C03007-T09P	T09P-2	T00-09P20
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2	T00-09P20
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D	T00-15P30
1.625	C03508-T15P	C05012-T15P	T15P-2D	T00-15P30
1.750-2.000	C04011-T15P	C05012-T15P	T15P-2D	T00-15P35

SD542

Bohrtiefe ca. 2,5 x D – Metrisch





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 312, 313
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm	mm	mm	mm	mm	mm	mm	Zentrums-schneide	Peripherie-schneide
SD542-60-150-40R7	02590456	60,0	150,0	156,0	201,5	68,0	40,0	79,0	SPGX0903-C1	SCGX09T308..
SD542-65-162.5-40R7	02590457	65,0	162,5	169,5	214,0	68,0	40,0	79,0	SPGX11T3-C1	SCGX09T308..
SD542-70-175-40R7	02590458	70,0	175,0	182,5	226,5	68,0	40,0	79,0	SPGX11T3-C1	SCGX120408..
SD542-75-187.5-50R7	02590459	75,0	187,5	196,0	239,0	78,0	50,0	79,0	SPGX11T3-C1	SCGX120408..
SD542-80-200-50R7	02590460	80,0	200,0	210,0	251,5	78,0	50,0	79,0	SPGX12T3-C1	SCGX120408..
SD542-85-212.5-50R7	02590461	85,0	212,5	221,0	264,0	78,0	50,0	89,0	SPGX12T3-C1	SCGX120408..

Ersatzteile

Bohrerdurchmesser (mm)	Schraube		Schlüssel	Stopfen	Schlauch-adapter
					
	Zentrumsschneide	Peripherieschneide			
60,00-64,99	C03007-T09P	C03009-T09P	T09P-2	R3/8	R3/8-HA
65,00-68,99	C03508-T15P	C03508-T15P	T15P-2D	R3/8	R3/8-HA
69,00-86,99	C03508-T15P	C05012-T15P	T15P-2D	R3/8	R3/8-HA

Zubehör

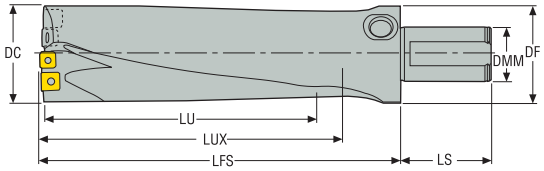
Bohrer-durchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
60,00-64,99	T00-09P20	T00-09P	3,0 Nm
65,00-68,99	T00-15P30	T00-15P	3,0 Nm
69,00-86,99	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD542

Bohrtiefe ca. 2.5 X D – Zoll





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 312, 313
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD542-2250-563-1500R7	02602085	2.250	5.630	5.800	7.000	4.500	1.500	3.110	SPGX 0903-C1	SCGX 09T308..
SD542-2500-625-1500R7	02602087	2.500	6.250	6.520	8.280	4.500	1.500	3.110	SPGX 0903-C1	SCGX 09T308..
SD542-2750-688-1500R7	02602088	2.750	6.880	7.190	8.900	4.500	1.500	3.110	SPGX 11T3-C1	SCGX 120408..
SD542-3000-750-2000R7	02602089	3.000	7.500	7.860	9.530	4.500	2.000	3.110	SPGX 11T3-C1	SCGX 120408..
SD542-3250-813-2500R7	02602090	3.250	8.130	8.460	10.150	4.500	2.500	3.500	SPGX 12T3-C1	SCGX 120408..
SD542-3500-875-2500R7	02602091	3.500	8.750	9.140	10.780	4.500	2.500	3.500	SPGX 1504-C1	SCGX 120408..

Ersatzteile

Bohrerdurchmesser (Zoll)	Schraube		Schlüssel	Stopfen	Schlauch-adapter
					
	Zentrumsschneide	Peripherieschneide			
2.250-2.500	C03007-T09P	C03009-T09P	T09P-2	R3/8	R3/8-HA
2.750-3.000	C03508-T15P	C03508-T15P	T15P-2D	R3/8	R3/8-HA
3.250-3.500	C03508-T15P	C05012-T15P	T15P-2D	R3/8	R3/8-HA

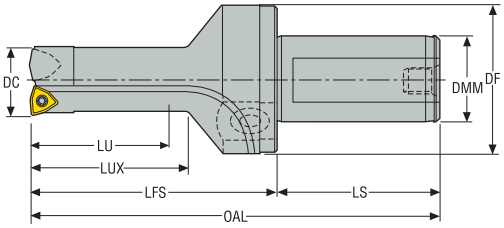
Zubehör

Bohrerdurchmesser (Zoll)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
2.250-2.500	T00-09P20	T00-09P	26.6 in/lbs
2.750-3.000	T00-15P30	T00-15P	26.6 in/lbs
3.250-3.500	T00-15P30	T00-15P	26.6 in/lbs

* Lieferung einschließlich Klinge.

SD572

Bohrtiefe ca. 2 x D – Metrisch





- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 314-315
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	DC	LU	LUX	LFS	LS	DMM	DF	Wendeschneidplatte	
		mm	mm	mm	mm	mm	mm	mm	Zentrums-schneide	Peripherie-schneide
SD572-15-30-25R7	02595777	15,0	30,0	35,0	65,0	56,0	25,0	42,0	WCMX030208-86	WCMX030208..
SD572-16-32-25R7	02595778	16,0	32,0	37,0	67,0	56,0	25,0	42,0	WCMX030208-86	WCMX030208..
SD572-17-34-25R7	02595779	17,0	34,0	39,0	69,0	56,0	25,0	42,0	WCMX030208-86	WCMX030208..
SD572-19-38-25R7	02595780	19,0	38,0	43,0	73,0	56,0	25,0	42,0	WCMX040208-86	WCMX030208..
SD572-22-44-25R7	02595781	22,0	44,0	49,0	79,0	56,0	25,0	42,0	WCMX050308-86	WCMX040208..
SD572-27-54-32R7	02595783	27,0	54,0	59,0	89,0	60,0	32,0	50,0	WCMX06T308-86	WCMX050308..
SD572-33-66-40R7	02595784	33,0	66,0	71,0	101,0	68,0	40,0	59,0	WCMX080412-86	WCMX06T308..
SD572-41-82-40R7	02595785	41,0	82,0	87,0	117,0	68,0	40,0	59,0	WCMX080412-86	WCMX080412..
SD572-47-94-40R7	02595786	47,0	94,0	99,0	129,0	68,0	40,0	59,0	WCMX080412-86	WCMX080412..

Ersatzteile

Bohrerdurchmesser (mm)	Schraube		Schlüssel	Stopfen	Schlauch-adapter
					
	Zentrumsschneide	Peripherieschneide			
15,00-20,50	C02205-T07P	C02205-T07P	T07P-2	R1/4	1310
20,51-24,50	C03007-T08P	C02506-T08P	T08P-2	R1/4	1310
24,51-32,50	C03508-T15P	C03007-T08P	T08P-2, T15P-2D	R1/4	1310
32,51-36,50	C03508-T15P	C03508-T15P	T15P-2D	R1/4	1310
36,51-59,00	C04011-T15P	C04011-T15P	T15P-2D	R1/4	1310

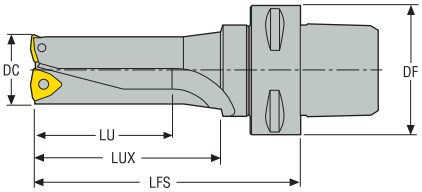
Zubehör

Bohrer-durchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-20,50	T00-07P09	T00-07P	0,9 Nm
20,51-24,50	T00-08P12	T00-08P	1,2 Nm
24,51-32,50	T00-08P12	T00-08P	1,2 Nm
32,51-36,50	T00-15P30	T00-15P	3,0 Nm
36,51-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.

SD572

Bohrtiefe ca. 2 x D – Zoll





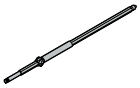
- ISO 9766 Schaft, -7
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 314-315
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	max (mm)-max (Zoll)	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
			Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	Zentrums-schneide	Peripherie-schneide
SD572-0591-118-1000R7	02602128	0.591-0.709	0.591	1.182	1.379	2.56	1.775	WCMX030208-86	WCMX 030208..
SD572-0669-134-1000R7	02602129	0.669-0.748	0.669	1.338	1.535	2.716	1.775	WCMX030208-86	WCMX 030208..
SD572-0748-150-1000R7	02602131	0.748-0.866	0.748	1.496	1.69	2.874	1.775	WCMX040208-86	WCMX 030208..
SD572-0866-173-1000R7	02602132	0.866-1.062	0.866	1.732	1.929	3.11	1.775	WCMX050308-86	WCMX 040208..
SD572-1062-212-1250R7	02602133	1.062-1.299	1.062	2.124	2.321	3.502	2.165	WCMX06T308-86	WCMX 050308..
SD572-1299-260-1500R7	02602134	1.299-1.614	1.299	2.598	2.795	3.976	2.303	WCMX080412-86	WCMX 06T308..
SD572-1614-322-1500R7	02602135	1.614-1.850	1.614	3.228	3.425	4.606	2.303	WCMX080412-86	WCMX 080412..
SD572-1850-370-1500R7	02602136	1.850-2.047	1.85	3.7	3.7	5.078	2.303	WCMX080412-86	WCMX 080412..

Ersatzteile

Bohrerdurchmesser (Zoll)	Schlauchadapter	Schlüssel für WSP	Schraube für Zentrums-WSP	Schraube für Peripherie-WSP	Schlüssel	Schraube
						
0.591-0.748	1310	T07P-2	C02205-T07P	C02245-T07P	C02245-T07P	R1/4
0.866	1310	T08P-2	C02506-T08P	C03007-T08P	–	R1/4
1.062	1310	T08P-2	C03508-T15P	C03007-T08P	T15P-2D	R1/4
1.299	1310	T15P-2D	C03508-T15P	C02506-T08P	C02506-T08P	R1/4
1.614-1.850	1310	T15P-2D	C04011-T15P	C04011-T15P	–	R1/4

Zubehör

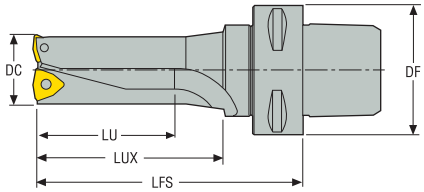
Bohrerdurchmesser (Zoll)	Ersatzklinge	Drehmoment-schlüssel
		
0.591-0.748	–	T00-07P09
0.866	–	T00-08P12
1.062	T00-15P	T00-15P30
1.299	–	T00-15P30
1.614-1.850	–	T00-15P30

* Lieferung einschließlich Klinge.

SD572

Bohrtiefe ca. 2 x D – Metrisch





- Seco-Capto™ C5-Schaft
- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 314-315
- Zwischendurchmesser siehe My Design.

Bezeichnung	Produkt-nummer	Bohrungs-durchmesser min.-max	DC	LU	LUX	LFS	DF	Wendeschneidplatte	
		mm	mm	mm	mm	mm	mm	Zentrums-schneide	Peripherie-schneide
SD572-15-30-C5	02595831	14,8-18,0	15,0	30,0	35,0	85,0	50,0	WCMX030208-86	WCMX030208..
SD572-16-32-C5	02595832	15,8-18,0	16,0	32,0	37,0	87,0	50,0	WCMX030208-86	WCMX030208..
SD572-17-34-C5	02595833	16,8-19,0	17,0	34,0	39,0	89,0	50,0	WCMX030208-86	WCMX030208..
SD572-19-38-C5	02595834	18,8-22,0	19,0	38,0	43,0	93,0	50,0	WCMX040208-86	WCMX030208..
SD572-22-44-C5	02595835	21,8-27,0	22,0	44,0	49,0	99,0	50,0	WCMX050308-86	WCMX040208..
SD572-27-54-C5	02595836	26,8-33,0	27,0	54,0	59,0	109,0	50,0	WCMX06T308-86	WCMX050308..
SD572-33-66-C5	02595837	32,8-41,0	33,0	66,0	71,0	121,0	50,0	WCMX080412-86	WCMX06T308..
SD572-41-82-C5	02595838	40,8-47,0	41,0	82,0	87,0	157,0	50,0	WCMX080412-86	WCMX080412..
SD572-47-94-C5	02595839	46,8-52,0	47,0	94,0	99,0	169,0	50,0	WCMX080412-86	WCMX080412..

Ersatzteile

Bohrerdurchmesser (mm)	Schraube		Schlüssel	Stopfen	Schlauch-adapter
					
	Zentrumsschneide	Peripherieschneide			
15,00-20,50	C02205-T07P	C02205-T07P	T07P-2	R1/4	1310
20,51-24,50	C03007-T08P	C02506-T08P	T08P-2	R1/4	1310
24,51-32,50	C03508-T15P	C03007-T08P	T08P-2, T15P-2D	R1/4	1310
32,51-36,50	C03508-T15P	C03508-T15P	T15P-2D	R1/4	1310
36,51-59,00	C04011-T15P	C04011-T15P	T15P-2D	R1/4	1310

Zubehör

Bohrer-durchmesser (mm)	Drehmoment-schlüssel*	Ersatzklinge	Drehmoment
			
15,00-20,50	T00-07P09	T00-07P	0,9 Nm
20,51-24,50	T00-08P12	T00-08P	1,2 Nm
24,51-32,50	T00-08P12	T00-08P	1,2 Nm
32,51-36,50	T00-15P30	T00-15P	3,0 Nm
36,51-59,00	T00-15P30	T00-15P	3,0 Nm

* Lieferung einschließlich Klinge.



Perfomax® SD602

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

- Die Sorte DP3000 bietet die nötige Zähigkeit für den optimierten Perfomax® SD602
- Die Sorte ermöglicht hohe Vorschübe und Geschwindigkeiten
- Mehr Flexibilität mit Verlängerungen

Code-Schlüssel

Bohrerkörper

Bohrertyp SD602: Zentrierbohrer und Einsatz	Möglicher Bohrerdurchmesser 89 - Untermaßdurchmesser 90 - Übermaßdurchmesser	Bunddurchmesser	Schafttyp
SD602	89/90	50	RG



Zentrierbohrer

	Bohrerdurchmesser	
SD601	1	10	R
	0 = Vollhartmetall 1 = HSS		Rechtsdrehend



(Der Zentrierbohrer muss separat erworben werden.)

Kassette

	WSP-Größe: SCGX07 SCGX09 SCGX07 SCGX09	
SD600	C	07	N
	C= Zentrum P= Peripherie		N = Nenndurchmesser



-N



-U

Kit

	Peripherie		
SD602	1	P	07	N
	0 = einschließlich 2 Führungsleisten (Durchmesser < 135 mm) 1 = einschließlich 4 Führungsleisten (Durchmesser < 135 mm)		WSP-Größe: SCGX07 SCGX09 SCGX12 SCGX15	N – Nenndurchmesser U – Untermaßdurchmesser



-N



-U

Hinweis: Ersatzteil-Kits “D” für nominalen (-N) oder Untermaßdurchmesser (-U) auf Seite 291 wählen, um den Bohrerkörper zu vervollständigen. Kit “D” ist separat zu erwerben.

Zoll

SD602 – 3500 – RG

Führungsleiste

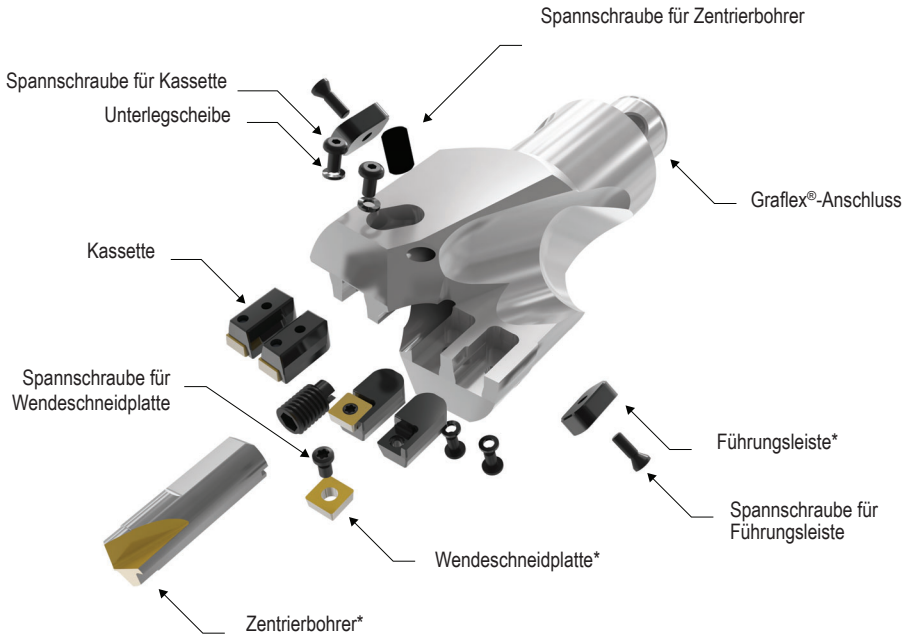
PAD	L20R25	-N
		N = Nenndurchmesser





Modularer Bohrkopf

SD602-59/60-40RG





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



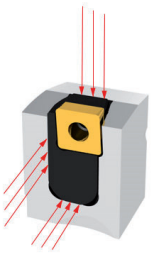
Beispiel: Durchmesser 60; SD602-60-40RG
Folgendes Kit verwenden: SD6020-P07-N*

Montagehinweise

- Klemmschraube für Kassette anziehen
- Wendeplatten einsetzen
- Zentrierbohrer einsetzen und auf dem Grund der Bohrung seitlich klemmen
- Verlängerungen anbringen

Kassette montieren

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

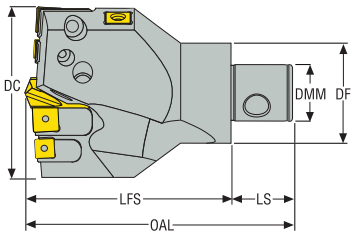


*** Nicht im Lieferumfang enthalten.** Peripherie-Kit, Zentrierbohrer und Wendeschneidplatten müssen separat bestellt werden.

SD602

SD602 - Modularer Bohrkopf





- Mit interner Kühlschmierstoffzufuhr
- Wendeschneidplatten, siehe Seite(n) 297-303
- Schnittdaten, siehe Seite(n) 316-317
- Einstellbarer Zentrierbohrer

Produkt-nummer	Bezeichnung	Graflex Größe	Bereich DCN	DCX	OAL	LFS	LS	DF	DMM	Gewicht	WSP
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
02846688	SD602-59/60-40RG	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*	0,9 *1.980*	SCGX07
02846689	SD602-69/70-40RG	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*	1,1 *2.430*	SCGX09
02846690	SD602-79/80-50RG	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*	1,8 *3.970*	SCGX09
02846691	SD602-89/90-50RG	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*	2,0 *4.410*	SCGX09/12
02846692	SD602-99/100-63RG	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*	3,1 *6.830*	SCGX12
02846693	SD602-119/120-63RG	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
02846694	SD602-139/140-90RG	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
02846695	SD602-159/160-90RG	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*	6,6 *14.550*	SCGX12/15
02846698	SD602-2500-40RG	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
02846699	SD602-2750-40RG	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
02846700	SD602-3000-40RG	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*	1,1 *2.430*	SCGX09
02846701	SD602-3250-50RG	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*	1,8 *3.970*	SCGX09/12
02846702	SD602-3500-50RG	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*	1,9 *4.190*	SCGX09/12
02846703	SD602-4000-63RG	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*	3,2 *7.050*	SCGX12

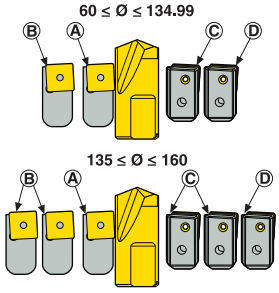
Ersatzteile

Kassette	Kassette	Schraube für Kassette	Unterleg-scheibe	Klemmschraube für Wendeschneidplatte	Schlüssel	Führungsleiste*	Führungsleiste*	Schraube für Führungsleiste
								
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

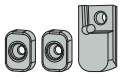
* Nicht im Lieferumfang enthalten

SD602

SD602 - Modularer Bohrkopf



Ersatzteile

Bezeichnung	Bohrer-durch-messer (mm)	Bohrer-durch-messer (Zoll)	Schraube für Zentrierbohrer	Einstell-schraube	Kassette (A)	Kassette (B)	Kassette (C)	Periph. Kit* (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

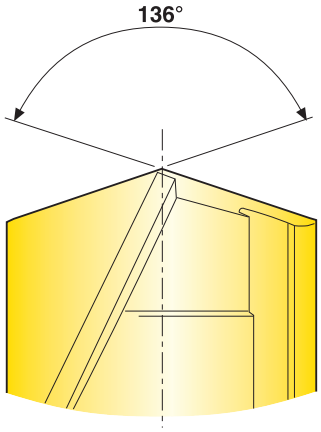
* Nicht im Lieferumfang enthalten. Peripherie-Kit, U-Untermaß, N-Nenngröße
Wendeschneidplatten-Größe, siehe Seite(n) 297-303

Nachschliff für SD602

Einzelheiten
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.

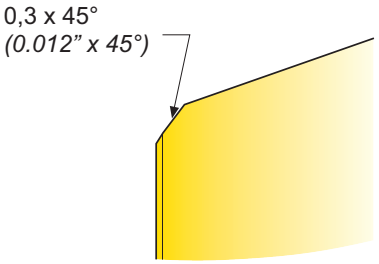
Wichtig:
- Beide Schneidkanten müssen einheitlich ausgeführt sein.
- Die negativen Primärfasen müssen auf der gesamten Länge der Schneiden angebracht sein.

1. **Hinterschliff**

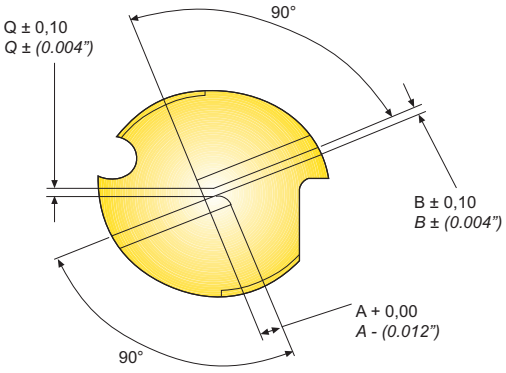


Schneidkantenausführung 0-0,1 mm *(0-.004")* x 20°. Bohrerspitze konischer Anschliff 10°

2. **Eckenfase**



3.

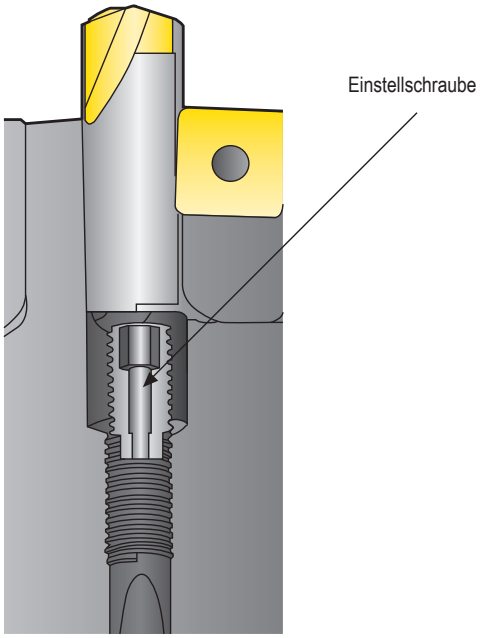


4.

Durchmesser	Abmessungen in mm (*Zoll*)			
	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)*

Einstellbare Schraube

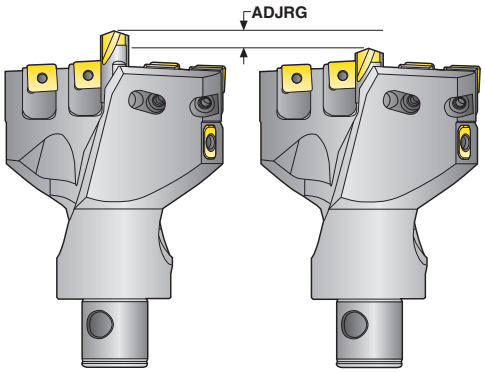
Merkmal: Einstellbarer Zentrierbohrer



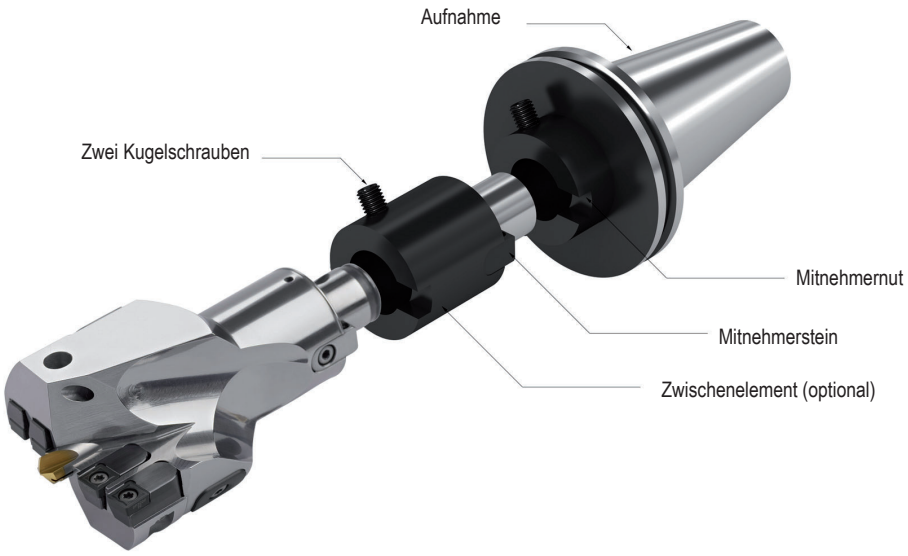
Bohrerdurchmesser	Einstellbarer Längenabstand ADJRG	
	mm	*Zoll*
SD602-59/60-40RG	3,0	*0.118*
SD602-69/70-40RG	3,0	*0.118*
SD602-79/80-50RG	5,0	*0.197*
SD602-89/90-50RG	5,0	*0.197*
SD602-99/100-63RG	5,0	*0.197*
SD602-119/120-63RG	5,0	*0.197*
SD602-139/140-90RG	5,0	*0.197*
SD602-159/160-90RG	5,0	*0.197*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

Ihre 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 Zentrierung zu gewährleisten.

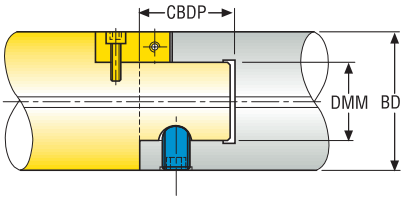


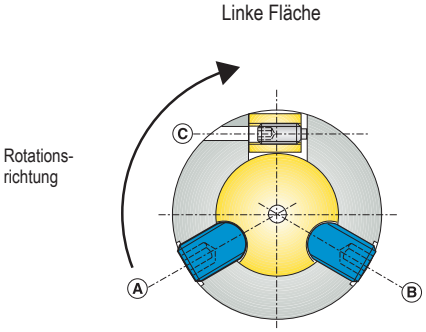
Modularer Bohrkopf



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.



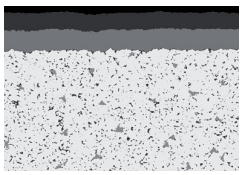
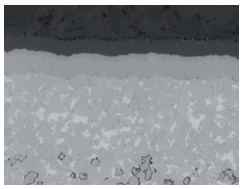
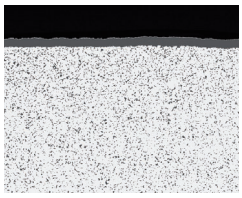
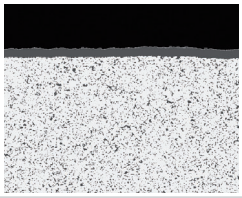


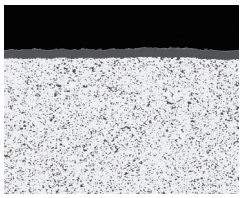
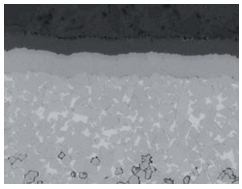
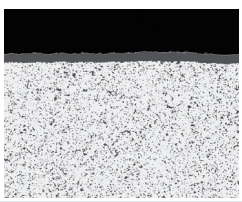
Graflex-Schaft	DMM mm (*Zoll*)	BD mm (*Zoll*)	CBDP mm (*Zoll*)	Empfohlene Anzugsmomente für Graflex-Verbindungen	
				Kugelkopfschrauben (A) & (B)	Mitnehmerschraube (C)
4	22 *(0.866)*	40 *(1.575)*	24 *(0.945)*	20 Nm *(14.7 ft/lbs)*	0,7 Nm *(0.5 ft/lbs)*
5	28 *(1.102)*	50 *(1.969)*	30 *(1.181)*	25 Nm *(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)*

Sorte

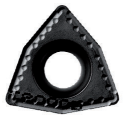
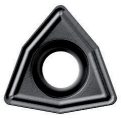
Merkmale:
- 4 Schneiden pro Wendeschneidplatte
- Stabile quadratische Wendeschneidplatten

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®
DP3000		DURATOMIC®-Technologie Universalsorte Überragende Verschleißfestigkeit und Kantenzähigkeit Zähe Sorte für maximale Anwendungssicherheit Ti(C,N) + Al_2O_3 DURATOMIC® Gradientensubstrat
T250D		Geeignet für harte Werkstoffe Erste Wahl für Aluminium Zähe Mikrokornsorte mit TiAlN-Beschichtung sorgt für - Extrem hohe Härte - Extremen Widerstand gegen chemischen Verschleiß und Oxidation PVD-beschichtet (Ti, Al)N + TiN
DS2050		Optimierte Sorte für Titan, Superlegierungen und schwierig zerspanbares Rostfrei PVD beschichtet TiAlN + NbN

Zentrum		
T400D		Erste Wahl Zähe Sorte für Zentrumsschneide mit maximaler Anwendungssicherheit PVD-beschichtet (Ti, Al)N + TiN
DP3000		DURATOMIC®-Technologie Universalsorte Überragende Verschleißfestigkeit und Kantenzähigkeit Zähe Sorte für maximale Anwendungssicherheit Ti(C,N) + Al_2O_3 DURATOMIC® Gradientensubstrat
DS4050		Optimierte Sorte für Titan, Superlegierungen und schwierig zerspanbares Rostfrei PVD beschichtet TiAlN + NbN

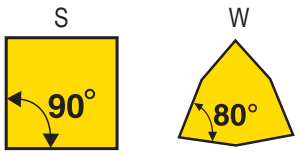
Geometrie

SCGX-P1	SCGX-P2	SCGX-MP	SPGX-C1	SPGX-MC	WCMX-85	WCMX-86
						

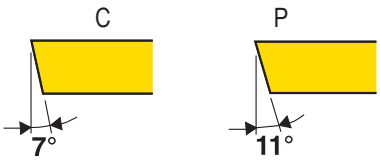


S	C	G	X	06	02	04	–	P1
1	2	3	4	5	6	7		10

1. Wendeschneidplatten-Form



2. Seitlicher Freiwinkel der Wendeschneidplatte



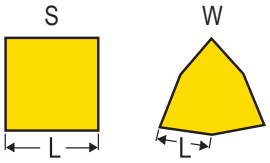
4. Typ

X=Spezial

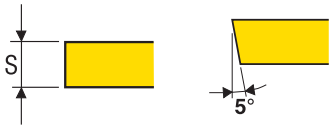
3. Toleranzen

Toleranz-klasse	Toleranz +/– mm (*Zoll*)			Für IC, Abmessung mm (*Zoll*)								
	m	S	IC	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)
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. Wendeschneidplatten mit Planschneide/ Radius



Eckenradius

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

10. Interne Bezeichnung

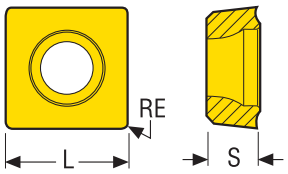
z. B. Spanbrecher-Bezeichnung

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

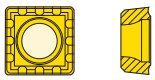
Wendeschneidplatten – Peripherieschneide P1*

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

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



SCGX-P1

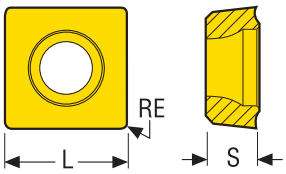


Bezeichnung	Wendeschneidplatten	L	S	RE	Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	**T250D**	**DP2000**	**DP3000**
SCGX060204-P1	SCGX-P1	6,35 *0.250*	2,381 *0.094*	0,4 *0.016*	00059712	02590849	02807362
SCGX070308-P1	SCGX-P1	7,938 *0.313*	3,175 *0.125*	0,8 *0.031*	00059713	02590850	02807363
SCGX09T308-P1	SCGX-P1	9,525 *0.375*	3,969 *0.156*	0,8 *0.031*	00059714	02590851	02807364
SCGX11T308-P1	SCGX-P1	11,509 *0.453*	3,97 *0.156*	0,8 *0.031*	03136962	03136963	03136964
SCGX120408-P1	SCGX-P1	12,7 *0.500*	4,762 *0.187*	0,8 *0.031*	00059715	02590852	02807365
SCGX150512-P1	SCGX-P1	15,875 *0.625*	5,556 *0.219*	1,2 *0.047*	00059716	02590853	02807366

* Spanbrecher für niedrige Vorschübe und hohe Oberflächengüten für alle Werkstoffe

Wendeschneidplatten – Peripherieschneide P2**

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



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

SCGX-P2



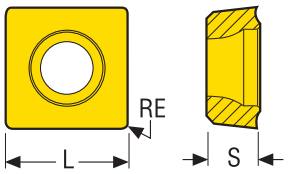
Bezeichnung	Wendeschneidplatten	L	S	RE	Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	T250D	DP2000	DP3000
SCGX050204-P2	SCGX-P2	5,556 *0.219*	2,38 *0.094*	0,4 *0.016*	00059711	02590854	02807356
SCGX060204-P2	SCGX-P2	6,35 *0.250*	2,38 *0.094*	0,4 *0.016*	02526803	02590855	02807357
SCGX070308-P2	SCGX-P2	7,937 *0.312*	3,18 *0.125*	0,8 *0.031*	02526787	02590856	02807358
SCGX09T308-P2	SCGX-P2	9,525 *0.375*	3,97 *0.156*	0,8 *0.031*	02794476	02590857	02807359
SCGX11T308-P2	SCGX-P2	11,509 *0.453*	3,97 *0.156*	0,8 *0.031*	03097760	03097761	03097762
SCGX120408-P2	SCGX-P2	12,7 *0.500*	4,76 *0.187*	0,8 *0.031*	02794477	02590858	02807360
SCGX150512-P2	SCGX-P2	15,875 *0.625*	5,56 *0.219*	1,2 *0.047*	02794478	02590859	02807361

** Spanbrecher für hohe Vorschübe bei Stahl, Rostfrei, Guss.

Wendeschneidplatten – Peripherieschneide für MP

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

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



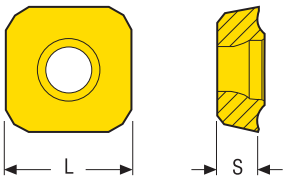
SCGX-MP



Bezeichnung	Wendeschneidplatten	L	S	RE	Sorten
		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 *0.250*	6,35 *0.250*	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 *0.500*	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 – Zentrumsschneide C1

für SD522, SD523, SD524, SD525, SD542



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

SPGX-C1

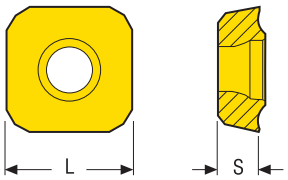


Bezeichnung	Wendeschneidplatten	L	S	Sorten	
		mm *Zoll*	mm *Zoll*	**T400D**	**DP3000**
SPGX0502-C1	SPGX-C1	5,556 *0.219*	2,38 *0.094*	74077370	02807367
SPGX0602-C1	SPGX-C1	6,35 *0.250*	2,38 *0.094*	74077371	02807368
SPGX0703-C1	SPGX-C1	7,937 *0.312*	3,18 *0.125*	74077372	02807369
SPGX0903-C1	SPGX-C1	9,525 *0.375*	3,18 *0.125*	74077373	02807370
SPGX11T3-C1	SPGX-C1	11,509 *0.453*	3,97 *0.156*	74077374	02807371
SPGX12T3-C1	SPGX-C1	12,7 *0.500*	3,97 *0.156*	74077375	02807372
SPGX1504-C1	SPGX-C1	15,875 *0.625*	4,76 *0.187*	74077376	02807373
SPGX1904-C1	SPGX-C1	19,05 *0.750*	4,76 *0.187*	74077377	02807374

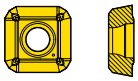
Wendeschneidplatten – Zentrumsschneide MC

für SD522, SD523, SD524, SD525, SD542

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



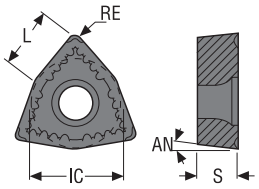
SPGX-MC



Bezeichnung	Wendeschneidplatten	L	S	Sorten
		mm *Zoll*	mm *Zoll*	**DS4050**
SPGX0502-MC	SPGX-MC	5,56 *0.219*	2,38 *0.094*	03134319
SPGX0602-MC	SPGX-MC	6,35 *0.250*	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 *0.500*	3,97 *0.156*	03134324
SPGX1504-MC	SPGX-MC	15,875 *0.625*	4,76 *0.187*	03134325
SPGX1904-MC	SPGX-MC	19,05 *0.750*	4,76 *0.187*	03134326

Wendeschneidplatten – Peripherieschneide 85*

für SD572



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

WCMX-85



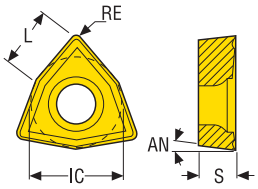
Bezeichnung	Wendeschneidplatten	IC	L	S	RE	Sorten
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	**DP3000**
WCMX040208-85	WCMX-85	6,35 *0.250*	3,99 *0.157*	2,38 *0.094*	0,8 *0.031*	02807375
WCMX050308-85	WCMX-85	7,94 *0.313*	5,07 *0.200*	3,18 *0.125*	0,8 *0.031*	02807376
WCMX06T308-85	WCMX-85	9,525 *0.375*	6,14 *0.242*	3,97 *0.156*	0,8 *0.031*	02807377
WCMX080412-85	WCMX-85	12,7 *0.500*	8,14 *0.320*	4,76 *0.187*	1,2 *0.047*	02807378

* Geometrie für niedrige Vorschübe und hohe Oberflächengüte für alle Werkstoffe

Zentrumsschneide, Peripherieschneide, Typ 86**

für SD572

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



WCMX-86



Bezeichnung	Wendeschneidplatten	IC	L	S	RE	Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	T400D	DP2000	DP3000
WCMX030208-86	WCMX-86	5,556 *0.219*	3,46 *0.136*	2,38 *0.094*	0,8 *0.031*	02506629	02899808	02807379
WCMX040208-86	WCMX-86	6,35 *0.250*	3,99 *0.157*	2,38 *0.094*	0,8 *0.031*	02506638	02899809	02807380
WCMX050308-86	WCMX-86	7,94 *0.313*	5,07 *0.200*	3,18 *0.125*	0,8 *0.031*	02506640	02899810	02807381
WCMX06T308-86	WCMX-86	9,525 *0.375*	6,14 *0.242*	3,97 *0.156*	0,8 *0.031*	02506645	02899811	02807382
WCMX080412-86	WCMX-86	12,7 *0.500*	8,14 *0.320*	4,76 *0.187*	1,2 *0.047*	02506646	02899812	02807383

** Für hohe Vorschübe bei Stahl, Rostfrei, Guss.

SD522 Durchmesser 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 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	345
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*1125*
P4	P2 DP3000	0,12	0,13	0,16	0,19	0,22	0,22	0,25	220
	P2 DP3000	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*720*
P5	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	210
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*690*
P6	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	235
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*770*
P7	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	225
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*740*
P8	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	210
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*690*
P11	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	215
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*710*
P12	P2 DP3000	0,075	0,090	0,11	0,12	0,14	0,15	0,17	130
	P2 DP3000	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*425*
M1	P2 DP3000	0,085	0,10	0,12	0,14	0,16	0,17	0,19	260
	P2 DP3000	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*850*
M2	P2 DP3000	0,080	0,090	0,11	0,13	0,14	0,15	0,17	210
	P2 DP3000	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*690*
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 Richtwerte.

SD522 Schnittgeschwindigkeit

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

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD523 Durchmesser 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 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	310
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*1025*
P4	P2 DP3000	0,12	0,13	0,16	0,19	0,22	0,22	0,25	190
	P2 DP3000	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*620*
P5	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	180
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*590*
P6	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	200
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*660*
P7	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	190
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*620*
P8	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	180
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*590*
P11	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	185
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*610*
P12	P2 DP3000	0,075	0,090	0,11	0,12	0,14	0,15	0,17	110
	P2 DP3000	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*360*
M1	P2 DP3000	0,085	0,10	0,12	0,14	0,16	0,17	0,19	245
	P2 DP3000	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*800*
M2	P2 DP3000	0,080	0,090	0,11	0,13	0,14	0,15	0,17	195
	P2 DP3000	*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	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 Richtwerte.

SD523 Schnittgeschwindigkeit

SMG	v_c			
	DP2000	DP3000	T250D	DS2050
P1	415 *1350*	370 *1225*	265 *870*	370 *1225*
P2	405 *1325*	360 *1175*	260 *850*	360 *1175*
P3	345 *1125*	310 *1025*	225 *740*	310 *1025*
P4	230 *750*	190 *620*	120 *395*	— —
P5	220 *720*	180 *590*	115 *375*	— —
P6	250 *820*	200 *660*	130 *425*	— —
P7	235 *770*	190 *620*	120 *395*	— —
P8	220 *720*	180 *590*	115 *375*	— —
P11	225 *740*	185 *610*	115 *375*	— —
P12	135 *445*	110 *360*	70 *230*	— —
M1	— —	245 *800*	135 *445*	— —
M2	— —	195 *640*	110 *360*	— —
M3	— —	150 *490*	85 *280*	150 *490*
M4	— —	115 *375*	65 *215*	120 *395*
M5	— —	95 *310*	55 *180*	100 *330*
K1	225 *740*	215 *710*	— —	— —
K2	195 *640*	185 *610*	— —	— —
K3	165 *540*	160 *520*	— —	— —
K4	160 *520*	150 *490*	— —	— —
K5	95 *310*	90 *295*	— —	— —
N1	— —	360 *1175*	310 *1025*	310 *1025*
N2	— —	230 *750*	200 *660*	200 *660*
N3	— —	155 *510*	135 *445*	135 *445*
N11	— —	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	— —	60 *195*	60 *195*	— —
H5	— —	115 *375*	110 *360*	— —
H7	— —	60 *195*	60 *195*	— —
H8	— —	115 *375*	110 *360*	— —
H11	— —	145 *475*	140 *460*	— —
H12	— —	65 *215*	130 *425*	— —
H21	— —	115 *375*	110 *360*	— —

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD524 Durchmesser 17-60 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 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	285
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*940*
P4	P2 DP3000	0,12	0,13	0,16	0,19	0,22	0,22	0,25	165
	P2 DP3000	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*540*
P5	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	160
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*520*
P6	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	180
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*590*
P7	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	170
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*560*
P8	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	160
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*0.010*	*520*
P11	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	165
	P2 DP3000	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*0.010*	*540*
P12	P2 DP3000	0,075	0,090	0,11	0,12	0,14	0,15	0,17	95
	P2 DP3000	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*0.0065*	*310*
M1	P2 DP3000	0,085	0,10	0,12	0,14	0,16	0,17	0,19	235
	P2 DP3000	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*0.0075*	*770*
M2	P2 DP3000	0,080	0,090	0,11	0,13	0,14	0,15	0,17	190
	P2 DP3000	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0055*	*0.0060*	*0.0065*	*620*
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 Richtwerte.

SD524 Schnittgeschwindigkeit

SMG	v_c			
	DP2000	DP3000	T250D	DS2050
P1	380 *1250*	340 *1125*	230 *750*	340 *1125*
P2	370 *1225*	330 *1075*	225 *740*	330 *1075*
P3	320 *1050*	285 *940*	195 *640*	285 *940*
P4	195 *640*	165 *540*	105 *345*	— —
P5	185 *610*	160 *520*	100 *330*	— —
P6	210 *690*	180 *590*	110 *360*	— —
P7	195 *640*	170 *560*	105 *345*	— —
P8	185 *610*	160 *520*	100 *330*	— —
P11	190 *620*	165 *540*	100 *330*	— —
P12	110 *360*	95 *310*	60 *195*	— —
M1	— —	235 *770*	120 *395*	— —
M2	— —	190 *620*	95 *310*	— —
M3	— —	145 *475*	75 *245*	145 *475*
M4	— —	110 *360*	55 *180*	105 *345*
M5	— —	90 *295*	46 *150*	90 *295*
K1	210 *690*	200 *660*	— —	— —
K2	180 *590*	170 *560*	— —	— —
K3	155 *510*	145 *475*	— —	— —
K4	145 *475*	140 *460*	— —	— —
K5	85 *280*	85 *280*	— —	— —
N1	— —	315 *1025*	270 *890*	270 *890*
N2	— —	205 *670*	175 *570*	175 *570*
N3	— —	135 *445*	115 *375*	115 *375*
N11	— —	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	— —	55 *180*	50 *165*	— —
H5	— —	100 *330*	95 *310*	— —
H7	— —	55 *180*	50 *165*	— —
H8	— —	100 *330*	95 *310*	— —
H11	— —	125 *410*	125 *410*	— —
H12	— —	55 *180*	110 *360*	— —
H21	— —	100 *330*	95 *310*	— —

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD525 Durchmesser 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 DP3000 *P2 DP3000*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	320 *1050*
P2	P2 DP3000 *P2 DP3000*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	310 *1025*
P3	P2 DP3000 *P2 DP3000*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,22 *0.0085*	265 *870*
P4	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,22 *0.0085*	150 *490*
P5	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	140 *460*
P6	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	160 *520*
P7	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	150 *490*
P8	P2 DP3000 *P2 DP3000*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,22 *0.0085*	140 *460*
P11	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	145 *475*
P12	P2 DP3000 *P2 DP3000*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	85 *280*
M1	P2 DP3000 *P2 DP3000*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,17 *0.0065*	225 *740*
M2	P2 DP3000 *P2 DP3000*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	0,15 *0.0060*	180 *590*
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 DP3000 *P2 DP3000*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	185 *610*
K2	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	160 *520*
K3	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	135 *445*
K4	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	130 *425*
K5	P2 DP3000 *P2 DP3000*	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 Richtwerte.

SD525 Schnittgeschwindigkeit

SMG	v_c			
	DP2000	DP3000	T250D	DS2050
P1	355 *1175*	320 *1050*	205 *670*	320 *1050*
P2	345 *1125*	310 *1025*	200 *660*	310 *1025*
P3	295 *970*	265 *870*	170 *560*	265 *870*
P4	165 *540*	150 *490*	90 *295*	— —
P5	155 *510*	140 *460*	90 *295*	— —
P6	175 *570*	160 *520*	100 *330*	— —
P7	165 *540*	150 *490*	95 *310*	— —
P8	155 *510*	140 *460*	90 *295*	— —
P11	160 *520*	145 *475*	90 *295*	— —
P12	95 *310*	85 *280*	55 *180*	— —
M1	— —	225 *740*	105 *345*	— —
M2	— —	180 *590*	85 *280*	— —
M3	— —	140 *460*	65 *215*	140 *460*
M4	— —	105 *345*	49 *160*	95 *310*
M5	— —	85 *280*	41 *135*	80 *260*
K1	195 *640*	185 *610*	— —	— —
K2	170 *560*	160 *520*	— —	— —
K3	145 *475*	135 *445*	— —	— —
K4	140 *460*	130 *425*	— —	— —
K5	80 *260*	80 *260*	— —	— —
N1	— —	285 *940*	240 *790*	240 *790*
N2	— —	185 *610*	155 *510*	155 *510*
N3	— —	120 *395*	100 *330*	100 *330*
N11	— —	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	— —	48 *155*	46 *150*	— —
H5	— —	90 *295*	85 *280*	— —
H7	— —	48 *155*	46 *150*	— —
H8	— —	90 *295*	85 *280*	— —
H11	— —	115 *375*	110 *360*	— —
H12	— —	50 *165*	100 *330*	— —
H21	— —	90 *295*	85 *280*	— —

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD542 Durchmesser 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 DP3000 *P2 DP3000*	0,095 *0.0038*	0,12 *0.0048*	390 *1275*
P2	P2 DP3000 *P2 DP3000*	0,10 *0.0040*	0,12 *0.0048*	380 *1250*
P3	P2 DP3000 *P2 DP3000*	0,19 *0.0075*	0,22 *0.0085*	325 *1075*
P4	P2 DP3000 *P2 DP3000*	0,19 *0.0075*	0,22 *0.0085*	205 *670*
P5	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	195 *640*
P6	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	220 *720*
P7	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	205 *670*
P8	P2 DP3000 *P2 DP3000*	0,19 *0.0075*	0,22 *0.0085*	195 *640*
P11	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	200 *660*
P12	P2 DP3000 *P2 DP3000*	0,12 *0.0048*	0,15 *0.0060*	120 *395*
M1	P2 DP3000 *P2 DP3000*	0,14 *0.0055*	0,17 *0.0065*	250 *820*
M2	P2 DP3000 *P2 DP3000*	0,13 *0.0050*	0,15 *0.0060*	205 *670*
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 DP3000 *P2 DP3000*	0,20 *0.0080*	0,24 *0.0095*	225 *740*
K2	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	195 *640*
K3	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	165 *540*
K4	P2 DP3000 *P2 DP3000*	0,18 *0.0070*	0,22 *0.0085*	160 *520*
K5	P2 DP3000 *P2 DP3000*	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 Richtwerte.

SD542 Schnittgeschwindigkeit

SMG	v_c			
	DP2000	DP3000	T250D	DS2050
P1	435 *1425*	390 *1275*	290 *950*	390 *1275*
P2	425 *1400*	380 *1250*	280 *920*	380 *1250*
P3	365 *1200*	325 *1075*	240 *790*	325 *1075*
P4	255 *840*	205 *670*	130 *425*	— —
P5	245 *800*	195 *640*	125 *410*	— —
P6	275 *900*	220 *720*	140 *460*	— —
P7	260 *850*	205 *670*	130 *425*	— —
P8	245 *800*	195 *640*	125 *410*	— —
P11	250 *820*	200 *660*	125 *410*	— —
P12	150 *490*	120 *395*	75 *245*	— —
M1	— —	250 *820*	150 *490*	— —
M2	— —	205 *670*	120 *395*	— —
M3	— —	155 *510*	90 *295*	155 *510*
M4	— —	115 *375*	70 *230*	130 *425*
M5	— —	95 *310*	55 *180*	105 *345*
K1	235 *770*	225 *740*	— —	— —
K2	205 *670*	195 *640*	— —	— —
K3	175 *570*	165 *540*	— —	— —
K4	165 *540*	160 *520*	— —	— —
K5	100 *330*	95 *310*	— —	— —
N1	— —	390 *1275*	335 *1100*	335 *1100*
N2	— —	250 *820*	215 *710*	215 *710*
N3	— —	165 *540*	145 *475*	145 *475*
N11	— —	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	— —	65 *215*	65 *215*	— —
H5	— —	120 *395*	120 *395*	— —
H7	— —	65 *215*	65 *215*	— —
H8	— —	120 *395*	120 *395*	— —
H11	— —	155 *510*	155 *510*	— —
H12	— —	70 *230*	140 *460*	— —
H21	— —	120 *395*	120 *395*	— —

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD572 Durchmesser 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 DP3000	0,042	0,042	0,048	0,060	0,070	0,085	310
	85 DP3000	*0.0017*	*0.0017*	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*1025*
P2	85 DP3000	0,042	0,042	0,050	0,060	0,070	0,085	305
	85 DP3000	*0.0017*	*0.0017*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*1000*
P3	86 DP3000	0,12	0,12	0,13	0,17	0,19	0,22	260
	86 DP3000	*0.0048*	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*850*
P4	86 DP3000	0,11	0,11	0,13	0,16	0,19	0,22	230
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*750*
P5	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	220
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*720*
P6	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	245
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*800*
P7	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	235
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*770*
P8	86 DP3000	0,12	0,12	0,13	0,17	0,19	0,22	220
	86 DP3000	*0.0048*	*0.0048*	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*720*
P11	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	225
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*740*
P12	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	135
	86 DP3000	*0.0030*	*0.0030*	*0.0034*	*0.0044*	*0.0048*	*0.0060*	*445*
M1	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	235
	86 DP3000	*0.0030*	*0.0030*	*0.0034*	*0.0044*	*0.0048*	*0.0060*	*770*
M2	86 DP3000	0,070	0,070	0,080	0,10	0,11	0,14	190
	86 DP3000	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0044*	*0.0055*	*620*
M3	85 DP3000	0,034	0,034	0,040	0,048	0,055	0,070	145
	85 DP3000	*0.0013*	*0.0013*	*0.0016*	*0.0019*	*0.0022*	*0.0028*	*475*
M4	85 DP3000	0,030	0,030	0,034	0,042	0,050	0,060	110
	85 DP3000	*0.0012*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0024*	*360*
M5	85 DP3000	0,030	0,030	0,034	0,042	0,050	0,060	90
	85 DP3000	*0.0012*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0024*	*295*
K1	86 DP3000	0,12	0,12	0,14	0,17	0,20	0,24	180
	86 DP3000	*0.0048*	*0.0048*	*0.0055*	*0.0065*	*0.0080*	*0.0095*	*590*
K2	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	155
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*510*
K3	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	130
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*425*
K4	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	125
	86 DP3000	*0.0044*	*0.0044*	*0.0050*	*0.0065*	*0.0070*	*0.0085*	*410*
K5	86 DP3000	0,10	0,10	0,11	0,14	0,16	0,19	75
	86 DP3000	*0.0040*	*0.0040*	*0.0044*	*0.0055*	*0.0065*	*0.0075*	*245*
S1	85 DP3000	0,055	0,055	0,060	0,075	0,090	0,11	40
	85 DP3000	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*130*
S2	85 DP3000	0,055	0,055	0,060	0,075	0,090	0,11	30
	85 DP3000	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*100*
S3	85 DP3000	0,050	0,050	0,060	0,070	0,085	0,10	30
	85 DP3000	*0.0020*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*100*
S11	85 DP3000	0,060	0,060	0,070	0,090	0,10	0,12	80
	85 DP3000	*0.0024*	*0.0024*	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*260*
S12	85 DP3000	0,060	0,060	0,070	0,090	0,10	0,12	60
	85 DP3000	*0.0024*	*0.0024*	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*195*
S13	85 DP3000	0,055	0,055	0,060	0,075	0,090	0,11	47
	85 DP3000	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*155*
H3	86 DP3000	0,050	0,050	0,060	0,070	0,085	0,10	80
	86 DP3000	*0.0020*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*260*
H5	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	150
	86 DP3000	*0.0030*	*0.0030*	*0.0034*	*0.0044*	*0.0048*	*0.0060*	*490*
H7	86 DP3000	0,050	0,050	0,060	0,070	0,085	0,10	80
	86 DP3000	*0.0020*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*260*
H8	86 DP3000	0,060	0,060	0,065	0,085	0,095	0,11	150
	86 DP3000	*0.0024*	*0.0024*	*0.0026*	*0.0034*	*0.0038*	*0.0044*	*490*
H11	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	195
	86 DP3000	*0.0030*	*0.0030*	*0.0034*	*0.0044*	*0.0048*	*0.0060*	*640*
H12	86 DP3000	0,060	0,060	0,065	0,085	0,095	0,11	80
	86 DP3000	*0.0024*	*0.0024*	*0.0026*	*0.0034*	*0.0038*	*0.0044*	*260*
H21	86 DP3000	0,060	0,060	0,065	0,085	0,095	0,11	150
	86 DP3000	*0.0024*	*0.0024*	*0.0026*	*0.0034*	*0.0038*	*0.0044*	*490*

SMG = Seco Werkstoff-Gruppe f = mm/U (IPR) v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD572 Schnittgeschwindigkeit

SMG	v_c
	DP2000
P1	375 *1225*
P2	365 *1200*
P3	315 *1025*
P4	280 *920*
P5	265 *870*
P6	300 *980*
P7	280 *920*
P8	265 *870*
P11	275 *900*
P12	160 *520*
M1	285 *940*
M2	230 *750*
M3	175 *570*
M4	130 *425*
M5	110 *360*
K1	215 *710*
K2	185 *610*
K3	160 *520*
K4	150 *490*
K5	90 *295*
S1	— —
S2	— —
S3	— —
S11	— —
S12	— —
S13	— —
H3	80 *260*
H5	150 *490*
H7	80 *260*
H8	150 *490*
H11	195 *640*
H12	95 *310*
H21	150 *490*

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

SD602 Durchmesser 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 DP3000	0,085	0,095	0,12	0,13	0,12	295
	P2 DP3000	*0.0034*	*0.0038*	*0.0048*	*0.0050*	*0.0048*	*970*
P2	P2 DP3000	0,085	0,10	0,12	0,13	0,12	285
	P2 DP3000	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0048*	*940*
P3	P2 DP3000	0,17	0,19	0,22	0,26	0,22	245
	P2 DP3000	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.0085*	*800*
P4	P2 DP3000	0,16	0,19	0,22	0,25	0,22	130
	P2 DP3000	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.0085*	*425*
P5	P2 DP3000	0,16	0,18	0,22	0,25	0,22	125
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*410*
P6	P2 DP3000	0,16	0,18	0,22	0,25	0,22	140
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*460*
P7	P2 DP3000	0,16	0,18	0,22	0,25	0,22	135
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*445*
P8	P2 DP3000	0,17	0,19	0,22	0,26	0,22	125
	P2 DP3000	*0.0065*	*0.0075*	*0.0085*	*0.010*	*0.0085*	*410*
P11	P2 DP3000	0,16	0,18	0,22	0,25	0,22	130
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.010*	*0.0085*	*425*
P12	P2 DP3000	0,11	0,12	0,15	0,17	0,15	75
	P2 DP3000	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0060*	*245*
M1	P2 DP3000	0,12	0,14	0,17	0,19	0,17	215
	P2 DP3000	*0.0048*	*0.0055*	*0.0065*	*0.0075*	*0.0065*	*710*
M2	P2 DP3000	0,11	0,13	0,15	0,17	0,15	175
	P2 DP3000	*0.0044*	*0.0050*	*0.0060*	*0.0065*	*0.0060*	*570*
M3	P1 DP3000	0,090	0,10	0,12	0,14	0,12	135
	P1 DP3000	*0.0036*	*0.0040*	*0.0048*	*0.0055*	*0.0048*	*445*
M4	P1 DP3000	0,075	0,090	0,11	0,12	0,11	100
	P1 DP3000	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0044*	*330*
M5	P1 DP3000	0,075	0,090	0,11	0,12	0,11	85
	P1 DP3000	*0.0030*	*0.0036*	*0.0044*	*0.0048*	*0.0044*	*280*
K1	P2 DP3000	0,17	0,20	0,24	0,26	0,24	175
	P2 DP3000	*0.0065*	*0.0080*	*0.0095*	*0.010*	*0.0095*	*570*
K2	P2 DP3000	0,16	0,18	0,22	0,24	0,22	150
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.0085*	*490*
K3	P2 DP3000	0,16	0,18	0,22	0,24	0,22	130
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.0085*	*425*
K4	P2 DP3000	0,16	0,18	0,22	0,24	0,22	120
	P2 DP3000	*0.0065*	*0.0070*	*0.0085*	*0.0095*	*0.0085*	*395*
K5	P2 DP3000	0,14	0,16	0,19	0,22	0,19	75
	P2 DP3000	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0075*	*245*
H3	P2 DP3000	0,070	0,080	0,10	0,11	0,10	42
	P2 DP3000	*0.0028*	*0.0032*	*0.0040*	*0.0044*	*0.0040*	*140*
H5	P2 DP3000	0,11	0,12	0,15	0,17	0,15	80
	P2 DP3000	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0060*	*260*
H7	P2 DP3000	0,070	0,080	0,10	0,11	0,10	42
	P2 DP3000	*0.0028*	*0.0032*	*0.0040*	*0.0044*	*0.0040*	*140*
H8	P2 DP3000	0,085	0,095	0,11	0,13	0,11	80
	P2 DP3000	*0.0034*	*0.0038*	*0.0044*	*0.0050*	*0.0044*	*260*
H11	P2 DP3000	0,11	0,12	0,15	0,17	0,15	100
	P2 DP3000	*0.0044*	*0.0048*	*0.0060*	*0.0065*	*0.0060*	*330*
H12	P2 DP3000	0,085	0,095	0,11	0,13	0,11	45
	P2 DP3000	*0.0034*	*0.0038*	*0.0044*	*0.0050*	*0.0044*	*150*
H21	P2 DP3000	0,085	0,095	0,11	0,13	0,11	80
	P2 DP3000	*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 Richtwerte.

SD602 Schnittgeschwindigkeit

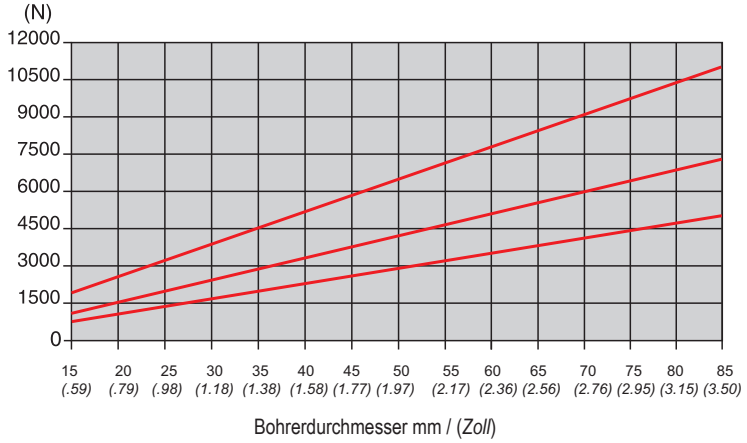
SMG	v_c	
	T250D	DS2050
P1	180 *590*	295 *970*
P2	175 *570*	285 *940*
P3	150 *490*	245 *800*
P4	80 *260*	— —
P5	75 *245*	— —
P6	85 *280*	— —
P7	80 *260*	— —
P8	75 *245*	— —
P11	80 *260*	— —
P12	46 *150*	— —
M1	90 *295*	— —
M2	75 *245*	— —
M3	55 *180*	135 *445*
M4	43 *140*	85 *280*
M5	36 *120*	70 *230*
K1	— —	— —
K2	— —	— —
K3	— —	— —
K4	— —	— —
K5	— —	— —
H3	40 *130*	— —
H5	75 *245*	— —
H7	40 *130*	— —
H8	75 *245*	— —
H11	95 *310*	— —
H12	85 *280*	— —
H21	75 *245*	— —

SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Bearbeitungsparameter SD522, SD523, SD524, SD525, SD542 and SD572 - 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

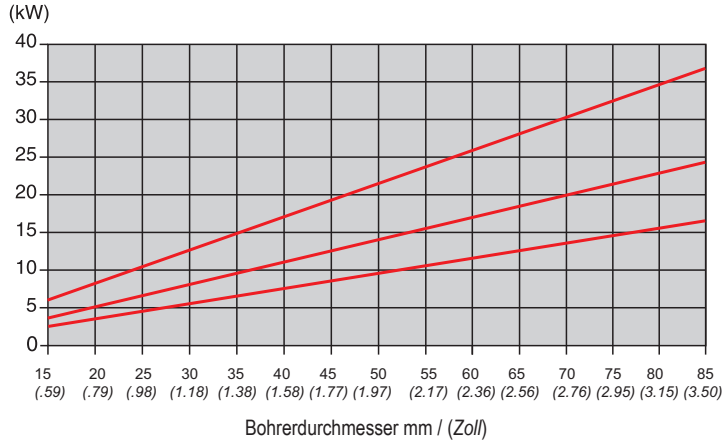


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Leistungsbedarf

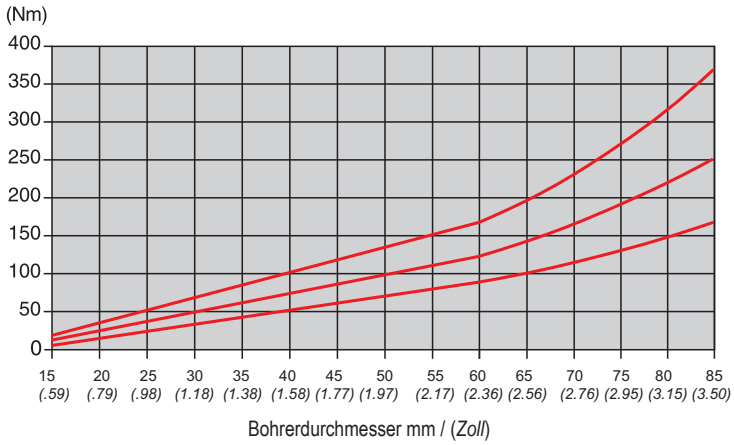


f = 0,18 mm/U
(f = 0.007 "/U)

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)

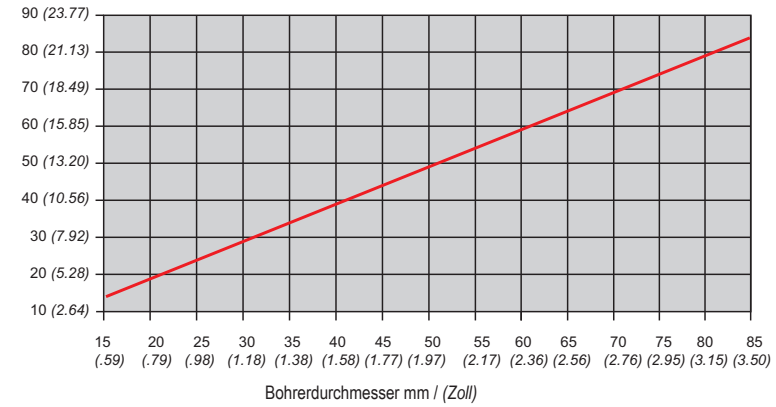
f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Bearbeitungsparameter

Kühlschmierstoffmenge

Liter/Minute *(Gallonen/Minute)*

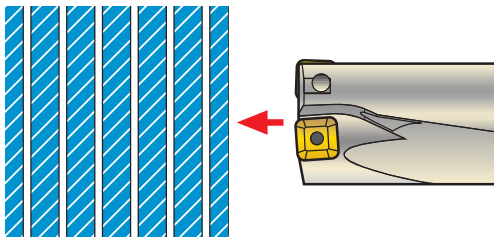


Kühlschmierstoffdruck

Empfohlener Druck bar *(PSI)*

Bohrtiefe	Bohrdurchmesser mm (*Zoll*) 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")*, ist 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:	WSP-Geometrie:	Hartmetallsorte
Zentrumsschneide	SPGX-C1	T400D
Peripherieschneide	SCGX-P2	DP3000

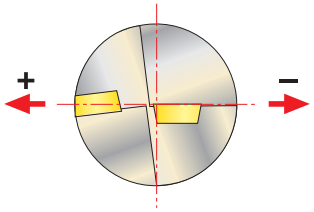
Schnittgeschwindigkeit: Siehe Empfehlung für die Hartmetallsorte DP3000
Vorschub/U: Siehe Empfehlung für Geometrie P2

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.



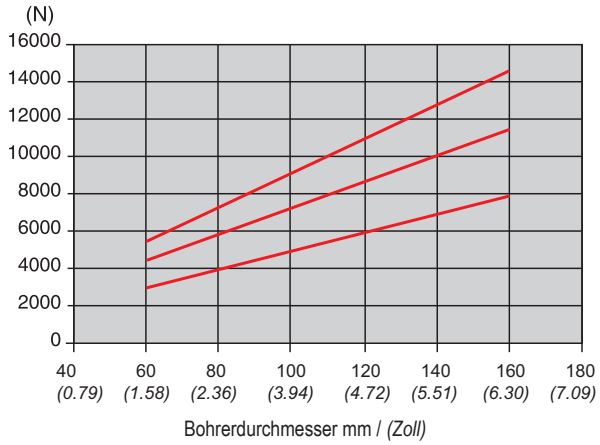
Rotierender Einsatz
Mit der einstellbaren Aufnahme von Seco werden präzise Bohrungen erzielt. Bohrungstoleranz IT10 mit SD522 und SD523, 3 x D bei rotierendem Einsatz.

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

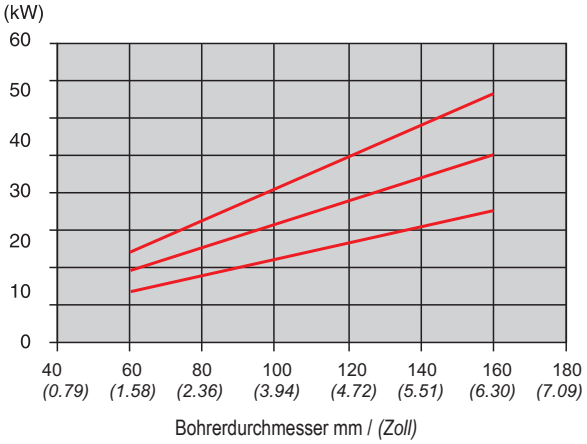


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Leistungsbedarf

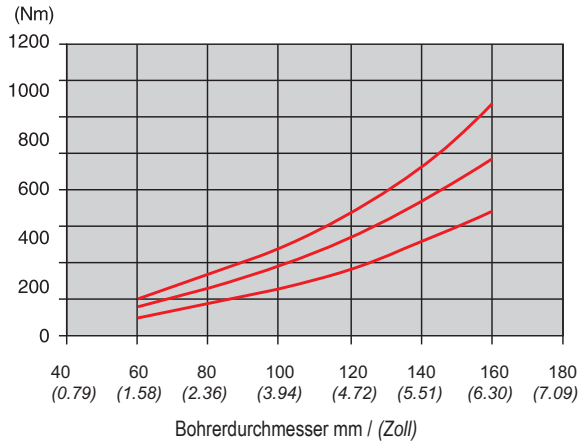


f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

f = 0,08 mm/U
(f = 0.003 "/U)

Drehmoment



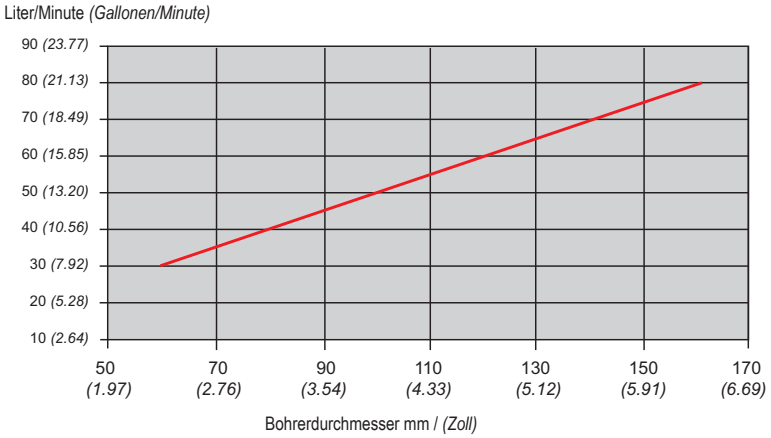
f = 0,18 mm/U
(f = 0.007 "/U)

f = 0,12 mm/U
(f = 0.005 "/U)

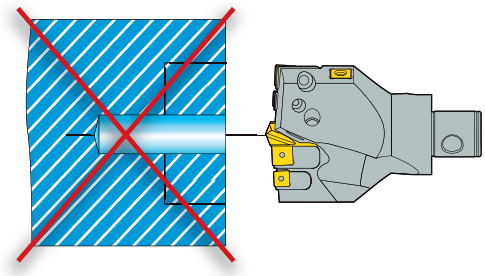
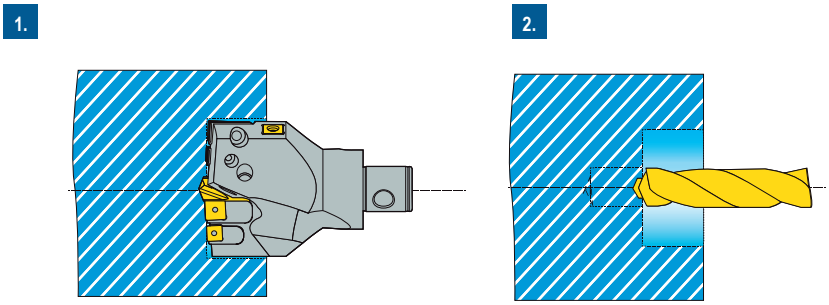
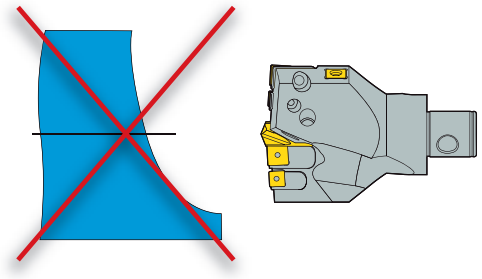
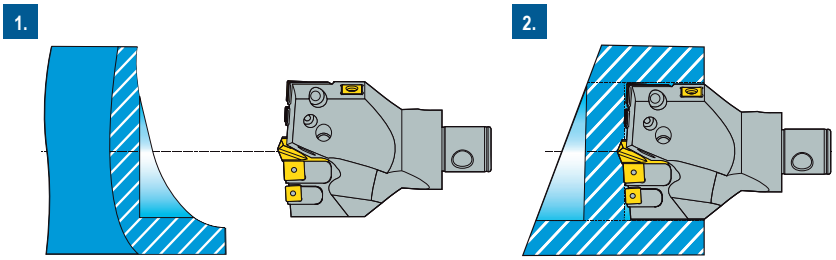
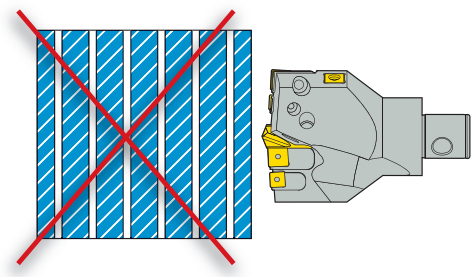
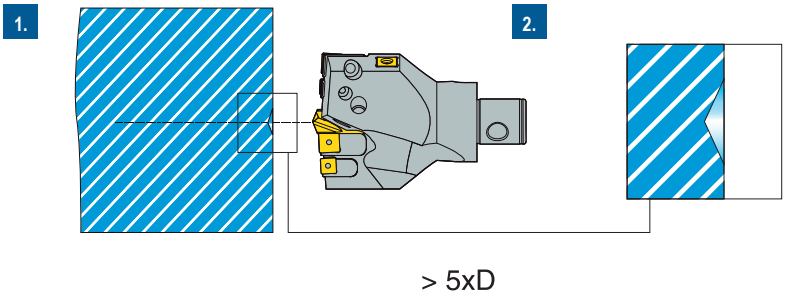
f = 0,08 mm/U
(f = 0.003 "/U)

Bearbeitungsparameter SD602

Kühlschmierstoffmenge



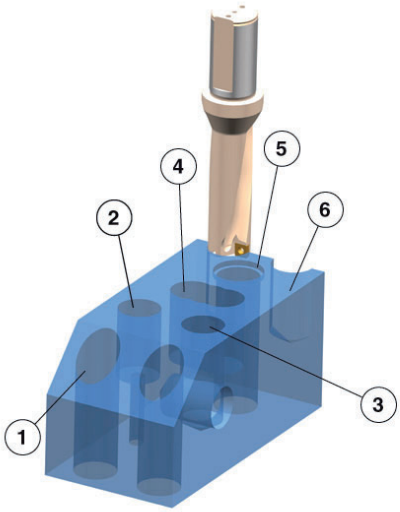
Einsatzbereiche

Nicht empfohlen	Lösung
	
	
	

Für vielfältige Einsatzmöglichkeiten geeignet:

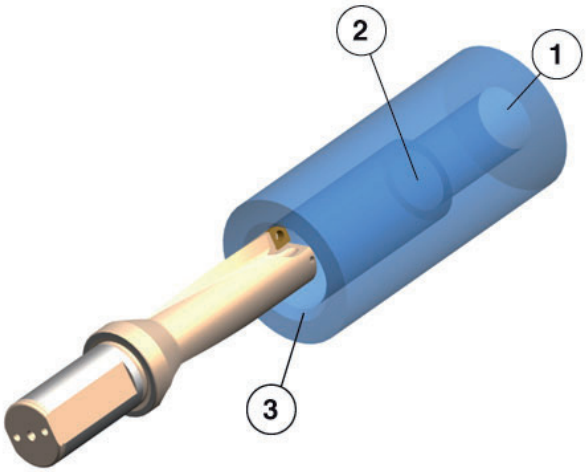
Anwendungsbereiche

1. Bohrungen mit winkeligem Eintritt
2. Ausdrehen
3. Querbohrungen
4. Bohren und Eintauchen
5. Bohren und Ansenken durch Bohrzirkularbearbeitung
6. Eintauchen



Mehrfachauswahl bei nichtrotierenden Bearbeitungen

1. Bohren
2. Ausspindeln / Konische Bohrungen
3. Anfasen



Empfehlungen

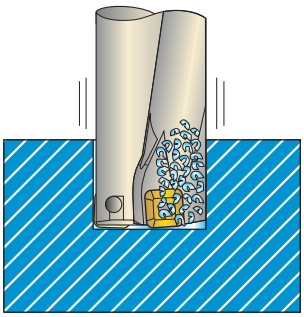
- 2 x D und 3 x D-Bohrer (SD522, SD523)
- Vorschub um ~ 50% reduzieren, wenn der Bohrer nicht im vollen Eingriff ist
- Sorte DP3000 einsetzen
- Spanbrecher -P2 einsetzen

Herausforderungen

Vibrationen

Anwendungsbereiche

- Aufspannung des Bohrers prüfen
- Aufspannung des Werkstücks prüfen
- Vorschub erhöhen Bei sehr weichen Werkstoffen Vorschub senken und Schnittgeschwindigkeit erhöhen



Drehmoment zu gering

- Vorschub senken
- Geometrie für kleinere Vorschübe einsetzen

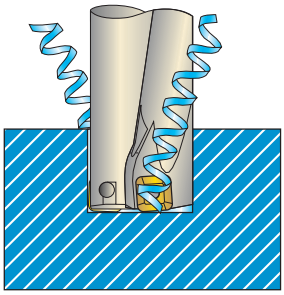
Maschinenleistung zu gering

- Schnittgeschwindigkeit reduzieren
- Vorschub senken
- Geometrie für kleinere Vorschübe einsetzen (SCGX-P1)

Spanprobleme

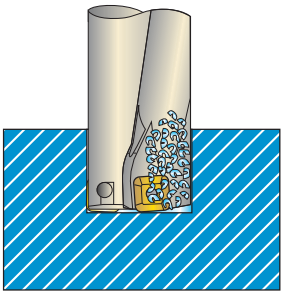
Spänestau durch lange Späne

- Vorschub erhöhen. Bei langspanenden Werkstoffen Vorschub senken und Schnittgeschwindigkeit erhöhen
- Geometrie für kleinere Vorschübe einsetzen (SCGX-P1).



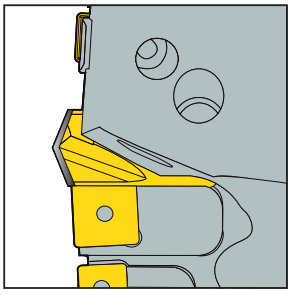
Spänestau durch kurze Späne

- Kühlmitteldruck/-menge erhöhen
- Schnittgeschwindigkeit reduzieren



Schneller Freiflächenverschleiß beim Zentrierbohrer

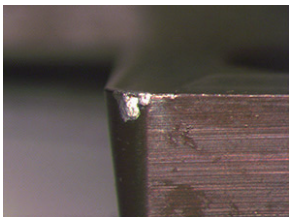
- Schnittgeschwindigkeit senken
- Kühlmittelkonzentration erhöhen



Werkzeugstandzeit – Herausforderungen

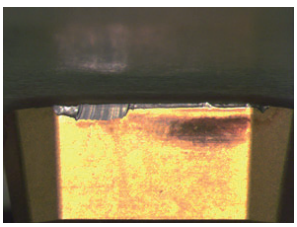
Ausbrüche an der Peripherieschneide

- Eintrittsvorschub reduzieren
- Zähere Sorte wählen
- Stabilere Wendeplatte einsetzen (SCGX-P2)
- Vorschub senken
- Schnittgeschwindigkeit senken



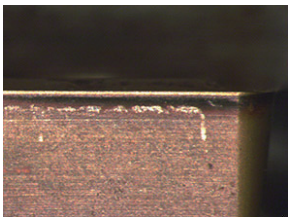
Ausbrüche an der Zentrumsschneide

- Aufspannung des Bohrers prüfen
- Aufspannung des Werkstückes prüfen
- Eintrittsvorschub reduzieren
- Vorschub erhöhen
- Schnittgeschwindigkeit reduzieren

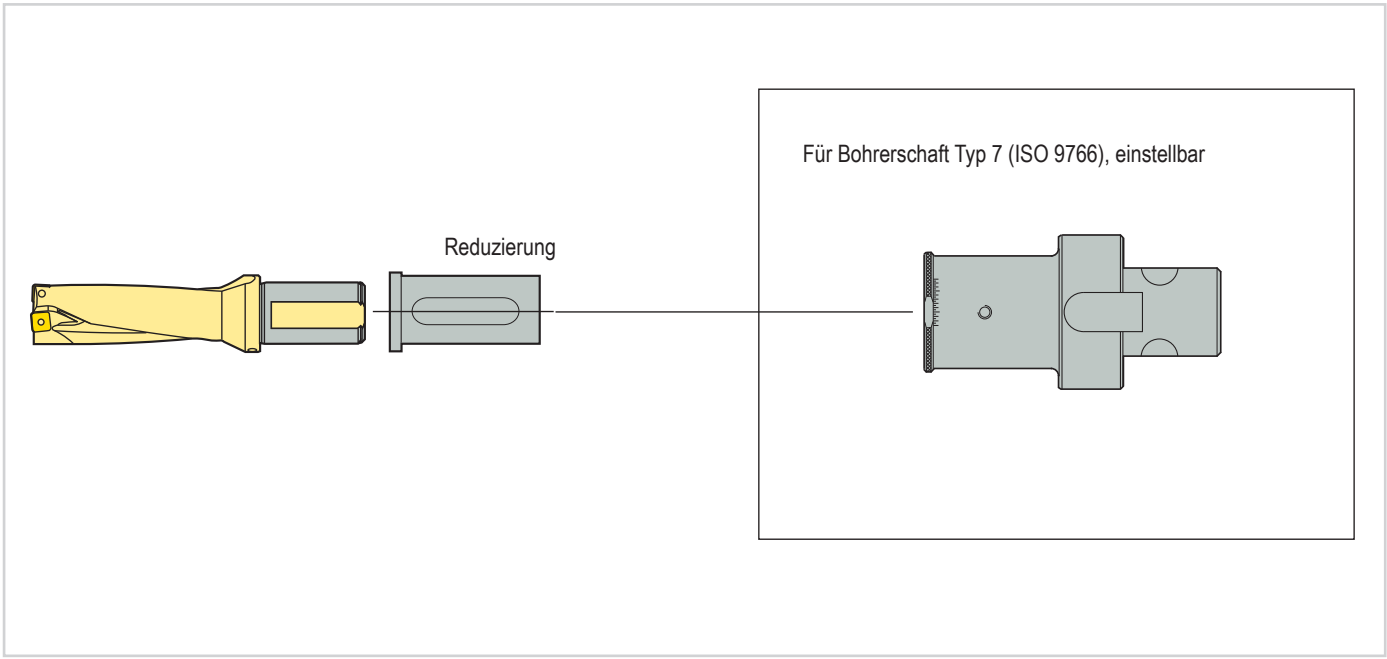


Schneller Verschleiß der Peripherieschneide

- Schnittgeschwindigkeit reduzieren
- Kühlmitteldruck erhöhen
- Verschleißfestere Sorte wählen

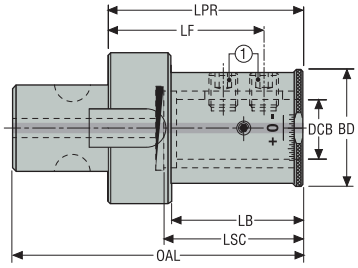


Einstellbare Aufnahmen für Bohrer



ADH 6101 – einstellbare Aufnahmen für Bohrer, R7-Schaft

Graflex®



1. Spannschraube



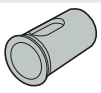
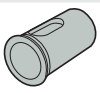
- Für Perfomax®-Bohrer
- Einstellbar von -0,3 mm bis +0,8 mm auf den Durchmesser

Produktnummer	Bezeichnung	Maschinenseite Graflex-Schaftgröße	Werkstückseite Schafttyp	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*	
02422113	BM061610025	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
02422116	BM061610125	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
02422114	BM061610032	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*	2,09 *4.610*	PB
02422118	BM061610138	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
02422115	BM061610040	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*	2,38 *5.250*	PB

Ersatzteile

Für DCB	Befestigungsschraube	Mitnehmer
		
25/0.984	950AF1210014	90M61
25,4/1.000	950AF1210014	90M61
32/1.260	950AF1210020	90M61
38,1/1.500	950AF1210020	90M61
40/1.575	950AF1210020	90M61

Zubehör

Für DCB	Schlüssel (Quergriff)	Schlüssel	Reduzierhülse	Reduzierhülse 2
				
25/0.984	DOUBLE-T	H6B-H6.0L	–	–
25,4/1.000	DOUBLE-T	H6B-H6.0L	–	–
32/1.260	DOUBLE-T	H6B-H6.0L	05B61003225	–
38,1/1.500	–	H06-4	–	–
40/1.575	DOUBLE-T	H6B-H6.0L	05B61004025	05B61004032

PB = Vorausgewuchtet (weitere Informationen unter Auswuchtung im Seco Katalog Werkzeug-Systeme)

REIBEN



PRECIMASTER™ PLUS
SCHNELL & EINFACH WECHSELBARE REIBKÖPFE

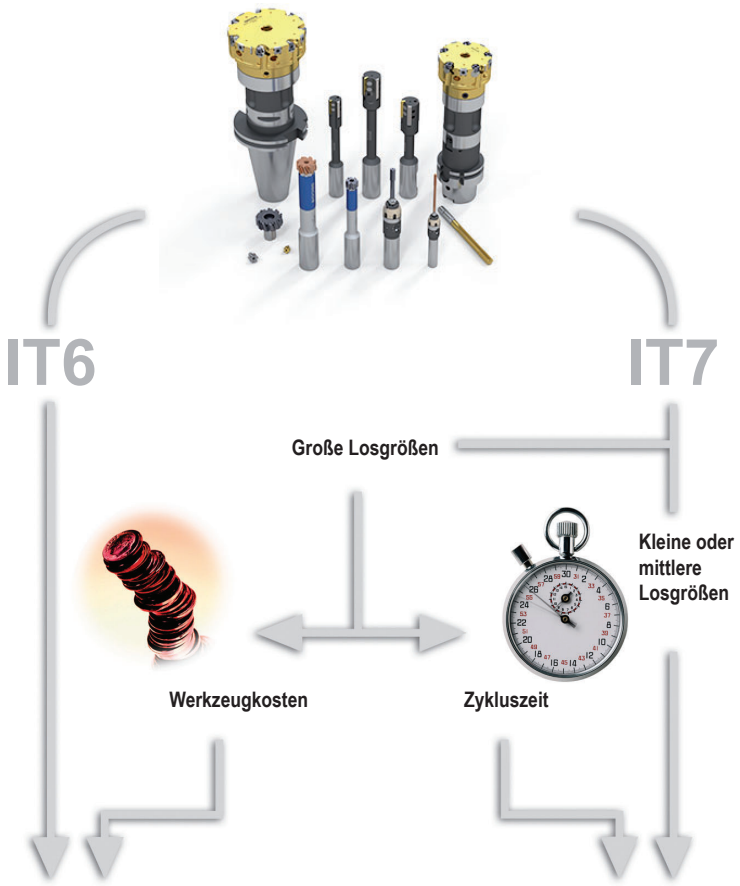
Precimaster™ Plus ist ein modulares Reibsystem für höhere Reibgeschwindigkeiten, mehr Stabilität und Vielseitigkeit für präzisere und kosteneffizientere Bohrungsbearbeitung. Aufbauend auf dem erfolgreichen Precimaster™ weist dieses System einen innovativen hochpräzisen Anschluss auf, Hartmetall-Wechselköpfe sowie Schäfte für Grundloch- und Durchgangsbohrung.



Precimaster, Bifix oder Precifix? – Die 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. Precimaster, Bifix, das neue Werkzeugkonzept Xfix und Nanofix Reibahlen bieten die richtige Lösung für Ihre Reibbearbeitung.

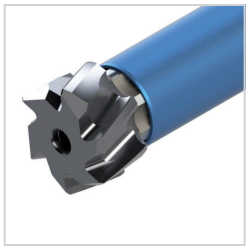
Wählen Sie anhand der nachstehenden Tabelle das ideale Werkzeug für Ihre Reibbearbeitung.



Bifix®



Precimaster™ Plus



Xfix™



Nanofix™



Programmübersicht

	Durchmesserbereich	Reibtiefe	Toleranz Bohrungs-durchmesser	Zwischendurchmesser	Oberflächengüte
Precimaster™ Plus  Seite(n) 329-367	7,75-60,500 mm *(0.3051-2.3818")*	~ 2-10 x D	IT 6-7-8	Ja, verfügbar über Custom Design	R_a 0,2-1,2 µm *(Ra 7.87-47.2 µin)*
Nanofix™  Seite(n) 368-397	2,970-12,050 mm *(0.1169-0.4744")*	~ 5-12 x D	IT 7	Ja, verfügbar über Custom Design	R_a 0,2-1,2 µm *(Ra 7.87-47.2 µin)*
Bifix®  Seite(n) 398-424	5,900-60,500 mm *(0.2323-2.3819")*	~ 2-7 x D	IT 6-7	Ja, verfügbar über Custom Design	R_a 0,2-0,8 µm *(Ra 7.87-31.5 µin)*
Xfix™  Seite(n) 425-465	39,500-154,500 mm *(1.5551-6.0827")*	~ 2,5-6,5 x D	IT 6	Ja, verfügbar über Custom Design	R_a 0,8-1,6 µm *(R_a 31-63 µin)*



Precimaster™ Plus

Precimaster™ Plus ist ein modulares Reibsystem für höhere Reibgeschwindigkeiten, 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 Ra 0,4 bis 0,8 µm (RMS 15 bis 35 Mikrozoll) sind möglich.

Precimaster™ Plus – Programmübersicht

	Durchmesserbereich	Reibtiefe	Toleranz Bohrungs-durchmesser	Zwischendurchmesser	Oberflächengüte
PMX5 / PMX6 / PMX8 	7,75-60 mm *(0.3051-2.3622")*	~ 2-3 x D	IT 6-7-8	Ja, verfügbar über Custom Design	R_a 0,4-0,8 µm *(Ra 15.7-31.5 µin)*
PMX5 / PMX6 / PMX8 	7,75-60 mm *(0.3051-2.3622")*	~ 4-5 x D	IT 6-7-8	Ja, verfügbar über Custom Design	R_a 0,4-0,8 µm *(Ra 15.7-31.5 µin)*
PMX5 / PMX6 / PMX8 	7,75-60 mm *(0.3051-2.3622")*	~ 8-10 x D	IT 6-7-8	Ja, verfügbar über Custom Design	R_a 0,4-0,8 µm *(Ra 15.7-31.5 µin)*

Code-Schlüssel

Precimaster-Plus-Aufnahmen sind sowohl für Grundlochbohrungen als auch Durchgangsbohrungen geeignet.

Werkzeugschaft

Reibahle Aufnahme-Größe		Maximale Reibtiefe		Zylindrischer Schaft Durchmesser		Neutral		Schaftart 1. Zylindrisch DIN1835
PMX08	–	08200	–	20	–	N		1



Schneidkopf

Schneidkopftyp		Bohrungs-Durchmesser und Toleranz		Anschnittgeometrie		Hartmetallsorte
PMX6	–	18H7	–	EB45	–	RX2000



PMX6

Zwischendurchmesser Schneidkopf

Schneidkopftyp		Bohrungs-Durchmesser und Toleranz		Anschnittgeometrie		Hartmetallsorte
PMX5	–	15,515 P7 0.6108”/0.6115”	–	EB845	–	RX2000

PMX5: Spreizbarer Reibkopf mit geraden Spankammern für Grundloch- und Durchgangsbohrungen
PMX6: Linksgedrallte Spankammern, nur für Durchgangsbohrungen.
PMX8: Spreizbarer Reibkopf mit geraden Spankammern für Grundloch- und Durchgangsbohrungen
Der Linksdrall sorgt für kurze Späne. Die Späne werden nach vorne abgeführt.
Siehe Auswahl des Precimaster-Schneidkopfes auf Seite 338.



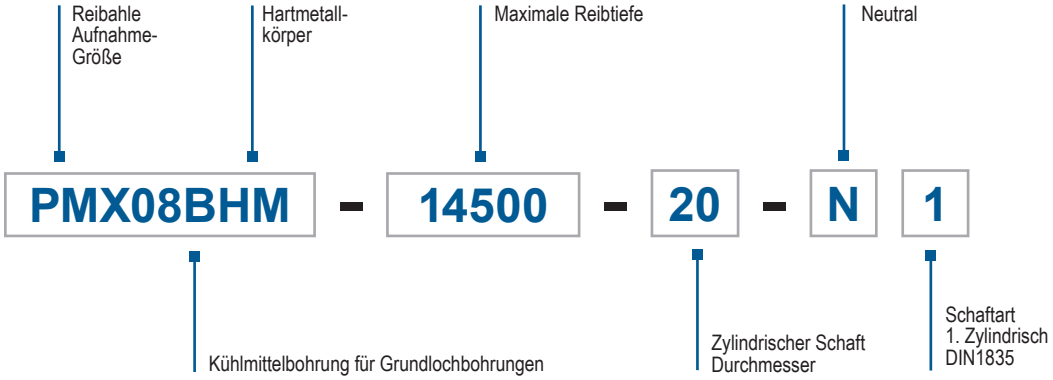
PMX5



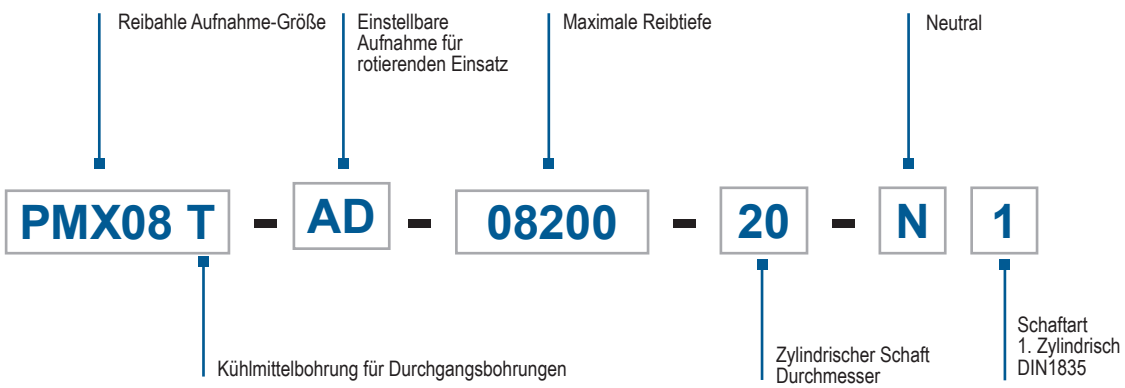
PMX8

Code-Schlüssel

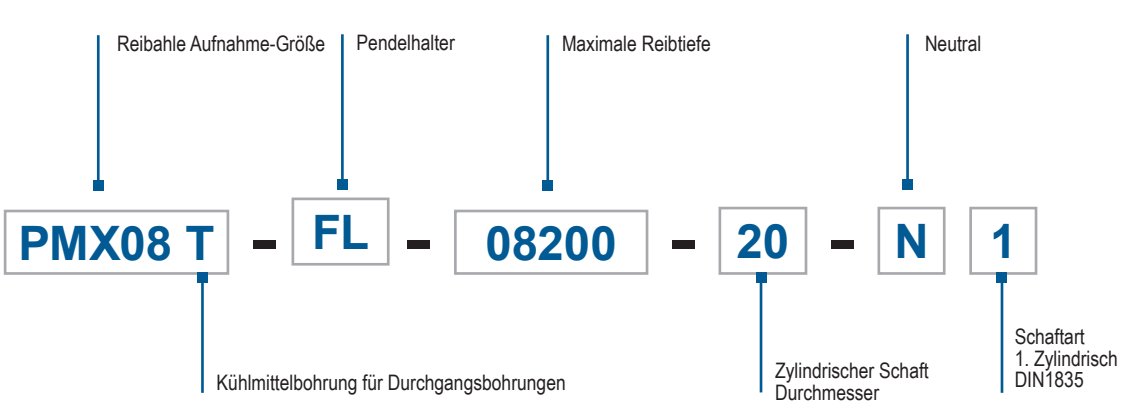
Precimaster-Plus-Aufnahmen sind sowohl für Grundlochbohrungen als auch Durchgangsbohrungen geeignet.







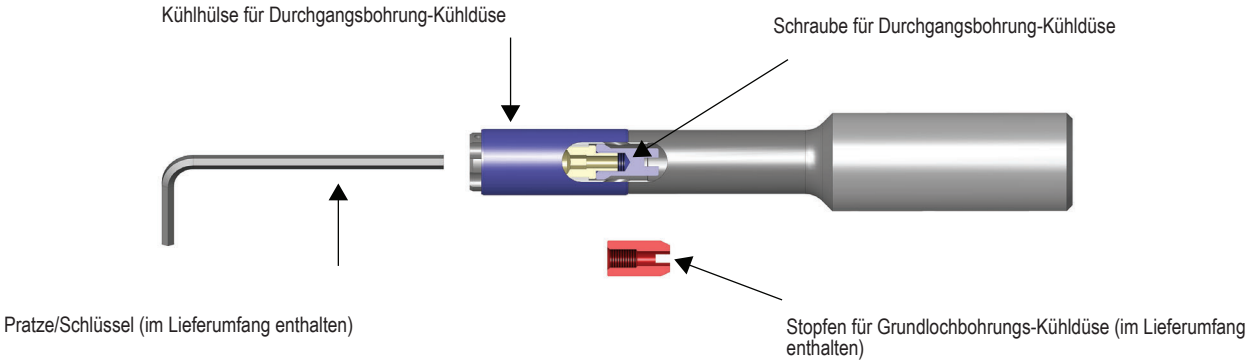






Einstellen der Kühlschmierstoffzufuhr

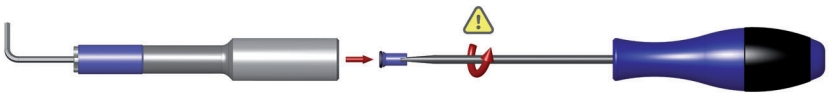
Kühlschmierstoffzufuhr einstellen: Beschreibung der Ersatzteile



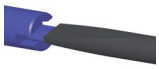
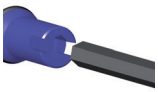
Kühlschmierstoffzufuhr einstellen: Einstellen der Kühldüse für Grundlochbohrungen

1.

Schraube für Durchgangsbohrung (blau) entnehmen
Hinweis: Dichtungsschrauben sind linksdrehend.

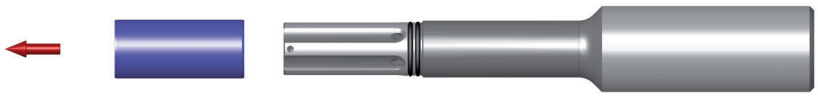


Einen Schraubendreher mit flacher Klinge oder einen Innensechskant-Schlüssel verwenden, wie in der Tabelle empfohlen.

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.

Kühlhülse entnehmen.



3.

Schraube für Blindbohrungs-Kühldüse einsetzen (rot)
Anmerkung: Dichtschrauben sind linksdrehend.



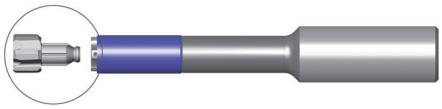
Einsetzen des Kopfes

1.

Darauf achten, dass die Kopfgeometrie für die Kühlung geeignet ist.


PMX5/PMX8


PMX6

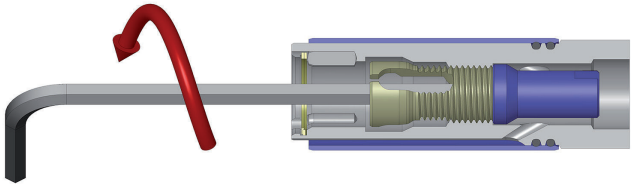

Durchgangsbohrung


PMX5/PMX8


Grundlochbohrung

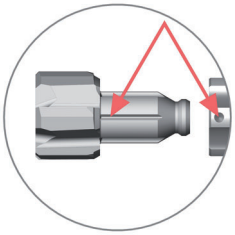
2.

Pratze vor der Montage des Kopfes positionieren.

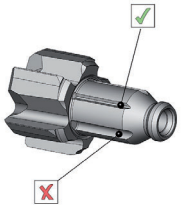


3.

Die Indexnut zum Markierungspunkt der Aufnahme ausrichten.



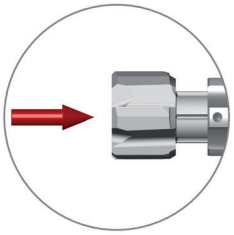
Kleine Nuten



Große Nuten

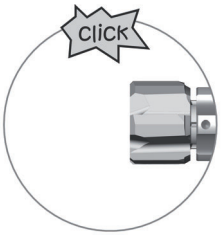
4.

Kopf in den Körper einsetzen



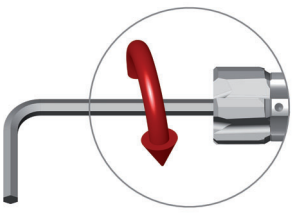
5.

Kopf in den Körper drücken, bis ein Klicken zu hören ist.



6.

Pratze mit einem Innensechskant-Schlüssel anziehen.

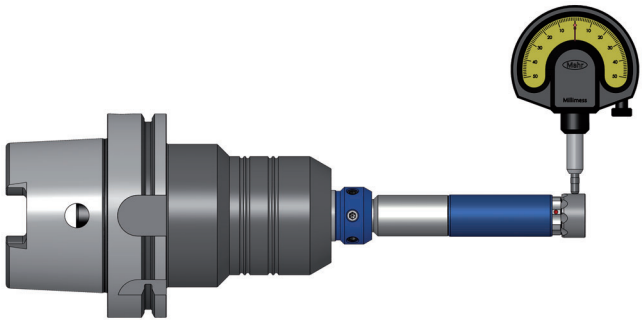


PMX Schaft-Größe	Empfohlener Anzugsmoment
PMX05	0,5 Nm
PMX06	0,9 Nm
PMX08	1,2 Nm
PMX12	2,0 Nm
PMX16	5,0 Nm

Aufspannung – Rundlaufabweichung

Rotierendes Werkzeug

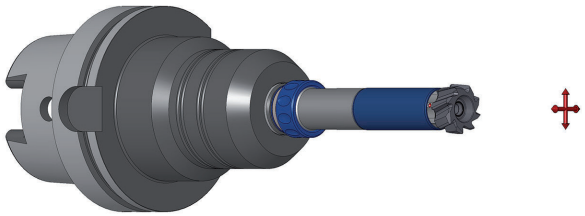
Die maximale empfohlene Rundlaufabweichung beträgt: 10-15 µm *(393.7008-590.5512 µin)*.
Empfehlung: Hydro-Dehnspannfutter, Präzisionsspannzange oder Schrumpffutter.
Für beste Rundlaufkontrolle empfehlen wir einstellbare Precimaster-Plus-Adapter PMX-AD, siehe Seite 351-352.



Statisches Werkzeug

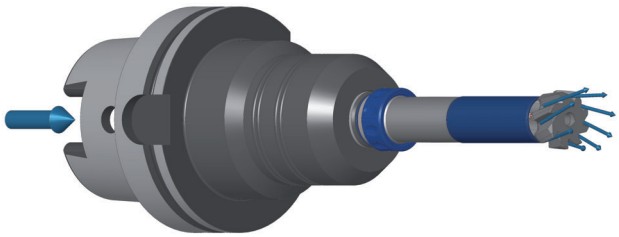
Verwenden Sie Precimaster-Plus-Pendelhalter PMX-FL, siehe Seite(n) 353-354.

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 Werkzeug-durchmesser
(Beispiel: Reibahle Durchmesser 10, Mindestvolumen beträgt 5 l/min *(1.3 gal/min)*.

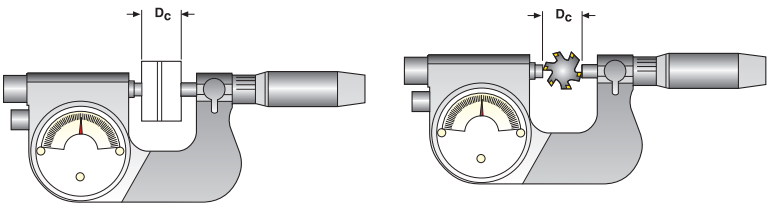


Messung des Durchmessers

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.

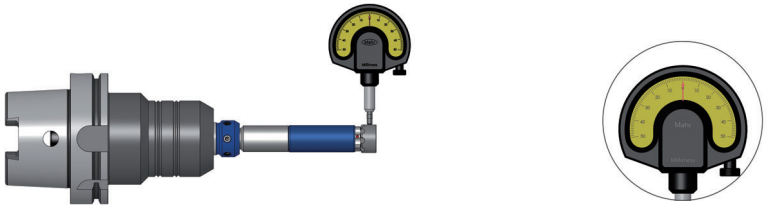


Schäfte anpassen

1.
Einstellung montieren (im Lieferumfang der einstellbaren Aufnahme enthalten).

Werkzeug in Spindel einsetzen.

2.
Uhr wie gezeigt einstellen.

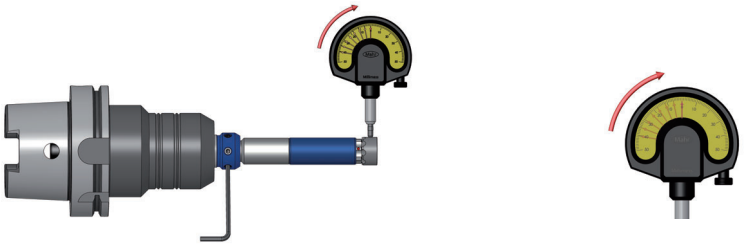


3.
Werkzeug manuell auf tiefste Position einstellen.

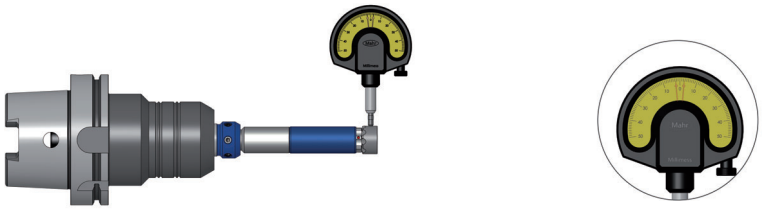


4.
Rundlaufausgleich mit Einstellschrauben vornehmen. Wie gezeigt an den Pfeilen ausrichten.

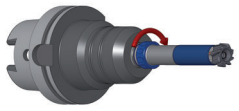
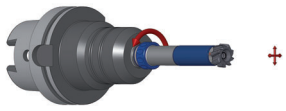
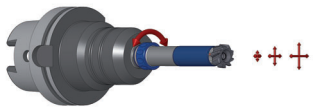
5.
Rundlaufabweichung prüfen und Kompensierung wiederholen, wenn nötig.



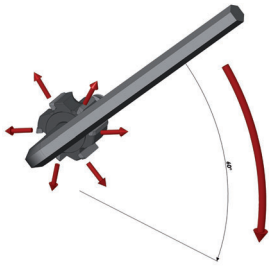
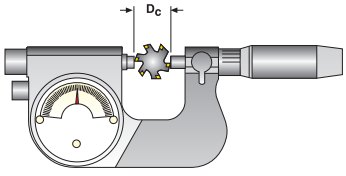
6.
Wenn die maximale Rundlaufabweichung geringer als 5 µm *(0.0002")* ist, die Einstellschrauben anziehen, um zu verhindern, dass sich die Einstellung löst.



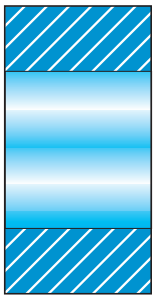
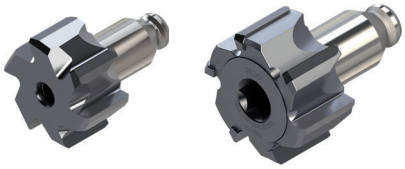
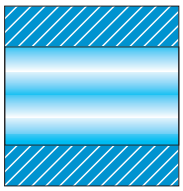
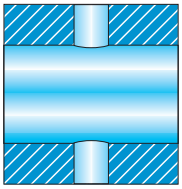
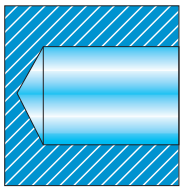
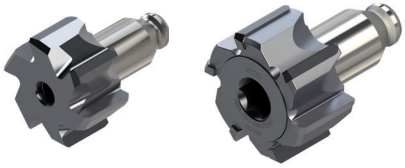
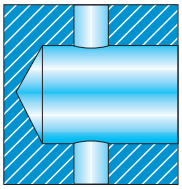
Pendelschäfte anpassen

1. Den Pendelschaft fest anziehen, indem Sie den Einstellring im Uhrzeigersinn drehen.	
2. Den Pendelschaft 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.	

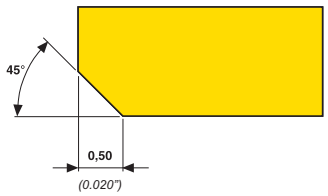
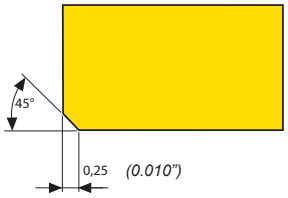
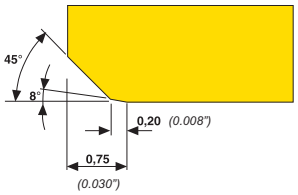
Dehnbare Reibahle mit Verschleißkompensierung

1. Einen Sechskantschlüssel verwenden, um den Durchmesser neu einzustellen (60° Erhöhung = ca. 5 µm *(197 Mikrozoll)* Kompensierung auf den Durchmesser)	
2. Den Durchmesser nach jeder Dehnung 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. 	
Grundlochbohrung und Querbohrung 		

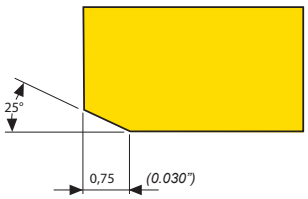
Auswahl der Geometrie – Anwendung

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)*	

Auswahl der Geometrie – Anwendung

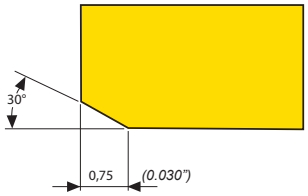
Anschnittgeometrie – EB25

Exzellente Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle



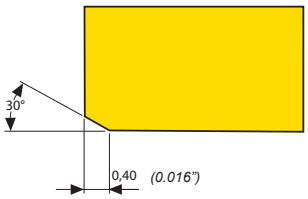
Anschnittgeometrie – EB30

Exzellente Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle

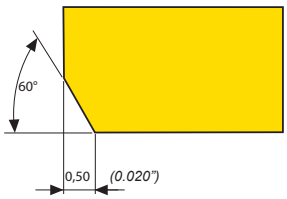


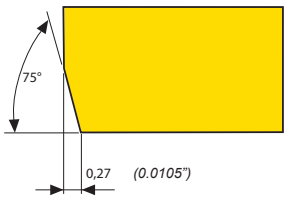
Anschnittgeometrie – EBS30

Exzellente Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle
EB30 kurz



Auswahl der Geometrie – Anwendung

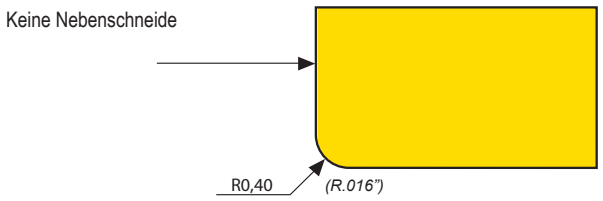
Anschnittgeometrie – EB60	
Oberflächengüte R_a 0,8-1,2 µm *(Oberflächengüte R_a 31-47 µin)* Sehr gute Spankontrolle	

Anschnittgeometrie – EB75	
Oberflächengüte R_a 0,8-1,2 µm *(Oberflächengüte R_a 31-47 µin)* Sehr gute Spankontrolle	

Auswahl der Geometrie – Anwendung

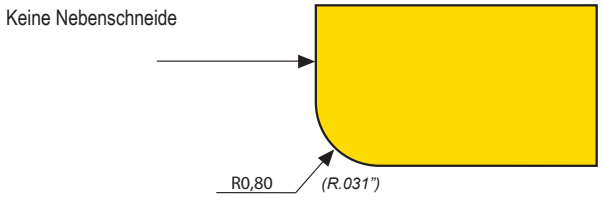
Anschnittgeometrie – RE040

Sehr gute Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle



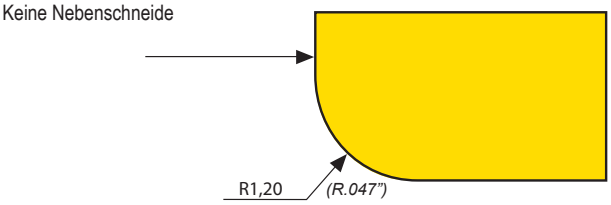
Anschnittgeometrie – RE080

Sehr gute Vorschubleistung
Sehr gute Oberflächengüte Ra 0,4- 0,8 µm
(Sehr gute Oberflächengüte Ra 16 - 31 µin)
Gute Spankontrolle



Anschnittgeometrie – RE120

Sehr gute Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle
Verfügbar ab einem Durchmesser von 14 mm *(0.551")*

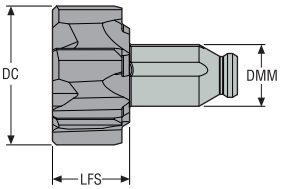


Sorten		
	**RX2000**	**Beschichtet** Beschichtete Hochleistungssorte für alle Werkstoffe.
	**CP20**	**Beschichtet** Eine vielseitige beschichtete Sorte, die für die meisten Werkstoffe außer Aluminium geeignet ist. TiN
	**H15**	**Unbeschichtet** Zähe Sorte mit scharfer Schneidkante für alle Werkstoffe. Dank der hervorragenden Kantenstabilität zum Feinreiben geeignet.
	**CF**	**Cermet** Hochverschleißfeste Sorte zur Optimierung bei Stahl.
	**RX1500**	**Cermet beschichtet** Verschleißfeste beschichtete Sorte zur Leistungsoptimierung bei Stahl und Guss.
	**RN2010**	**Unbeschichtet** Feinstkörnige, unbeschichtete Sorte mit optimierten Geometrien für Nichteisen-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 von M-Bearbeitungen.
	**RK2050**	**Beschichtet** Zähe beschichtete Sorte zum Feinreiben mit optimierter Geometrie für K-Werkstoffe.
	**RK1550**	**Cermet beschichtet** Verschleißfeste beschichtete Sorte mit spezieller Geometrie für K-Werkstoffe. Optimiert für K-Werkstoffe.
	**RS2090**	**Beschichtet** Verschleißfeste beschichtete Sorte mit besonderen Geometrien für S-Werkstoffe. Optimierung von S-Bearbeitungen.

Schneidköpfe für Grundloch- und Durchgangsbohrungen

Durchmesser 8-32 mm / *0.315-1.260”*





- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

Bezeichnung	Produkt-nummer	DC	Bohrergröße*		LFS	DMM	Körpergröße	Geometrie			Sorten				
		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	□	□	■	□	□	■	□	□
PMX5-10H7-EB45	02965840	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	□	□	■	□	□	■	□	□

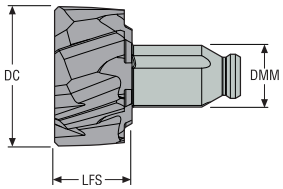
Bezeichnung	Produkt-nummer	DC	Bohrergröße*		LFS	DMM	Körpergröße	Geometrie			Sorten				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX5-28H7-EB45	02925771	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-29H7-EB45	02925772	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-30H7-EB30	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	■	□	□	□	□	■	□	□
PMX5-31H7-EB45	02925774	31,0	30,8/30,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
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 zur Auswahl und zum Einsatz des richtigen Bohrers, siehe Seite(n) 7
■ **Lagerstandard.** □ **Kein Lagerstandard.**

Schneidköpfe für Grundloch- und Durchgangsbohrungen

Durchmesser 8-32 mm / *0.315-1.260”*





- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

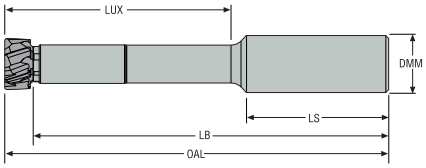
Bezeichnung	Produkt-nummer	DC	Bohrergröße*		LFS	DMM	Körpergröße	Geometrie			Sorten				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX6-8H7-EB45	03123161	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	□	□
PMX6-9H7-EB45	03123162	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	□	□
PMX6-10H7-EB45	02965863	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 zur Auswahl und zum Einsatz des richtigen Bohrers, siehe Seite(n) 7

■ **Lagerstandard.** □ **Kein Lagerstandard.**

Aufnahmen für Grundloch- und Durchgangsbohrungen

Durchmesser 7,75-60,500 mm / *0.305-2.381”*

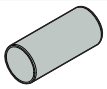
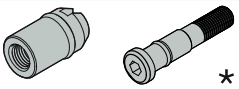
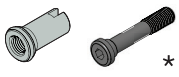




- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

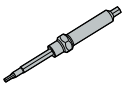
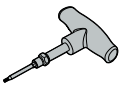
Bezeichnung	Produkt-nummer	Material der Aufnahme	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05-02800-10N1	03123012	Stahl	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05-04100-10N1	02929923	Stahl	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05-10000-10N1	03123013	Stahl	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06-03700-12N1	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	61,0	63,0	32,0
PMX16-12700-32N1	02925841	Stahl	32,5 - 60,5	188,0	174,0	61,0	127,0	32,0
PMX16-17000-32N1	02925842	Stahl	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0
PMX16HM-17000-32N1	02925843	Hartmetall	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

Ersatzteile

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

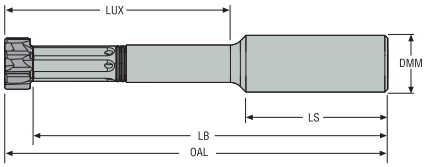
* Die Ersatzteile gelten nur für den PMX16-Körper. Für PMX16 werden die Schrauben auch für die Klemmung verwendet.

Zubehör

Durchmesser (mm)	Schaft-Größe	Produktnummer	Klinge	Produktnummer	Ersatzschneide	Produktnummer	Drehmoment-schlüssel	Produktnummer	Drehmoment-schlüssel	Drehmoment
										
7,750-9,900	PMX05	03178237	H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Aufnahmen für Grundlochbohrungen

Durchmesser 7,75-60,500 mm / *0.305-2.381”*

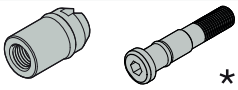




- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

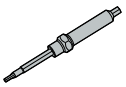
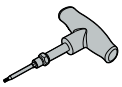
Bezeichnung	Produkt-nummer	Material der Aufnahme	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05B-02800-10N1	03144322	Stahl	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05B-04100-10N1	03144323	Stahl	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05B-10000-10N1	03144324	Stahl	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
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

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

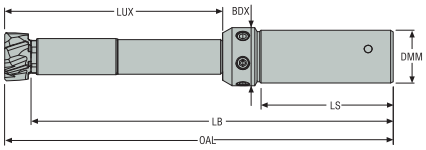
* Die Ersatzteile gelten nur für den PMX16-Körper. Für PMX16 werden die Schrauben auch für die Klemmung verwendet.

Zubehör

Durchmesser (mm)	Schaft-Größe	Produktnummer	Klinge	Produktnummer	Ersatzschneide	Produktnummer	Drehmoment-schlüssel	Produktnummer	Drehmoment-schlüssel	Drehmoment
										
7,750-9,900	PMX05	03178237	H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Einstellbare Aufnahmen für Durchgangsbohrungen

Durchmesser 7,75-60,500 mm / *0.305-2.381”*

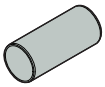




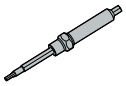
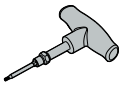
- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

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

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Kühlring	Einstellschlüssel	Kontrolldorn-Kopf
					
PMX05T	7,750-9,900	1.5SMS795	RT05-KI	2SMS795	PMX05-MSTR
PMX06T	9,901-14,499	2SMS795	RT06-KI	–	PMX06-MSTR
PMX08T	14,50-21,499	2.5SMS795	RT08-KI	–	PMX08-MSTR
PMX12T	21,50-32,499	4SMS795	RT12-KI	3SMS795	PMX12-MSTR
PMX16T	32,50-60,000	5SMS795	–	3SMS795	–

Zubehör

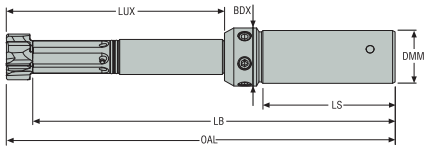
Durchmesser (mm)	Schaft-Größe	Produktnummer	Klinge	Produktnummer	Ersatzschneide	Produktnummer	Drehmoment-schlüssel	Produktnummer	Drehmoment-schlüssel	Drehmoment
										
7,750-9,900	PMX05	03178237	H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Hinweis: Das Reparatur-Klemmkit PMxx-CLKI eignet sich nicht für Typ PMX FL & AD.

Einstellbare Aufnahmen für Grundlochbohrungen

Durchmesser 7,75-60,500 mm / *0.305-2.381”*





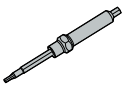
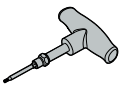
- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

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

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Einstellschlüssel	Kontrolldorn-Kopf
				
PMX05B	7,750-9,900	1.5SMS795	2SMS795	PMX05-MSTR
PMX06B	9,901-14,499	2SMS795	–	PMX06-MSTR
PMX08B	14,50-21,499	2.5SMS795	–	PMX08-MSTR
PMX12B	21,50-32,499	4SMS795	3SMS795	PMX12-MSTR
PMX16B	32,50-60,000	5SMS795	3SMS795	–

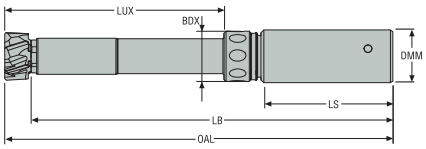
Zubehör

Durchmesser (mm)	Schaft-Größe	Produktnummer	Klinge	Produktnummer	Ersatzschneide	Produktnummer	Drehmoment-schlüssel	Produktnummer	Drehmoment-schlüssel	Drehmoment
										
7,750-9,900	PMX05	03178237	H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Hinweis: Das Reparatur-Klemmkit PMxx-CLKI eignet sich nicht für Typ PMX FL & AD.

Pendelschäfte für Durchgangsbohrungen

Durchmesser 7,75-60,500 mm / *0.305-2.381”*

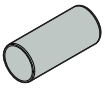




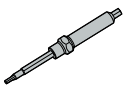
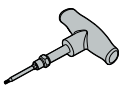
- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

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

Für Schaft	Für Durchmesser (mm)	Schlüssel für Pratze	Kühlring
			
PMX05T	7,750-9,900	1.5SMS795	RT05-KI
PMX06T	9,901-14,499	2SMS795	RT06-KI
PMX08T	14,50-21,499	2.5SMS795	RT08-KI
PMX12T	21,50-32,499	4SMS795	RT12-KI
PMX16T	32,50-60,000	5SMS795	–

Zubehör

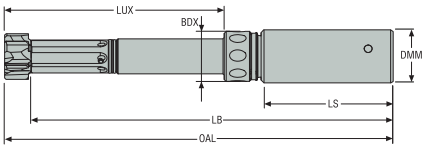
Durchmesser (mm)	Schaft-Größe	Produktnummer	Klinge	Produktnummer	Ersatzschneide	Produktnummer	Drehmoment-schlüssel	Produktnummer	Drehmoment-schlüssel	Drehmoment
										
7,750-9,900	PMX05	03178237	H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Hinweis: Das Reparatur-Klemmkit PMxx-CLKI eignet sich nicht für Typ PMX FL & AD.

Pendelschäfte für Grundlochbohrungen

Durchmesser 7,75-60,500 mm / *0.305-2.381”*





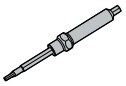
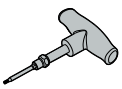
- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

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

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

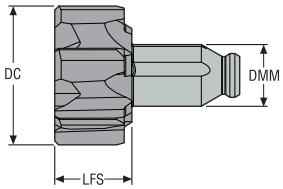
Zubehör

Durchmesser (mm)	Schaft-Größe	Produktnummer	Klinge	Produktnummer	Ersatzschneide	Produktnummer	Drehmoment-schlüssel	Produktnummer	Drehmoment-schlüssel	Drehmoment
										
7,750-9,900	PMX05	03178237	H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Hinweis: Das Reparatur-Klemmkit PMxx-CLKI eignet sich nicht für Typ PMX FL & AD.

Schneidköpfe für Grundloch- und Durchgangsbohrungen, Custom Design

Durchmesser 7,75-60,500 mm / *0.305-2.381”*





- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

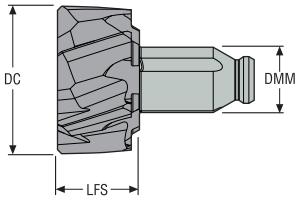
Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Sorten										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX5-7.75-XX-XXXX	7,75 *0.305*	9,999 *0.394*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
PMX5-10.0-XX-XXXX	10,0 *0.394*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
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	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

☐ **Kein Lagerstandard. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.**
Hinweis: Bei Bestellungen von Precimaster Plus-Reibahlen in Zwischendurchmessern Durchmesser und Toleranz der zu bearbeitenden Bohrung angeben.
Bestell-Beispiel: PMX5-16.515 P7-EB45 RM2020. PMX6-16.515 P7-EB45 RM2020.

Schneidköpfe für Durchgangsbohrungen, Custom Design

Durchmesser 7,75-60,500 mm / *0.305-2.381”*





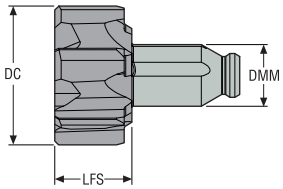
- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

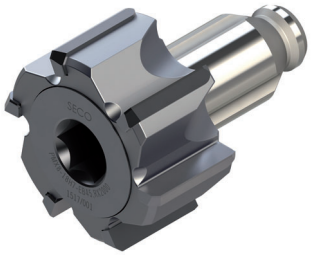
Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Sorten										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX6-7.75-XX-XXXX	7,75 *0.305*	9,999 *0.394*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
PMX6-10.0-XX-XXXX	10,0 *0.394*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
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	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

☐ **Kein Lagerstandard. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.**
Hinweis: Bei Bestellungen von Precimaster Plus-Reibahlen in Zwischendurchmessern Durchmesser und Toleranz der zu bearbeitenden Bohrung angeben.
Bestell-Beispiel: PMX5-16.515 P7-EB45 RM2020. PMX6-16.515 P7-EB45 RM2020.

Dehnbare Köpfe für Durchgangs- und Grundlochbohrungen

Durchmesser 10,00-32,500 mm / *0.393-1.279”*





- Schnittdaten, siehe Seite(n) 360-367
- Anschnittgeometrie EB45 oder EB845 oder EB30, siehe Seite(n) 339

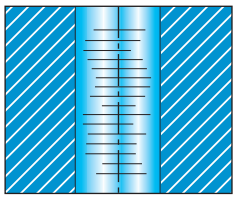
Bezeichnung	DCN	DCX	LFS	DMM		Körpergröße	Geometrie	Sorten										
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX8-10.0-XX-XXXX	10,0 *0.394*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
PMX8-14.5-XX-XXXX	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	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

☐ **Kein Lagerstandard. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.**
Hinweis: Bei Bestellungen von Precimaster Plus-Reibahlen in Zwischendurchmessern Durchmesser und Toleranz der zu bearbeitenden Bohrung angeben.
Bestell-Beispiel: PMX8-16.515 P7-EB45 RM2020.

Herausforderungen

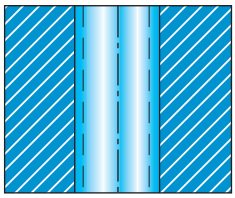
Geringe Oberflächengüte

- Aufmaß prüfen.
- Kühlung verbessern (Anschluss, Druck, Qualität).
- Vorschub reduzieren.



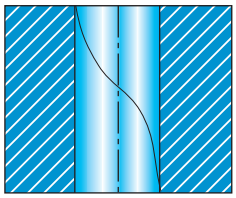
Durchmesser zu groß

- Konzentrizität prüfen (Werkstück/ Werkzeug).



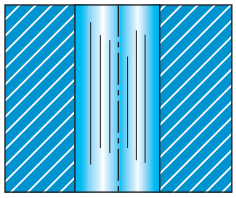
Rückzugsriefen

- Kühlung verbessern (Anschluss, Druck, Qualität).
- Konzentrizität prüfen (Werkstück/ Werkzeug).
- Ausgangsvorschub reduzieren.



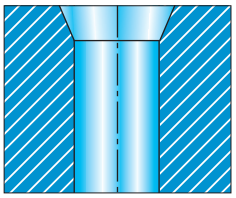
Rattermarken

- Konzentrizität prüfen (Werkstück/ Werkzeug).
- Aufmaß prüfen.



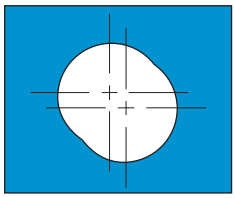
Konischer Eintritt

- Vorschub reduzieren.
- Konzentrizität (Werkstück/Werkzeug) prüfen.
- Rundlauf des Werkzeuges prüfen.



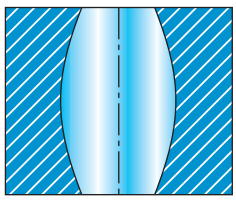
Exzentrische Bohrung

- Werkstückklemmung prüfen.
- Aufmaß prüfen.
- Konzentrizität prüfen (Werkstück/ Werkzeug).



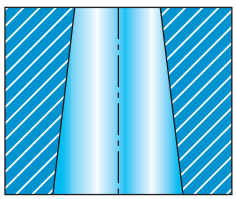
Deformierte Bohrung

- Werkstückklemmung prüfen.



Konische Bohrung

- Konzentrizität prüfen (Werkstück/ Werkzeug).



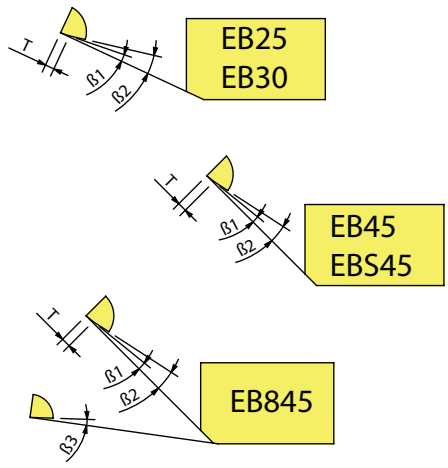
Hinweise zum Nachschleifen

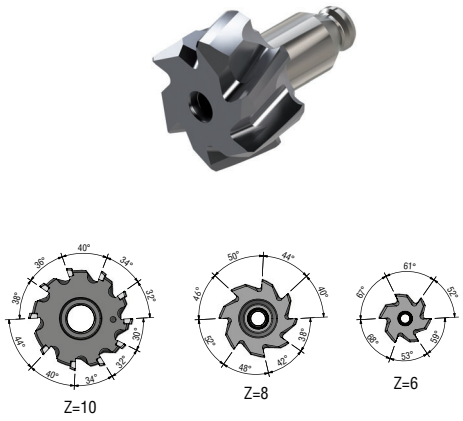
Einzelheiten

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)*





Durchmesser 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 (Durchmesser)		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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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)	-	-	-	-	-	-	-	-
S2	PMX5 ..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)	-	-	-	-	-	-	-	-
S3	PMX5 ..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)	-	-	-	-	-	-	-	-
S11	PMX5 ..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)	-	-	-	-	-	-	-	-
S12	PMX5 ..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)	-	-	-	-	-	-	-	-
S13	PMX5 ..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)	-	-	-	-	-	-	-	-

Fortsetzung der Tabelle auf der folgenden Seite.

Schnittdaten – PM Plus... -EB45 Metrisch

SMG		a_p (Durchmesser)		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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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)	-	-	-	-	-	-	-	-
TP1	PMX5 ..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)	-	-	-	-	-	-	-	-
TP2	PMX5 ..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)	-	-	-	-	-	-	-	-
TP3	PMX5 ..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)	-	-	-	-	-	-	-	-
TP4	PMX5 ..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)	-	-	-	-	-	-	-	-
GR1	PMX5 ..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)	-	-	-	-	-	-	-	-

SMG = Seco Werkstoff-Gruppe
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – PM Plus...-EB45 *Zoll*

SMG		a_p (Durchmesser)		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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..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	PMX5..6..8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N2	PMX5..6..8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N3	PMX5..6..8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N11	PMX5..6..8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
S1	PMX5..6..8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S2	PMX5..6..8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S3	PMX5..6..8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S11	PMX5..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	PMX5..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	PMX5..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)

Fortsetzung der Tabelle auf der folgenden Seite.

Schnittdaten – PM Plus...-EB45 *Zoll*

SMG		a_p (Durchmesser)		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	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
H7	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
H8	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
H11	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
H12	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
H21	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
H31	*PMX5 ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	-	-	-	-
PM1	*PMX5 ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	-	-	-	-
PM2	*PMX5 ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	-	-	-	-
PM3	*PMX5 ..6 ..8 -EB45*	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	-	-	-	-
TS1	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TS2	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TS3	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TS4	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TP1	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TP2	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TP3	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
TP4	*PMX5 ..6 ..8 -EB45*	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	–	130 (65-195)	–	–	–	–	-	-	-	-
GR1	*PMX5 ..6 ..8 -EB45*	.004 -.012	.004 -.016	.012 -.035	.016 -.047	.020 -.059	130 (260-65)	–	195 (100-395)	–	–	–	–	-	-	-	-

SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – PM Plus...-EB845 Metrisch

SMG		a_p (Durchmesser)		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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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 Richtwerte.

Schnittdaten – PM Plus...-EB845 *Zoll*

SMG		a_p (Durchmesser)		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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S2	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S3	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S11	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H5	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H7	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H8	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H11	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H12	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H21	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H31	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
PM1	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–
PM2	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–
PM3	PMX5 ..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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – Plus... -EB25/EB30 Metrisch

SMG		a_p (Durchmesser)		f			v_c						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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	PMX5 ..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 Richtwerte.

Schnittdaten – PM Plus... -EB25/EB30 *Zoll*

SMG		a_p (Durchmesser)		f			v_c						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..6 ..8 -EB25/EB30*	*.003 –.006*	*.004 –.008*	*.031 –.047*	*.039 –.079*	*.039-.098*	–	*80 (50-130)*	*115 (65-230)*	–	–	–	–
K1	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..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	*PMX5 ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N2	*PMX5 ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N3	*PMX5 ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N11	*PMX5 ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
PM1	*PMX5 ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.020 –.071*	*.031 –.079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–
PM2	*PMX5 ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.020 –.071*	*.031 –.079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–
PM3	*PMX5 ..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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.



Nanofix™

Nanofix™ Vollhartmetall-Reibahlen eignen sich für kleine Durchmesser von 2,97 bis 12,05 mm (.117” - .474”).

- Interne Kühlschmierstoffzufuhr mit einfach verstellbarem System für entweder Durchgangs- oder Grundlochbohrung.
- Ermöglicht Toleranzen zwischen 10 und 15 µm (.0004 - .0006”)
- Vier verfügbare Geometrien: EB45, EB845, EB25 und EB30

Programmübersicht

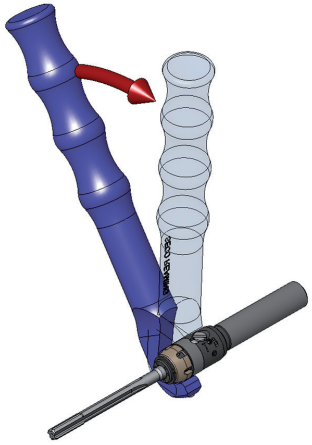
	Durchmesserbereich	Reibtiefe	Toleranz Bohrdurchmesser	Zwischendurchmesser	Oberflächengüte
Nanofix™ 	2,97-12,05 mm *(0.1169-0.4744")*	5-12 x D	IT 7	Ja, verfügbar über Custom Design	R_a 0,8-1,2 µm *(R_a 31-47 µin)*

Seco Nanofix™ sind Vollhartmetall-Reibahlen für Durchmesser von 2,97 bis 12,05 mm *(0.1169 to 0.4744")*.
Durch die einzigartige, patentierte Quick-Fit-Klemmung wird der gesamte Durchmesserbereich mit nur zwei Aufnahmen abgedeckt.
Die Aufnahmen verfügen über eine einfach einstellbare interne Kühlschmierstoffzufuhr, die je nach Anwendung auf Durchgangs- oder Grundlochbohrung umgestellt werden kann.

Quick-Fit

Quick-Fit

Schneller und einfacher Werkzeugwechsel
Präzise Positionierung in Rundlauf und Länge



Zwei Quick-Fit Größen decken alle Durchmesserbereiche ab.

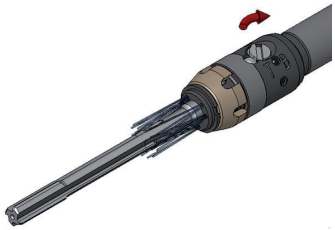


Quick-Fit Durchmesser 10 mm für
Durchmesser 6,051-12,050 mm
(∅ 0.2382-0.4744")



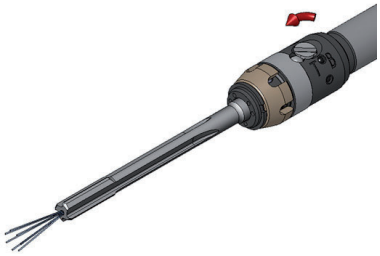
Quick-Fit Durchmesser 6 mm für
Durchmesser 2,97 -6,050 mm
(∅ 0.1169-0.2382")

Dasselbe Werkzeug für Durchgangs- und Grundlochbohrungen



Durchgangsbohrung

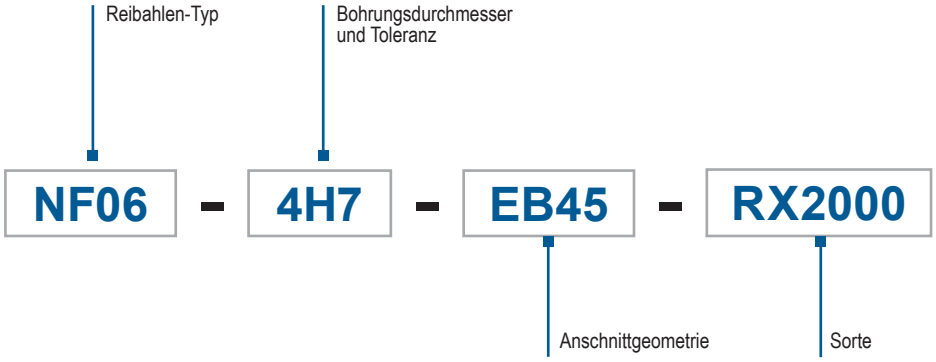
Stellen Sie die Ventilschraube der Kühlung
mit 1/4-Drehung von Durchgangs- auf
Grundlochbohrung um und umgekehrt.



Grundlochbohrung

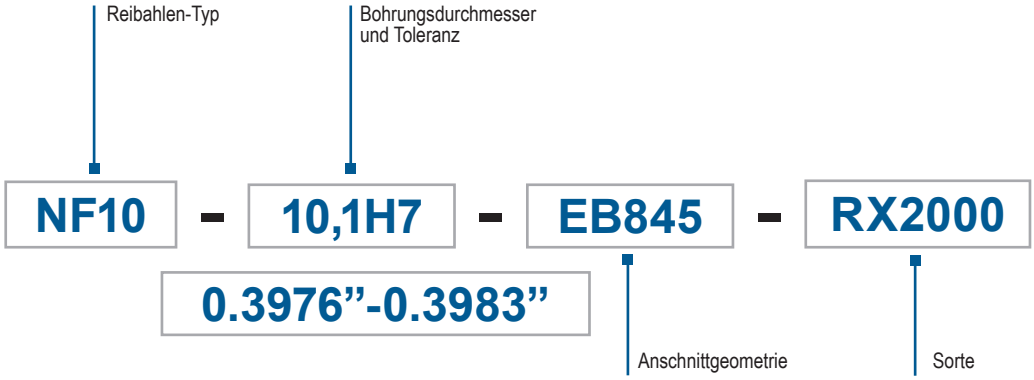
Code-Schlüssel

Reibahlen

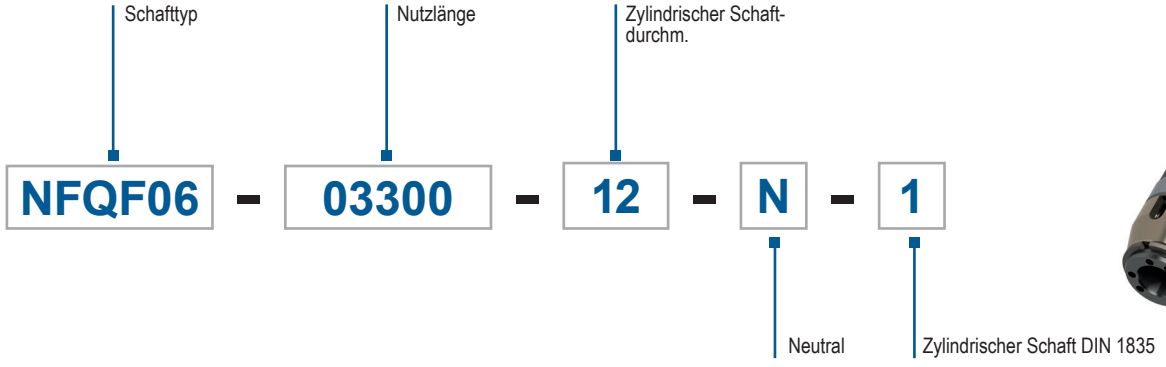




Reibahle Zwischendurchmesser



Aufnahmen



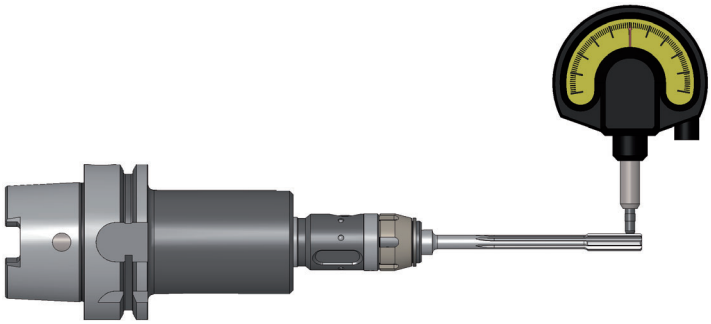


Rundlaufabweichung

Rotierendes Werkzeug

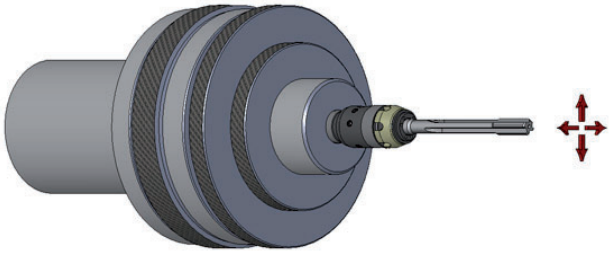
Die empfohlene maximale Rundlaufabweichung beträgt 5 µm *(197 µin)*.
Präzisionsaufnahmen werden empfohlen: Hydro-Dehnspannfutter, Präzisionsspannzange Typ 5672

Ein O-Ring wird als Dichtung für das Kühlsystem verwendet. Daher empfehlen wir, keine Schrumpfaufnahme einzusetzen.



Statisches Werkzeug

Einen Seco Pendelhalter verwenden, siehe Seite 480-484.
Mit Pendelhaltern erzielen Sie eine Selbstzentrierung in der Vorbohrung.



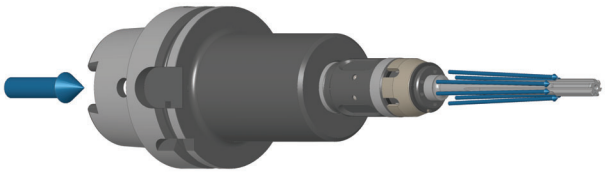
Kühlschmierstoffzufuhr

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.

Lösliches Qualitätsöl 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 Werkzeug-durchmesser (Beispiel: Reibahle Durchmesser 10, Mindestvolumen beträgt 5 l/min *(1.3 gal/min)*.

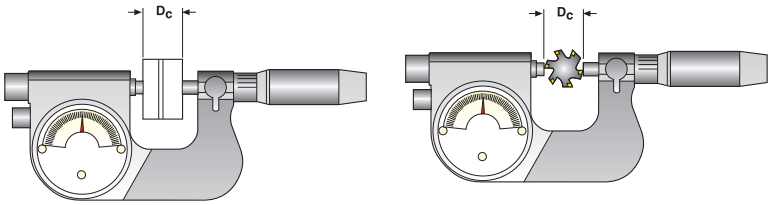


Messung des Durchmessers

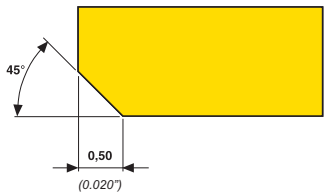
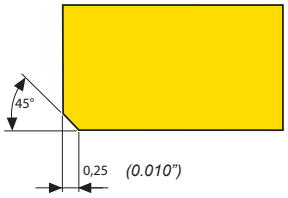
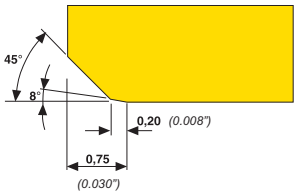
Messung des Durchmessers mit Mikrometer-Uhr

Wichtig:
Nanofix 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.



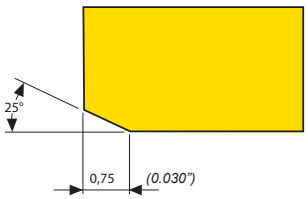
Auswahl der Geometrie – Anwendung

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)*	

Auswahl der Geometrie – Anwendung

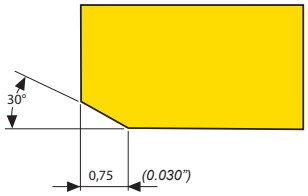
Anschnittgeometrie – EB25

Exzellente Vorschubleistung
Sehr gute Oberflächengüte R_a 0,4- 0,8 µm
(Sehr gute Oberflächengüte R_a 16 - 31 µin)
Gute Spankontrolle



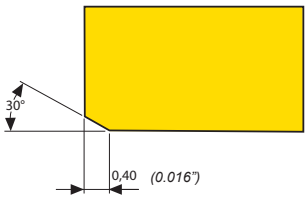
Anschnittgeometrie – EB30

Exzellente Vorschubleistung
Sehr gute Oberflächengüte Ra 0,4- 0,8 µm
(Sehr gute Oberflächengüte Ra 16 - 31 µin)
Gute Spankontrolle

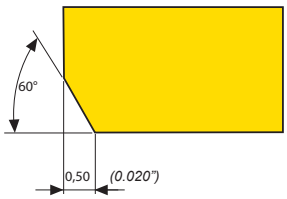
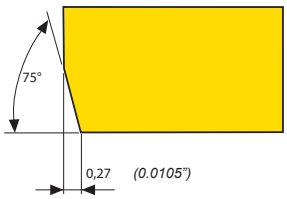


Anschnittgeometrie – EBS30

Exzellente Vorschubleistung
Sehr gute Oberflächengüte Ra 0,4- 0,8 µm
(Sehr gute Oberflächengüte Ra 16 - 31 µin)
Gute Spankontrolle
EB30 kurz



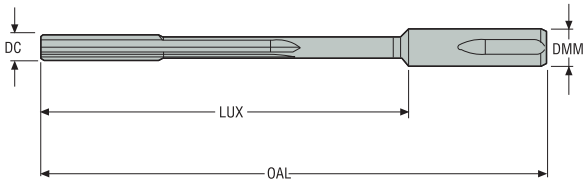
Auswahl der Geometrie – Anwendung

Anschnittgeometrie – EB60	
Oberflächengüte R_a 0,8 - 1,2 µm *(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)* Sehr gute Spankontrolle	

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 Nichteisen-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 von M-Bearbeitungen.
	**RK2050**	**Beschichtet** Zähe beschichtete Sorte zum Feinreiben mit optimierter Geometrie für K-Werkstoffe.
	**RS2090**	**Beschichtet** Verschleißfeste beschichtete Sorte mit besonderen Geometrien für S-Werkstoffe. Optimierung von S-Bearbeitungen.

Reibahlen für Grundloch- und Durchgangsbohrungen

Durchmesser 2,97-12,05 mm / *0.116-0.474”*





Bezeichnung	Produkt-nummer	DC	Bohrungsdurchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NF06-2.98H7-EB45	02728853	2,98 *0.1173*	2,98 *0.1173*	2,99 *0.1177*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-2.99H7-EB45	02728854	2,99 *0.1177*	2,99 *0.1177*	3,0 *0.1181*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3H7-EB45	02728858	3,0 *0.1181*	3,0 *0.1181*	3,01 *0.1185*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3.01H7-EB45	02728860	3,01 *0.1185*	3,01 *0.1185*	3,022 *0.1190*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3.02H7-EB45	02728862	3,02 *0.1189*	3,02 *0.1189*	3,032 *0.1194*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3.03H7-EB45	02728864	3,03 *0.1193*	3,03 *0.1193*	3,042 *0.1198*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3.04H7-EB45	02728865	3,04 *0.1197*	3,04 *0.1197*	3,052 *0.1202*	40,0 *1.5750*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3.05H7-EB45	02728866	3,05 *0.1201*	3,05 *0.1201*	3,062 *0.1206*	60,0 *2.3620*	6,0 *0.2360*	60,0 *2.3620*	4	■	□	□	■	□	□
NF06-3.167H7-EB45	02761485	3,167 *0.1247*	3,167 *0.1247*	3,179 *0.1252*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-3.175H7-EB45	02761489	3,175 *0.1250*	3,175 *0.1250*	3,187 *0.1255*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-3.51H7-EB45	02728869	3,51 *0.1382*	3,51 *0.1382*	3,522 *0.1387*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-3.5H7-EB45	02728868	3,5 *0.1378*	3,5 *0.1378*	3,512 *0.1383*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-3.97H7-EB45	02728871	3,97 *0.1563*	3,97 *0.1563*	3,982 *0.1568*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-3.98H7-EB45	02728872	3,98 *0.1567*	3,98 *0.1567*	3,992 *0.1572*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-3.99H7-EB45	02728873	3,99 *0.1571*	3,99 *0.1571*	4,002 *0.1576*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4H7-EB45	02728874	4,0 *0.1575*	4,0 *0.1575*	4,012 *0.1580*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.01H7-EB45	02728875	4,01 *0.1579*	4,01 *0.1579*	4,022 *0.1583*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.02H7-EB45	02728876	4,02 *0.1583*	4,02 *0.1583*	4,032 *0.1587*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.04H7-EB45	02728879	4,04 *0.1591*	4,04 *0.1591*	4,052 *0.1595*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.05H7-EB45	02728880	4,05 *0.1594*	4,05 *0.1594*	4,062 *0.1599*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.5H7-EB45	02728881	4,5 *0.1772*	4,5 *0.1772*	4,512 *0.1776*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.750H7-EB45	02761490	4,75 *0.1870*	4,75 *0.1870*	4,762 *0.1875*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.762H7-EB45	02761494	4,762 *0.1875*	4,762 *0.1875*	4,774 *0.1880*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□

Bezeichnung	Produkt-nummer	DC	Bohrungsdurchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NF06-4.97H7-EB45	02728882	4,97 *0.1957*	4,97 *0.1957*	4,982 *0.1961*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.98H7-EB45	02728883	4,98 *0.1961*	4,98 *0.1961*	4,992 *0.1965*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-4.99H7-EB45	02728884	4,99 *0.1965*	4,99 *0.1965*	5,002 *0.1969*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.01H7-EB45	02728928	5,01 *0.1972*	5,01 *0.1972*	5,022 *0.1977*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.02H7-EB45	02728929	5,02 *0.1976*	5,02 *0.1976*	5,032 *0.1981*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.03H7-EB45	02728930	5,03 *0.1980*	5,03 *0.1980*	5,042 *0.1985*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.05H7-EB45	02728932	5,05 *0.1988*	5,05 *0.1988*	5,062 *0.1993*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.5H7-EB45	02728933	5,5 *0.2165*	5,5 *0.2165*	5,512 *0.2170*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.97H7-EB45	02728934	5,97 *0.2350*	5,97 *0.2350*	5,982 *0.2355*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.98H7-EB45	02728935	5,98 *0.2354*	5,98 *0.2354*	5,992 *0.2359*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5.99H7-EB45	02728936	5,99 *0.2358*	5,99 *0.2358*	6,002 *0.2363*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-5H7-EB45	02728927	5,0 *0.1969*	5,0 *0.1969*	5,012 *0.1973*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-6H7-EB45	02728937	6,0 *0.2362*	6,0 *0.2362*	6,015 *0.2368*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-6.01H7-EB45	02728938	6,01 *0.2366*	6,01 *0.2366*	6,025 *0.2372*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-6.02H7-EB45	02728939	6,02 *0.2370*	6,02 *0.2370*	6,035 *0.2376*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-6.03H7-EB45	02728940	6,03 *0.2374*	6,03 *0.2374*	6,045 *0.2380*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-6.04H7-EB45	02728941	6,04 *0.2378*	6,04 *0.2378*	6,055 *0.2384*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF06-6.05H7-EB45	02728942	6,05 *0.2382*	6,05 *0.2382*	6,065 *0.2388*	60,0 *2.3620*	6,0 *0.2360*	80,0 *3.1500*	4	■	□	□	■	□	□
NF10-6.334H7-EB45	02761987	6,334 *0.2494*	6,33 *0.2492*	6,345 *0.2498*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-6.350H7-EB45	02762016	6,35 *0.2500*	6,35 *0.2500*	6,365 *0.2506*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-6.3754H7-EB45	02762017	6,375 *0.2510*	6,375 *0.2510*	6,39 *0.2516*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-6.5H7-EB45	02728943	6,5 *0.2559*	6,5 *0.2559*	6,515 *0.2565*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-6.98H7-EB45	02728947	6,98 *0.2748*	6,98 *0.2748*	6,995 *0.2754*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7H7-EB45	02728949	7,0 *0.2756*	7,0 *0.2756*	7,015 *0.2762*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.01H7-EB45	02728950	7,01 *0.2760*	7,01 *0.2760*	7,025 *0.2766*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.02H7-EB45	02728951	7,02 *0.2764*	7,02 *0.2764*	7,035 *0.2770*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.05H7-EB45	02728954	7,05 *0.2776*	7,05 *0.2776*	7,065 *0.2781*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.5H7-EB45	02728955	7,5 *0.2953*	7,5 *0.2953*	7,515 *0.2959*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.9375H7-EB45	02762018	7,9375 *0.3125*	7,937 *0.3125*	7,952 *0.3131*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.97H7-EB45	02728956	7,97 *0.3138*	7,97 *0.3138*	7,985 *0.3144*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□

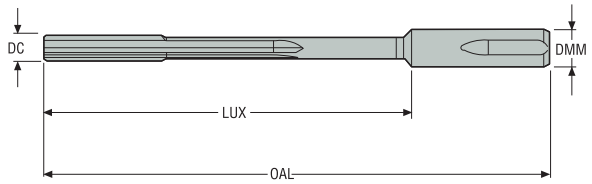
Bezeichnung	Produkt-nummer	DC	Bohrungsdurchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NF10-7.98H7-EB45	02728957	7,98 *0.3142*	7,98 *0.3142*	7,995 *0.3148*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-7.99H7-EB45	02728958	7,99 *0.3146*	7,99 *0.3146*	8,005 *0.3152*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8H7-EB45	02728959	8,0 *0.3150*	8,0 *0.3150*	8,015 *0.3156*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8.01H7-EB45	02728960	8,01 *0.3154*	8,01 *0.3154*	8,025 *0.3159*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8.02H7-EB45	02728961	8,02 *0.3157*	8,02 *0.3157*	8,035 *0.3163*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8.03H7-EB45	02728962	8,03 *0.3161*	8,03 *0.3161*	8,045 *0.3167*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8.04H7-EB45	02728963	8,04 *0.3165*	8,04 *0.3165*	8,055 *0.3171*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8.05H7-EB45	02728964	8,05 *0.3169*	8,05 *0.3169*	8,065 *0.3175*	83,0 *3.2680*	10,0 *0.3940*	115,0 *4.5280*	6	■	□	□	■	□	□
NF10-8.5H7-EB45	02728965	8,5 *0.3346*	8,5 *0.3346*	8,515 *0.3352*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9H7-EB45	02728974	9,0 *0.3543*	9,0 *0.3543*	9,015 *0.3549*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.01H7-EB45	02728975	9,01 *0.3547*	9,01 *0.3547*	9,025 *0.3553*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.05H7-EB45	02728979	9,05 *0.3563*	9,05 *0.3563*	9,065 *0.3569*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.5H7-EB45	02728980	9,5 *0.3740*	9,5 *0.3740*	9,515 *0.3746*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.5250H7-EB45	02762020	9,525 *0.3750*	9,525 *0.3750*	9,54 *0.3756*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.97H7-EB45	02728981	9,97 *0.3925*	9,97 *0.3925*	9,985 *0.3931*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.98H7-EB45	02728982	9,98 *0.3929*	9,98 *0.3929*	9,995 *0.3935*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-9.99H7-EB45	02728983	9,99 *0.3933*	9,99 *0.3933*	10,005 *0.3939*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-10H7-EB45	02728986	10,0 *0.3937*	10,0 *0.3937*	10,015 *0.3943*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-10.01H7-EB45	02728987	10,01 *0.3941*	10,01 *0.3941*	10,028 *0.3948*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-10.02H7-EB45	02728988	10,02 *0.3945*	10,02 *0.3945*	10,038 *0.3952*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-10.04H7-EB45	02728990	10,04 *0.3953*	10,04 *0.3953*	10,058 *0.3960*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-10.05H7-EB45	02728991	10,05 *0.3957*	10,05 *0.3957*	10,068 *0.3964*	93,0 *3.6610*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-11H7-EB45	02728997	11,0 *0.4331*	11,0 *0.4331*	11,018 *0.4338*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-11.04H7-EB45	02729004	11,04 *0.4346*	11,04 *0.4346*	11,058 *0.4354*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-11.05H7-EB45	02729005	11,05 *0.4350*	11,05 *0.4350*	11,068 *0.4357*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-11.112H7-EB45	02762021	11,112 *0.4375*	11,112 *0.4375*	11,13 *0.4382*	114,0 *4.4880*	10,0 *0.3940*	145,0 *5.7090*	6	■	□	□	■	□	□
NF10-11.97H7-EB45	02729008	11,97 *0.4713*	11,97 *0.4713*	11,988 *0.4720*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-11.98H7-EB45	02729009	11,98 *0.4717*	11,98 *0.4717*	11,998 *0.4724*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-11.99H7-EB45	02729010	11,99 *0.4720*	11,99 *0.4720*	12,008 *0.4728*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-12H7-EB45	02729011	12,0 *0.4724*	12,0 *0.4724*	12,018 *0.4731*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□

Bezeichnung	Produkt-nummer	DC	Bohrungsdurchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NF10-12.01H7-EB45	02729012	12,01 *0.4728*	12,01 *0.4728*	12,028 *0.4735*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-12.02H7-EB45	02729013	12,02 *0.4732*	12,02 *0.4732*	12,038 *0.4739*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-12.03H7-EB45	02729014	12,03 *0.4736*	12,03 *0.4736*	12,048 *0.4743*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-12.04H7-EB45	02729015	12,04 *0.4740*	12,04 *0.4740*	12,058 *0.4747*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□
NF10-12.05H7-EB45	02729016	12,05 *0.4744*	12,05 *0.4744*	12,068 *0.4751*	114,0 *4.4880*	10,0 *0.3940*	125,0 *4.9210*	6	■	□	□	■	□	□

■ **Lagerstandard.** □ **Kein Lagerstandard.**
Hinweis: Geben Sie bei Bestellung von Nanofix-Reibahlen in Zwischendurchmessern immer Durchmesser und Toleranz der zu bearbeitenden Bohrung an.
Bestell-Beispiel: NF10-10,187/10,213-EB845, RX2000.

Zwischendurchmesser

Gerade Schneide, lange Version





- Schnittdaten, siehe Seite(n) 391-396
- Anschnittgeometrie siehe Seite(n) 373-375

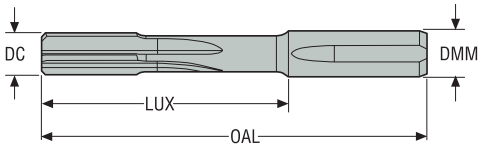
Bezeichnung	DCN	DCX	LUX	DMM	OAL		Körper-größe	Geometrie	Sorten						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
NF06-2.970-XX-XXXX	2,97 *0.117*	3,05 *0.120*	40,0 *1.575*	6,0 *0.236*	60,0 *2.362*	4	NFQF06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NF06-3.051-XX-XXXX	3,051 *0.120*	6,05 *0.238*	60,0 *2.362*	6,0 *0.236*	80,0 *3.150*	4	NFQF06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NF10-6.051-XX-XXXX	6,051 *0.238*	8,05 *0.317*	83,0 *3.268*	10,0 *0.394*	115,0 *4.528*	6	NFQF10-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NF10-8.051-XX-XXXX	8,051 *0.317*	10,05 *0.396*	93,0 *3.661*	10,0 *0.394*	125,0 *4.921*	6	NFQF10-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NF10-10.051-XX-XXXX	10,051 *0.396*	12,05 *0.474*	114,0 *4.488*	10,0 *0.394*	145,0 *5.709*	6	NFQF10-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐

☐ **Kein Lagerstandard. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.**
Hinweis: Bei Bestellungen von Nanofix-Reibahlen in Zwischendurchmessern Durchmesser und Toleranz der zu bearbeitenden Bohrung angeben.
Bestell-Beispiel: NF10-10,187/10,213-EB845, RX2000.

Reibahlen für Grundloch- und Durchgangsbohrungen – kurze Version

Durchmesser 2,97-12,05 mm / *0.116-0.474”*





Bezeichnung	Produkt-nummer	DC	Bohrungs-durchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NS06-2.97H7-EB...	–	2,97 *0.1169*	2,97 *0.1169*	2,98 *0.1173*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-2.98H7-EB...	–	2,98 *0.1173*	2,98 *0.1173*	2,99 *0.1177*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-2.99H7-EB...	–	2,99 *0.1177*	2,99 *0.1177*	3,00 *0.1181*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3.00H7-EB...	–	3,0 *0.1181*	3,00 *0.1181*	3,01 *0.1185*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3H7-EB30	10019456	3,0 *0.1181*	3,01 *0.1185*	3,00 *0.1181*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	■	■	☐	☐
NS06-3.01H7-EB...	–	3,01 *0.1185*	3,01 *0.1185*	3,02 *0.1190*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3.02H7-EB...	–	3,02 *0.1189*	3,02 *0.1189*	3,03 *0.1194*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3.03H7-EB...	–	3,03 *0.1193*	3,03 *0.1193*	3,04 *0.1198*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3.04H7-EB...	–	3,04 *0.1197*	3,04 *0.1197*	3,05 *0.1202*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3.05H7-EB...	–	3,05 *0.1201*	3,05 *0.1201*	3,06 *0.1206*	25,0 *0.9840*	6,0 *0.2360*	45,0 *1.7720*	4	☐	☐	☐	☐	☐	☐
NS06-3.167H7-EB...	–	3,167 *0.1247*	3,18 *0.1252*	3,17 *0.1247*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.175H7-EB...	–	3,175 *0.1250*	3,18 *0.1250*	3,19 *0.1255*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.49H7-EB...	–	3,49 *0.1374*	3,49 *0.1374*	3,50 *0.1379*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.50H7-EB...	–	3,5 *0.1378*	3,50 *0.1378*	3,51 *0.1383*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.51H7-EB...	–	3,51 *0.1382*	3,51 *0.1382*	3,52 *0.1387*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.52H7-EB...	–	3,52 *0.1386*	3,52 *0.1386*	3,53 *0.1391*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.97H7-EB...	–	3,97 *0.1563*	3,97 *0.1563*	3,98 *0.1568*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.98H7-EB...	–	3,98 *0.1567*	3,98 *0.1567*	3,99 *0.1572*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-3.99H7-EB...	–	3,99 *0.1571*	3,99 *0.1571*	4,00 *0.1576*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.00H7-EB...	–	4,0 *0.1575*	4,00 *0.1575*	4,01 *0.1580*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4H7-EB30	10019457	4,0 *0.1575*	4,01 *0.1580*	4,00 *0.1575*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	■	■	☐	☐
NS06-4.01H7-EB...	–	4,01 *0.1579*	4,01 *0.1579*	4,02 *0.1583*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.02H7-EB...	–	4,02 *0.1583*	4,02 *0.1583*	4,03 *0.1587*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐

Bezeichnung	Produkt-nummer	DC	Bohrungs-durchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NS06-4.03H7-EB...	–	4,03 *0.1587*	4,03 *0.1587*	4,04 *0.1591*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.04H7-EB...	–	4,04 *0.1591*	4,04 *0.1591*	4,05 *0.1595*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.05H7-EB...	–	4,05 *0.1594*	4,05 *0.1594*	4,06 *0.1599*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.50H7-EB...	–	4,5 *0.1772*	4,50 *0.1772*	4,51 *0.1776*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.750H7-EB...	–	4,75 *0.1870*	4,75 *0.1870*	4,76 *0.1875*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.750H7-EB30	10019458	4,75 *0.1870*	4,76 *0.1875*	4,75 *0.1870*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	■	■	☐	☐
NS06-4.762H7-EB...	–	4,762 *0.1875*	4,76 *0.1875*	4,77 *0.1880*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.97H7-EB...	–	4,97 *0.1957*	4,97 *0.1957*	4,98 *0.1961*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.98H7-EB...	–	4,98 *0.1961*	4,98 *0.1961*	4,99 *0.1965*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-4.99H7-EB...	–	4,99 *0.1965*	4,99 *0.1965*	5,00 *0.1969*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.00H7-EB...	–	5,0 *0.1969*	5,00 *0.1969*	5,01 *0.1973*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5H7-EB30	10019459	5,0 *0.1969*	5,01 *0.1973*	5,00 *0.1969*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	■	■	☐	☐
NS06-5.01H7-EB...	–	5,01 *0.1972*	5,01 *0.1972*	5,02 *0.1977*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.02H7-EB...	–	5,02 *0.1976*	5,02 *0.1976*	5,03 *0.1981*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.03H7-EB...	–	5,03 *0.1980*	5,03 *0.1980*	5,04 *0.1985*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.04H7-EB...	–	5,04 *0.1984*	5,04 *0.1984*	5,05 *0.1989*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.05H7-EB...	–	5,05 *0.1988*	5,05 *0.1988*	5,06 *0.1993*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.50H7-EB...	–	5,5 *0.2165*	5,50 *0.2165*	5,51 *0.2170*	30,0 *1.1810*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.97H7-EB...	–	5,97 *0.2350*	5,97 *0.2350*	5,98 *0.2355*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.98H7-EB...	–	5,98 *0.2354*	5,98 *0.2354*	5,99 *0.2359*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-5.99H7-EB...	–	5,99 *0.2358*	5,99 *0.2358*	6,00 *0.2363*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-6.00H7-EB...	–	6,0 *0.2362*	6,00 *0.2362*	6,01 *0.2367*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-6H7-EB30	10019460	6,0 *0.2362*	6,01 *0.2367*	6,00 *0.2362*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	■	■	☐	☐
NS06-6.01H7-EB...	–	6,01 *0.2366*	6,01 *0.2366*	6,03 *0.2372*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-6.02H7-EB...	–	6,02 *0.2370*	6,02 *0.2370*	6,04 *0.2376*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-6.03H7-EB...	–	6,03 *0.2374*	6,03 *0.2374*	6,05 *0.2380*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-6.04H7-EB...	–	6,04 *0.2378*	6,04 *0.2378*	6,06 *0.2384*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS06-6.05H7-EB...	–	6,05 *0.2382*	6,05 *0.2382*	6,07 *0.2388*	31,0 *1.2200*	6,0 *0.2360*	50,0 *1.9690*	4	☐	☐	☐	☐	☐	☐
NS10-6.334H7-EB...	–	6,334 *0.2494*	6,33 *0.2494*	6,35 *0.2500*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-6.334H7-EB30	10019461	6,334 *0.2494*	6,35 *0.2500*	6,33 *0.2494*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	☐	☐	■	■	☐	☐

Bezeichnung	Produkt-nummer	DC	Bohrungs-durchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NS10-6.350H7-EB...	–	6,35 *0.2500*	6,35 *0.2500*	6,37 *0.2506*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-6.375H7-EB...	–	6,375 *0.2510*	6,38 *0.2510*	6,39 *0.2516*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-6.3754H7-EB30	10019462	6,375 *0.2510*	6,39 *0.2516*	6,38 *0.2510*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	□	□	■	■	□	□
NS10-6.5H7-EB...	–	6,5 *0.2559*	6,50 *0.2559*	6,52 *0.2565*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-6.97H7-EB...	–	6,97 *0.2744*	6,97 *0.2744*	6,99 *0.2750*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-6.98H7-EB...	–	6,98 *0.2748*	6,98 *0.2748*	7,00 *0.2754*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-6.99H7-EB...	–	6,99 *0.2752*	6,99 *0.2752*	7,01 *0.2758*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.00H7-EB...	–	7,0 *0.2756*	7,00 *0.2756*	7,02 *0.2762*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7H7-EB30	10019463	7,0 *0.2756*	7,02 *0.2762*	7,00 *0.2756*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	□	□	■	■	□	□
NS10-7.01H7-EB...	–	7,01 *0.2760*	7,01 *0.2760*	7,03 *0.2766*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.02H7-EB...	–	7,02 *0.2764*	7,02 *0.2764*	7,04 *0.2770*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.03H7-EB...	–	7,03 *0.2768*	7,03 *0.2768*	7,05 *0.2774*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.04H7-EB...	–	7,04 *0.2772*	7,04 *0.2772*	7,06 *0.2778*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.05H7-EB...	–	7,05 *0.2776*	7,05 *0.2776*	7,07 *0.2781*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.50H7-EB...	–	7,5 *0.2953*	7,50 *0.2953*	7,52 *0.2959*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.9375H7-EB...	–	7,9375 *0.3125*	7,94 *0.3125*	7,95 *0.3131*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.97H7-EB...	–	7,97 *0.3138*	7,97 *0.3138*	7,99 *0.3144*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.98H7-EB...	–	7,98 *0.3142*	7,98 *0.3142*	8,00 *0.3148*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-7.99H7-EB...	–	7,99 *0.3146*	7,99 *0.3146*	8,01 *0.3152*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.00H7-EB...	–	8,0 *0.3150*	8,00 *0.3150*	8,02 *0.3156*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8H7-EB30	10019464	8,0 *0.3150*	8,02 *0.3156*	8,00 *0.3150*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	□	□	■	■	□	□
NS10-8.01H7-EB...	–	8,01 *0.3154*	8,01 *0.3154*	8,03 *0.3159*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.02H7-EB...	–	8,02 *0.3157*	8,02 *0.3157*	8,04 *0.3163*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.03H7-EB...	–	8,03 *0.3161*	8,03 *0.3161*	8,05 *0.3167*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.04H7-EB...	–	8,04 *0.3165*	8,04 *0.3165*	8,06 *0.3171*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.05H7-EB...	–	8,05 *0.3169*	8,05 *0.3169*	8,07 *0.3175*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.50H7-EB...	–	8,5 *0.3346*	8,50 *0.3346*	8,52 *0.3352*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.97H7-EB...	–	8,97 *0.3531*	8,97 *0.3531*	8,99 *0.3537*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.98H7-EB...	–	8,98 *0.3535*	8,98 *0.3535*	9,00 *0.3541*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□
NS10-8.99H7-EB...	–	8,99 *0.3539*	8,99 *0.3539*	9,01 *0.3545*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	□	□	□	□	□	□

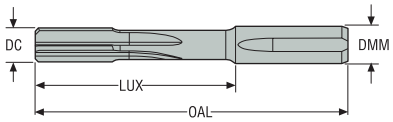
Bezeichnung	Produkt-nummer	DC	Bohrungs-durchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NS10-9.00H7-EB...	–	9,0 *0.3543*	9,00 *0.3543*	9,02 *0.3549*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9H7-EB30	10019465	9,0 *0.3543*	9,02 *0.3549*	9,00 *0.3543*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	☐	☐	■	■	☐	☐
NS10-9.01H7-EB...	–	9,01 *0.3547*	9,01 *0.3547*	9,03 *0.3553*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.02H7-EB...	–	9,02 *0.3551*	9,02 *0.3551*	9,04 *0.3557*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.03H7-EB...	–	9,03 *0.3555*	9,03 *0.3555*	9,05 *0.3561*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.04H7-EB...	–	9,04 *0.3559*	9,04 *0.3559*	9,06 *0.3565*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.05H7-EB...	–	9,05 *0.3563*	9,05 *0.3563*	9,07 *0.3569*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.50H7-EB...	–	9,5 *0.3740*	9,50 *0.3740*	9,52 *0.3746*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.5123H7-EB...	–	9,5123 *0.3745*	9,51 *0.3745*	9,53 *0.3751*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.5250H7-EB...	–	9,525 *0.3750*	9,53 *0.3750*	9,54 *0.3756*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.525H7-EB30	10019466	9,525 *0.3750*	9,54 *0.3756*	9,53 *0.3750*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	☐	☐	■	■	☐	☐
NS10-9.97H7-EB...	–	9,97 *0.3925*	9,97 *0.3925*	9,99 *0.3931*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.98H7-EB...	–	9,98 *0.3929*	9,98 *0.3929*	10,00 *0.3935*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-9.99H7-EB...	–	9,99 *0.3933*	9,99 *0.3933*	10,01 *0.3939*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10.00H7-EB...	–	10,0 *0.3937*	10,00 *0.3937*	10,02 *0.3943*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10H7-EB30	10019467	10,0 *0.3937*	10,02 *0.3943*	10,00 *0.3937*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	4	☐	☐	■	■	☐	☐
NS10-10.01H7-EB...	–	10,01 *0.3941*	10,01 *0.3941*	10,03 *0.3948*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10.02H7-EB...	–	10,02 *0.3945*	10,02 *0.3945*	10,04 *0.3952*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10.03H7-EB...	–	10,03 *0.3949*	10,03 *0.3949*	10,05 *0.3956*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10.04H7-EB...	–	10,04 *0.3953*	10,04 *0.3953*	10,06 *0.3960*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10.05H7-EB...	–	10,05 *0.3957*	10,05 *0.3957*	10,07 *0.3964*	46,0 *1.8110*	10,0 *0.3940*	78,0 *3.0710*	6	☐	☐	☐	☐	☐	☐
NS10-10.50H7-EB...	–	10,5 *0.4134*	10,50 *0.4134*	10,52 *0.4141*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-10.97H7-EB...	–	10,97 *0.4319*	10,97 *0.4319*	10,99 *0.4326*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-10.98H7-EB...	–	10,98 *0.4323*	10,98 *0.4323*	11,00 *0.4330*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-10.99H7-EB...	–	10,99 *0.4327*	10,99 *0.4327*	11,01 *0.4334*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.00H7-EB...	–	11,0 *0.4331*	11,00 *0.4331*	11,02 *0.4338*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.01H7-EB...	–	11,01 *0.4335*	11,01 *0.4335*	11,03 *0.4342*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.02H7-EB...	–	11,02 *0.4339*	11,02 *0.4339*	11,04 *0.4346*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.03H7-EB...	–	11,03 *0.4343*	11,03 *0.4343*	11,05 *0.4350*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.04H7-EB...	–	11,04 *0.4346*	11,04 *0.4346*	11,06 *0.4354*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐

Bezeichnung	Produkt-nummer	DC	Bohrungs-durchmesser min-max		LUX	DMM	OAL		Geometrie			Sorten		
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*		EB45	EB845	EB30	RX2000	RK2050	H15
NS10-11.05H7-EB...	–	11,05 *0.4350*	11,05 *0.4350*	11,07 *0.4357*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.112H7-EB...	–	11,112 *0.4375*	11,11 *0.4375*	11,13 *0.4382*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.50H7-EB...	–	11,5 *0.4528*	11,50 *0.4528*	11,52 *0.4535*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.97H7-EB...	–	11,97 *0.4713*	11,97 *0.4713*	11,99 *0.4720*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.98H7-EB...	–	11,98 *0.4717*	11,98 *0.4717*	12,00 *0.4724*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-11.99H7-EB...	–	11,99 *0.4720*	11,99 *0.4720*	12,01 *0.4728*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-12.00H7-EB...	–	12,0 *0.4724*	12,00 *0.4724*	12,02 *0.4731*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-12H7-EB30	10019468	12,0 *0.4724*	12,02 *0.4731*	12,00 *0.4724*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	4	☐	☐	■	■	☐	☐
NS10-12.01H7-EB...	–	12,01 *0.4728*	12,01 *0.4728*	12,03 *0.4735*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-12.02H7-EB...	–	12,02 *0.4732*	12,02 *0.4732*	12,04 *0.4739*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-12.03H7-EB...	–	12,03 *0.4736*	12,03 *0.4736*	12,05 *0.4743*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-12.04H7-EB...	–	12,04 *0.4740*	12,04 *0.4740*	12,06 *0.4747*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐
NS10-12.05H7-EB...	–	12,05 *0.4744*	12,05 *0.4744*	12,07 *0.4751*	57,0 *2.2440*	10,0 *0.3940*	88,0 *3.4650*	6	☐	☐	☐	☐	☐	☐

■ **Lagerstandard.** ☐ **Kein Lagerstandard.**
Hinweis: Geben Sie bei Bestellung von Nanofix-Reibahlen in Zwischendurchmessern immer Durchmesser und Toleranz der zu bearbeitenden Bohrung an.
Bestell-Beispiel: NF10-10,187/10,213-EB845, RX2000.

Zwischendurchmesser

Gerade Schneide, kurze Version





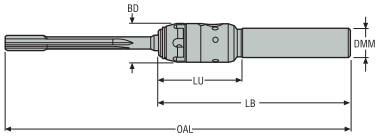
- Schnittdaten, siehe Seite(n) 391-396
- Anschnittgeometrie siehe Seite(n) 373-375

Bezeichnung	DCN	DCX	LUX	DMM	OAL		Körpergröße	Geometrie	Sorten						
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
NS06-2.970-XX-XXXX	2,97 *0.117*	3,05 *0.120*	25,0 *0.984*	6,0 *0.236*	45,0 *1.772*	4	NFQF06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NS06-3.051-XX-XXXX	3,051 *0.120*	6,05 *0.238*	30,0 *1.181*	6,0 *0.236*	50,0 *1.969*	4	NFQF06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NS10-6.051-XX-XXXX	6,051 *0.238*	10,05 *0.396*	46,0 *1.811*	10,0 *0.394*	78,0 *3.071*	6	NFQF10-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐
NS10-10.051-XX-XXXX	10,051 *0.396*	12,05 *0.474*	57,0 *2.244*	10,0 *0.394*	88,0 *3.465*	6	NFQF10-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐

☐ **Kein Lagerstandard. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.**
Hinweis: Bei Bestellungen von Nanofix-Reibahlen in Zwischendurchmessern Durchmesser und Toleranz der zu bearbeitenden Bohrung angeben.
Bestell-Beispiel: NS10-10,187/10,213-EB845, RS2090.

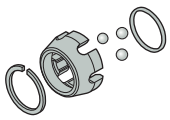
Nanofix-Aufnahme





Produktnummer	Bezeichnung	DC	DMM	BD	LU	LBN
		mm	mm	mm	mm	mm
02729036	NFQF06-03700-10N1	2,97-6,05	10,0	16,0	37,0	–
02729037	NFQF06-03300-12N1	2,97-6,05	12,0	16,0	35,0	–
02729041	NFQF06-03000-16N1	2,97-6,05	16,0	16,0	30,0	–
02729044	NFQF10-05200-12N1	6,051-12,05	12,0	23,0	52,0	–
02729045	NFQF10-04900-16N1	6,051-12,05	16,0	23,0	49,0	–
02729046	NFQF10-04700-20N1	6,051-12,05	20,0	23,0	47,0	–

Ersatzteile

DC	Ersatz Klemmset	Schlüssel
		
2,97-6,050	NF06-CLKI	CLC06KEY
6,051-12,050	NF10-CLKI	CLC10KEY

Das Ersatz-Klemmset für Nanofix-Aufnahmen beinhaltet:
- 1 Klemmmutter
- 1 axialer Anschlagfederring
- 3 Anlagekugeln (Durchmesser 3,5 mm für Größe NF06 & Durchmesser 5 mm für Größe NF10)
- 1 Indexierkugel (Durchmesser 3 mm für Größe NF06 & Durchmesser 4 mm für Größe NF10)
- 1 O-Ring

Beachten Sie, dass die Indexierkugel hier nicht abgebildet ist.

Schnittdaten – NF/NS...-EB45 Metrisch

SMG		a_p (Durchmesser)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RN2010	RM2020	RM2090	RS2090
P1	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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)	–	–	–	–
K2	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	25 (20-40)	40 (30-70)	–	–	–	–
K3	NF/NS-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)	–	–	–	–
K4	NF/NS-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)	–	–	–	–
K5	NF/NS-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)	–	–	–	–
K6	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	60 (40-100)	80 (30-150)	–	–	–	–
K7	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	60 (40-100)	80 (30-150)	–	–	–	–
N1	NF/NS-EB45	0,10-20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	–	–	–
N2	NF/NS-EB45	0,10-20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	–	–	–
N3	NF/NS-EB45	0,10-20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	–	–	–
N4	NF/NS-EB45	0,10-20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	–	–	–
S1	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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)

Fortsetzung der Tabelle auf der folgenden Seite.

Schnittdaten – NF/NS...-EB45 Metrisch

SMG		a_p (Durchmesser)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
H3	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H5	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H7	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H8	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H11	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H12	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H21	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
H31	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	–	–	–	–
PM1	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM2	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM3	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
TS1	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TS2	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TS3	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TS4	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TP1	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TP2	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TP3	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
TP4	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	–	–	–	–
GR1	NF/NS-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 Richtwerte.

Schnittdaten – NF/NS...-EB45 *Zoll*

SMG		a_p (Durchmesser)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RN2010	RM2020	RM2090	RS2090
P1	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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)	–	–	–	–
K2	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	80 (65-130)	130 (100-230)	–	–	–	–
K3	NF/NS-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)	–	–	–	–
K4	NF/NS-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)	–	–	–	–
K5	NF/NS-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)	–	–	–	–
K6	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	195 (130-330)	260 (100-490)	–	–	–	–
K7	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	195 (130-330)	260 (100-490)	–	–	–	–
N1	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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)

Fortsetzung der Tabelle auf der folgenden Seite.

Schnittdaten – NF/NS...-EB45 *Zoll*

SMG		a_p (Durchmesser)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RN2010	RM2020	RM2090	RS2090
H3	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H5	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H7	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H8	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H11	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H12	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H21	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
H31	*NF/NS-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–
PM1	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–
PM2	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–
PM3	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–
TS1	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TS2	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TS3	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TS4	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TP1	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TP2	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TP3	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
TP4	*NF/NS-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–
GR1	*NF/NS-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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – NF/NS...-EB845 Metrisch

SMG		a_p (Durchmesser)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,30	0,20 -0,60	–	60 (30-100)	80 (30-150)	–	–	–	-
P4	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	60 (30-120)	–	–	–	-
P5	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H5	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H7	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H8	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H11	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H12	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H21	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
H31	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	-
PM1	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	-
PM2	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	-
PM3	NF/NS-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 Richtwerte.

Schnittdaten – NF/NS...-EB845 *Zoll*

SMG		a_p (Durchmesser)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.012	0.008 -0.024	–	195 (100-330)	260 (100-490)	–	–	–	-
P4	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	–	165 (100-260)	195 (100-395)	–	–	–	-
P5	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H5	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H7	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H8	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H11	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H12	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H21	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
H31	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	–	–	35 (25-50)	–	–	–	-
PM1	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	–	165 (100-260)	230 (130-350)	–	–	–	-
PM2	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	–	165 (100-260)	230 (130-350)	–	–	–	-
PM3	NF/NS-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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – NF/NS...-EB25/EB30 Metrisch

SMG		a_p (Durchmesser)		f		v_c			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-EB25/EB30	0,08-0,15	0,10-0,15	0,3-0,7	0,5-1	–	25 (15-40)	35 (20-60)	–
K1	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-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	NF/NS-EB25/EB30	0,10-20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N2	NF/NS-EB25/EB30	0,10-20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N3	NF/NS-EB25/EB30	0,10-20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N11	NF/NS-EB25/EB30	0,10-20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
PM1	NF/NS-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	NF/NS-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	NF/NS-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 Richtwerte.

Schnittdaten – EB25/EB30 *Zoll*

SMG		a_p (Durchmesser)		f		v_c			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-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	*NF/NS-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N2	*NF/NS-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N3	*NF/NS-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N11	*NF/NS-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
PM1	*NF/NS-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	*NF/NS-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	*NF/NS-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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

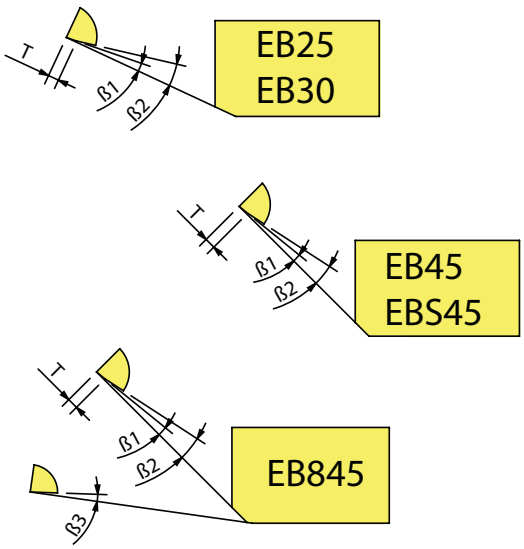
Hinweise zum Nachschleifen

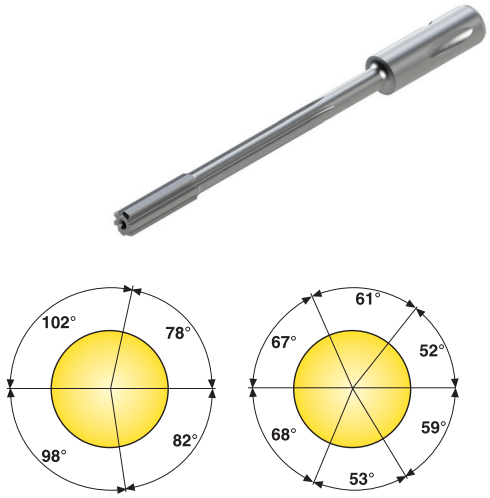
Einzelheiten

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)*.





Durchmesser Nanofix mm *(Zoll)*	β_1	β_2	β_3	T (mm) *(Zoll)*
2,97-9,999 *(0.1169-0.3936)*	8°	25°	10°	0,15 *(0.006)*
10,12–12,050 *(0.3937-0.4744)*	8°	25°	10°	0,15 *(0.006)*



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 Mikrozoll).
- Mit zwei Schneidkanten pro Wendeplatte.
- Drei Cermet-Führungsleisten und ein präzises Einstellsystem.

Programmübersicht

	Durchmesserbereich	Reibtiefe	Toleranz Bohrdurchmesser	Zwischendurchmesser	Oberflächengüte
SR80 Für Durchgangsbohrungen 	6,875-60,500 mm *(0.2707-2.3819")*	5-7 x D	IT 6	Ja, verfügbar über Custom Design	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, verfügbar über Custom Design	R_a 0,2-0,8 µm *(R_a 8-31 µin)*
SR82 Für Grundlochbohrungen kurze Version 	7,875-60,500 mm *(0.3100-2.3819")*	3-5 x D	IT 6-7	Ja, verfügbar über Custom Design	R_a 0,2-0,8 µm *(R_a 8-31 µin)*

Code-Schlüssel

Reibahlen

Reibahlen-Typ
Typ 80: Durchgangsbohrung
Typ SR81: Grundlochbohrung
Typ SR82: Grundlochbohrung, kurze Ausführung



Reibahlen-Typ
Typ 80: Durchgangsbohrung
Typ SR81: Grundlochbohrung
Typ SR82: Grundlochbohrung, kurze Ausführung

Bohrungsdurchmesser und Toleranz

Anschnittgeometrie: EN1, EN2, EN3

SR80 - 16,85 P6 - EN1 - R - 9

0.6624”-0.6628”

Schafttyp: (angeben, wenn abweichend von Standard)
SR80 und SR81: R1 vollzylindrischer Schaft
SR82: R9 zylindrischer Schaft mit Spannfläche

Wendeplatten

Wichtig:
Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.

WSP-Größe
P0, P1, P2, P4

Spanwinkel:
0°, 6°, 12°

P2 - EN1 - 06 - CP20

Anschnittgeometrie:
EN1, EN2, EN3

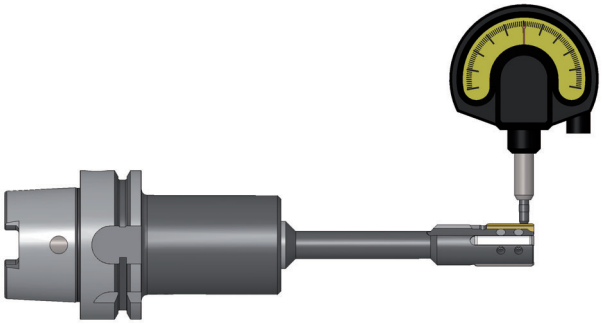
Hartmetallsorte:
CP20, H15

Aufspannung und technische Informationen

Rotierendes Werkzeug

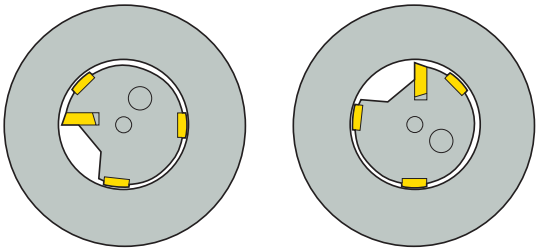
Die empfohlene maximale Rundlaufabweichung beträgt 0,02 mm *(0.0008")*.
Präzisionsaufnahmen werden empfohlen: Hydrodehnspannfutter, Präzisionsspannzange Typ 5672 oder Schrumpffutter.

Statischer Einsatz
Pendelhalter verwenden, siehe Seite 480-484.



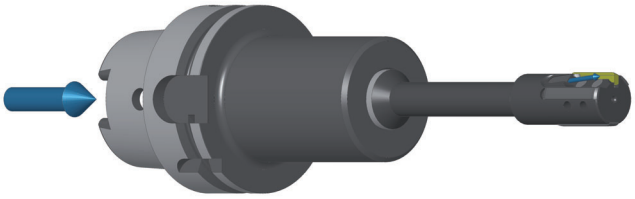
Optimale Späneabfuhr

Die Schneidenausrichtung für den statischen Einsatz wird gemäß der Zeichnung empfohlen (Vorderansicht Werkzeuge).



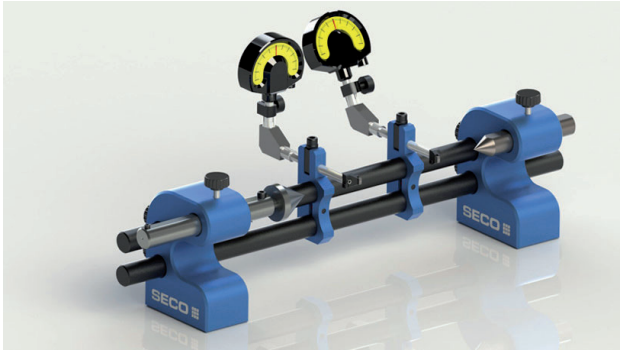
Kühlschmierstoffzufuhr

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 Werkzeug-durchmesser
Beispiel: Reibahle Durchmesser 10, Mindestvolumen beträgt 5 l/min *(1.3 gal/min)*.



Einstellgerät

SF-60200-C160C190: Produktnummer 02885396
- Horizontales Gestell
- Erste Wahl für Durchmesser kleiner als 60 mm *(2.362")*
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 60,5 mm *(2.382")*
- Maximale Werkzeuglänge: 200 mm *(7.784")*



Auswahl der Geometrie – Schneidenhalter

Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.

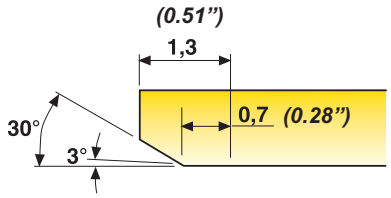
Schneidstoffe und Spanwinkel
Den zu bearbeitenden Werkstoff anhand der Seco Werkstoff-Gruppen auf Seite 666-672 klassifizieren.

Die Schnittdatenempfehlungen entnehmen Sie den Tabellen auf Seite 413-415, um Schneidstoffe und Spanwinkel zu wählen.

Das Wendeschneidplatten-Programm finden Sie auf Seite(n) 411- 412

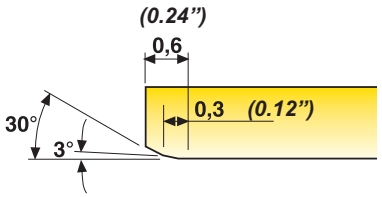
EN1 – Allgemein

Maximales Aufmaß Durchmesser 0,5 mm *(0.020")*
Gute Oberflächengüte R_a 0,3 - 0,8 µm
(Gute Oberflächengüte R_a 12 - 31 µin)



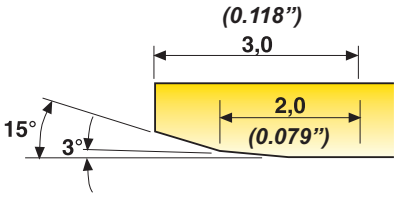
EN2 – Kurzer Anschnitt

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

WSP-Größe	Stahl	Rostfrei	Guss	NE-Metalle	Aluminium	Verschleißfester ⟷ Zäher			Bezeichnung	
						Produktivität	Vielseitigkeit	Sicherheit	Wendeschneidplatte	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

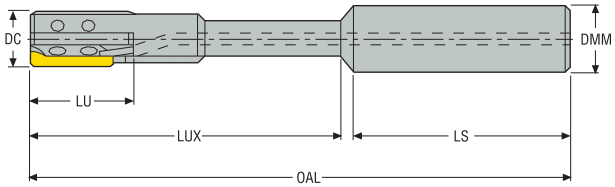
Sorten

	**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, vollzylindrisch, SR80





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Interne Kühlschmierstoffzufuhr

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

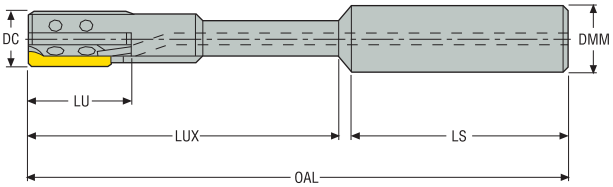
Im Lieferumfang enthaltene Ersatzteile

Für Durchmesser (mm)	Einstell-schraube	Pratze	Klemmschraube	Schlüssel	Anlagekugel	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

*Drehmomentschlüssel wird mit Klinge geliefert.

Für Durchgangsbohrungen ∅ 27H6–60H6

Schafttyp R1, vollzylindrisch, SR80





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Interne Kühlschmierstoffzufuhr

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

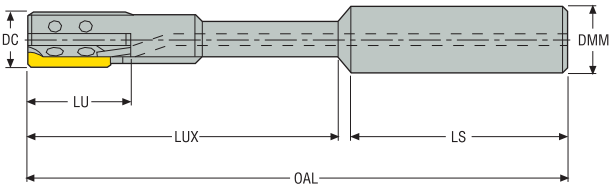
Im Lieferumfang enthaltene Ersatzteile

Für Durchmesser (mm)	Einstell-schraube	Pratze	Klemmschraube	Schlüssel	Anlagekugel	Drehmomentschlüssel*	Drehmoment
							
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Für Durchgangsbohrungen – Zwischendurchmesser

Schafttyp R1, vollzylindrisch, SR80





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Achtung! Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.
- Auswahl der Anschnittgeometrie EN1, EN2 oder EN3 auf Seite 402

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	P3-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

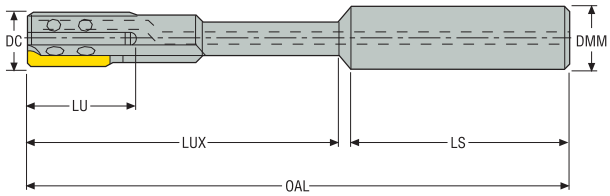
Zubehör

Für Durchmesser (mm)	Einstellschraube	Pratze	Schraube für Pratze	Einstellschlüssel	Stützkugel	Drehmomentschlüssel
						
6,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–
8,750-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305
9,750-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,750-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.0	H00-1509
19,500-60,500	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020

*Drehmomentschlüssel wird mit Klinge geliefert.
Achtung! Bei Bestellung von Zwischendurchmessern unbedingt angeben: Durchmesser sowie Toleranz der Bohrung und Anschnittgeometrie (EN1, EN2 oder EN3).
Bestell-Beispiel: SR80-11.50 H7-EN2, P1-EN2-06, CP20.

Für Grundlochbohrungen ∅ 8H6-26H6

Schafttyp R1, vollzylindrisch, SR81





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Interne Kühlschmierstoffzufuhr

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

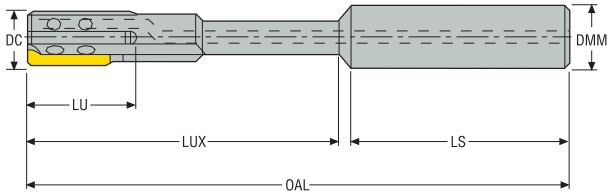
Im Lieferumfang enthaltene Ersatzteile

Für Durchmesser (mm)	Einstellschraube	Pratze	Klemmschraube	Schlüssel	Anlagekugel	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

Für Grundlochbohrungen ∅ 27H6–60H6

Schafttyp R1, vollzylindrisch, SR81





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Interne Kühlschmierstoffzufuhr

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

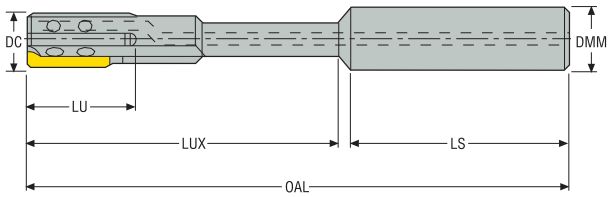
Im Lieferumfang enthaltene Ersatzteile

Für Durchmesser (mm)	Einstellschraube	Pratze	Klemmschraube	Schlüssel	Anlagekugel	Drehmomentschlüssel*	Drehmoment
							
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

*Drehmomentschlüssel wird mit Klinge geliefert.

Für Grundlochbohrungen – Zwischendurchmesser

Schafttyp R1, vollzylindrisch, SR81





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Achtung! Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.
- Auswahl der Anschnittgeometrie EN1, EN2 oder EN3 auf Seite 402

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

Zubehör

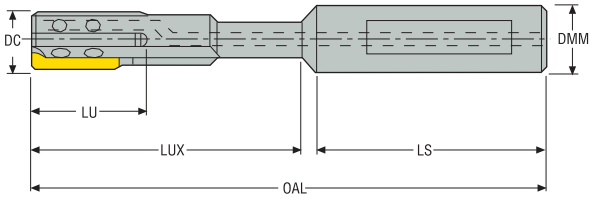
Für Durchmesser (mm)	Einstellschraube	Pratze	Schraube für Pratze	Einstellschlüssel	Stützkugel	Drehmomentschlüssel
						
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305

*Drehmomentschlüssel wird mit Klinge geliefert.
Achtung! Bei Bestellung von Zwischendurchmessern unbedingt angeben: Durchmesser sowie Toleranz der Bohrung und Anschnittgeometrie (EN1, EN2 oder EN3).
Bestell-Beispiel: SR81-11.50 H7-EN2, P1-EN2-06, CP20.

Für Grundlochbohrungen – Kurze Ausführung für Drehmaschinen

Schafttyp R9, zylindrisch mit Abflachung, SR82





- Auswahl der Wendeschneidplatten, siehe Seite(n) 411, 412
- Achtung! Reibahle und Wendeschneidplatte müssen die gleiche Anschnittgeometrie haben.
- Auswahl der Anschnittgeometrie EN1, EN2 oder EN3 auf Seite 402

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

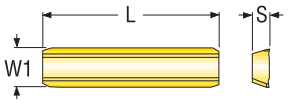
Ersatzteile

Zubehör

Für Durchmesser (mm)	Einstellschraube	Pratze	Schraube für Pratze	Einstellschlüssel	Stützkugel	Drehmomentschlüssel
						
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305

*Drehmomentschlüssel wird mit Klinge geliefert.
Achtung! Bei Bestellung von Zwischendurchmessern unbedingt angeben: Durchmesser sowie Toleranz der Bohrung und Anschnittgeometrie (EN1, EN2 oder EN3).
Bestell-Beispiel: SR82-11.50 H7EN2, P1-EN2-06, CP20.

P0-P4 Schneide



Bezeichnung	WSP	L	S	W1	Sorten	
		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

Bezeichnung	WSP	L	S	W1	Sorten	
		mm *Zoll*	mm *Zoll*	mm *Zoll*	H15	CP20
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
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 (Durchmesser)		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 Richtwerte.

Schnittdaten – Pxx-EN1/EN2-00 *Zoll*

SMG		a_p (Durchmesser)		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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – Pxx-EN1/EN2-06 Metrisch

SMG		a_p (Durchmesser)		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 Richtwerte.

Schnittdaten – Pxx-EN1/EN2-06 *Zoll*

SMG		a_p (Durchmesser)		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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – Pxx-EN1/EN2-12 Metrisch

SMG		a_p (Durchmesser)		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 Richtwerte.

Schnittdaten – Pxx-EN1/EN2-12 *Zoll*

SMG		a_p (Durchmesser)		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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – Pxx-EN3-00 Metrisch

SMG		a_p (Durchmesser)		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 Richtwerte.

Schnittdaten – Pxx-EN3-00 *Zoll*

SMG		a_p (Durchmesser)		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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – Pxx-EN3-06 Metrisch

SMG		a_p (Durchmesser)		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 Richtwerte.

Schnittdaten – Pxx-E3-06 *Zoll*

SMG		a_p (Durchmesser)		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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – Pxx-EN3-12 Metrisch

SMG		a_p (Durchmesser)		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 Richtwerte.

Schnittdaten – Pxx-EN3-12 *Zoll*

SMG		a_p (Durchmesser)		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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Einstellhinweise

1.		Die beiden Einstellschrauben (7) mit einer 1/4 Drehung gegen den Uhrzeigersinn lösen.
2.		Die zwei Klemmschrauben (5) lösen.
3.		Plattensitz und Wendeschneidplatte gründlich reinigen. Platte wenden oder eine neue einsetzen.
4.		Die Wendeschneidplatte fest gegen den Axialanschlag und die Anlagekugeln drücken.
5.		Klemmschrauben sorgfältig festziehen. Klemmschraube fest spannen, dabei den Schlüssel am kurzen Ende halten.
6.		Die Messuhr auf der unteren Führungsleiste auf Null stellen.

Einstellhinweise

7.



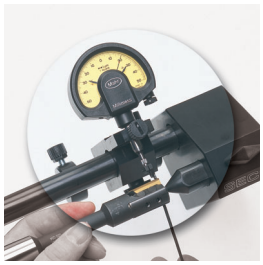
Die Wendeschneidplatte so einstellen, dass eine Verjüngung von 0,01 mm/10 mm *(0.0004"/0.394")* Schneidenlänge erreicht wird (Abb. 2, Messuhr B).

8.



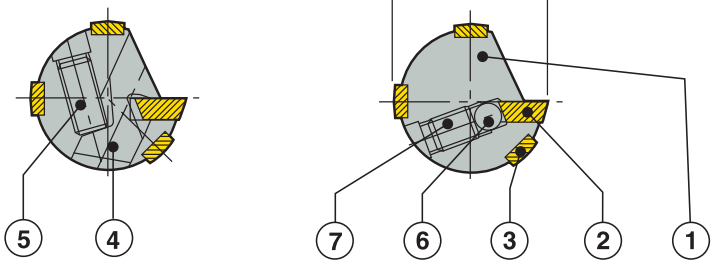
Führungsleiste mit Messuhr abnullen.

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.



Hinweis: Wenn die geforderten Durchmesser während der Einstellung überschritten werden, noch einmal von neuem beginnen, um das Spiel der Einstellschrauben zu eliminieren.

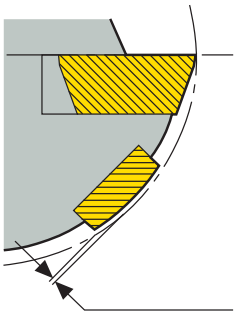


Abb. 1

0,015 mm (∅ ≤ 10 mm)
0,020 mm (∅ >10 mm)
Uhr A zur Durchmesser-einstellung

0,0006" (∅ ≤ 0.394")
0,0008" (∅ > 0.394")
Uhr A zur Durchmesser-einstellung

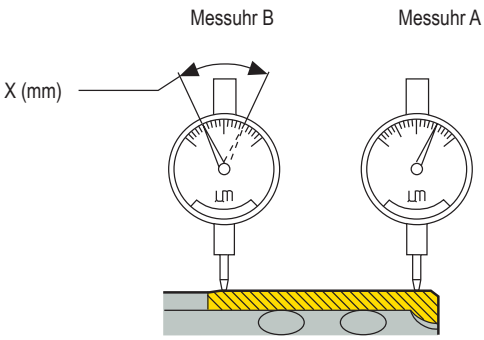


Abb. 2

- 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")*.

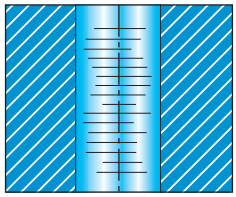
Einstelltabelle

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

Herausforderungen

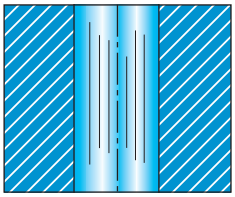
Geringe Oberflächengüte

- Aufmaß prüfen.
- Kühlung verbessern (Anschluss, Druck, Qualität).
- Vorschub reduzieren.
- Eine andere Anschnittgeometrie wählen (Wendeschneidplatte/Reibahle).
- Axiale Lage der Wendeschneidplatte prüfen.



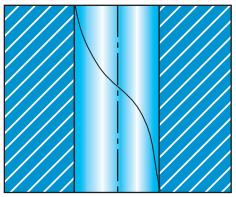
Rattermarken

- Konzentrizität prüfen (Werkstück/Werkzeug)
- Verjüngung vergrößern.



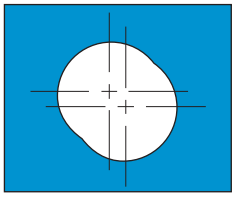
Rückzugsriefen

- Kühlung verbessern (Anschluss, Druck, Qualität).
- Konzentrizität prüfen (Werkstück/Werkzeug).
- Verjüngung vergrößern.



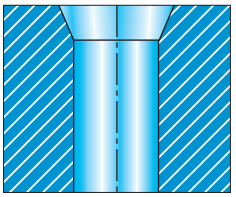
Exzentrische Bohrung

- Werkstückklemmung prüfen.
- Aufmaß prüfen.
- Konzentrizität prüfen (Werkstück/Werkzeug).
- Axiale Lage der Wendeschneidplatte prüfen.



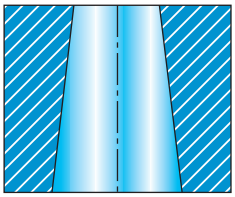
Konischer Eintritt

- Vorschub reduzieren.
- Konzentrizität prüfen (Werkstück/Werkzeug).
- Verjüngung prüfen.
- Rundlauf des Werkzeuges prüfen.



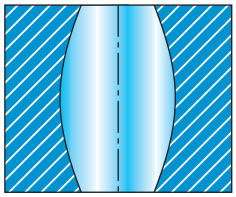
Konische Bohrung

- Konzentrizität prüfen (Werkstück/Werkzeug).
- Verjüngung prüfen.



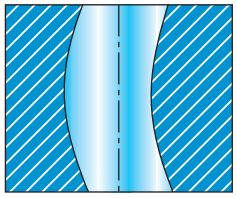
Deformierte Bohrung

- Werkstückklemmung prüfen.



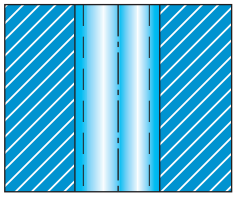
Verlaufende Bohrung

- Eine andere Anschnittgeometrie wählen (Wendeschneidplatte/Reibahle).
- Axiale Lage der Wendeschneidplatte prüfen.



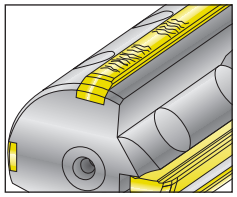
Durchmesser zu groß

- Konzentrizität prüfen (Werkstück/Werkzeug).
- Durchmesser prüfen.



Aufbau auf Führungsleiste

- Kühlung verbessern (Anschluss, Druck, Qualität).
- Reibahle neu einstellen.





Xfix™

Die Mehrzahn-Reibahlen Xfix™ für große Durchmesser bieten 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 Einstellschraube pro Zahn für den Durchmesser.
- Präzises Einstellsystem für enge Toleranzen zwischen 16 und 25 µm (.0006 - .0010”).
- Die Wendeschneidplatten sind entweder 4- oder 8-schneidig.

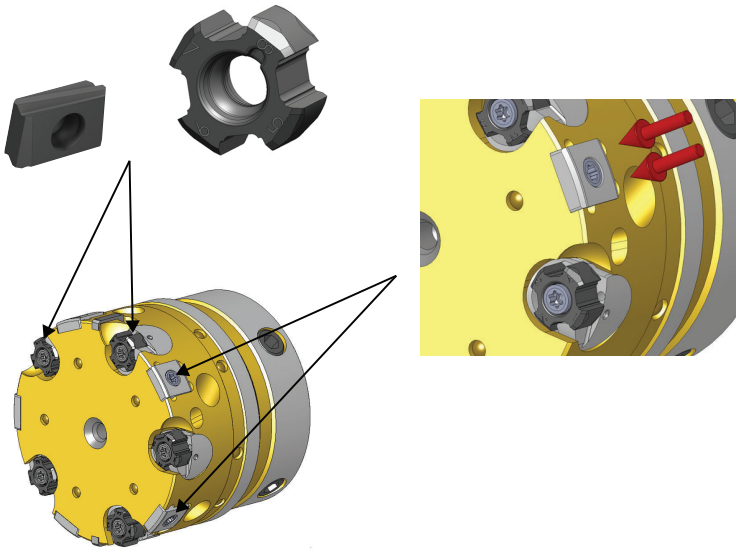
Programmübersicht

	Durchmesserbereich	Reibtiefe	Toleranz Bohrdurchmesser	Zwischendurchmesser	Oberflächengüte
Xfix™ 	39,500-154,500 mm *(1.5551-6.0827")*	2,5-6,5 x D	IT 6	Ja, verfügbar über Custom Design	R_a 0,8-1,2 µm *(R_a 31-47 µin)*

Das Xfix-Reibahlenprogramm von Seco wurde speziell für die Bearbeitung großer Durchmesser von 39,5 bis 154,5 mm *(1.555" – 6.083")* entwickelt. Zum Programm gehören Wendeschneidplatten für besonders enge Toleranzen (IT6) sowie ein integrierter Rundlaufadapter, der eine hohe Werkstückqualität sicherstellt.
Das patentierte System vorgespannter Führungsleisten gewährleistet einen stabilen Zerspanungsprozess sowie eine zuverlässige Standzeit.

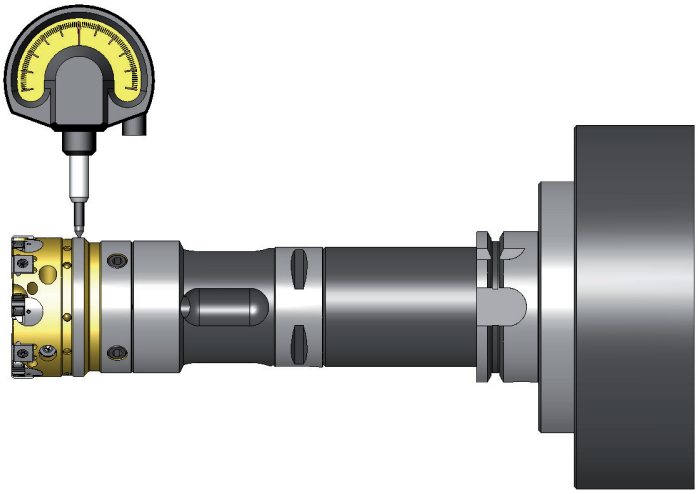
Merkmale – Details

- 4 oder 8 wirtschaftliche Schneidkanten
- Stabiles Klemmsystem
- Einfache Einstellung mit nur einer Einstellschraube
- Verschiedene Sorten und Geometrien für unterschiedliche Anwendungen

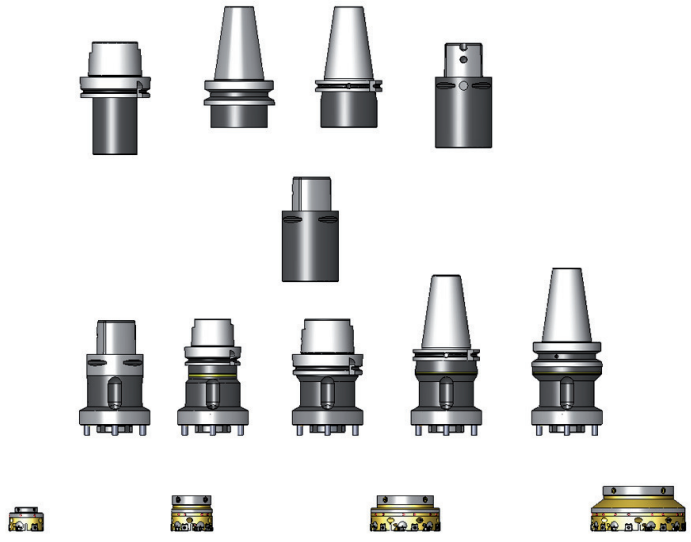


- Patentierte vorgespannte Führungsleisten für hohe Anwendungssicherheit
- Kühlung auf die Führungsleisten für mehr Leistung und Sicherheit

- Perfekte Rundlaufkontrolle durch integrierten einstellbaren Adapter



- Umfangreiches Programm an Aufnahmen und Verlängerungen
- Weitere Informationen zum modularen System finden Sie im Katalog Werkzeug-Systeme



Code-Schlüssel

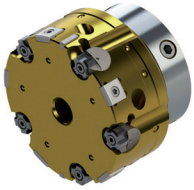
Adapter

Flanschgröße		Länge		Schafttyp
HF55	-	088	-	C5



Standardköpfe

Schneidkopftyp		Durchmesser und Toleranz		Zähnezahl		Flanschgröße D
HF85	-	60H6	-	05	-	55



Zwischenelemente Köpfe

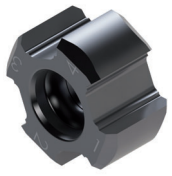
Schneidkopftyp		Durchmesser und Toleranz		Zähnezahl		Flanschgröße D
HF85	-	65,2G7	-	05	-	55

Informationen zum Reibkopf:

- HF85, Durchgangsbohrung, kurz spanende Werkstoffe
- HF85B, Grundlochbohrung, kurz spanende Werkstoffe
- HF86, Durchgangsbohrung, alle Werkstoffe
- HF86B, Grundlochbohrung, alle Werkstoffe

Wendeschneidplatten

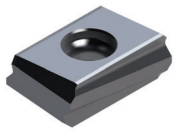
WSP-Größe		Anschnittgeometrie		Spanwinkel		Sorte
RNAX1005	-	EB45	-	03	-	RX2000



RNAX-Wendeschneidplatten für HF85 und HF 85B Xfix-Köpfe

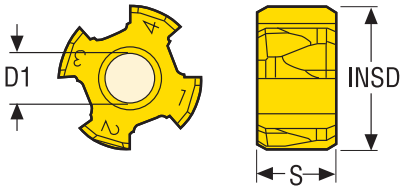
Wendeschneidplatten

WSP-Größe		Anschnittgeometrie		Spanwinkel		Sorte
LNEG	-	EB45	-	06	-	RX2000



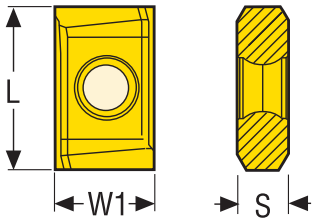
LNEG-Wendeschneidplatten für HF86 und HF86B Xfix-Köpfe

RNAX



Bezeichnung	Wendeschneidplatten	INSD	S	D1	Sorten		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	3,0 °
RNAX1005-EB45-03	RNAX	10,0 *0.394*	5,5 *0.217*	3,5 *0.138*	02687600	02688608	3,0 °
RNAX1005-EB845-03	RNAX	10,0 *0.394*	5,5 *0.217*	3,5 *0.138*	02687593	02688606	3,0 °

LNEG

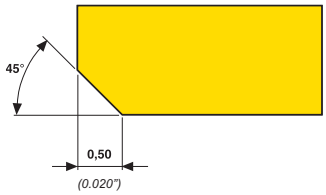


Bezeichnung	Wendeschneidplatten	L	S	W1	Sorten			Spanwinkel
		mm *Zoll*	mm *Zoll*	mm *Zoll*	RX1500	RX2000	CF	
LNEG1003-EB45-03	LNEG	10,0 *0.394*	3,5 *0.138*	6,35 *0.250*		02781311		3,0 °
LNEG1003-EB45-06	LNEG	10,0 *0.394*	3,5 *0.138*	6,35 *0.250*	02904277	02781313	02904276	6,0 °
LNEG1003-EB845-03	LNEG	10,0 *0.394*	3,5 *0.138*	6,35 *0.250*		02781314		3,0 °
LNEG1003-EB845-06	LNEG	10,0 *0.394*	3,5 *0.138*	6,35 *0.250*		02781315		6,0 °

Anschnittgeometrie

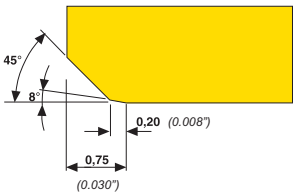
Anschnittgeometrie EB45 – Anwendung

Hervorragende Spankontrolle
Gute Oberflächengüte R_a 1,2- 2 µm
(Gute Oberflächengüte R_a 0,047- 0,0787 µin)
Erste Wahl Geometrie



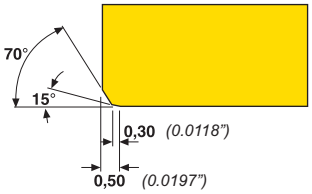
Anschnittgeometrie EB845 – Anwendung

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

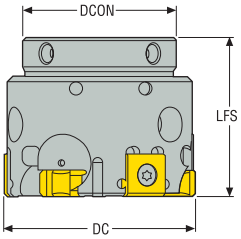


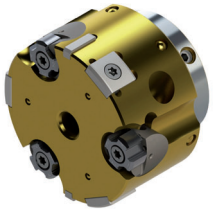
Sorten

Sorten		
	**RX1500**	**Cermet beschichtet** 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

Schneidköpfe für RNAX Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 39,5-59,499 mm / *1.555-2.342”*

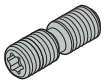




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85 03-32	SH4075S	CARTCYHF16	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

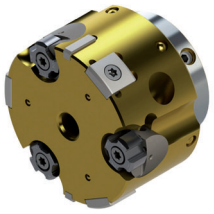
Zubehör

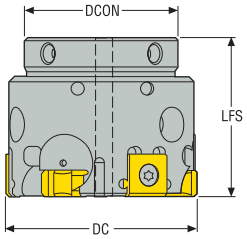
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85 03-32	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Schneidköpfe für RNAX Wendeschneidplatten, Grundlochbohrung mit Durchmesser 39,5-59,499 mm / *1.555-2.342”*

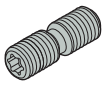




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85B 03-32	SH4075S	CARTCYHF16B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

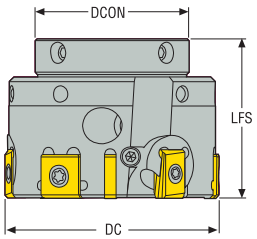
Zubehör

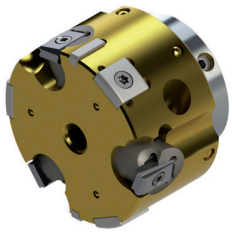
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85B 03-32	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Schneidköpfe für LNEG Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 39,5-59,499 mm / *1.555-2.342”*

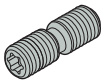




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86 03-32	SH4075S	CARTCYLN16	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

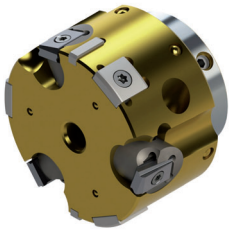
Zubehör

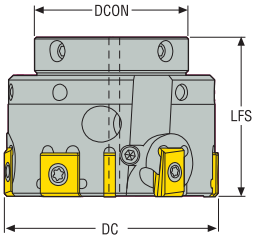
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86 03-32	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Schneidköpfe für LNEG Wendeschneidplatten, Grundlochbohrung mit Durchmesser 39,5-59,499 mm / *1.555-2.342”*

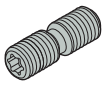




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86B 03-32	SH4075S	CARTCYLN16B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

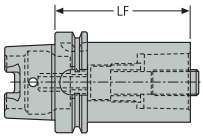
Zubehör

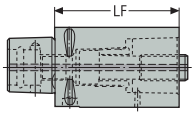
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86B 03-32	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

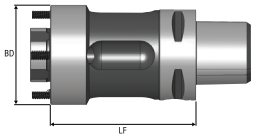
HF32

Seco-Capto™ Aufnahme für Durchmesser 39,5-59,499 mm

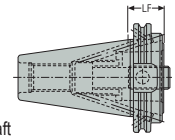




Verlängerung



Aufnahme für Reibahlen



Schaft



Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		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

Aufnahmen und Verlängerungen für HF32-050-C3 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

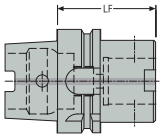
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C3-390.410-63075C	75039871	75	HSK-A63	C3	0,9
C3-390.410-100080A	75039873	80	HSK-A100	C3	2,3
C3-390B.140-40030	02924104	30	DIN40 ADB	C3	0,8
C3-390B.55-40030	02925959	30	BT40 ADB	C3	0,9
C3-390B.55-40060	02925960	60	BT40 ADB	C3	1,1
C3-390B.140-50030	02924106	30	DIN50 ADB	C3	2,6
C3-390B.140-50060	02924107	60	DIN50 ADB	C3	2,7
C3-390B.58-50040	02925961	40	BT50 ADB	C3	3,5
C3-390B.58-50070	02925962	70	BT50 ADB	C3	3,7

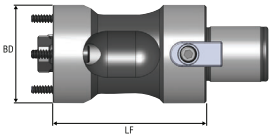
Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C3-391.01-32060A	75039884	–	C3	C3	0,34
C3-391.01-32080A	00090847	–	C3	C3	0,45
C4-391.02-32055A	75039889	–	C4	C3	0,42
C4-391.02-32070A	02535687	–	C4	C3	0,56
C5-391.02-32060A	75039890	–	C5	C3	0,64
C6-391.02-32070A	75039892	–	C6	C3	1,06

HF32

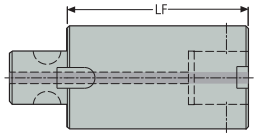
Graflex® Aufnahme für Durchmesser 39,5-59,499 mm



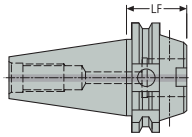




Aufnahme für Reibahlen



Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		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

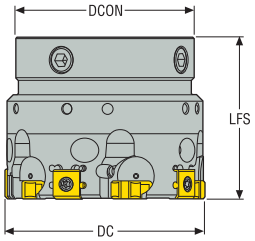
Aufnahmen und Verlängerungen für HF32-050-G3 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

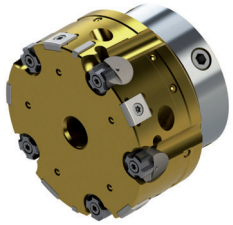
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
EM93044011850	00086918	50	HSK-A63	G3	0,73
EM93064011855	00086925	55	HSK-A100	G3	2,1
EM34694011835	02420097	35	DIN40 ADB	G3	0,91
EM346940118100	02503298	100	DIN40 ADB	G3	1,22
EM34144011840	02503366	40	BT40 ADB	G3	1,07
EM341440118100	02503367	100	BT40 ADB	G3	1,31
EM34714011835	02503307	35	DIN50 ADB	G3	2,67
EM34164011845	02503376	45	BT50 ADB	G3	3,58
EM341640118120	02503377	120	BT50 ADB	G3	3,9

Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
M402330	00056758	–	G3	G3	0,24
M402331	75056759	–	G3	G3	0,36

HF85

Schneidköpfe für RNAX Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 59,5-84,499 mm / *2.343-3.327”*

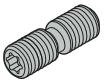




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85 05-55	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

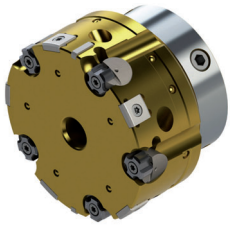
Zubehör

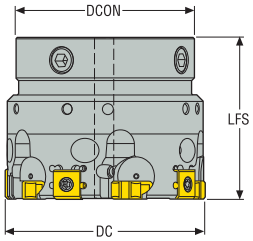
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85 05-55	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Schneidköpfe für RNAX Wendeschneidplatten, Grundlochbohrung mit Durchmesser 59,5-84,499 mm / *2.343-3.327”*

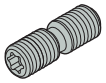




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85B 05-55	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

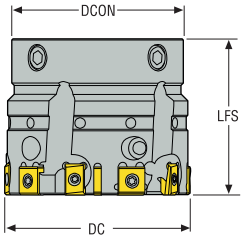
Zubehör

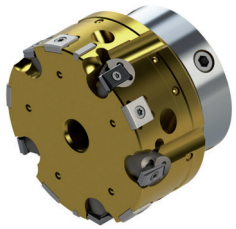
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85B 05-55	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Schneidköpfe für LNEG Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 59,5-84,499 mm / *2.343-3.327”*

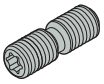




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86 05-55	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

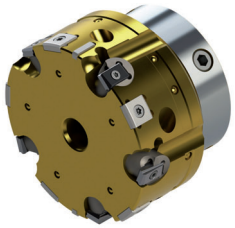
Zubehör

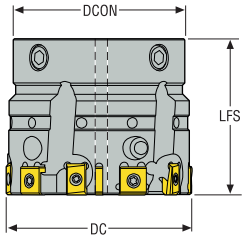
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86 05-55	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Schneidköpfe für LNEG Wendeschneidplatten, Grundlochbohrung mit Durchmesser 59,5-84,499 mm / *2.343-3.327”*

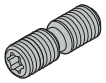




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86B 05-55	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

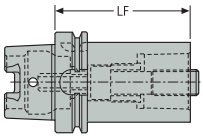
Zubehör

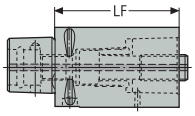
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86B 05-55	H00-2020	T00-07P09

Drehmoment T00-07P09: 2 Nm.
Drehmoment H00-2020: 2 Nm.

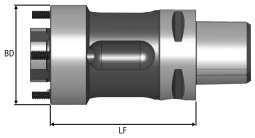
HF55

Seco-Capto™ Aufnahme für Durchmesser 59,5-84,499 mm

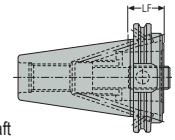




Verlängerung



Aufnahme für Reibahlen



Schaft



Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		mm	mm		mm	kg
HF55-080-C5	02688647	–	80	C5	55	1,5
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

Aufnahmen und Verlängerungen für HF55-080-C5 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

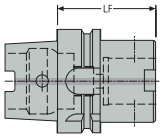
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C5-390.410-63090C	75039878	90	HSK-A63	C5	1,41
C5-390.410-100100A	75039880	100	HSK-A100	C5	2,9
C5-390B.140-40040	02924112	40	DIN40 ADB	C5	0,9
C5-390B.140-40080	02924113	80	DIN40 ADB	C5	1,5
C5-390B.55-40050	02925967	50	BT40 ADB	C5	1,1
C5-390B.55-40090	02925968	90	BT40 ADB	C5	1,7
C5-390B.140-50030	02924114	30	DIN50 ADB	C5	2,6
C5-390B.140-50070	02924115	70	DIN50 ADB	C5	3,1
C5-390B.58-50040	02925969	40	BT50 ADB	C5	3,4
C5-390B.58-50080	02925970	80	BT50 ADB	C5	4,0

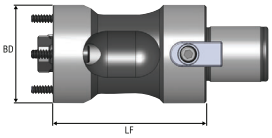
Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C5-391.01-50080A	75039886	–	C5	C5	1,12
C5-391.01-50100A	00004773	–	C5	C5	1,39
C6-391.02-50080A	75039894	–	C6	C5	1,45
C6-391.02-50110A	02207400	–	C6	C5	2,15
C8-391.02-50080B	03080011	–	–	–	2,4

HF55

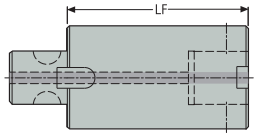
Graflex® Aufnahme für Durchmesser 59,5-84,499 mm



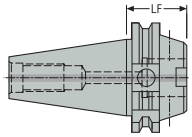




Aufnahme für Reibahlen



Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		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

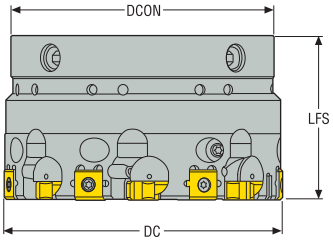
Aufnahmen und Verlängerungen für HF55-080-G5 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

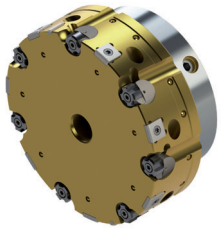
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
EM93044012860	00086920	60	HSK-A63	G5	0,98
EM930440128100	00086921	100	HSK-A63	G5	1,58
EM930440128140	00086922	140	HSK-A63	G5	2,18
EM93064012865	00086927	65	HSK-A100	G5	2,37
EM930640128110	00086928	110	HSK-A100	G5	3,02
EM930640128150	00086929	150	HSK-A100	G5	3,7
EM34694012840	02458421	40	DIN40 ADB	G5	0,93
EM34694012880	02503301	80	DIN40 ADB	G5	1,5
EM346940128120	02503302	120	DIN40 ADB	G5	2,08
EM34144012845	02457989	45	BT40 ADB	G5	1,12
EM34144012880	02503371	80	BT40 ADB	G5	1,54
EM341440128120	02503372	120	BT40 ADB	G5	2,12
EM34714012840	02503312	40	DIN50 ADB	G5	2,75
EM341640128100	02503381	100	BT50 ADB	G5	4,22
EM34164012855	02503380	55	BT50 ADB	G5	4,0
EM341640128140	02503382	140	BT50 ADB	G5	4,8

Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
M402550	00056762	–	G5	G5	0,72
M402551	00056763	–	G5	G5	1,12
M402552	00056764	–	G5	G5	1,48

HF85

Schneidköpfe für RNAX Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 84,5-119,499 mm / *3.327-4.705”*





- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85 07-80	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

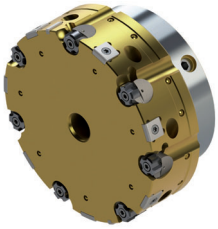
Zubehör

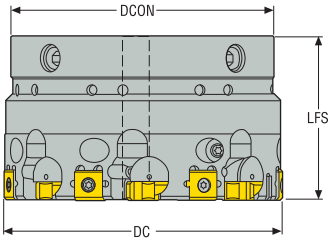
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85 07-80	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Schneidköpfe für RNAX Wendeschneidplatten, Grundlochbohrung mit Durchmesser 84,5-119,499 mm / *3.327-4.705”*

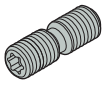




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85B 07-80	SH4075S	CARTCYHF20B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

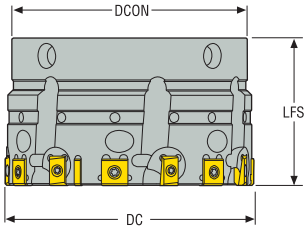
Zubehör

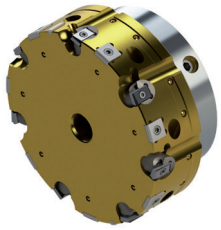
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85B 07-80	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Schneidköpfe für LNEG Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 84,5-119,499 mm / *3.327-4.705”*





- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86 07-80	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

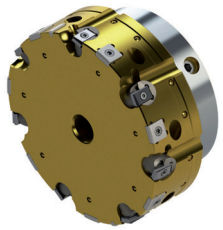
Zubehör

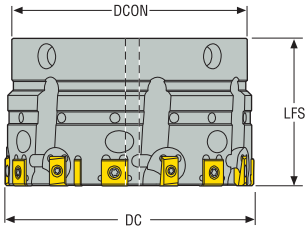
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86 07-80	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Schneidköpfe für LNEG Wendeschneidplatten, Grundlochbohrung mit Durchmesser 84,5-119,499 mm / *3.327-4.705”*

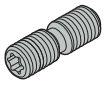




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86B	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

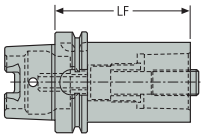
Zubehör

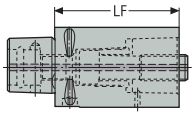
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86B	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

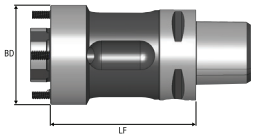
HF80

Seco-Capto™ Aufnahme für Durchmesser 84,5-119,499 mm

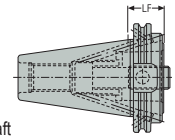




Verlängerung



Aufnahme für Reibahlen



Schaft



Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		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

Aufnahmen und Verlängerungen für HF80-080-C6 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

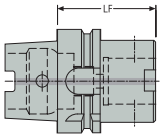
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C6-390.410-100110A	75039882	110	HSK-A100	C6	3,56
C6-390B.140-40085	02924116	85	DIN40 ADB	C6	1,8
C6-390B.140-50030	02924117	30	DIN50 ADB	C6	2,5
C6-390B.140-50080	02924118	80	DIN50 ADB	C6	3,6
C6-390B.55-40075	02925971	75	BT40 ADB	C6	1,7
C6-390B.58-50100	02925973	100	BT50 ADB	C6	4,6
C6-390B.58-50050	02925972	50	BT50 ADB	C6	3,5

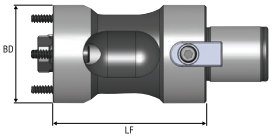
Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C6-391.01-63100A	75039887	–	C6	C6	2,2
C6-391.01-63140A	00004840	–	C6	C6	3,1
C6-391.01-63060	02300834	–	C6	C6	1,31

HF80

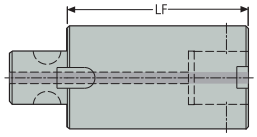
Graflex® Aufnahme für Durchmesser 84,5-119,499 mm



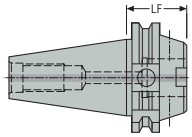




Aufnahme für Reibahlen



Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		mm	mm		mm	kg
HF80-080-G6	02698873	–	80	G6	80	3,0
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

Aufnahmen und Verlängerungen für HF80-080-G6 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

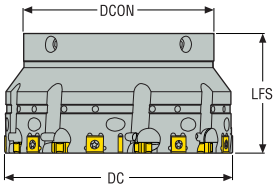
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
EM93044013670	00086923	70	HSK-A63	G6	1,21
EM930440136120	00086924	120	HSK-A63	G6	2,38
EM930640136120	00086931	120	HSK-A100	G6	3,82
EM930640136160	00086932	160	HSK-A100	G6	4,72
EM34694013660	02503303	60	DIN40 ADB	G6	1,24
EM346940136120	02503304	120	DIN40 ADB	G6	2,65
EM34144013650	02503373	50	BT40 ADB	G6	1,13
EM341440136120	02503374	120	BT40 ADB	G6	2,78
EM34714013645	02503317	45	DIN50 ADB	G6	2,88
EM347140136100	02503318	100	DIN50 ADB	G6	4,1
EM347140136140	02503319	140	DIN50 ADB	G6	4,99
EM34164013663	02503383	63	BT50 ADB	G6	4,2
EM341640136100	02503384	100	BT50 ADB	G6	4,6
EM341640136140	02503385	140	BT50 ADB	G6	5,54

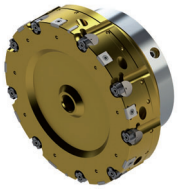
Aufnahmen und Verlängerungen für HF32-050-G3 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
M402660	00056765	–	G6	G6	1,38
M402661	00056766	–	G6	G6	2,1
M402662	00056767	–	G6	G6	2,82

HF85

Schneidköpfe für RNAX Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 119,5-154,499 mm / *4.705-6.083”*





- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85 09-100	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

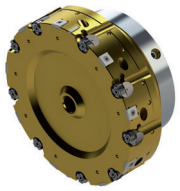
Zubehör

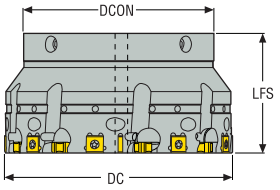
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85 09-100	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF85B

Schneidköpfe für RNAX Wendeschneidplatten, Grundlochbohrung mit Durchmesser 119,5-154,499 mm / *4.705-6.083”*

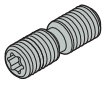




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF85B 09-100	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

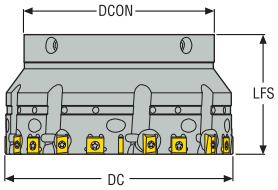
Zubehör

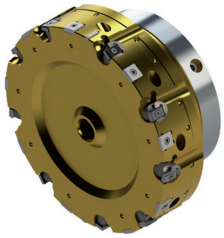
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF85B 09-100	H00-2020	T00-09P20

Drehmoment T00-09P20: 2 Nm.
Drehmoment H00-2020: 2 Nm.

HF86

Schneidköpfe für LNEG Wendeschneidplatten, Durchgangsbohrung mit Durchmesser 119,5-154,499 mm / *4.705-6.083”*





- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86 09-100	SH4075S	CARTCYHF20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

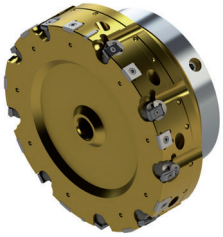
Zubehör

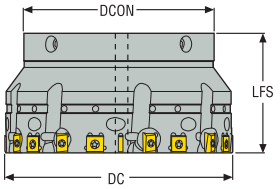
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86 09-100	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

HF86B

Schneidköpfe für LNEG Wendeschneidplatten, Grundlochbohrung mit Durchmesser 119,5-154,499 mm / *4.705-6.083”*

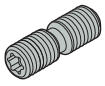




- Wendeschneidplatten, Sorten und Geometrien, siehe Seite(n) 429-430

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

Für Kopf	Einstellschraube	Kassette	Schraube für Pratze	Schraube für WSP	Schlüssel	Einstellschlüssel	Pratze
							
HF86B 09-100	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

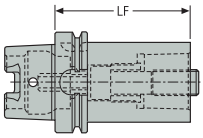
Zubehör

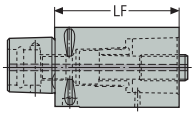
Für Kopf	Drehmomentschlüssel	Torx-Schlüssel für WSP/Spannschraube
		
HF86B 09-100	H00-2020	T00-07P09

Drehmoment T00-07P09: 0,9 Nm.
Drehmoment H00-2020: 2 Nm.

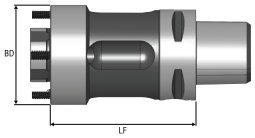
HF100

Seco-Capto™ Aufnahme für Durchmesser 119,5-154,499 mm

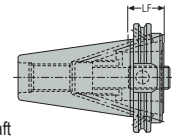




Verlängerung



Aufnahme für Reibahlen



Schaft



Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		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

Aufnahmen und Verlängerungen für HF100-100-C8 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

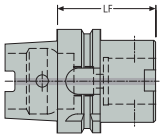
Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C8-390.410-100120A	75039883	120	HSK-A100	C8	4,72
C8-390B.140-50070	02924119	70	DIN50 ADB	C8	3,7
C8-390B.140-50120	02924120	120	DIN50 ADB	C8	5,6
C8-390B.58-50070	02925974	70	BT50 ADB	C8	4,0
C8-390B.58-50120	02925975	120	BT50 ADB	C8	5,9

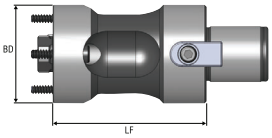
Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Seco-Capto Größe	Gewicht
		mm			kg
C8-391.01-80100A	75039888	–	C8	C8	3,62
C8-391.01-80125A	00004841	–	C8	C8	4,54

HF100

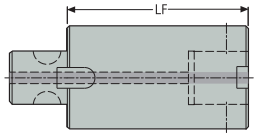
Graflex® Aufnahme für Durchmesser 119,5-154,499 mm



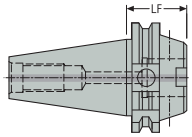




Aufnahme für Reibahlen



Verlängerung



Schaft

Bezeichnung Aufnahmen für Reibahlen	Produktnummer	LF min	LF max	Aufnahme	BD	Gewicht
		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

Aufnahmen und Verlängerungen für HF100-100-G7 (weitere Informationen siehe Seco Katalog Werkzeug-Systeme)

Bezeichnung Aufnahmen	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
EM93064014685	00074385	85	HSK-A100	G7	3,99
EM930640146160	00086933	160	HSK-A100	G7	7,67
EM34714014650	02503320	50	DIN50 ADB	G7	3,23
EM347140146120	02503321	120	DIN50 ADB	G7	6,48
EM347140146200	02503324	200	DIN50 ADB	G7	10,4
EM34164014665	02503386	65	BT50 ADB	G7	4,4
EM341640146120	02503387	120	BT50 ADB	G7	6,8
EM341640146200	02503388	200	BT50 ADB	G7	10,7

Bezeichnung Zwischenaufnahme	Produktnummer	LF	Aufnahme	Graflex Größe	Gewicht
		mm			kg
M402770	00056768	–	G7	G7	2,9
M402771	00056769	–	G7	G7	4,03
M402772	00056770	–	G7	G7	5,8

Schnittdaten – LNEG...-EB45 Metrisch

SMG		a_p (Durchmesser)	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 Richtwerte.

Schnittdaten – LNEG...-EB45 *Zoll*

SMG		a_p (Durchmesser)	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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – LNEG...-EB845 Metrisch

SMG		a_p (Durchmesser)	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 Richtwerte.

Schnittdaten – LNEG...-EB845 *Zoll*

SMG		a_p (Durchmesser)	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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – LNEG...-EB1570 Metrisch

SMG		a_p (Durchmesser)	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 Richtwerte.

Schnittdaten – LNEG...-EB1570 *Zoll*

SMG		a_p (Durchmesser)	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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – RNAX...-EB45 Metrisch

SMG		a_p (Durchmesser)	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 Richtwerte.

Schnittdaten – RNAX...-EB45 *Zoll*

SMG		a_p (Durchmesser)	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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – RNAX...-EB845 Metrisch

SMG		a_p (Durchmesser)	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 = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – RNAX...-EB845 *Zoll*

SMG		a_p (Durchmesser)	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*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Schnittdaten – RNAX...-EB1570 Metrisch

SMG		a_p (Durchmesser)	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 Richtwerte.

Schnittdaten – RNAX...-EB1570 *Zoll*

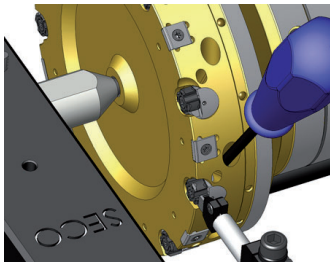
SMG		a_p (Durchmesser)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490- 985)*
K2	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*165 (115-260)*	*230 (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)*

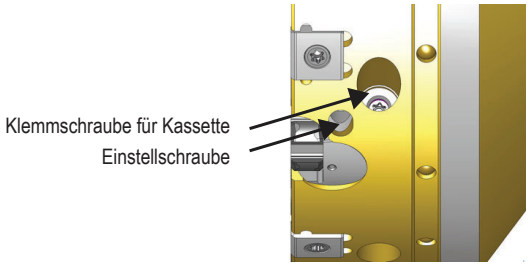
SMG = Seco Werkstoff-Gruppe
a_p = *Zoll*
a_p = mm
f = mm/U
v_c= m/min
Alle Schnittdaten sind Richtwerte.

Einstellhinweise

1.

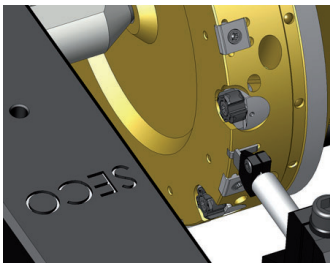
- Klemmschraube der Kassette lösen.
- Wendeschneidplatte wechseln oder eine neue einsetzen.
- Einstellschraube durch eine Vierteldrehung lösen und Kassette leicht zurückdrücken.
- Kassettenschraube sanft anziehen 0,5 Nm *(4.4 in/lbs)*.

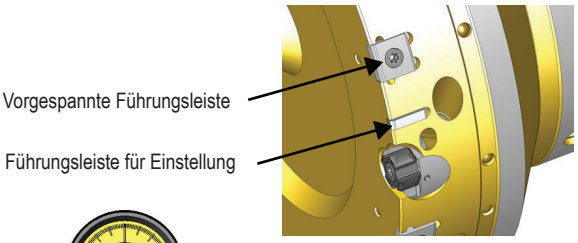


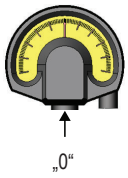


2.

- Die Messuhr auf der entsprechenden Führungsleiste auf Null stellen.
- Der Messpunkt muss hinter dem Anstellwinkel liegen.

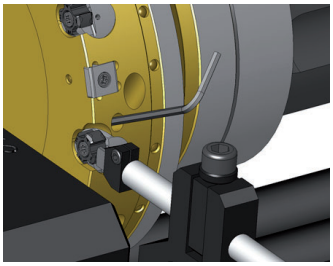


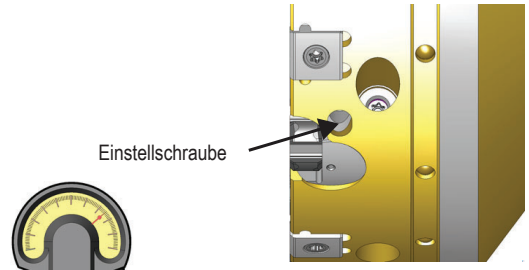


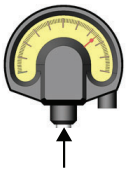


3.

- Wendeschneidplatte mittels Einstellschraube 0,025 mm *(0.001”)* über der Führungsleiste einsetzen.
- Einstellverfahren für alle WSP wiederholen.

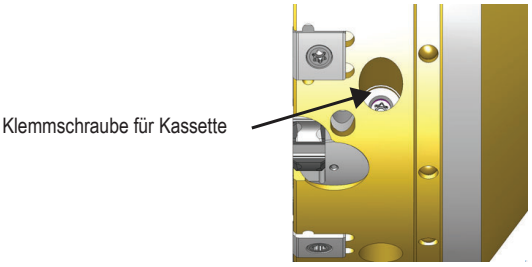






4.

- 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.

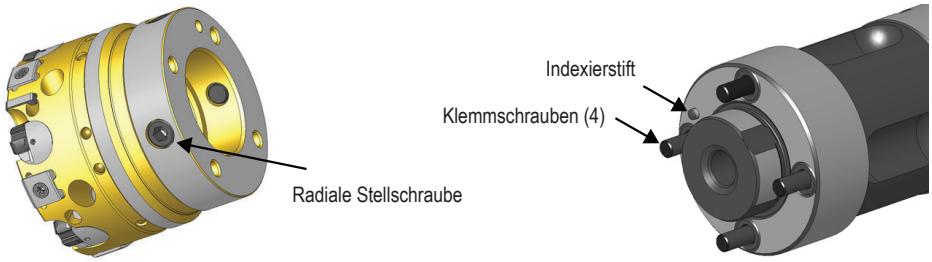
Einstellhinweise

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)

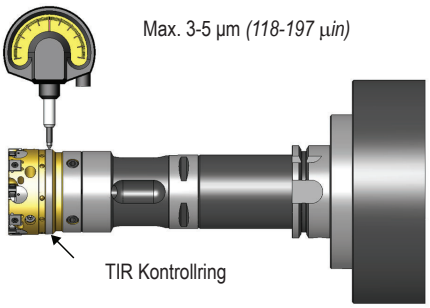


2.

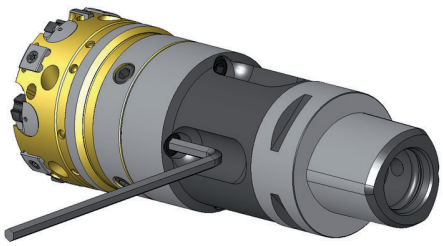
Einstellung:

- 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)



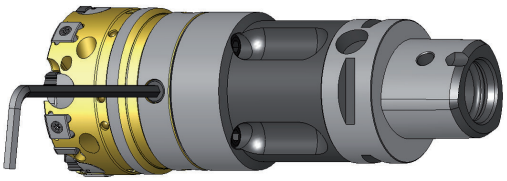
Klemmschrauben (Abb. 3)



3.

- Rundlaufeinstellung beenden (max. 5 µm) *(max. 197 µin)*.

Radiale Einstellschraube (Abb. 4)



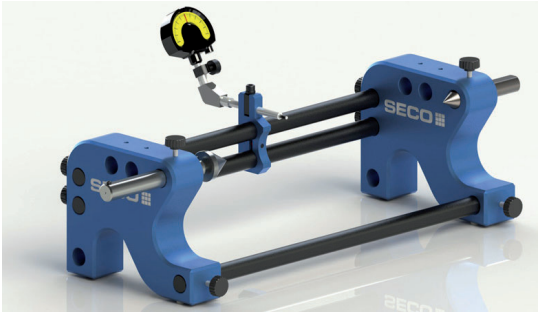
Drehmomenttabelle

Durchmesser (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 – Vorrichtungen für eine Messuhr

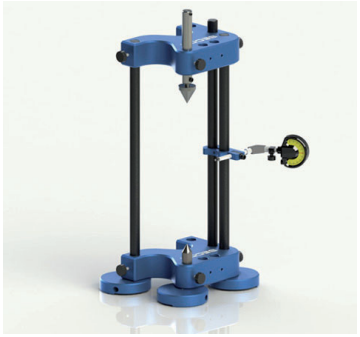
SF-210340-C160: Bezeichnung 02885391

- Horizontales Gestell
- Erste Wahl für Xfix-Reibahlen
- 1 Messuhr
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 340 mm *(13.386")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- Zentrierspitze SSC5700 ist im Lieferumfang enthalten.



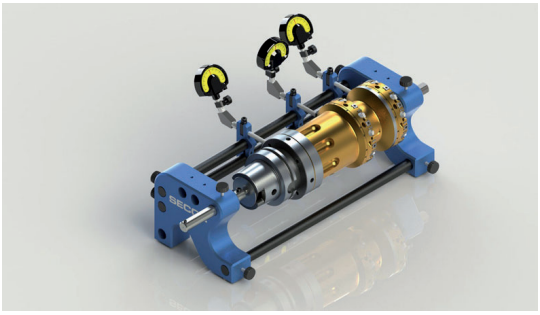
SF-210290V-C160: Bezeichnung 02885392

- Vertikales Gestell
- Erste Wahl für Xfix-Reibahlen
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 290 mm *(11.417")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- Zentrierspitze SSC5700 ist im Lieferumfang enthalten.



Einstellgerät – Spannvorrichtungen für mehrere Messuhren

Weitere Informationen zur Einstellung mit mehreren Messuhren, finden Sie im Kapitel „Einstellgerät“ Seite 485-490.



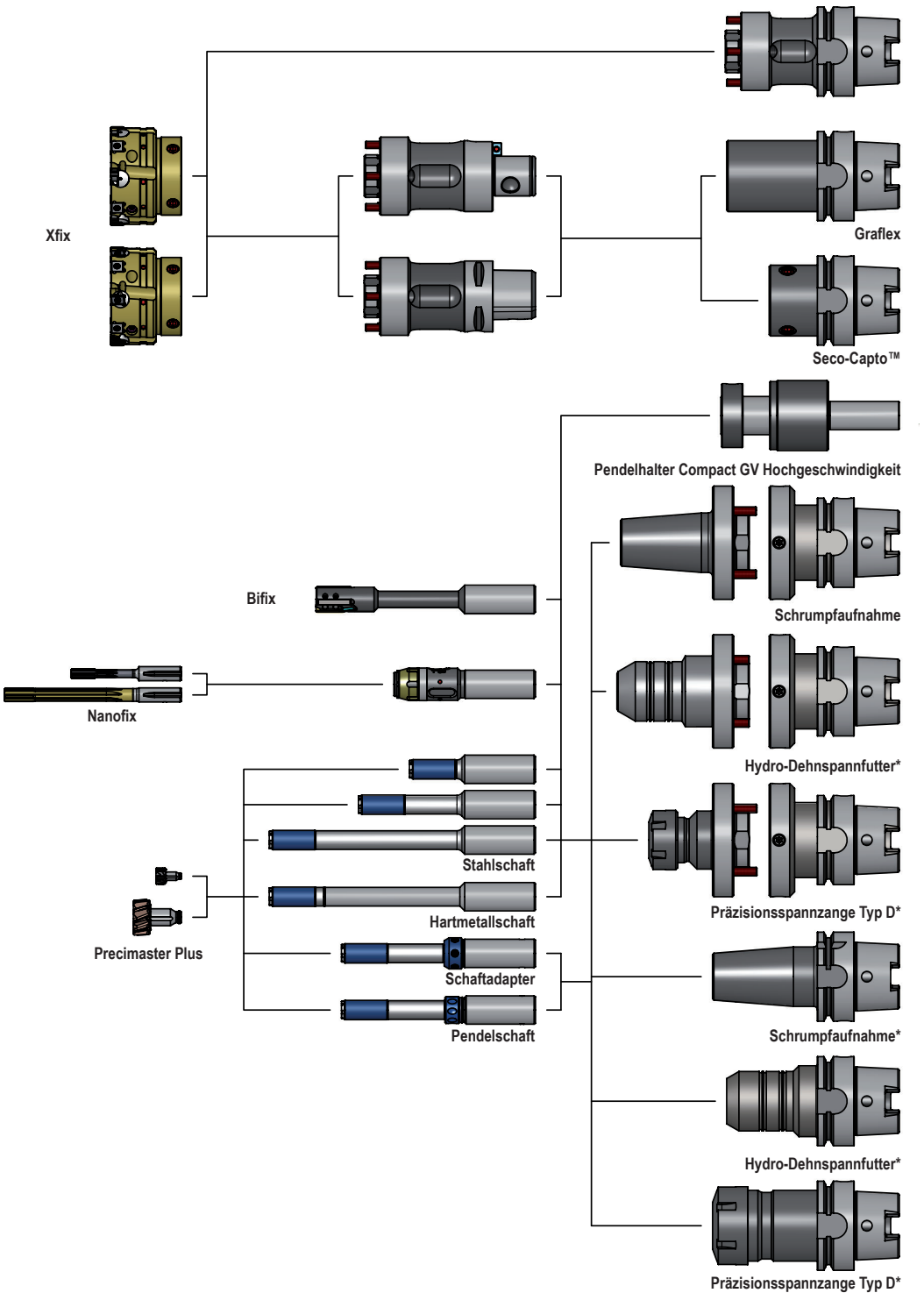
Werkzeugsystem-Übersicht



Durchmesser (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 Werkzeuges in der Maschine überprüfen.

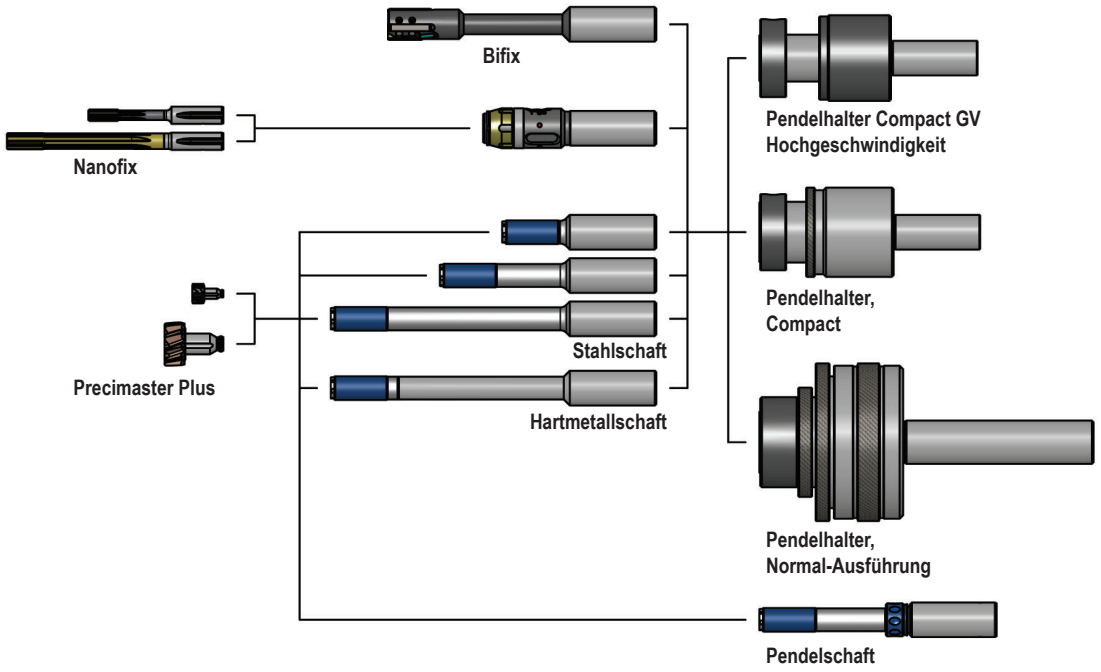
Rotierender Einsatz



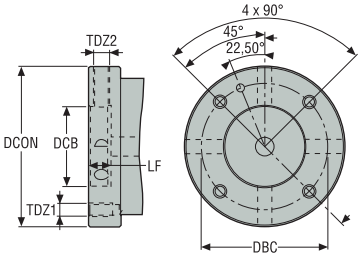
* Siehe Seco Katalog Werkzeug-Systeme

Für beste Ergebnisse empfehlen wir eine stabile Klemmung (mit Hydro-Dehnspannfutter, Spannzange Typ D oder Schrumpffutter).

Statischer Einsatz



Flanschabmessung

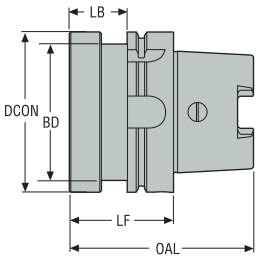




DCON	DBC +/- 0,1	DCB F8	LF	TDZ1	TDZ2
60	44	30	12	M5	M8x1
70	53	35	12	M6	M8x1
80	63	40	12	M6	M8x1
100	79	50	14	M8	M10x1
117	96	60	14	M8	M10x1
140	119	80	14	M10	M10x1

Schnittstelle HSK-A

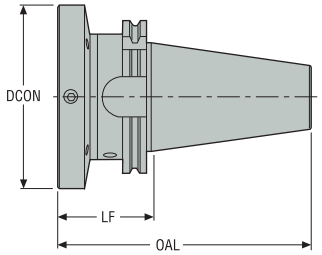




- Beachten Sie, dass Kühlrohre und Schrauben im Lieferumfang enthalten sind.

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-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-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-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*	2,8 *6.170*
SAH-2340540001	02836564	HSK-A 40	60,0 *2.362*	34,0 *1.339*	35,0 *1.378*	55,0 *2.165*	75,0 *2.953*	0,8 *1.760*
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-2340550002	02836573	HSK-A 50	80,0 *3.150*	42,0 *1.654*	34,0 *1.339*	60,0 *2.362*	85,0 *3.346*	1,2 *2.650*
SAH-2340550003	02836567	HSK-A 50	70,0 *2.756*	42,0 *1.654*	34,0 *1.339*	60,0 *2.362*	85,0 *3.346*	1,0 *2.200*
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-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-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-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-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-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-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-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*

Schnittstelle DIN 69871



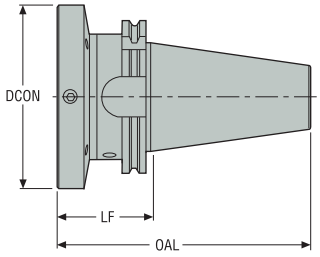


- Beachten Sie, dass Schrauben im Lieferumfang enthalten sind.

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*	1,1 *2.430*
SAH-2340640202	02836685	DIN40 ADB	80,0 *3.150*	55,0 *2.165*	123,4 *4.858*	1,5 *3.310*
SAH-2340640203	02836686	DIN40 ADB	100,0 *3.937*	60,0 *2.362*	128,4 *5.055*	2,3 *5.070*
SAH-2340640204	02836684	DIN40 ADB	70,0 *2.756*	50,0 *1.969*	118,4 *4.661*	1,2 *2.650*
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*	3,6 *7.940*
SAH-2340650203	02836691	DIN50 ADB	100,0 *3.937*	60,0 *2.362*	161,8 *6.370*	4,3 *9.480*
SAH-2340650206	02836688	DIN50 ADB	70,0 *2.756*	50,0 *1.969*	151,8 *5.976*	3,3 *7.280*

Schnittstelle ANSI CAT

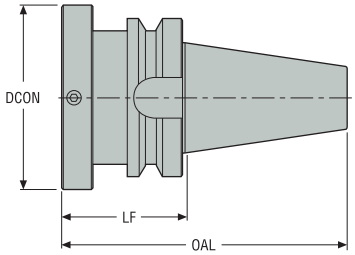




- Beachten Sie, dass Schrauben im Lieferumfang enthalten sind.
- Anzugsbolzen Gewinde in Zoll

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-2784940202	02836702	CAT 40	80,0 *3.150*	55,0 *2.165*	123,4 *4.858*	1,5 *3.310*
SAH-2784940203	02836704	CAT 40	100,0 *3.937*	60,0 *2.362*	128,4 *5.055*	2,3 *5.070*
SAH-2784950201	02836707	CAT 50	60,0 *2.362*	50,0 *1.969*	151,8 *5.976*	3,1 *6.830*
SAH-2784950202	02836709	CAT 50	80,0 *3.150*	50,0 *1.969*	151,8 *5.976*	3,4 *7.500*
SAH-2784950203	02836710	CAT 50	100,0 *3.937*	60,0 *2.362*	161,8 *6.370*	5,5 *12.130*
SAH-2784950206	02836708	CAT 50	70,0 *2.756*	50,0 *1.969*	151,8 *5.976*	3,3 *7.280*

Schnittstelle BT



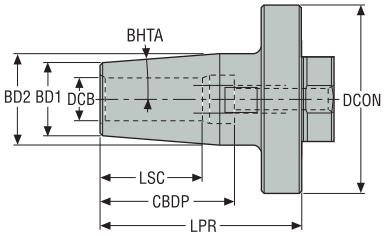


- Beachten Sie, dass Schrauben im Lieferumfang enthalten sind.

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-2340740002	02836719	BT40 ADB	80,0 *3.150*	65,0 *2.559*	130,4 *5.134*	2,0 *4.410*
SAH-2340740003	02836721	BT40 ADB	100,0 *3.937*	60,0 *2.362*	125,4 *4.937*	2,7 *5.950*
SAH-2340740004	02836718	BT40 ADB	70,0 *2.756*	55,0 *2.165*	120,4 *4.740*	1,5 *3.310*
SAH-2340750001	02836724	BT50 ADB	60,0 *2.362*	70,0 *2.756*	171,8 *6.764*	4,2 *9.260*
SAH-2340750002	02836725	BT50 ADB	70,0 *2.756*	70,0 *2.756*	171,8 *6.764*	4,4 *9.700*
SAH-2340750003	02836726	BT50 ADB	80,0 *3.150*	70,0 *2.756*	171,8 *6.764*	4,6 *10.140*
SAH-2340750004	02836727	BT50 ADB	100,0 *3.937*	70,0 *2.756*	171,8 *6.764*	4,9 *10.800*

Frontseitig Schrumpffutter

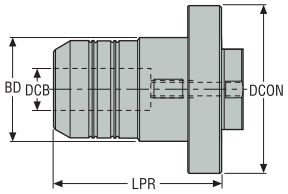




- Beachten Sie, dass Einstellschrauben im Lieferumfang enthalten sind.

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-2341006235	02836735	60,0 *2.362*	27,0 *1.063*	21,0 *0.827*	6,0 *0.236*	22,0 *0.866*	37,5 *1.476*	70,0 *2.756*	0,5 *1.100*	4,5
SAH-2341010237	02836736	60,0 *2.362*	32,0 *1.260*	24,0 *0.945*	10,0 *0.394*	31,0 *1.220*	42,5 *1.673*	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

Frontseitig Hydro-Dehnspannfutter



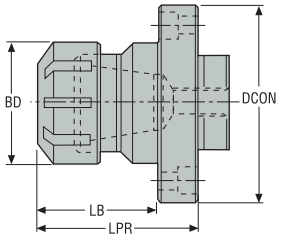


- Beachten Sie, dass Einstellschrauben im Lieferumfang enthalten sind.

Bezeichnung	Produktnummer	DCON	BD	DCB	LPR	Gewicht
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
SAH-2341112255	02836752	80,0 *3.150*	32,0 *1.260*	12,0 *0.472*	77,5 *3.051*	1,1 *2.430*
SAH-2341112259	02836757	100,0 *3.937*	32,0 *1.260*	12,0 *0.472*	90,0 *3.543*	1,9 *4.190*
SAH-2341116253	02836749	70,0 *2.756*	38,0 *1.496*	16,0 *0.630*	50,0 *1.969*	0,75 *1.650*
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-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*

Frontseitig ER-Spannzangenfutter

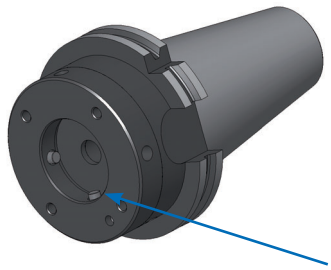




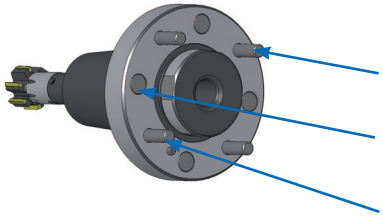
- Beachten Sie, dass Einstellschrauben im Lieferumfang enthalten sind.

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*

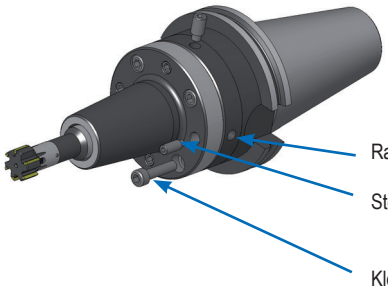
Montagehinweise



- Kontaktoberfläche reinigen
- Sicherstellen, dass die radialen Einstellschrauben die Einheit nicht behindern.



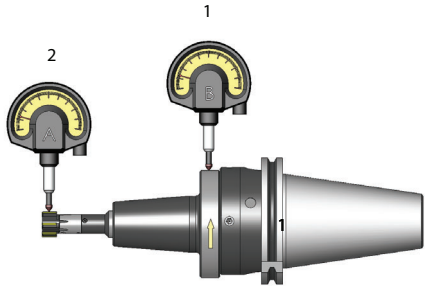
- Sicherstellen, dass die Winkeleinstellschrauben die Einheit nicht behindern.



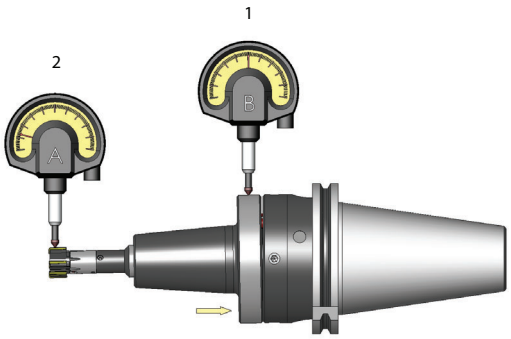
- Weiter montieren und Klemmschrauben dabei leicht anziehen (x4).

Einstellhinweise

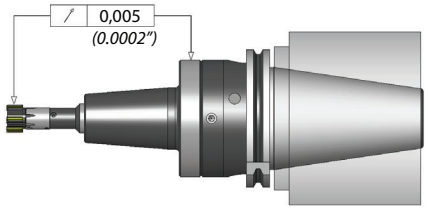
- Werkzeug in die Maschinenspindel einsetzen
- Messuhr 1 wie dargestellt aufstellen (Messuhr 2 hier nicht erforderlich)
- Werkzeug manuell in die niedrigste Position drehen
- Ausgleich des radialen Rundlaufes siehe Pfeil
- Ausgleich überprüfen und ggf. wiederholen



- Werkzeug in die Maschinenspindel einsetzen
- Messuhr 2 wie dargestellt aufstellen
- Werkzeug manuell in die niedrigste Position drehen
- Ausgleich des radialen Rundlaufes 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.



Programmübersicht

Die Verwendung einer Seco Pendelbohrerhülse wird empfohlen

- Wenn die Rundlaufabweichung 0.02 mm *(0.0008")* übertrifft
- Für statische Werkzeuge

Kompakte GV Hochgeschwindigkeits-Baureihe • Erste Wahl für rotierende Werkzeuge • Keine Einstellung erforderlich (vom Hersteller voreingestellt) • Rotation bis 3.000 U/m je nach Anwendung • Für statische Bearbeitungen	
Compact Serie • Erste Wahl für statische Werkzeuge • Nur radiale Justierung • Geeignet für rotierende Bearbeitung – 800 U/m max.	
Normale Baureihe • Wenn sowohl Winkel- als auch radiale Korrektur erforderlich ist • Für rotierende Anwendungen – 800 U/m max.	

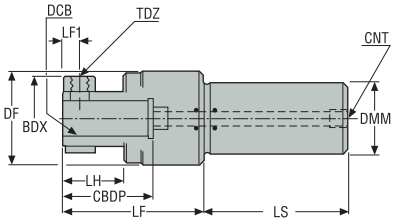
Alle Pendelhalter eignen sich für interne Kühlschmierstoffzufuhr.
Es gibt 2 Arten der Kühlschmierstoffzufuhr

JJL: mit seitlichem Anschluss
JJ: durch den Schaft

Die Betriebsanleitung ist in der Lieferung enthalten.

Compact GV Hochgeschwindigkeit

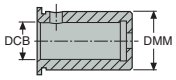




Produktnummer	Bezeichnung	DCB	DMM	LF	LS	DF	BDX	LH	CBDP	CNT	LF1	TDZ	ADJRG	Gewicht
		mm	mm	mm	mm	mm	mm	mm	mm		mm		mm	kg
00088959	SFH-GV11019JJ	10,0	19,05	47,5	40,0	33,0	30,0	11,5	25,0	1/8	5,5	M6	0,2	0,7
00088945	SFH-GV11020JJ	10,0	20,0	47,5	40,0	33,0	30,0	11,5	25,0	1/8	5,5	M6	0,2	0,8
00076815	SFH-GV21619JJ	16,0	19,05	66,0	50,0	49,5	39,0	24,5	40,0	1/8	8,0	M8	0,2	0,8
00072133	SFH-GV21620JJ	16,0	20,0	66,0	50,0	49,5	39,0	24,5	40,0	1/8	8,0	M8	0,2	0,8
00076827	SFH-GV22019JJ	20,0	19,05	76,0	50,0	49,5	45,0	34,5	50,0	1/8	8,0	M8	0,2	0,8
00072134	SFH-GV22020JJ	20,0	20,0	76,0	50,0	49,5	45,0	34,5	50,0	1/8	8,0	M8	0,2	0,8
00076828	SFH-GV32525JJ	25,0	25,4	89,0	60,0	62,0	52,0	43,5	60,0	1/4	11,0	M10	0,3	1,4
00072135	SFH-GV32525MJJ	25,0	25,0	89,0	60,0	62,0	52,0	43,5	60,0	1/4	11,0	M10	0,3	1,4
00088960	SFH-GV325425JJ	25,4	25,4	89,0	60,0	62,0	52,0	43,5	60,0	1/4	11,0	M10	0,3	1,4
02602671	SFH-GV43232JJ	32,0	32,0	90,0	80,0	72,0	60,0	34,0	60,0	3/8	9,0	M10	0,3	2,2

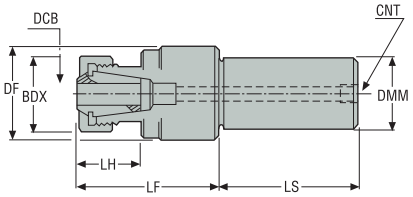
Zubehör

Bezeichnung — **Reduzierhülse**



	DCB	DMM
SRR-BR11016	10	16
SRR-BR11216	12	16
SRR-BR11220	12	20
SRR-BR21620	16	20
SRR-BR31625	16	25
SRR-BR32025	20	25
SRR-GV42532	25	32

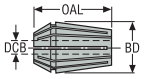
Compact GV Hochgeschwindigkeit mit Spannzangenfutter





Produktnummer	Bezeichnung	CZC	DMM	LF	LS	DF	BDX	LH	CNT	ADJRG	Gewicht
			mm	mm	mm	mm	mm	mm		mm	kg
00088946	SFH-GV3BC25MJJ	ER32	25,0	80,0	60,0	62,0	50,0	35,0	1/4	0,3	1,3
00088961	SFH-GV3BC25JJ	ER32	25,4	80,0	60,0	62,0	50,0	35,0	1/4	0,3	1,3
00088962	SFH-GV4BC31JJ	ER40	31,75	94,0	80,0	72,0	63,0	39,0	3/8	0,3	0,7
00088947	SFH-GV4BC32JJ	ER40	32,0	94,0	80,0	72,0	63,0	39,0	3/8	0,3	2,4

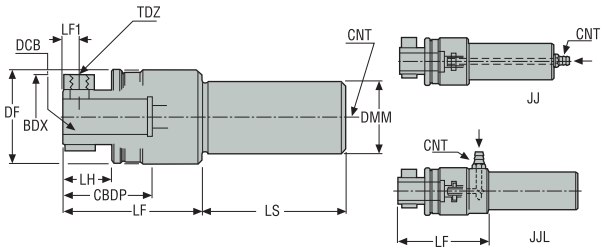
Zubehör

Bezeichnung	Größe	Spannzangenfutter*			Größe	Schraubenschlüssel*
						
		DCB	BD	OAL		
58803210	ER32	10	33	40	ER32	03B587532
58803212	ER32	12	33	40	-	-
58803213	ER32	13	33	40	-	-
58803216	ER32	16	33	40	-	-
58803220	ER32	20	33	40	-	-
58804016	ER40	16	41	46	ER40	03B537540
58804020	ER40	20	41	46	-	-
58804025	ER40	25	41	46	-	-
58804026	ER40	26	41	46	-	-

*Spannfutter werden nicht mit Spannzangen und Schlüssel geliefert.

Compact Serie

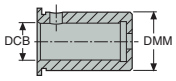




Produktnummer	Bezeichnung	DCB	DMM	LF	LS	DF	BDX	LH	CBDP	CNT	LF1	TDZ	ADJRG	Gewicht
		mm	mm	mm	mm	mm	mm	mm	mm		mm		mm	kg
00088963	SFH-C01019JJ	10,0	19,05	44,5	40,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,575
00088964	SFH-C01019JJL	10,0	19,05	62,0	60,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,575
00088965	SFH-C21619JJL	16,0	19,05	87,0	60,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	1,1
00076829	SFH-C21619CJJ	16,0	19,05	67,5	50,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	0,97
00088966	SFH-C22019JJL	20,0	19,05	97,0	70,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	1,1
00076830	SFH-C22019CJJ	20,0	19,05	77,5	50,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	0,97
00088948	SFH-C01020JJ	10,0	20,0	44,5	40,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,59
00088949	SFH-C01020JJL	10,0	20,0	62,0	60,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,59
00088950	SFH-C21620JJL	16,0	20,0	87,0	60,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	1,1
00072142	SFH-C21620CJJ	16,0	20,0	67,5	50,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	0,97
00072145	SFH-C22020CJJ	20,0	20,0	77,5	50,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	1,0
00088951	SFH-C22020JJL	20,0	20,0	97,0	60,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	1,1
00076846	SFH-C32525JJ	25,0	25,4	90,0	110,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,7
00088967	SFH-C32525JJL	25,0	25,4	125,0	70,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,98
00072149	SFH-C32525MJJ	25,0	25,0	90,0	110,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,7
00088952	SFH-C32525MJJL	25,0	25,0	125,0	70,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,98

Zubehör

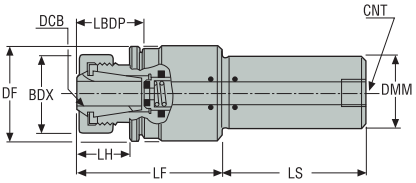
Bezeichnung — **Reduzierhülse**



	DCB	DMM
SRR-BR11016	10	16
SRR-BR11216	12	16
SRR-BR11220	12	20
SRR-BR21620	16	20
SRR-BR31625	16	25
SRR-BR32025	20	25

Schlauchadapter nicht im Lieferumfang enthalten.

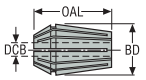
Compact C mit Spannzangenfutter





Produktnummer	Bezeichnung	CZC	DMM	LF	LS	DF	BDX	CBDP	LH	CNT	ADJRG	Gewicht
			mm	mm	mm	mm	mm	mm	mm		mm	kg
00088953	SFH-C65BC25MCJJ	ER32	25,0	94,0	50,0	64,5	50,0	42,0	33,0	3/8	1,5	1,7
00088968	SFH-C65BC25CJJ	ER32	25,4	94,0	50,0	64,5	50,0	42,0	33,0	3/8	1,5	1,7

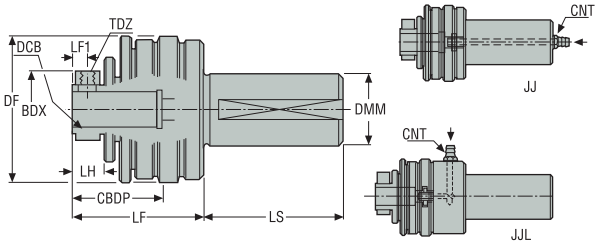
Zubehör

Bezeichnung	Größe	Spannzangenfutter*			Größe	Schraubenschlüssel*
						
		DCB	BD	OAL		
58803210	ER32	10	33	40	ER32	03B587532
58803212	ER32	12	33	40	-	-
58803213	ER32	13	33	40	-	-
58803216	ER32	16	33	40	-	-
58803220	ER32	20	33	40	-	-
58804016	ER40	16	41	46	ER40	03B537540
58804020	ER40	20	41	46	-	-
58804025	ER40	25	41	46	-	-
58804026	ER40	26	41	46	-	-

*Spannfutter werden nicht mit Spannzangen und Schlüssel geliefert.

Normal-Serie

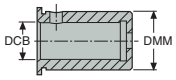




Produktnummer	Bezeichnung	DCB	DMM	LF	LS	DF	BDX	LH	CBDP	CNT	LF1	TDZ	ADJRG	ANADJ	Gewicht
		mm	mm	mm	mm	mm	mm	mm	mm		mm		mm		kg
00088969	SFH-11619JJ	16,0	19,05	64,0	50,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	0,9
00088970	SFH-11619JJL	16,0	19,05	81,0	40,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	1,32
00088954	SFH-11620JJ	16,0	20,0	64,0	50,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	0,95
00088955	SFH-11620JJL	16,0	20,0	81,0	40,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	1,34
00088971	SFH-22025JJ	20,0	25,4	74,0	65,0	82,0	44,0	16,0	50,0	3/8	8,0	M8	1,5	1,0 °	1,9
00088972	SFH-22025JJL	20,0	25,4	98,0	70,0	82,0	44,0	16,0	50,0	1/4	8,0	M8	1,5	1,0 °	2,2
00088956	SFH-22025MJJ	20,0	25,0	74,0	65,0	82,0	44,0	16,0	50,0	3/8	8,0	M8	1,5	1,0 °	1,9
00088957	SFH-22025MJJL	20,0	25,0	98,0	70,0	82,0	44,0	16,0	50,0	1/4	8,0	M8	1,5	1,0 °	2,2
00088973	SFH-32525JJ	25,0	25,4	82,5	110,0	91,0	52,0	22,0	60,0	3/8	11,0	M8	2,0	1,0 °	2,5
00088958	SFH-32525MJJ	25,0	25,0	82,5	110,0	91,0	52,0	22,0	60,0	3/8	11,0	M8	2,0	1,0 °	2,5

Zubehör

Bezeichnung — **Reduzierhülse**



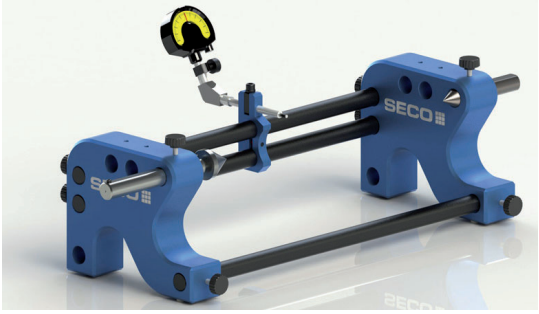
	DCB	DMM
SRR-BR11016	10	16
SRR-BR11216	12	16
SRR-BR11220	12	20
SRR-BR21620	16	20
SRR-BR31625	16	25
SRR-BR32025	20	25

Schlauchadapter nicht im Lieferumfang enthalten.

Einstellgerät – Vorrichtungen für eine Messuhr

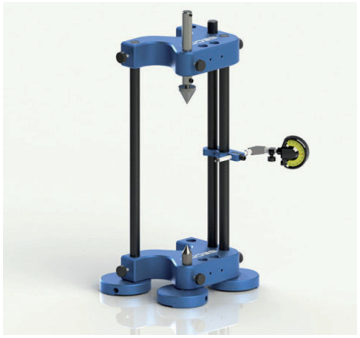
SF-210340-C160: Bezeichnung 02885391

- Horizontales Gestell
- Erste Wahl für Xfix-Reibahlen
- 1 Messuhr
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 340 mm *(13.386")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.



SF-210290V-C160: Bezeichnung 02885392

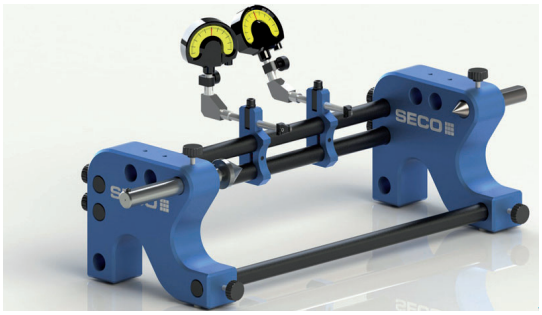
- Vertikales Gestell
- Erste Wahl für Xfix-Reibahlen
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 290 mm *(11.417")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm (2.244") Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.



Einstellgerät – Vorrichtungen für zwei Messuhren

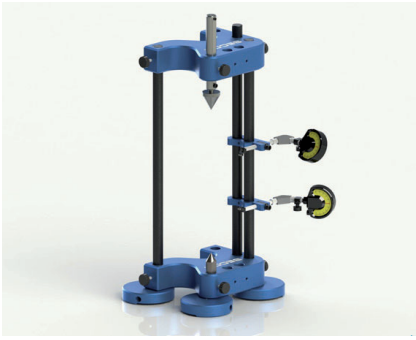
SF-210340-C160C190: Bezeichnung 02885393

- Horizontales Gestell
- Erste Wahl für Bifix-Reibahlen
- 2 Messuhren
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 340 mm *(13.386")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.



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")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.



Weitere Informationen hierzu erhalten Sie von Ihrem zuständigen Seco Tools Ansprechpartner.

Einstellgerät – Vorrichtungen 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")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.



SF-210690V-C160: Bezeichnung 02885387

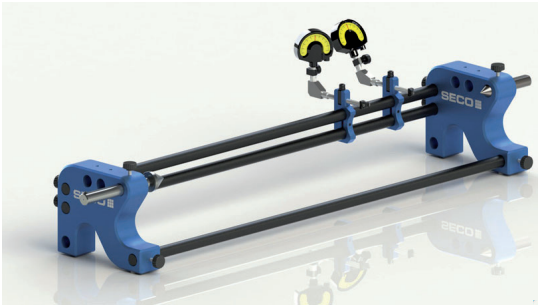
- Vertikales Gestell
- Erste Wahl für Xfix-Reibahlen
- Maximaler Werkzeugdurchmesser: 210 mm *(8.268")*
- Maximale Werkzeuglänge: 690 mm *(27.165")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm (2.244") Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.



Einstellgerät –Vorrichtungen 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 *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 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")*
- Zusätzliche gefederte Zentrierspitze mit 57 mm *(2.244")* Durchmesser für HSK 63/80/100 und Capto C8
- SSC5700 ist im Lieferumfang enthalten.

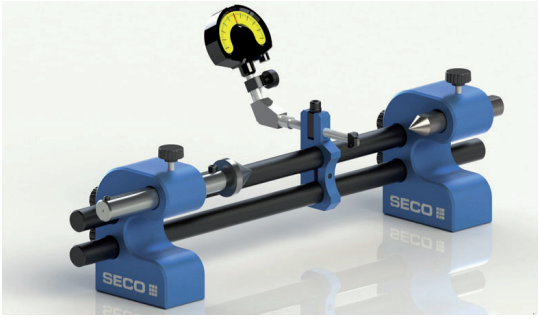


Weitere Informationen hierzu erhalten Sie von Ihrem zuständigen Seco Tools Ansprechpartner.

Einstellvorrichtung – Kompakt

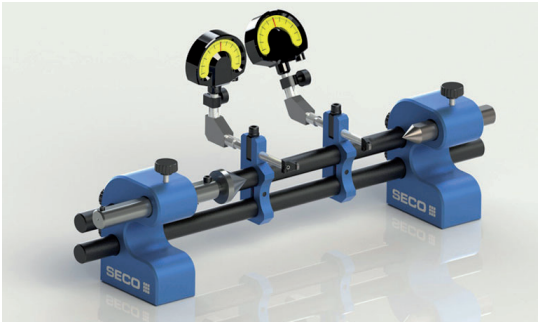
SF-60200-C160: Bezeichnung 02885395

- 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")*



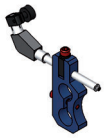
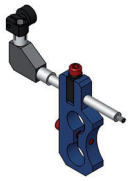
SF-60200-C160C190: Bezeichnung 02885396

- 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")*

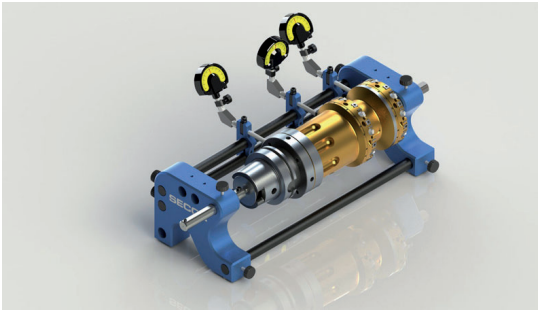


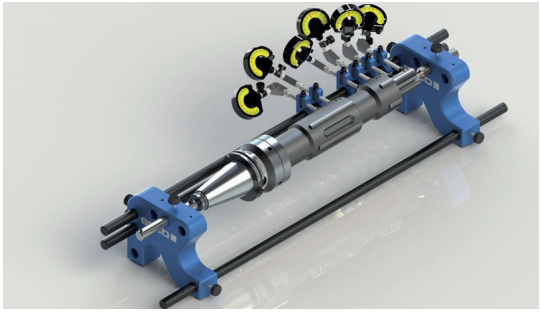
Weitere Informationen hierzu erhalten Sie von Ihrem zuständigen Seco Tools Ansprechpartner.

Zusätzliche Messfühler

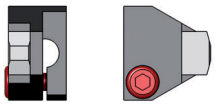
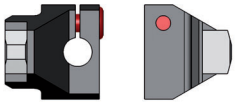
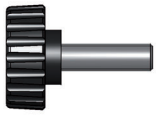
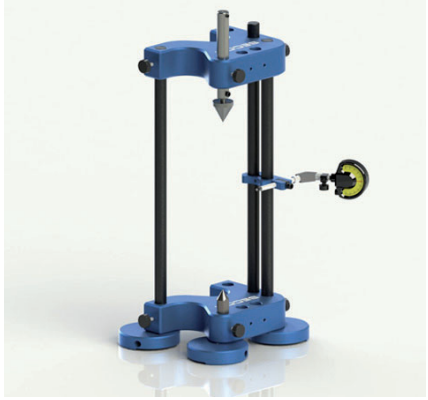
	**SFB-60: Bezeichnung 02208619** • Gewinkelter Halter 60° • Messuhr im Lieferumfang enthalten • Messtaster nicht im Lieferumfang enthalten, siehe Seite 489
	**SFB-60 WC: Bezeichnung 02885754** • Gewinkelter Halter 60° • Messuhr im Lieferumfang enthalten • Messtaster nicht im Lieferumfang enthalten, siehe Seite 489
	**SFB-90: Bezeichnung 02208622** • Gewinkelter Halter 90° • Messuhr im Lieferumfang enthalten • Messtaster nicht im Lieferumfang enthalten, siehe Seite 489
	**SFB-90 WC: Bezeichnung 02885755** • Gewinkelter Halter 90° • Messuhr im Lieferumfang enthalten • Messtaster nicht im Lieferumfang enthalten, siehe Seite 489
	**DG-1: Bezeichnung 75079579** • Messuhr, 1 µm *(0,00004")*

Beispiele von Einstellvorrichtungen mit mehreren Messuhren





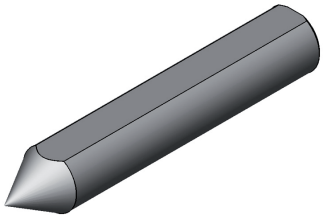
Zubehör

	**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")*
	**SMES-915: Bezeichnung 02208616** • Messpunkt für Bifix-Reibahlen • Hartmetall-Spitze • Versatz 15 mm *(0.591")*
	**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

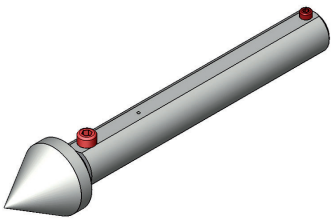
SFC-2000HM: Bezeichnung 02884023

- Durchmesser 20 mm *(0.787")*
- Geeignet für Xfix, Precifix und Bifix (Standardprodukte und Sonderlösungen)
- Für die Werkzeugvorderseite



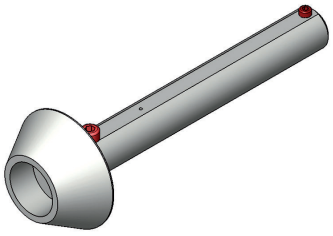
SSC-3400: Bezeichnung 02208617

- 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



AUSDREHKÖPFE



SCHRUPP- UND FEINAUSDREHKÖPFE FÜR MEHR FLEXIBILITÄT UND HERAUSRAGENDE ERGEBNISSE

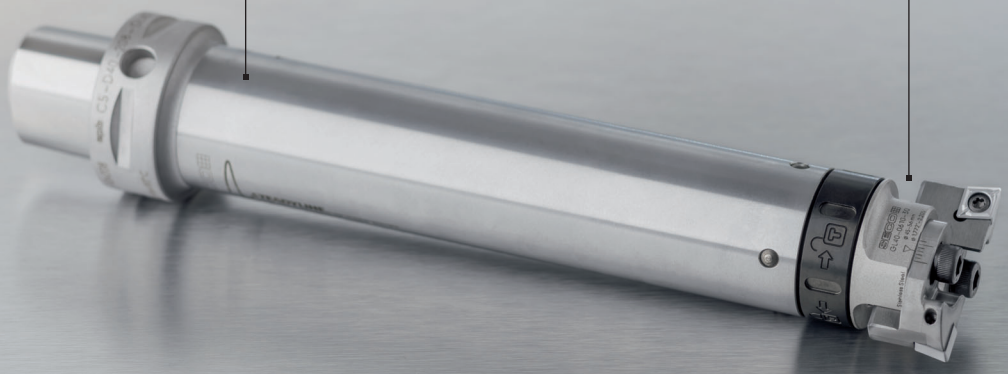
Seco Tools bietet ein umfangreiches Spektrum an Ausdrehköpfen mit Graflex®- und Seco-Capto™-Schnittstelle. Schruppausdrehköpfe ermöglichen starke, steife Systeme für hohe Zeitspanvolumen und präzise Bohrungsgeometrie bei gegossenen oder vorgebohrten Bohrungen. Feinausdrehköpfe ermöglichen eine Präzision bis 2.5 µm *(98.43 µin)* auf den Durchmesser, exzellente Oberflächengüten und enge Toleranzen von IT5.

GEEIGNETE WERKZEUGAUFNAHMEN

- Modulare Systeme Graflex® und Seco-Capto™ für optimierte und mehrwertige Systeme
- Schwingungsdämpfende Steadyline®-Lösungen für exzellente Leistung bei großen Auskragungen

AUSDREHKÖPFE

- Durchmesserbereich von 0,3 mm bis 3.205 mm *(0.0118" bis 126.181")*
- Schruppausdrehköpfe für hohe Zeitspanvolumen
- Feinausdrehköpfe für hohe Präzision, bis IT5, für exzellente Oberflächengüte



Übersicht

Graflex® und Seco-Capto™

Graflex® und Seco-Capto™ -Grundaufnahmen, -Erweiterungen und -Reduzierstücke zum Zusammenstellen von Bohrstangen




Seite(n) 494-553, 554

- Bohrstangen können schnell nach Erfordernis zusammengestellt werden. Hierfür eignen sich die modularen Systeme Graflex oder Seco-Capto mit einem umfassenden Programm an Grundaufnahmen und Zwischenstücken.
- Beide Systeme bieten steife und präzise Anschlüsse für Schrupp- oder Schlichtbearbeitungen.
- Die Module eignen sich für eine große Anzahl an Werkzeugaufnahmen, wie Spannzangen, Hydro-Dehnspannfutter, usw. (siehe Katalog Werkzeug-Systeme).

RB750 Ausdrehköpfe, Schruppausdrehen

Doppelschneider mit integriertem Kupplungsmechanismus für Wendeschneidplatten-Halter




Seite(n) 560-566

- 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

RB 610 Schruppausdrehköpfe

Doppelschneider





Seite(n) 572-575

- 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

FB 760 Ausdrehköpfe, Typ Axiabore™, Feinausdrehen

Feinausdrehköpfe für axiale Werkzeuge




Seite(n) 583-594

- 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

Durchmesserbereich 0,3 bis 108 mm
(0.012 bis 4.252")

sowie Zapfendrehen und Nutstechen

IT 5/6

Übersicht

FB 620, FB 780 und FB 790-Feinausdrehköpfe, radial

Feinausdrehköpfe mit radialen Wendeschneidplatten-Haltern



- Mikrometrische Einstellungen für hohe Präzision ab IT5
- 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 von 15 bis 205 mm
(0.591 bis 8.071")

IT 5/6

Seite(n) 613-621

Brückenwerkzeuge und Jumbo Ausdrehköpfe

Zum Schrupp- und Feinausdrehen großer Durchmesser



- 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

Durchmesserbereich 204 bis 3205 mm
(8.031-126.181")

IT 5/6 (zum Feinausdrehen) oder 9/10 (zum Schruppausdrehen) + Zapfendrehen

IT6

Seite(n) 623-640

Wendeschneidplatten zum Ausdrehen



- Zum Ausdrehen in allen Werkstoffen
- Hohe Zähigkeit für Schruppbearbeitungen
- Positive Geometrien zum Feinausdrehen
- Sortenauswahl für hohe Standzeit

Seite(n) 642-654

Graflex® oder Seco-Capto™ modulares Aufnahmesystem



- Alle Ausdrehköpfe haben eine Graflex® oder eine Seco-Capto™-Verbindung und sind daher äußerst flexibel einsetzbar. Sie eignen sich für eine Vielzahl von Ausdrehtiefen und -durchmessern.
- Wählen Sie die gewünschten Graflex® oder Seco-Capto™-Aufnahmen und Zwischenelemente aus dem Katalog Werkzeug-Systeme (HSK, DIN, BT, ANSI-CAT, Seco-Capto™.
- Ersatzteile für Graflex®-Anschlüsse finden Sie im entsprechenden Kapitel.

Seite(n) 655-657



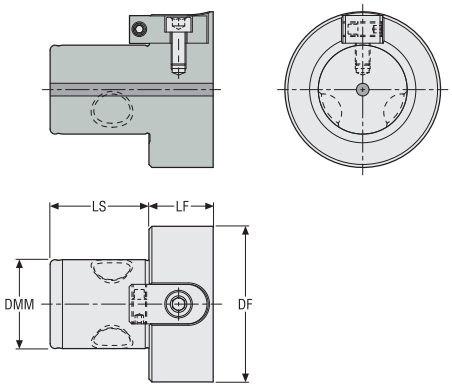
Graflex®

Graflex®-Aufnahmen sind verfügbar für Aufsteckfräser, Zwischenelemente, Werkzeughalter und Ausdrehköpfe, die schnell montiert werden können. Sie sind geeignet zum Fräsen, Bohren, Gewinden und Ausdrehen. Graflex®-Module ermöglichen den Einsatz verschiedener Längen und Durchmesser und können durch ersetzen der Graflex®-Grundaufnahme in allen Maschinen verwendet werden.

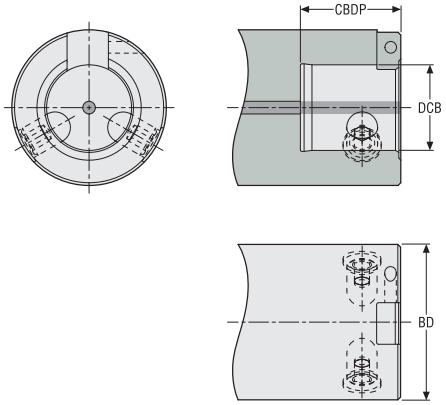
- Exzellente Anschlussfestigkeit
- Große Anzahl an Modulen für hohe Flexibilität
- Für interne Kühlschmierstoffzufuhr geeignet

Graflex®, Abmessungen

Maschinenseite



Werkstückseite



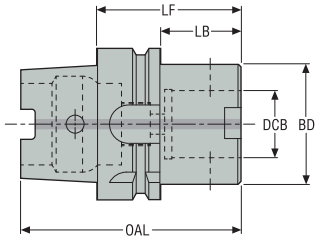
Maschinenseite	RFID-Bohrung*	DF	DMM	LS	LF
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
G0	Nein	16 *0.630*	8 *0.315*	12 *0.472*	8 *0.315*
G1	Nein	20 *0.787*	11 *0.433*	13 *0.512*	9,5 *0.374*
G2	Nein	25 *0.984*	14 *0.551*	16 *0.630*	11 *0.433*
G3	Nein	32 *1.260*	18 *0.709*	20 *0.787*	14 *0.551*
G4	Nein	40 *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*

G 401 – Graflex®-Aufnahmen

HSK-A/ ISO12164-1-HSK-A

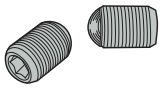




- HSK-Dichtungsstopfen, Kühlmittelrohre und Spannschlüssel, siehe Seite(n) 523

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-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	0,79 *1.740*
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	0,69 *1.520*
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	0,73 *1.610*
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	0,83 *1.830*
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	0,98 *2.160*
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	1,58 *3.480*
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	1,21 *2.670*
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	2,1 *4.630*
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	2,19 *4.830*
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	2,37 *5.220*
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	3,02 *6.660*
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	2,6 *5.730*
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	3,82 *8.420*
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	4,72 *10.410*
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	3,99 *8.800*
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

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®-Aufnahmen

DIN 69871-ADB



Abb. 1

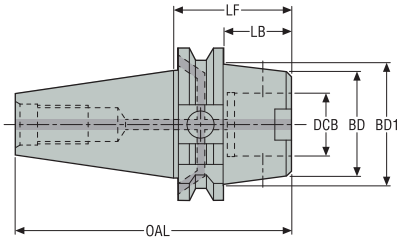
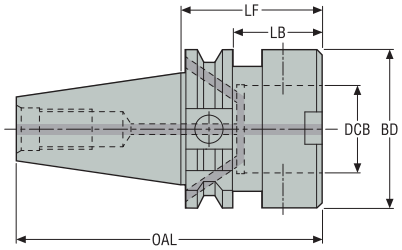


Abb. 2



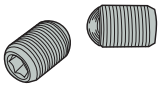
Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM34694011190	02503292	DIN40 ADB	G1	11,0 *0.433*	90,0 *3.543*	70,9 *2.791*	–	20,0 *0.787*	158,4 *6.236*	2	1	G6.3	0,94 *2.070*
EM34694011435	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	1,02 *2.250*
EM34694011835	02420097	DIN40 ADB	G3	18,0 *0.709*	35,0 *1.378*	15,9 *0.626*	50,0 *1.969*	32,0 *1.260*	103,4 *4.071*	1	1	G6.3	0,91 *2.010*
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	1,22 *2.690*
EM34694012235	02503299	DIN40 ADB	G4	22,0 *0.866*	35,0 *1.378*	15,9 *0.626*	50,0 *1.969*	40,0 *1.575*	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	1,44 *3.170*
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	0,93 *2.050*
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	2,08 *4.590*
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	1,24 *2.730*
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	2,65 *5.840*
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	2,8 *6.170*
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	3,0 *6.610*
EM34714012235	02503309	DIN50 ADB	G4	22,0 *0.866*	35,0 *1.378*	15,9 *0.626*	80,0 *3.150*	40,0 *1.575*	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	3,5 *7.720*
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	2,88 *6.350*
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	4,99 *11.000*

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
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	3,23 *7.120*
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	6,48 *14.290*
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*

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

Ersatzteile

Für Größe	Schraube	Dichtschrauben
		
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

G 401 – Graflex®-Aufnahmen

DIN 2080



Abb. 1

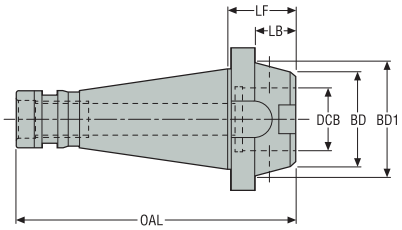
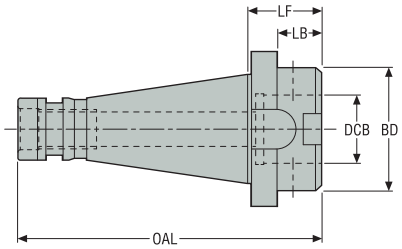


Abb. 2

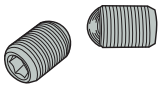


Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM00404013650	00076707	DIN(2080)40	G6	36,0 *1.417*	50,0 *1.969*	0,0 *0.0*	–	63,0 *2.480*	143,4 *5.646*	2	0	PB	1,27 *2.800*
EM00504012835	00076710	DIN(2080)50	G5	28,0 *1.102*	35,0 *1.378*	19,8 *0.780*	78,0 *3.071*	50,0 *1.969*	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	2,82 *6.220*
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*

Zubehör

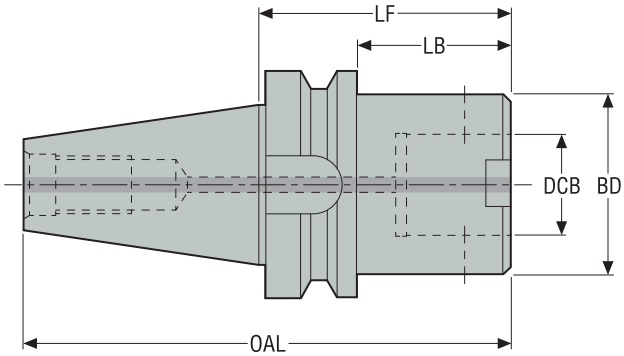
Für Größe	Spannschlüssel
	
G5	03H05
G6	03H06
G7	03H10

Ersatzteile

Für Größe	Schraube
	
G5	90F5
G6	90F6
G7	90F7

G 401 – Graflex®-Aufnahmen

BT JIS B 6339-AD



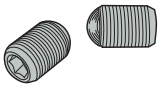


Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
EM40404011835	00056699	BT30 AD	G3	18,0 *0.709*	35,0 *1.378*	13,0 *0.512*	32,0 *1.260*	83,4 *3.283*	0	G6.3	0,41 *0.900*
EM40404012850	00056705	BT30 AD	G5	28,0 *1.102*	50,0 *1.969*	25,0 *0.984*	50,0 *1.969*	98,4 *3.874*	0	PB	0,62 *1.370*

Zubehör

Für Halter	Spannschlüssel
	
EM40404011835	03H03
EM40404012850	03H05

Ersatzteile

Für Halter	Schraube
	
EM40404011835	90F3
EM40404012850	90F5

G 401 – Graflex®-Aufnahmen

BT JIS B 6339-ADB



Abb. 1

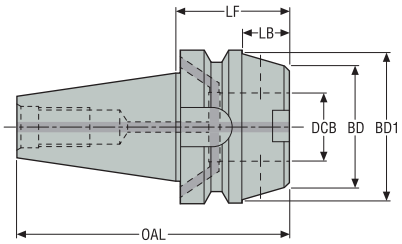
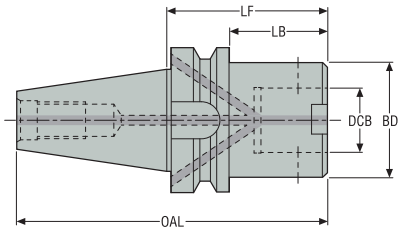


Abb. 2



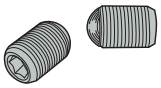
Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM34144011190	02503364	BT40 ADB	G1	11,0 *0.433*	90,0 *3.543*	63,0 *2.480*	–	20,0 *0.787*	155,4 *6.118*	2	1	G6.3	1,06 *2.340*
EM34144011440	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	1,15 *2.540*
EM34144011840	02503366	BT40 ADB	G3	18,0 *0.709*	40,0 *1.575*	13,0 *0.512*	62,0 *2.441*	32,0 *1.260*	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*	62,0 *2.441*	40,0 *1.575*	110,4 *4.346*	1	1	G6.3	1,14 *2.510*
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	1,54 *3.400*
EM34144012845	02457989	BT40 ADB	G5	28,0 *1.102*	45,0 *1.772*	18,0 *0.709*	62,0 *2.441*	50,0 *1.969*	110,4 *4.346*	1	1	PB	1,12 *2.470*
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	1,54 *3.400*
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	2,12 *4.670*
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	1,13 *2.490*
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	2,78 *6.130*
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	3,7 *8.160*
EM34164011845	02503376	BT50 ADB	G3	18,0 *0.709*	45,0 *1.772*	7,0 *0.276*	70,0 *2.756*	32,0 *1.260*	146,8 *5.780*	1	1	G6.3	3,58 *7.890*
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	3,9 *8.600*
EM34164012250	02503378	BT50 ADB	G4	22,0 *0.866*	50,0 *1.969*	12,0 *0.472*	70,0 *2.756*	40,0 *1.575*	151,8 *5.976*	1	1	G6.3	3,66 *8.070*
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	4,5 *9.920*
EM34164012855	02503380	BT50 ADB	G5	28,0 *1.102*	55,0 *2.165*	17,0 *0.669*	98,0 *3.858*	50,0 *1.969*	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	4,22 *9.300*
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	4,8 *10.580*
EM34164013663	02503383	BT50 ADB	G6	36,0 *1.417*	63,0 *2.480*	25,0 *0.984*	98,0 *3.858*	63,0 *2.480*	164,8 *6.488*	1	1	PB	4,2 *9.260*
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	4,6 *10.140*
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	5,54 *12.210*

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM34164014665	02503386	BT50 ADB	G7	46,0 *1.811*	65,0 *2.559*	27,0 *1.063*	98,0 *3.858*	90,0 *3.543*	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	6,8 *14.990*
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*

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

Ersatzteile

Für Größe	Schraube	Dichtschrauben
		
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

G 401 – Graflex®-Aufnahmen

BT Steilkegel mit Plananlage-AD/ADB



Abb. 1

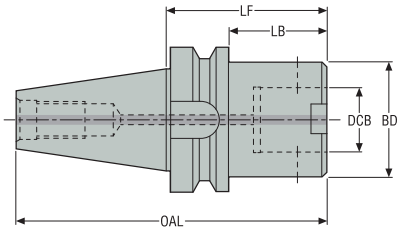
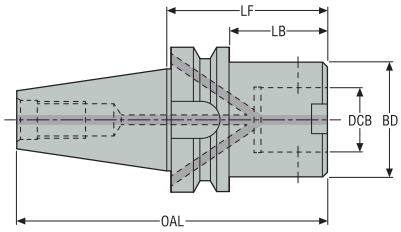


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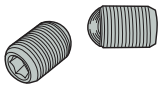


Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
EM40024011850	02998757	BT30 TF AD	G3	18,0 *0.709*	50,0 *1.969*	28,0 *1.102*	32,0 *1.260*	98,4 *3.874*	1	0	G6.3	0,5 *1.100*
EM40024012250	02998758	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	2,1 *4.630*
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	10,7 *23.590*

Zubehör

Für Halter	Spannschlüssel
	
EM40024011850	03H03
EM40024012250	03H04
EM321440122100	03H04
EM321440128120	03H05
EM321440136120	03H06
EM321640128140	03H05
EM321640136140	03H06
EM321640146200	03H10

Ersatzteile

Für Halter	Schraube	Dichtschrauben
		
EM40024011850	90F3	–
EM40024012250	90F4	–
EM321440122100	90F4	950A0406
EM321440128120	90F5	950A0406
EM321440136120	90F6	950A0406
EM321640128140	90F5	950A0606
EM321640136140	90F6	950A0606
EM321640146200	90F7	950A0606

G 401 – Graflex®-Aufnahmen

CAT / ASME B5.50-1994-ADB



Abb. 1

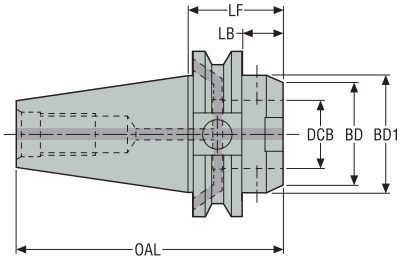
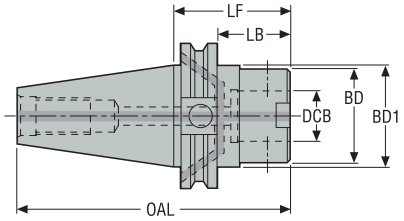


Abb. 2

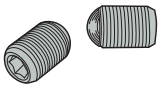


Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
EM25024011435	02469734	CAT40 ADB	G2	0.551	1.380	0.630	1.750	0.984	4.070	1	1	G6.3	2.120
EM25024011835	00056660	CAT40 ADB	G3	0.709	1.380	0.630	1.750	1.260	4.070	1	1	G6.3	2.090
EM25024012235	00056661	CAT40 ADB	G4	0.866	1.380	0.630	1.750	1.575	4.070	1	1	G6.3	2.030
EM25024012840	00056663	CAT40 ADB	G5	1.102	1.570	0.820	1.750	1.969	4.270	2	1	PB	1.980
EM250240128100	00056662	CAT40 ADB	G5	1.102	3.940	3.190	1.750	1.969	7.420	2	1	PB	3.860
EM25024013660	00056665	CAT40 ADB	G6	1.417	2.360	1.610	1.750	2.480	5.060	2	1	PB	2.710
EM25044011835	00056666	CAT50 ADB	G3	0.709	1.380	0.630	2.750	1.260	5.380	1	1	G6.3	6.720
EM25044012235	00056667	CAT50 ADB	G4	0.866	1.380	0.630	2.750	1.575	5.380	1	1	G6.3	6.530
EM25044012840	00056669	CAT50 ADB	G5	1.102	1.570	0.820	2.750	1.969	5.580	2	1	PB	6.590
EM250440128100	00056668	CAT50 ADB	G5	1.102	3.940	3.190	2.750	1.969	7.940	2	1	PB	8.380
EM25044013645	00056671	CAT50 ADB	G6	1.417	1.770	1.020	2.750	2.480	5.780	1	1	PB	7.050
EM250440136120	00056670	CAT50 ADB	G6	1.417	4.720	3.970	2.750	2.480	9.520	1	1	PB	10.140
EM25044014665	00056675	CAT50 ADB	G7	1.811	2.560	1.810	2.750	3.543	5.970	2	1	PB	8.330
EM250440146120	00056673	CAT50 ADB	G7	1.811	4.720	3.970	2.750	3.543	8.730	2	1	PB	13.800
EM250440146200	00056674	CAT50 ADB	G7	1.811	7.870	7.120	2.750	3.543	11.880	2	1	PB	22.750

Zubehör

Für Größe	Spannschlüssel
	
CAT40/ G2	03H025
CAT40/ G3	03H03
CAT40/ G4	03H04
CAT40/ G5	03H05
CAT40/ G6	03H06
CAT50/ G3	03H03
CAT50/ G4	03H04
CAT50/ G5	03H05
CAT50/ G6	03H06
CAT50/ G7	03H10

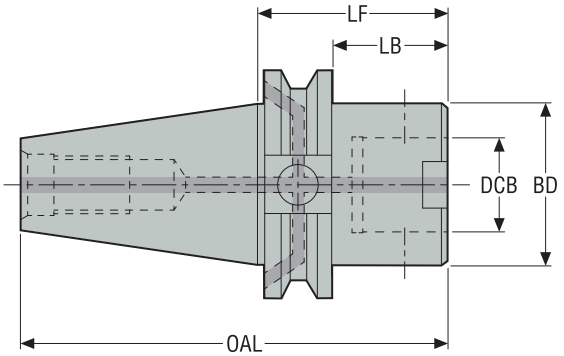
Ersatzteile

Für Größe	Schraube	Dichtschrauben
		
CAT40/ G2	90F2	950A0406
CAT40/ G3	90F3	950A0406
CAT40/ G4	90F4	950A0406
CAT40/ G5	90F5	950A0406
CAT40/ G6	90F6	950A0406
CAT50/ G3	90F3	950A0606
CAT50/ G4	90F4	950A0606
CAT50/ G5	90F5	950A0606
CAT50/ G6	90F6	950A0606
CAT50/ G7	90F7	950A0606

G 401 – Graflex®-Aufnahmen

CAT TF / ASME B5.50-2009-ADB



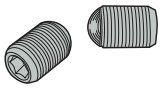


Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
EM26424011880	02998750	CAT40 TF ADB	G3	0.709	3.150	2.398	1.260	5.843	2	1	G6.3	2.650
EM26424012280	02998751	CAT40 TF ADB	G4	0.866	3.150	2.398	1.575	5.843	2	1	G6.3	3.090
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	5.070
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

Zubehör

Für Halter	Spannschlüssel
	
EM26424011880	03H03
EM26424012280	03H04
EM264240128100	03H05
EM264240136100	03H06
EM264440122100	03H04
EM264440128100	03H05
EM264440136120	03H06
EM264440146200	03H10

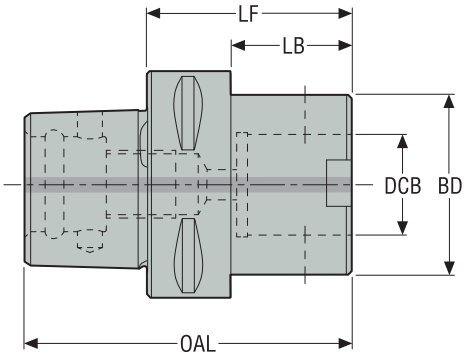
Ersatzteile

Für Halter	Schraube	Dichtschrauben
		
EM26424011880	90F3	950A0406
EM26424012280	90F4	950A0406
EM264240128100	90F5	950A0406
EM264240136100	90F6	950A0406
EM264440122100	90F4	950A0606
EM264440128100	90F5	950A0606
EM264440136120	90F6	950A0606
EM264440146200	90F7	950A0606

G 401 – Graflex® Adapter

Seco-Capto™



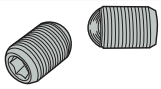


Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-391.0401-08025	02532939	C3	G0	8,0 *0.315*	25,0 *0.984*	7,0 *0.276*	16,0 *0.630*	44,0 *1.732*	0	G6.3	0,14 *0.310*
C3-391.0401-11025	02532940	C3	G1	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	0,15 *0.330*
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	0,31 *0.680*
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	0,47 *1.040*
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	0,51 *1.120*
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	0,64 *1.410*
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	0,84 *1.850*
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	0,89 *1.960*
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	1,04 *2.290*
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	1,19 *2.620*
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	1,92 *4.230*
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	2,02 *4.450*
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	2,71 *5.970*

Zubehör

Für Größe	Spannschlüssel
	
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

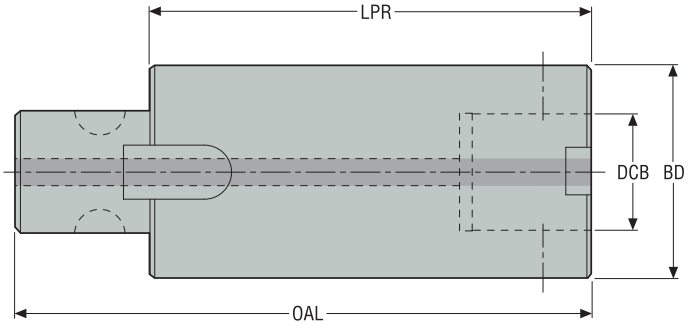
Ersatzteile

Für Größe	Schraube
	
G0	90F0
G1	90F1
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

G 402 – Graflex® Verlängerungen

Graflex®





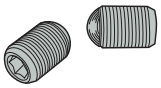
Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	DCB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M402000	00056752	G0	G0	30,0 *1.181*	8,0 *0.315*	16,0 *0.630*	42,0 *1.654*	0	PB	0,05 *0.110*
M402001	00056753	G0	G0	50,0 *1.969*	8,0 *0.315*	16,0 *0.630*	62,0 *2.441*	0	PB	0,08 *0.180*
M402110	00056754	G1	G1	30,0 *1.181*	11,0 *0.433*	20,0 *0.787*	43,0 *1.693*	0	PB	0,07 *0.150*
M402111	00056755	G1	G1	50,0 *1.969*	11,0 *0.433*	20,0 *0.787*	63,0 *2.480*	0	PB	0,12 *0.260*
M402220	00056756	G2	G2	30,0 *1.181*	14,0 *0.551*	25,0 *0.984*	46,0 *1.811*	0	PB	0,11 *0.240*
M402221	00056757	G2	G2	50,0 *1.969*	14,0 *0.551*	25,0 *0.984*	66,0 *2.598*	0	PB	0,18 *0.400*
M402330	00056758	G3	G3	40,0 *1.575*	18,0 *0.709*	32,0 *1.260*	60,0 *2.362*	0	PB	0,24 *0.530*
M402331	75056759	G3	G3	60,0 *2.362*	18,0 *0.709*	32,0 *1.260*	80,0 *3.150*	0	PB	0,36 *0.790*
M402440	00056760	G4	G4	40,0 *1.575*	22,0 *0.866*	40,0 *1.575*	64,0 *2.520*	0	PB	0,37 *0.820*
M402441	00056761	G4	G4	60,0 *2.362*	22,0 *0.866*	40,0 *1.575*	84,0 *3.307*	0	PB	0,57 *1.260*
M402444	02786252	G4	G4	200,0 *7.874*	22,0 *0.866*	40,0 *1.575*	224,0 *8.819*	0	PB	1,95 *4.300*
M402550	00056762	G5	G5	50,0 *1.969*	28,0 *1.102*	50,0 *1.969*	80,0 *3.150*	0	PB	0,72 *1.590*
M402551	00056763	G5	G5	75,0 *2.953*	28,0 *1.102*	50,0 *1.969*	105,0 *4.134*	0	PB	1,12 *2.470*
M402552	00056764	G5	G5	100,0 *3.937*	28,0 *1.102*	50,0 *1.969*	130,0 *5.118*	0	PB	1,48 *3.260*
M402554	02786254	G5	G5	250,0 *9.843*	28,0 *1.102*	50,0 *1.969*	280,0 *11.024*	0	PB	3,9 *8.600*
M402660	00056765	G6	G6	60,0 *2.362*	36,0 *1.417*	63,0 *2.480*	100,0 *3.937*	0	PB	1,38 *3.040*
M402661	00056766	G6	G6	90,0 *3.543*	36,0 *1.417*	63,0 *2.480*	130,0 *5.118*	0	PB	2,1 *4.630*
M402662	00056767	G6	G6	120,0 *4.724*	36,0 *1.417*	63,0 *2.480*	160,0 *6.299*	0	PB	2,82 *6.220*
M402664	02786255	G6	G6	300,0 *11.811*	36,0 *1.417*	63,0 *2.480*	340,0 *13.386*	0	PB	7,2 *15.870*
M402770	00056768	G7	G7	60,0 *2.362*	46,0 *1.811*	90,0 *3.543*	110,0 *4.331*	0	-	2,9 *6.390*
M402771	00056769	G7	G7	90,0 *3.543*	46,0 *1.811*	90,0 *3.543*	140,0 *5.512*	0	-	4,03 *8.880*

Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	DCB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M402772	00056770	G7	G7	120,0 *4.724*	46,0 *1.811*	90,0 *3.543*	170,0 *6.693*	0	-	5,8 *12.790*
M402774	02786257	G7	G7	300,0 *11.811*	46,0 *1.811*	90,0 *3.543*	350,0 *13.780*	0	-	14,6 *32.190*

Zubehör

Für Größe	Spannschlüssel
	
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

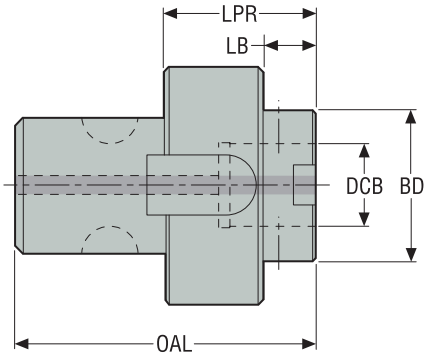
Ersatzteile

Für Größe	Schraube	Mitnehmer
		
G0	90F0	90M0
G1	90F1	90M1
G2	90F2	90M2
G3	90F3	90M3
G4	90F4	90M4
G5	90F5	90M5
G6	90F6	90M6
G7	90F7	90M7

G 403 – Graflex® Reduzierungen

Graflex®



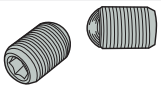


Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	LB	DCB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40310	00056771	G1	G0	30,0 *1.181*	22,0 *0.866*	8,0 *0.315*	16,0 *0.630*	43,0 *1.693*	0	PB	0,06 *0.130*
M40320	00056772	G2	G0	30,0 *1.181*	19,0 *0.748*	8,0 *0.315*	16,0 *0.630*	46,0 *1.811*	0	PB	0,08 *0.180*
M40321	00056773	G2	G1	30,0 *1.181*	19,0 *0.748*	11,0 *0.433*	20,0 *0.787*	46,0 *1.811*	0	PB	0,1 *0.220*
M40330	00056774	G3	G0	30,0 *1.181*	16,0 *0.630*	8,0 *0.315*	16,0 *0.630*	50,0 *1.969*	0	PB	0,15 *0.330*
M40331	00056775	G3	G1	30,0 *1.181*	16,0 *0.630*	11,0 *0.433*	20,0 *0.787*	50,0 *1.969*	0	PB	0,15 *0.330*
M40332	00056776	G3	G2	30,0 *1.181*	16,0 *0.630*	14,0 *0.551*	25,0 *0.984*	50,0 *1.969*	0	PB	0,16 *0.350*
M40341	00056778	G4	G1	30,0 *1.181*	13,0 *0.512*	11,0 *0.433*	20,0 *0.787*	54,0 *2.126*	0	PB	0,25 *0.550*
M40342	00056779	G4	G2	30,0 *1.181*	13,0 *0.512*	14,0 *0.551*	25,0 *0.984*	54,0 *2.126*	0	PB	0,27 *0.600*
M40343	00056780	G4	G3	30,0 *1.181*	13,0 *0.512*	18,0 *0.709*	32,0 *1.260*	54,0 *2.126*	0	PB	0,27 *0.600*
M40350	00056781	G5	G0	40,0 *1.575*	20,0 *0.787*	8,0 *0.315*	16,0 *0.630*	70,0 *2.756*	0	PB	0,47 *1.040*
M40351	00056783	G5	G1	40,0 *1.575*	20,0 *0.787*	11,0 *0.433*	20,0 *0.787*	70,0 *2.756*	0	PB	0,49 *1.080*
M40352	00056785	G5	G2	40,0 *1.575*	20,0 *0.787*	14,0 *0.551*	25,0 *0.984*	70,0 *2.756*	0	PB	0,49 *1.080*
M40353	00056787	G5	G3	40,0 *1.575*	20,0 *0.787*	18,0 *0.709*	32,0 *1.260*	70,0 *2.756*	0	PB	0,52 *1.150*
M40354	00056789	G5	G4	40,0 *1.575*	20,0 *0.787*	22,0 *0.866*	40,0 *1.575*	70,0 *2.756*	0	PB	0,55 *1.210*
M40363	00056797	G6	G3	40,0 *1.575*	14,0 *0.551*	18,0 *0.709*	32,0 *1.260*	80,0 *3.150*	0	PB	0,98 *2.160*
M40364	00056799	G6	G4	40,0 *1.575*	14,0 *0.551*	22,0 *0.866*	40,0 *1.575*	80,0 *3.150*	0	PB	0,97 *2.140*
M40365	00056807	G6	G5	45,0 *1.772*	19,0 *0.748*	28,0 *1.102*	50,0 *1.969*	85,0 *3.346*	0	PB	1,04 *2.290*
M40375	00056811	G7	G5	50,0 *1.969*	24,0 *0.945*	28,0 *1.102*	50,0 *1.969*	100,0 *3.937*	0	-	2,08 *4.590*
M40376	00056812	G7	G6	55,0 *2.165*	29,0 *1.142*	36,0 *1.417*	63,0 *2.480*	105,0 *4.134*	0	-	2,23 *4.920*

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

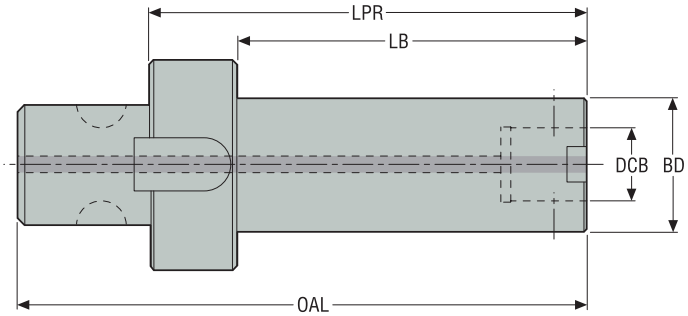
Ersatzteile

Für Größe	Schraube	Mitnehmer
		
M40310	90F0	90M1
M40320	90F0	90M2
M40321	90F1	90M2
M40330	90F0	90M3
M40331	90F1	90M3
M40332	90F2	90M3
M40341	90F1	90M4
M40342	90F2	90M4
M40343	90F3	90M4
M40350	90F0	90M5
M40351	90F1	90M5
M40352	90F2	90M5
M40353	90F3	90M5
M40354	90F4	90M5
M40363	90F3	90M6
M40364	90F4	90M6
M40365	90F5	90M6
M40375	90F5	90M7
M40376	90F6	90M7

G 403 – Graflex® lange Reduzierungen

Graflex®



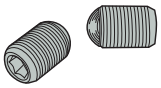


Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	LB	DCB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40350070	00056782	G5	G0	70,0 *2.756*	50,0 *1.969*	8,0 *0.315*	16,0 *0.630*	100,0 *3.937*	0	PB	0,51 *1.120*
M40351080	00056784	G5	G1	80,0 *3.150*	60,0 *2.362*	11,0 *0.433*	20,0 *0.787*	110,0 *4.331*	0	PB	0,57 *1.260*
M40352100	00056786	G5	G2	100,0 *3.937*	80,0 *3.150*	14,0 *0.551*	25,0 *0.984*	130,0 *5.118*	0	PB	0,71 *1.570*
M40353120	00056788	G5	G3	120,0 *4.724*	100,0 *3.937*	18,0 *0.709*	32,0 *1.260*	150,0 *5.906*	0	PB	1,02 *2.250*
M40354150	00056790	G5	G4	150,0 *5.906*	130,0 *5.118*	22,0 *0.866*	40,0 *1.575*	180,0 *7.087*	0	PB	1,62 *3.570*
M40361090	00056794	G6	G1	90,0 *3.543*	64,0 *2.520*	11,0 *0.433*	20,0 *0.787*	130,0 *5.118*	0	PB	1,08 *2.380*
M40362110	00056796	G6	G2	110,0 *4.331*	84,0 *3.307*	14,0 *0.551*	25,0 *0.984*	150,0 *5.906*	0	PB	1,23 *2.710*
M40363120	00056798	G6	G3	120,0 *4.724*	94,0 *3.701*	18,0 *0.709*	32,0 *1.260*	160,0 *6.299*	0	PB	1,46 *3.220*
M40364150	00056800	G6	G4	150,0 *5.906*	124,0 *4.882*	22,0 *0.866*	40,0 *1.575*	190,0 *7.480*	0	PB	2,07 *4.560*
M40365190	00056808	G6	G5	190,0 *7.480*	164,0 *6.457*	28,0 *1.102*	50,0 *1.969*	230,0 *9.055*	0	PB	3,2 *7.050*

Zubehör

Für Halter	Spannschlüssel 
M40350070	03H02
M40351080	03H02
M40352100	03H025
M40353120	03H03
M40354150	03H04
M40361090	03H02
M40362110	03H025
M40363120	03H03
M40364150	03H04
M40365190	03H05

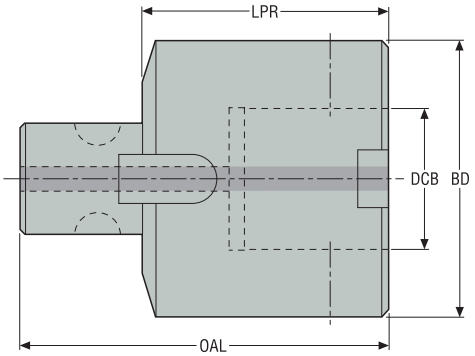
Ersatzteile

Für Halter	Schraube	Mitnehmer
		
M40350070	90F0	90M5
M40351080	90F1	90M5
M40352100	90F2	90M5
M40353120	90F3	90M5
M40354150	90F4	90M5
M40361090	90F1	90M6
M40362110	90F2	90M6
M40363120	90F3	90M6
M40364150	90F4	90M6
M40365190	90F5	90M6

G 403 – Graflex® Vergrößerungen

Graflex®



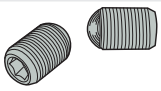


Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	DCB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
M40356	00056791	G5	G6	55,0 *2.165*	36,0 *1.417*	63,0 *2.480*	85,0 *3.346*	0	PB	1,08 *2.380*
M40367	00056810	G6	G7	80,0 *3.150*	46,0 *1.811*	90,0 *3.543*	120,0 *4.724*	0	PB	3,46 *7.630*

Zubehör

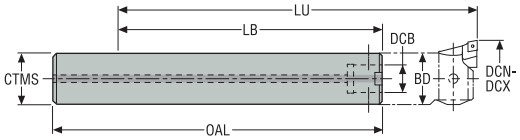
Für Halter	Spannschlüssel
	
M40356	03H06
M40367	03H10

Ersatzteile

Für Halter	Schraube	Mitnehmer
		
M40356	90F6	90M5
M40367	90F7	90M6

G 401 – Graflex® Aufnahmen, Stahl

Zylindrisch

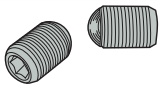




- Für Feinausdrehtiefe bis LU mit montiertem Ausdrehkopf Typ A780 oder A790
- Zylindrischer Anschluss maschinenseitig CTMS mit Toleranz h5, kompatibel mit Shrinkfit

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID-Bohrung	Auswuch-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	0,12 *0.260*
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	0,2 *0.440*
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	0,53 *1.170*
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	0,87 *1.920*

Ersatzteile

Für Halter	Schraube
	
M4011408	90F01
M4011608	90F0
M4012011	90F1
M4012514	90F2
M4013218	90F3

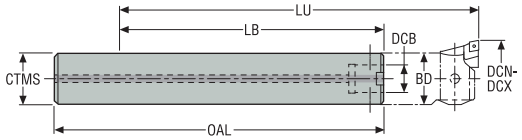
Zubehör

Für Halter	Spannschlüssel
	
M4011408	03H025
M4011608	03H02
M4012011	03H02
M4012514	03H025
M4013218	03H03

G 401 – Graflex® Aufnahmen, Stahl

Zylindrisch

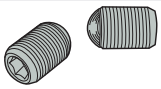




- Für Feinausdrehtiefe bis LU mit montiertem Ausdrehkopf Typ A780 oder A790
- Zylindrischer Anschluss maschinenseitig CTMS mit Toleranz h5, kompatibel mit Shrinkfit

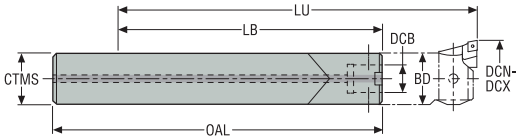
Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID-Bohrung	Auswuch-tung	Gewicht
		Zoll		*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*			lbs
M40107511	00056741	0.750	G1	0.433	0.906	1.220	5.906	0.827	5.510	3.906	0	G6.3	0.640

Ersatzteile

Für Halter	Schraube	Spannschlüssel
		
M40107511	90F1	03H02

G 401 – Graflex® Aufnahmen, Hartmetall

Zylindrisch

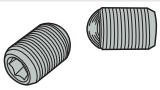




- Für Feinausdrehtiefe bis LU mit montiertem Ausdrehkopf Typ A780 oder A790
- CTMS Toleranz h5

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID-Bohrung	Auswuch-tung	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	0,31 *0.680*
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	0,47 *1.040*
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	0,89 *1.960*
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

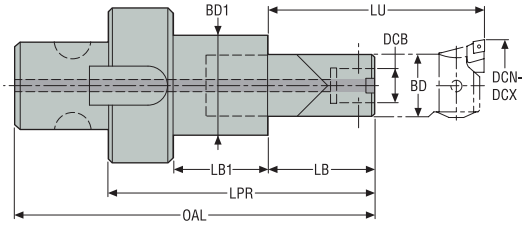
Für Halter	Schraube
	
M4011408C	90F01
M4011608C	90F0
M4012011C	90F1
M4012514C	90F2
M4013218C	90F3

Zubehör

Für Halter	Spannschlüssel
	
M4011408C	03H025
M4011608C	03H02
M4012011C	03H02
M4012514C	03H025
M4013218C	03H03

G 403 – Graflex® extra lange Reduzierungen, Hartmetall

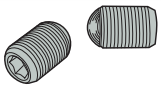




- Der Verlängerungsbereich besteht aus Hartmetall.
- Für Feinausdrehtiefe bis LU mit montiertem Ausdrehkopf Typ A780 oder A790

Bezeichnung	Produkt-nummer	CTMS	CTWS	DCB	DCN	DCX	LPR	LU	BD	BD1	LB1	LB	OAL	RFID-Bohrung	Auswuch-tung	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*	150,0 *5.906*	130,0 *5.118*	16,0 *0.630*	32,0 *1.260*	35,0 *1.378*	95,0 *3.740*	180,0 *7.087*	0	PB	1,0 *2.200*
M40351C180	00056943	G5	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	180,0 *7.087*	160,0 *6.299*	20,0 *0.787*	36,0 *1.417*	40,0 *1.575*	120,0 *4.724*	210,0 *8.268*	0	PB	1,33 *2.930*
M40352C220	00057605	G5	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	220,0 *8.661*	200,0 *7.874*	25,0 *0.984*	41,0 *1.614*	45,0 *1.772*	155,0 *6.102*	250,0 *9.843*	0	PB	2,01 *4.430*

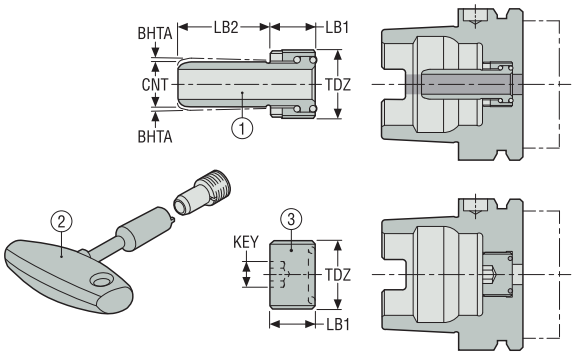
Ersatzteile

Für Halter	Schraube	Mitnehmer
		
M40350C150	90F0	90M5
M40351C180	90F1	90M5
M40352C220	90F2	90M5

Zubehör

Für Halter	Spannschlüssel
	
M40350C150	03H02
M40351C180	03H02
M40352C220	03H025

HSK Kühlmittelrohre, Spannschlüssel und Stopfen





- HSK-A-Seco-Capto™-Aufnahmen werden mit einem speziellen Kühlmittelrohr als Ersatzteil geliefert und benötigen einen speziellen Schlüssel, siehe Produktseite(n) 530, 531-532, 533

Bezeichnung	Bezeichnung	Produkt-nummer	Für Aufnahmen HSK Form 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
Kühlmittelrohr- Spannschlüssel (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	–	–	–	–	–	–
Stopfen (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™

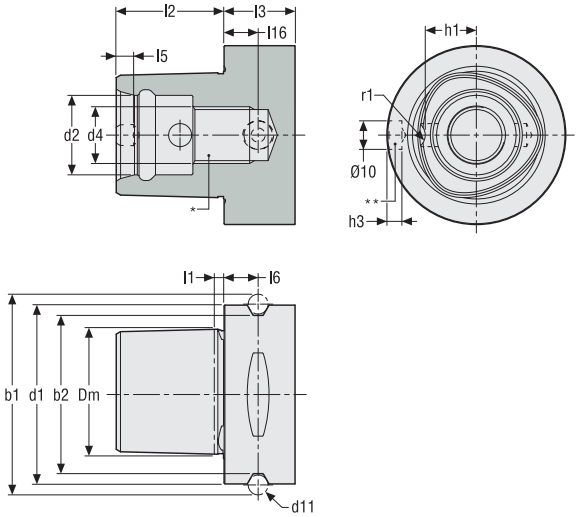
Seco-Capto™ ist ein modulares Schnellwechsel-Werkzeugsystem für alle Werkzeugmaschinen. Das modulare Seco-Capto™ Werkzeugsystem verwendet PSC (Polygonale Schaft-)Kupplungen, gemäß der Norm ISO 26623 und verfügt über einen selbsthemmenden Kegel.

- Seco-Capto™-Grundaufnahmen mit HSK-, DIN-, BT-Anschlüssen

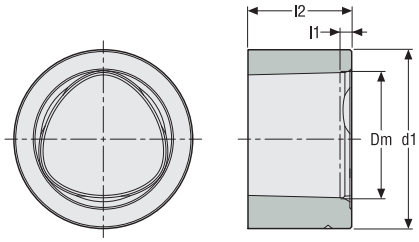
Seco-Capto™, Normabmessungen

ISO 26623-1-PSC/ ISO 26623-2-PSC

Maschinenseite



Werkstückseite



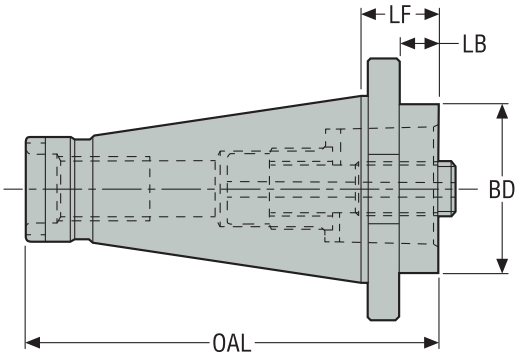
Maschinenseite	RFID-Bohrung**	d_1	d_2	d_4	d_{11}	Dm	b_1	b_2	l_1	l_2	$l_{3\,min}$	l_5	l_6	l_{16}	h_1	h_3	r_1
		mm *Zoll*	mm *Zoll*		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*
C3	Nein**	32 *1.260*	15 *0.591*	M12	5 *0.197*	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-Bohrung**	$d_{1\,min}$	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*

C 00 – DIN 2080 – Seco-Capto™-Aufnahmen – ISO 26623-2

DIN 2080



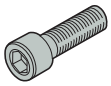


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-390.00-40030	75039844	DIN(2080)40	C3	30,0 *1.181*	18,4 *0.724*	32,0 *1.260*	123,4 *4.858*	0	-	0,8 *1.760*
C4-390.00-40030	75039848	DIN(2080)40	C4	30,0 *1.181*	18,4 *0.724*	40,0 *1.575*	123,4 *4.858*	0	-	0,82 *1.810*
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*

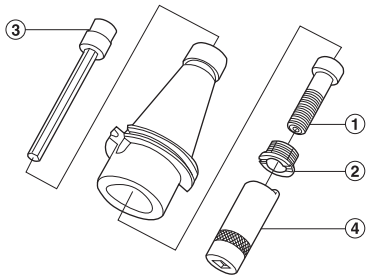
Zubehör

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

Ersatzteile

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 / Ersatzteile



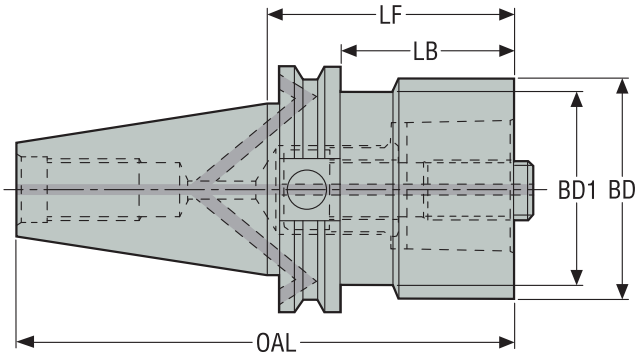
Zubehör:
3 = Verlängerungsschlüssel
4 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter

C 55/58 – CAT – Seco-Capto™ Aufnahmen

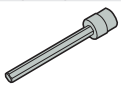
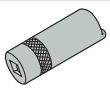
CAT / ASME B5.50-2009-ADB



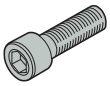


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	BD1	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
C3-A390B.45-40060	02925929	CAT40 ADB	C3	2.362	1.610	1.260	1.260	5.055	2	0	PB	2.200
C4-A390B.45-40030	02925932	CAT40 ADB	C4	1.181	0.429	1.575	1.575	3.874	2	0	PB	1.830
C4-A390B.45-40060	02925933	CAT40 ADB	C4	2.362	1.610	1.575	1.575	5.055	2	0	PB	2.430
C5-A390B.45-40040	02925935	CAT40 ADB	C5	1.575	0.823	1.969	1.969	4.268	2	0	PB	2.050
C5-A390B.45-40080	02925936	CAT40 ADB	C5	3.150	2.398	1.969	1.969	5.843	2	0	PB	3.310
C6-A390B.45-40085	02925939	CAT40 ADB	C6	3.346	1.378	2.480	2.480	6.039	2	0	PB	4.250
C3-A390B.45-50030	02925930	CAT50 ADB	C3	1.181	0.429	1.260	1.260	5.185	2	0	PB	5.730
C3-A390B.45-50060	02925931	CAT50 ADB	C3	2.362	1.610	1.260	1.260	6.366	2	0	PB	5.970
C4-A390B.45-50030	02925948	CAT50 ADB	C4	1.181	0.429	1.575	1.575	5.185	2	0	PB	5.780
C4-A390B.45-50060	02925934	CAT50 ADB	C4	2.362	1.610	1.969	1.575	6.366	2	0	PB	6.240
C5-A390B.45-50030	02925937	CAT50 ADB	C5	1.181	0.429	1.969	1.969	5.185	2	0	PB	5.730
C5-A390B.45-50070	02925938	CAT50 ADB	C5	2.756	2.004	1.969	1.969	6.760	2	0	PB	6.830
C6-A390B.45-50030	02925940	CAT50 ADB	C6	1.181	0.429	2.480	2.480	5.185	2	0	PB	5.530
C6-A390B.45-50080	02925941	CAT50 ADB	C6	3.150	2.398	2.480	2.480	7.154	2	0	PB	7.940
C8-A390B.45-50070	02925942	CAT50 ADB	C8	2.756	2.004	3.150	3.150	6.760	2	0	PB	8.220
C8-A390B.45-50120	02925943	CAT50 ADB	C8	4.724	3.972	3.150	3.150	8.728	2	0	PB	12.240

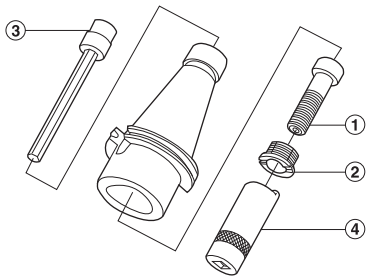
Zubehör

Für Größe	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

Ersatzteile

Für Größe	Zentrumsschraube	Stopfen	Sicherungsmutter
			
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
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 / Ersatzteile



Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 410 – HSK-A - Seco-Capto™ Aufnahmen – ISO 26623-2

HSK-A/ ISO12164-1-HSK-A



Abb. 1

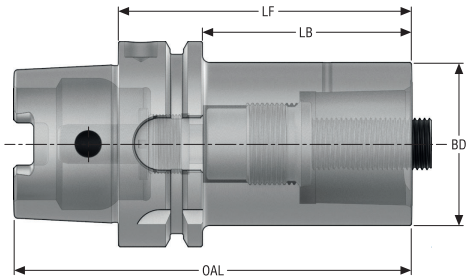
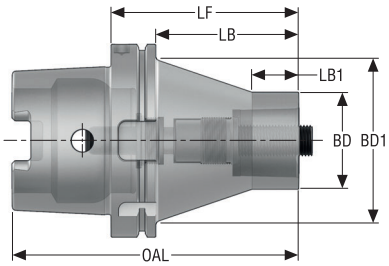
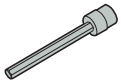
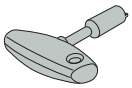
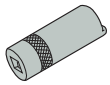


Abb. 2

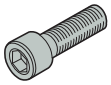
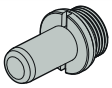


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C3-390.410-63075C	75039871	HSK-A63	C3	75,0 *2.953*	49,0 *1.929*	–	32,0 *1.260*	–	107,0 *4.213*	1	0	PB	0,9 *1.980*
C4-390.410-63080C	02425047	HSK-A63	C4	80,0 *3.150*	54,0 *2.126*	–	40,0 *1.575*	–	112,0 *4.409*	1	0	PB	1,06 *2.340*
C5-390.410-63090C	75039878	HSK-A63	C5	90,0 *3.543*	64,0 *2.520*	–	50,0 *1.969*	–	122,0 *4.803*	1	0	PB	1,41 *3.110*
C3-390.410-100080A	75039873	HSK-A100	C3	80,0 *3.150*	51,0 *2.008*	–	32,0 *1.260*	–	130,0 *5.118*	1	0	-	2,3 *5.070*
C4-390.410-100090A	75039877	HSK-A100	C4	90,0 *3.543*	61,0 *2.402*	–	40,0 *1.575*	–	140,0 *5.512*	1	0	-	2,5 *5.510*
C5-390.410-100100A	75039880	HSK-A100	C5	100,0 *3.937*	71,0 *2.795*	–	50,0 *1.969*	–	150,0 *5.906*	1	0	-	2,9 *6.390*
C6-390.410-100110A	75039882	HSK-A100	C6	110,0 *4.331*	81,0 *3.189*	–	63,0 *2.480*	–	160,0 *6.299*	1	0	-	3,56 *7.850*
C8-390.410-100120A	75039883	HSK-A100	C8	120,0 *4.724*	91,0 *3.583*	–	80,0 *3.150*	–	170,0 *6.693*	1	0	-	4,72 *10.410*
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	5,3 *11.680*
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*

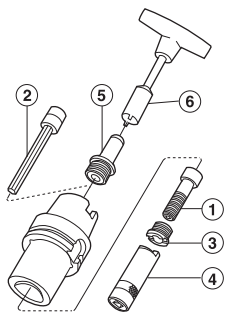
Zubehör

Für Halter	Verlängerungsschlüssel	Schlüssel	Spannschlüssel
			
C3-390.410-63075C	5680015-05	5680094-04	5680065-13
C4-390.410-63080C	5680015-05	5680094-04	5680065-10
C5-390.410-63090C	5680015-01	5680094-04	5680065-11
C3-390.410-100080A	5680015-05	5680094-06	5680065-13
C4-390.410-100090A	5680015-05	5680094-06	5680065-10
C5-390.410-100100A	5680015-01	5680094-06	5680065-11
C6-390.410-100110A	5680015-02	5680094-06	5680065-12
C8-390.410-100120A	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

Ersatzteile

Für Halter	Zentrumsschraube	Kühlmittelrohr	Sicherungsmutter
			
C3-390.410-63075C	5512063-10	5692020-04	5512091-04
C4-390.410-63080C	5512063-07	5692020-04	5512091-03
C5-390.410-63090C	5512063-08	5692020-04	5512091-01
C3-390.410-100080A	5512063-10	5692020-06	5512091-04
C4-390.410-100090A	5512063-07	5692020-06	5512091-03
C5-390.410-100100A	5512063-08	5692020-06	5512091-01
C6-390.410-100110A	5512063-09	5692020-06	5512091-02
C8-390.410-100120A	5512063-09	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 / Ersatzteile



Zubehör:
2 = Verlängerungsschlüssel
4 = Schraubenschlüssel
6 = Schlüssel für Kühlmittelrohr

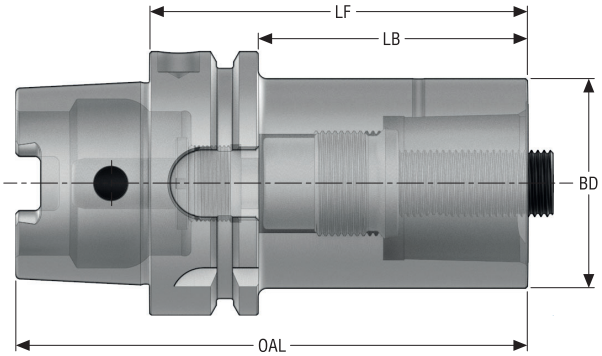
Ersatzteile:
1 = Zentrumsschraube
3 = Sicherungsmutter
5 = Kühlmittelrohr*

*Ein spezielles Kühlmittelrohr wird zusammen mit den HSK-A-Seco-Capto™-Aufnahmen geliefert

C 411 – HSK-T - Seco-Capto™ Aufnahmen – ISO 26623-2

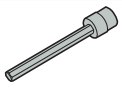
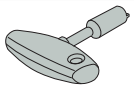
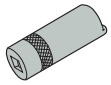
HSK-T/ ISO12164-3-HSK-T



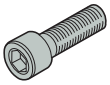
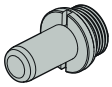


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C4-390.411-63080	02786511	HSK-T63	C4	80,0 *3.150*	54,0 *2.126*	40,0 *1.575*	112,0 *4.409*	1	-	1,0 *2.200*
C5-390.411-63090	02786520	HSK-T63	C5	90,0 *3.543*	64,0 *2.520*	50,0 *1.969*	122,0 *4.803*	1	-	1,3 *2.870*
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	-	2,4 *5.290*
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	-	2,7 *5.950*
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	-	3,3 *7.280*
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	-	4,5 *9.920*

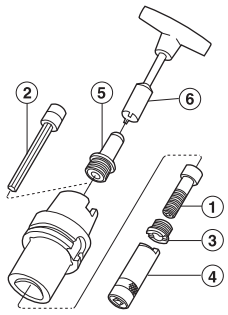
Zubehör

Für Halter	Verlängerungsschlüssel	Schlüssel	Spannschlüssel
			
C4-390.411-63080	5680015-05	5680094-04	5680065-10
C5-390.411-63090	5680015-01	5680094-04	5680065-11
C4-390.411-100090	5680015-05	5680094-06	5680065-10
C5-390.411-100100	5680015-01	5680094-06	5680065-11
C6-390.411-100110	5680015-02	5680094-06	5680065-12
C8-390.411-100120	5680015-02	5680094-06	5680065-12

Ersatzteile

Für Halter	Zentrumsschraube	Kühlmittelrohr	Sicherungsmutter
			
C4-390.411-63080	5512063-07	5692020-04	5512091-03
C5-390.411-63090	5512063-08	5692020-04	5512091-01
C4-390.411-100090	5512063-07	20E9306	5512091-03
C5-390.411-100100	5512063-08	20E9306	5512091-01
C6-390.411-100110	5512063-09	5692020-06	5512091-02
C8-390.411-100120	5512063-09	5692020-06	5512091-02

Zubehör / Ersatzteile



Zubehör:
2 = Verlängerungsschlüssel
4 = Schraubenschlüssel
6 = Schlüssel für Kühlmittelrohr

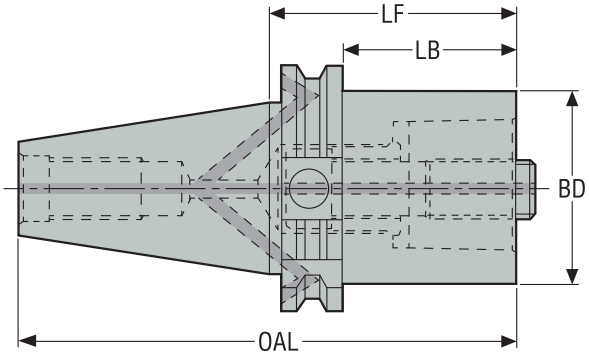
Ersatzteile:
1 = Zentrumsschraube
3 = Sicherungsmutter
5 = Kühlmittelrohr*

*Ein spezielles Kühlmittelrohr wird zusammen mit den HSK-A-Seco-Capto™-Aufnahmen geliefert

C 140 – DIN - Seco-Capto™ Aufnahmen – ISO 26623-2

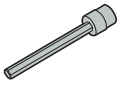
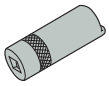
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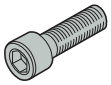


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-390B.140-40030	02924104	DIN40 ADB	C3	30,0 *1.181*	10,9 *0.429*	32,0 *1.260*	98,4 *3.874*	0	PB	0,8 *1.760*
C3-390B.140-40060	02924105	DIN40 ADB	C3	60,0 *2.362*	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	2,5 *5.510*
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	5,6 *12.350*

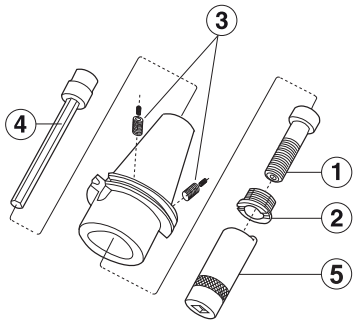
Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C3-400	5680015-05	5680065-13
C4-400	5680015-05	5680065-10
C5-400	5680015-01	5680065-11
C6-400	5680015-01	5680065-12
C3-500	5680015-05	5680065-13
C4-500	5680015-05	5680065-10
C5-500	5680015-01	5680065-11
C6-500	5680015-02	5680065-12
C8	5680015-02	5680065-12

Ersatzteile

Für Halter	Zentrumsschraube	Stopfen	Sicherungsmutter
			
C3-400	5512063-10	564301701	5512091-04
C4-400	5512063-07	564301701	5512091-03
C5-400	5512063-08	564301701	5512091-01
C6-400	5512063-13	564301701	5512091-02
C3-500	5512063-10	564301702	5512091-04
C4-500	5512063-07	564301702	5512091-03
C5-500	5512063-08	564301702	5512091-01
C6-500	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Zubehör / Ersatzteile



Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 5191 – Seco-Capto™ Grundaufnahmen – ISO 26623-2

DIN Steilkegel mit Plananlage-ADB



Abb. 1

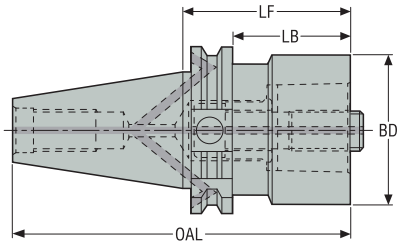
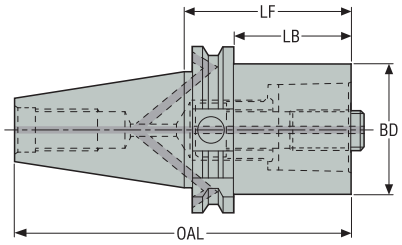
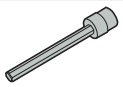
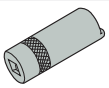


Abb. 2

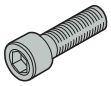


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
E316951915050	03030258	DIN40 TF ADB	C5	50,0 *1.969*	30,9 *1.217*	50,0 *1.969*	118,4 *4.661*	2	0	PB	1,1 *2.430*
E316951916385	03030259	DIN40 TF ADB	C6	85,0 *3.346*	65,9 *2.594*	63,0 *2.480*	153,4 *6.039*	1	0	PB	1,9 *4.190*
E317151914030	03030260	DIN50 TF ADB	C4	30,0 *1.181*	10,9 *0.429*	40,0 *1.575*	131,7 *5.185*	2	0	–	2,7 *5.950*
E317151915030	03030261	DIN50 TF ADB	C5	30,0 *1.181*	10,9 *0.429*	50,0 *1.969*	131,7 *5.185*	2	0	–	2,8 *6.170*
E317151915070	03030264	DIN50 TF ADB	C5	70,0 *2.756*	50,9 *2.004*	50,0 *1.969*	171,7 *6.760*	2	0	–	3,15 *6.940*
E317151916350	03030262	DIN50 TF ADB	C6	50,0 *1.969*	30,9 *1.217*	63,0 *2.480*	151,7 *5.972*	2	0	–	2,4 *5.290*
E3171519163100	03030265	DIN50 TF ADB	C6	100,0 *3.937*	80,9 *3.185*	63,0 *2.480*	201,7 *7.941*	2	0	–	4,08 *8.990*
E317151918070	03030263	DIN50 TF ADB	C8	70,0 *2.756*	50,9 *2.004*	80,0 *3.150*	171,7 *6.760*	2	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*	2	0	–	5,62 *12.390*

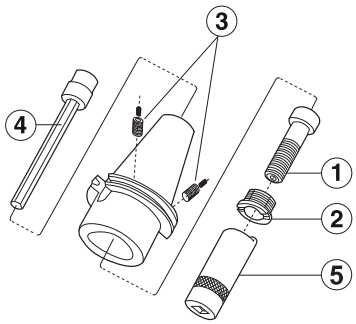
Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
DIN40 TF/ C5	5680015-01	5680065-11
DIN40 TF/ C6	5680015-01	5680065-12
DIN50 TF/ C4	5680015-05	5680065-10
DIN50 TF/ C5	5680015-01	5680065-11
DIN50 TF/ C6-C8	5680015-02	5680065-12

Ersatzteile

Für Halter	Zentrumsschraube	Stopfen	Sicherungsmutter
		 1x	
DIN40 TF/ C5	5512063-08	564301701	5512091-01
DIN40 TF/ C6	5512063-13	564301701	5512091-02
DIN50 TF/ C4	5512063-07	564301702	5512091-03
DIN50 TF/ C5	5512063-08	564301702	5512091-01
DIN50 TF/ C6-C8	5512063-09	564301702	5512091-02

Zubehör / Ersatzteile



Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 55/58 – BT - Seco-Capto™-Aufnahmen – ISO 26623-2

BT



Abb. 1

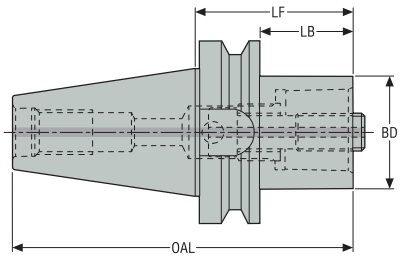
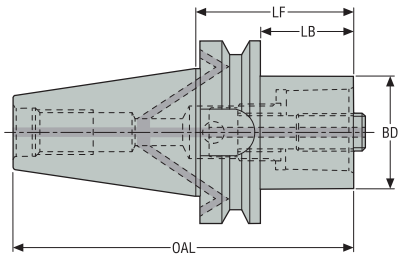
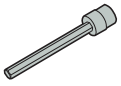
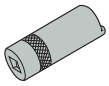


Abb. 2

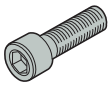


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
C3-390.55-30030	75039807	BT30 AD	C3	30,0 *1.181*	8,0 *0.315*	32,0 *1.260*	78,4 *3.087*	1	0	PB	0,53 *1.170*
C3-390.55-30060	75039808	BT30 AD	C3	60,0 *2.362*	38,0 *1.496*	32,0 *1.260*	108,4 *4.268*	1	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*	2	0	PB	0,9 *1.980*
C3-390B.55-40060	02925960	BT40 ADB	C3	60,0 *2.362*	33,0 *1.299*	32,0 *1.260*	125,4 *4.937*	2	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*	2	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*	2	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*	2	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*	2	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*	2	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*	2	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*	2	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*	2	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*	2	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*	2	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*	2	0	PB	4,0 *8.820*
C6-390B.58-50050	02925972	BT50 ADB	C6	50,0 *1.969*	12,0 *0.472*	63,0 *2.480*	151,8 *5.976*	2	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*	2	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*	2	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*	2	0	PB	5,9 *13.010*

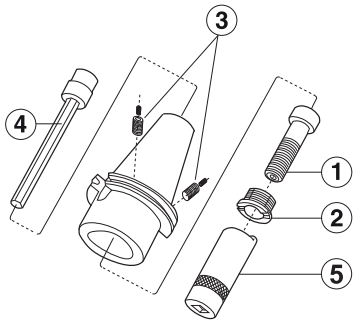
Zubehör

Für Halter	Verlängerungsschlüssel	Spannschlüssel
		
C3-390.55	5680015-05	5680065-13
C3-390B.55	5680015-05	5680065-13
C4-390B.55	5680015-05	5680065-10
C5-390B.55	5680015-01	5680065-11
C6-390B.55	5680015-01	5680065-12
C3-390B.58	5680015-05	5680065-13
C4-390B.58	5680015-05	5680065-10
C5-390B.58	5680015-01	5680065-11
C6-390B.58	5680015-02	5680065-12
C8	5680015-02	5680065-12

Ersatzteile

Für Halter	Zentrumsschraube	Stopfen	Sicherungsmutter
			
C3-390.55	5512063-10	–	5512091-04
C3-390B.55	5512063-10	564301701	5512091-04
C4-390B.55	5512063-07	564301701	5512091-03
C5-390B.55	5512063-08	564301701	5512091-01
C6-390B.55	5512063-13	564301701	5512091-02
C3-390B.58	5512063-10	564301702	5512091-04
C4-390B.58	5512063-07	564301702	5512091-03
C5-390B.58	5512063-08	564301702	5512091-01
C6-390B.58	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Zubehör / Ersatzteile



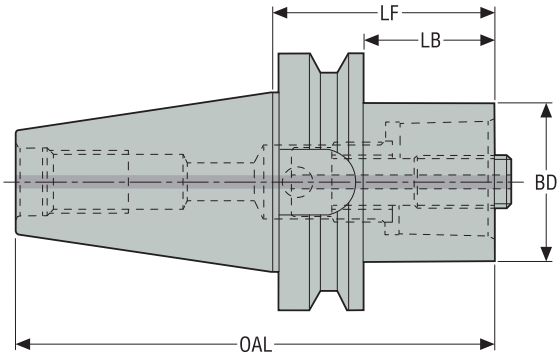
Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 605 – BT Mazak - Seco-Capto™-Aufnahmen – ISO 26623-2

BT Mazak

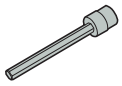
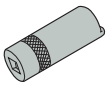




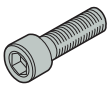
- Mazak-Ausführung heißt um 90° gedrehtes Seco-Capto™ Polygon im Vergleich zu klassischen BT Grundaufnahmen
- Für Mazak e-Maschinen

Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	RFID-Bohrung	Auswuch-tung	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	-	4,1 *9.040*

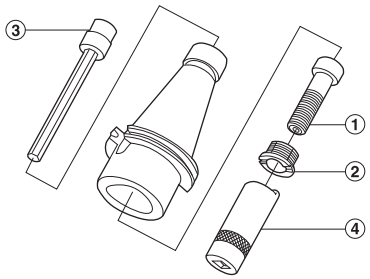
Zubehör

Für Größe	Verlängerungsschlüssel	Spannschlüssel
		
C5	5680015-01	5680065-11
C6	5680015-02	5680065-12
C8	5680015-02	5680065-12

Ersatzteile

Für Größe	Zentrumsschraube	Sicherungsmutter
		
C5	5512063-08	5512091-01
C6	5512063-09	5512091-02
C8	5512063-09	5512091-02

Zubehör / Ersatzteile



Zubehör:
3 = Verlängerungsschlüssel
4 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter

C 5191 – Seco-Capto™ Grundaufnahmen – ISO 26623-2

BT Steilkegel mit Plananlage-AD/ADB



Abb. 1

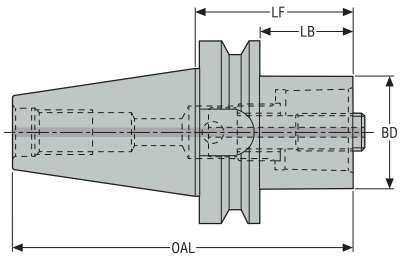
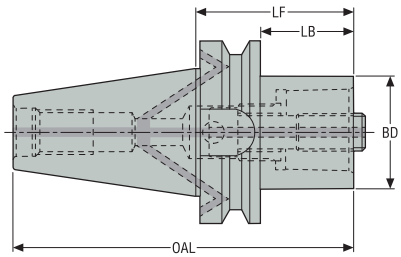
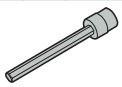
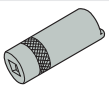


Abb. 2

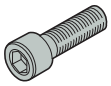


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	BD	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				kg *lbs*
E400251913240	03030234	BT30 TF AD	C3	40,0 *1.575*	22,0 *0.866*	32,0 *1.260*	88,4 *3.480*	1	0	PB	0,454 *1.000*
E400251914060	03030235	BT30 TF AD	C4	60,0 *2.362*	22,0 *0.866*	40,0 *1.575*	108,4 *4.268*	1	0	PB	0,651 *1.440*
E311451914040	03030236	BT40 TF ADB	C4	40,0 *1.575*	13,0 *0.512*	40,0 *1.575*	105,4 *4.150*	2	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*	2	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*	2	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*	2	0	PB	3,6 *7.940*
E311651915040	03030240	BT50 TF ADB	C5	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	2	0	PB	3,5 *7.720*
E311651916350	03030241	BT50 TF ADB	C6	50,0 *1.969*	12,0 *0.472*	63,0 *2.480*	151,8 *5.976*	2	0	PB	3,6 *7.940*
E3116519163100	03030242	BT50 TF ADB	C6	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	201,8 *7.945*	2	0	PB	4,63 *10.210*
E311651918070	03030243	BT50 TF ADB	C8	70,0 *2.756*	32,0 *1.260*	80,0 *3.150*	171,8 *6.764*	2	0	PB	4,2 *9.260*
E3116519180120	03030244	BT50 TF ADB	C8	120,0 *4.724*	82,0 *3.228*	80,0 *3.150*	121,8 *4.795*	2	0	PB	5,91 *13.030*

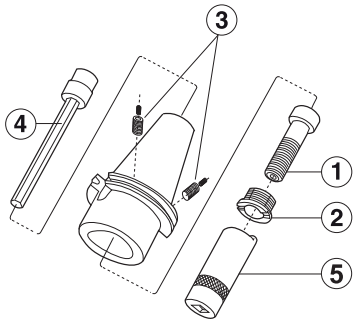
Zubehör

Für Größe	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

Ersatzteile

Für Größe	Zentrumsschraube	Stopfen	Sicherungsmutter
		 1x	
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 / Ersatzteile



Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 5191 – Seco-Capto™ Grundaufnahmen

CAT TF / ASME B5.50-1994-ADB



Abb. 1

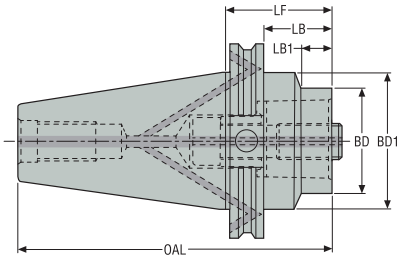
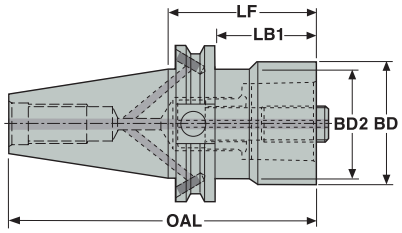
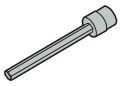
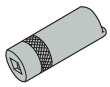


Abb. 2

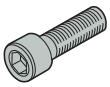


Bezeichnung	Produkt-nummer	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Abb.	RFID-Bohrung	Auswuch-tung	Gewicht
				Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*				lbs
E234251914040	03030246	CAT40 TF ADB	C4	1.575	0.140	0.140	1.575	1.750	4.270	1	0	PB	2.200
E234251915050	03030247	CAT40 TF ADB	C5	1.969	1.220	1.220	1.969	1.750	4.660	2	0	PB	2.250
E234451914040	03030249	CAT50 TF ADB	C4	1.575	0.090	0.090	1.575	2.750	5.580	1	0	–	6.830
E234451915040	03030250	CAT50 TF ADB	C5	1.575	0.090	0.090	1.969	2.750	5.580	1	0	–	6.390
E234451916340	03030251	CAT50 TF ADB	C6	1.575	0.120	0.120	2.480	2.750	5.580	1	0	–	6.390
E234451916390	03030252	CAT50 TF ADB	C6	3.543	2.085	2.085	2.480	2.750	7.543	1	0	–	8.660
E2344519180100	03030253	CAT50 TF ADB	C8	3.937	3.185	3.185	3.150	2.750	7.937	2	0	–	9.040
E2344519180150	03030254	CAT50 TF ADB	C8	5.906	5.154	5.154	3.150	2.750	9.906	2	0	–	14.350

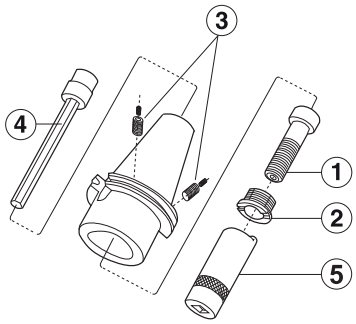
Zubehör

Für Größe	Verlängerungsschlüssel	Spannschlüssel
		
CAT40/ C4	5680015-05	5680065-10
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

Ersatzteile

Für Größe	Zentrumsschraube	Stopfen	Sicherungsmutter
			
CAT40/ C4	5512063-07	564301701	5512091-03
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 / Ersatzteile



Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 5191 – Seco-Capto™ Grundaufnahmen

CAT TF Mazak™ e-Machine und Mori Seiki NT™ -Serie



Abb. 1

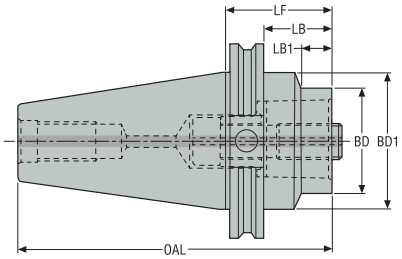
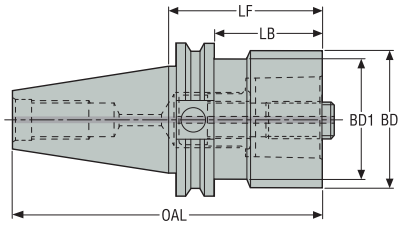


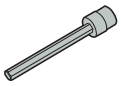
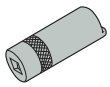
Abb. 2



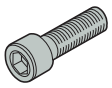
- 90° rotiertes Polygon für präzise Kontrolle der Werkzeugschneide

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	-	6.830
E947451918070	03030256	CAT50 TF AD Mazak	C8	2.756	2.000	2.000	3.150	2.750	6.756	2	0	-	7.890
E945451918070	03030257	CAT50 TF AD Mazak	C8	2.756	2.000	2.000	3.150	3.543	6.756	1	0	-	9.040

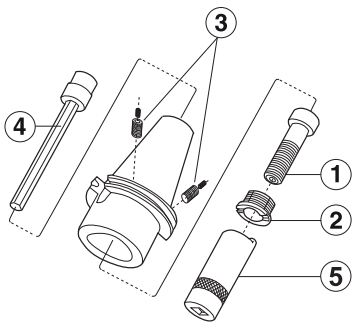
Zubehör

Für Größe	Verlängerungsschlüssel	Spannschlüssel
		
E947451916350	5680015-02	5680065-12
E947451918070	5680015-02	5680065-12
E945451918070	5680015-02	5680065-12

Ersatzteile

Für Größe	Zentrumsschraube	Sicherungsmutter
		
E945451918070	5512067-04	5512091-02
E947451916350	5512063-09	5512091-02
E947451918070	5512063-09	5512091-02

Zubehör / Ersatzteile

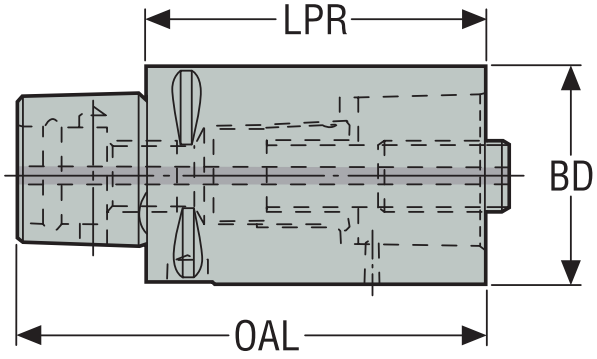


Zubehör:
4 = Verlängerungsschlüssel
5 = Schraubenschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter
3 = Dichtstopfen

C 01 – Seco-Capto™ Verlängerungen

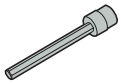
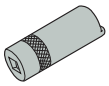
ISO 26623-1



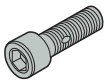


Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	BD	OAL	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*			kg *lbs*
C3-391.01-32060A	75039884	C3	C3	60,0 *2.362*	32,0 *1.260*	79,0 *3.110*	0	-	0,34 *0.750*
C3-391.01-32080A	00090847	C3	C3	80,0 *3.150*	32,0 *1.260*	99,0 *3.898*	0	-	0,45 *0.990*
C4-391.01-40060A	75039885	C4	C4	60,0 *2.362*	40,0 *1.575*	84,0 *3.307*	0	-	0,54 *1.190*
C4-391.01-40080A	02207391	C4	C4	80,0 *3.150*	40,0 *1.575*	104,0 *4.094*	0	-	0,71 *1.570*
C5-391.01-50080A	75039886	C5	C5	80,0 *3.150*	50,0 *1.969*	110,0 *4.331*	0	-	1,12 *2.470*
C5-391.01-50100A	00004773	C5	C5	100,0 *3.937*	50,0 *1.969*	130,0 *5.118*	0	-	1,39 *3.060*
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	-	3,62 *7.980*
C8-391.01-80125A	00004841	C8	C8	125,0 *4.921*	80,0 *3.150*	173,0 *6.811*	0	-	4,54 *10.010*

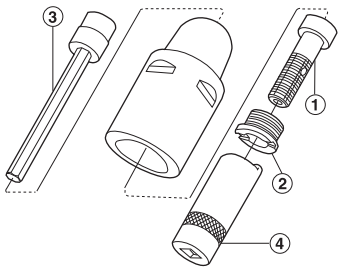
Zubehör

Für Größe	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

Ersatzteile

Für Größe	Zentrumsschraube	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 / Ersatzteile



Zubehör:
3 = Verlängerungsschlüssel
4 = Schlüssel für Sicherungsmutter

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter

C 02 – Seco-Capto™-Reduzierstück

ISO 26623-1

Abb. 1

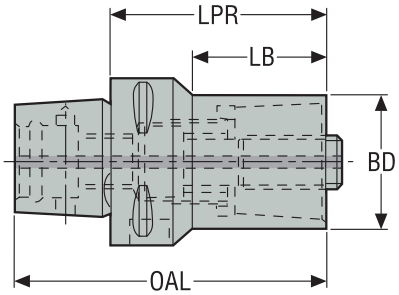
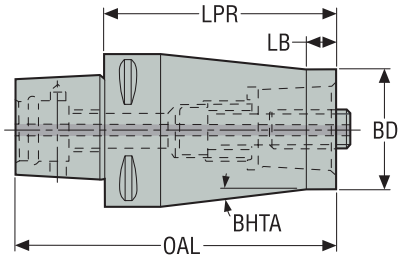


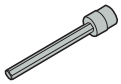
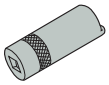
Abb. 2



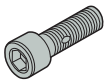


Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	LB	BD	OAL	Abb.	BHTA°	RFID-Bohrung	Auswuch-tung	Gewicht
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					kg *lbs*
C4-391.02-32055A	75039889	C4	C3	55,0 *2.165*	31,0 *1.220*	32,0 *1.260*	79,0 *3.110*	1	–	0	-	0,42 *0.930*
C4-391.02-32070A	02535687	C4	C3	70,0 *2.756*	12,0 *0.472*	32,0 *1.260*	94,0 *3.701*	2	6,0	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	-	0,64 *1.410*
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	-	0,77 *1.700*
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	-	1,06 *2.340*
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	-	1,24 *2.730*
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	-	1,45 *3.200*
C6-391.02-50110A	02207400	C6	C5	110,0 *4.331*	12,0 *0.472*	50,0 *1.969*	148,0 *5.827*	2	4,5	0	-	2,15 *4.740*
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	6,0	0	-	3,96 *8.730*

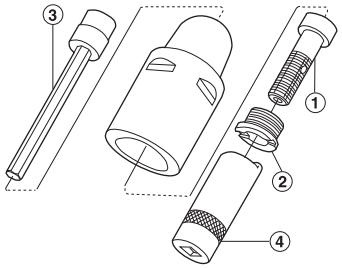
Zubehör

Für Größe	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

Ersatzteile

Für Größe	Zentrumsschraube	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 / Ersatzteile

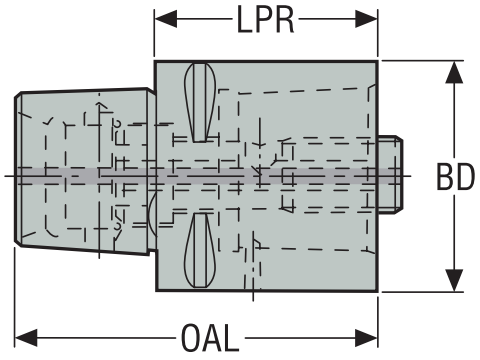


Zubehör:
3 = Verlängerungsschlüssel
4 = Schlüssel für Sicherungsmutter

Ersatzteile:
1 = Zentrumsschraube
2 = Sicherungsmutter

C 01 – Seco-Capto™ Verlängerungen, kurze Ausführung, nur für Spannelemente

ISO 26623-1

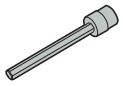




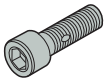
- Die maschinenseitige Verbindung der kurzen Seco-Capto™ Verlängerungen kann nur durch Spindeln mit Spannelementen erfolgen (nicht mittels Zentrierklemmung)

Bezeichnung	Produkt-nummer	CTMS	CTWS	LPR	BD	OAL	RFID-Bohrung	Auswuch-tung	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	-	0,21 *0.460*
C4-391.01-40040	02535686	C4	C4	40,0 *1.575*	40,0 *1.575*	64,0 *2.520*	0	-	0,37 *0.820*
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	-	1,31 *2.890*
C8-391.01-80065	02417041	C8	C8	65,0 *2.559*	80,0 *3.150*	113,0 *4.449*	0	-	2,3 *5.070*

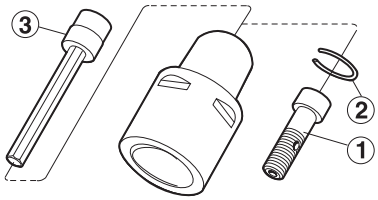
Zubehör

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

Ersatzteile

Für Halter	Zentrumsschraube	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 / Ersatzteile

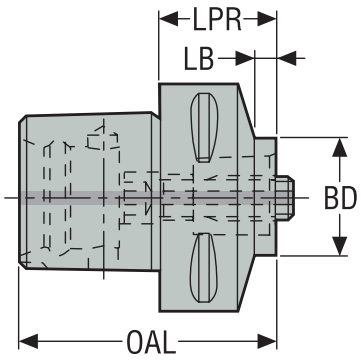


Zubehör:
3 = Verlängerungsschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Seegerring

C 02 – Seco-Capto™ Reduzierungen, kurze Ausführung, nur für Spannelemente

ISO 26623-1

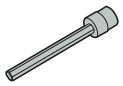




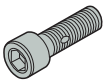
- Der maschinenseitige Seco-Capto™ Anschluss kurzer Reduzierungen kann nur durch Spindeln mit Spannelementen (nicht mit zentraler Anzugsschraube) erfolgen
- * Mit 180° Versatz maschinenseitig vs. werkstückseitig

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	0,5 *1.100*
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	-	0,93 *2.050*
C6-391.02-50050A	03080019	C6	C5	50,0 *1.969*	20,0 *0.787*	50,0 *1.969*	88,0 *3.465*		0	-	1,0 *2.200*
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*

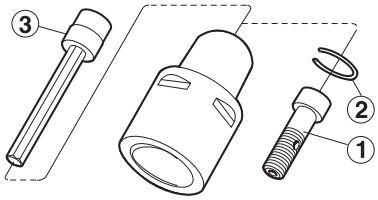
Zubehör

Für Halter	Verlängerungsschlüssel
	
C5-391.02-32033A	5680015-05
C5-391.02-40040A	5680015-05
C6-391.02-32032	5680015-05
C6-391.02-40040	5680015-05
C6-391.02-50050A	5680015-01
C8-391.02-50045A	5680015-01
C8-391.02-63055A	5680015-02
C8-391.02R-63055A	5680015-02

Ersatzteile

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 / Ersatzteile



Zubehör:
3 = Verlängerungsschlüssel

Ersatzteile:
1 = Zentrumsschraube
2 = Seegerring



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.

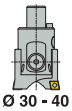
- RB 750 Schruppausdrehköpfe bieten höchste Schruppleistung
- RB 610 Schruppausdrehköpfe sind kurze, einfache und robuste Ausdrehköpfe zum Schruppen

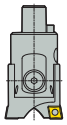
Übersicht Schruppausdrehköpfe

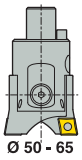
Graflex®

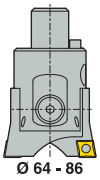

Ø 18-24 *(Ø 0.709"-0.945")*

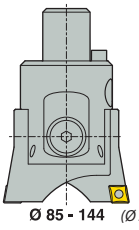

Ø 23 - 31 *(Ø 0.906"-1.220")*

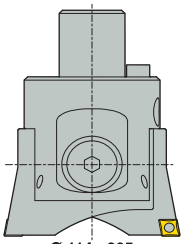

Ø 30 - 40 *(Ø 1.181"-1.575")*


Ø 39 - 51 *(Ø 1.535"-2.008")*

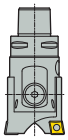

Ø 50 - 65 *(Ø 1.968"-2.559")*

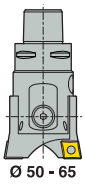

Ø 64 - 86 *(Ø 2.520"-3.386")*

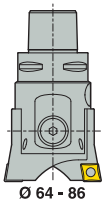

Ø 85 - 144 *(Ø 3.346"-5.669")*

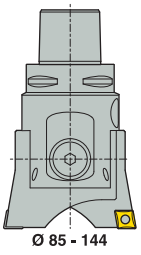

Ø 114 - 205
(Ø 4.488"-8.071")

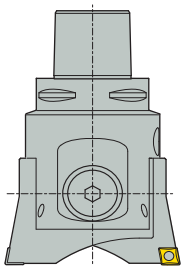
Seco-Capto™


Ø 39 - 51 *(Ø 1.535"-2.008")*

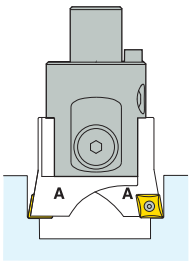

Ø 50 - 65 *(Ø 1.968"-2.559")*

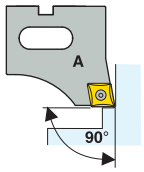

Ø 64 - 86 *(Ø 2.520"-3.386")*

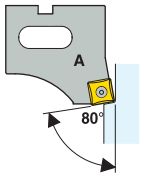

Ø 85 - 144 *(Ø 3.346"-5.669")*


Ø 114 - 205
(Ø 4.488"-8.071")

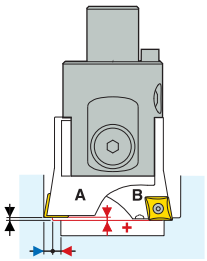
Symmetrische Bearbeitung:
2 Standard-Wendeschneidplatten-Halter Typ A

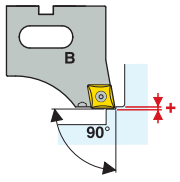


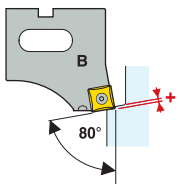




Asymmetrische Bearbeitung:
1 verlängerter Halter Typ B und 1 Standard-Werkzeughalter Typ A



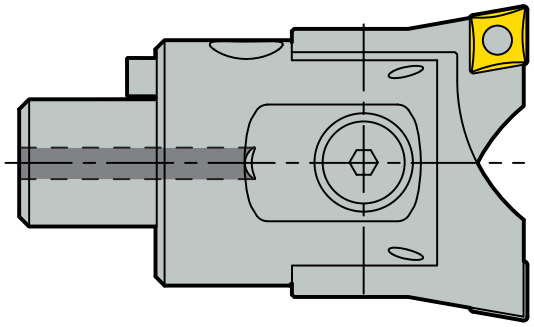




Merkmale

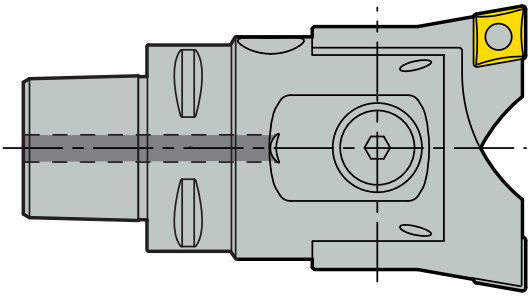
Graflex® Schruppausdrehköpfe

- 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")*



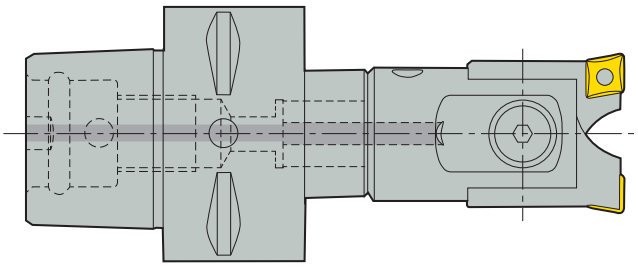
Seco-Capto™ Schruppausdrehköpfe

- **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.



Seco-Capto™ Schruppausdrehköpfe

- **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 zu Seco-Capto™ und Graflex®-Adapter und modulare Erweiterungen: siehe Katalog Werkzeug-Systeme



Merkmale

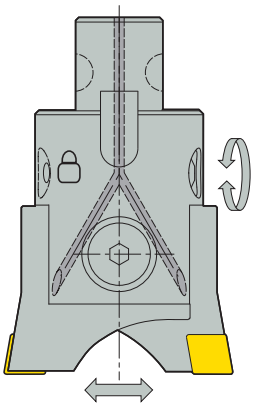
Ein Schruppausdrehwerkzeug besteht aus einem Werkzeugkörper (Kopf) und zwei Wendeschneidplatten-Haltern.

Eine symmetrische oder asymmetrische Einstellung der Wendeschneidplatten-Halter ist möglich:

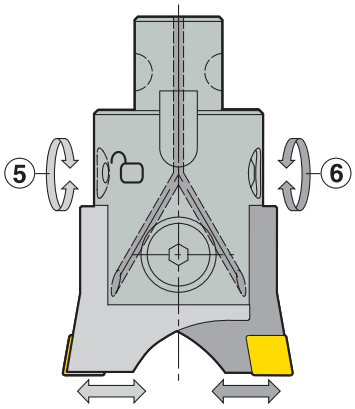
Der Wendeschneidplatten-Halter wird durch einen Kupplungsmechanismus symmetrisch eingestellt (nicht beim kleinsten Kopf 18 bis 24 mm *(0,709-0,9445")*.

Hierbei werden beide Wendeschneidplatten-Halter gleichzeitig durch den Verzahnungsmechanismus der Einstellschrauben eingestellt.

Eine Durchmessereinstellung ist ohne Voreinstellung möglich (Mikrometer-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.

Merkmale

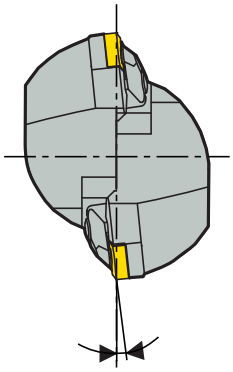
Wendeplattenhalter-Typ CC, CP, SC oder CN

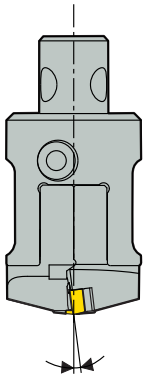
A750...CC..., A750...CP... und A750...SC... Wendeschneidplatten-Halter haben einen Spanwinkel von 0° (GAMO) und einen Neigungswinkel von 0° (LAMS).

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 646) 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.

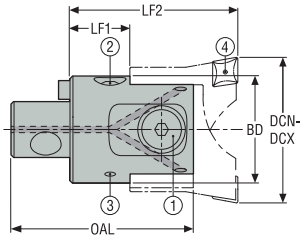




RB750

Graflex®





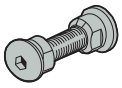
- Symmetrische oder asymmetrische Positionierung ist möglich.
- Synchrone Einstellung der Wendeschneidplatten-Halter durch Einstellschraube

1. Spannschraube
2. Einstellschraube
3. Klemmschraube des Kupplungsmechanismus
4. Klemmschraube für Wendeschneidplatte

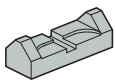
Bezeichnung	Produkt-nummer	Maschinen-seite Graflex Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Symmetrische Einstellung		Asymmetrische Einstellung		Max. Dreh-zahl
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Ja	Nein	Ja	Nein	
A75000	00026687	G0	18,0 *0.709*	24,0 *0.945*	38,0 *1.496*	12,5 *0.492*	35,0 *1.378*	16,5 *0.650*	0,03 *0.070*		■	■		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*	0,11 *0.240*	■		■		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*	0,5 *1.100*	■		■		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*	0,46 *1.010*	■		■		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*	0,8 *1.760*	■		■		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*	1,69 *3.730*	■		■		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

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 562-566
Hinweis: Gewicht ohne Aufnahme

Ersatzteile

Für Kopf	Schraube	Schlüssel für Pratze	Antriebs-schlüssel	Schlüssel für WSP	Schlüssel (Quergriff)	Einstell-schlüssel	Mitnehmer
							
A75000	90A75000	03HL03	–	H4B-T07P	DOUBLE-T	H1.5-2D	90M0
A75010	90A75010	03HL03	H4B-T06P	H4B-T07P	DOUBLE-T	H1.5-2D	90M11
A75020	90A75020	03HL04	H4B-T07P	–	DOUBLE-T	H2.0-2D	90M21
A75030	90A75030	03HL05	H4B-T08P	–	DOUBLE-T	H2.0-2D	90M31
A75040	90A75040	03HL05	H4B-T09P	–	DOUBLE-T	H2.5-2D	90M41
A75050	90A75050	03HL06	–	–	DOUBLE-T	03M03C	90M51
A75060	90A75060	03HL08	–	–	DOUBLE-T	H04-4	90M61
A75070	90A75070	03HL10	H4B-T15P	H4B-T15PL	DOUBLE-T	H04-4	90M71

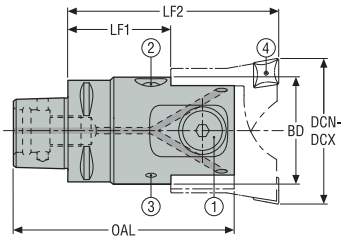
Zubehör

Einstelllehre

–
CAA75010
CAA75020
CAA75030
CAA75040
CAA75050
CAA75060
CAA75070

Zubehör, separat zu bestellen

RB750

Seco-Capto™



1. Spannschraube
2. Einstellschraube
3. Klemmschraube des Kupplungsmechanismus
4. Klemmschraube für Wendeschneidplatte

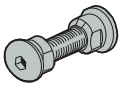


- Symmetrische oder asymmetrische Positionierung ist möglich.
- Synchrone Einstellung der Wendeschneidplatten-Halter durch Einstellschraube

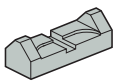
Bezeichnung	Produkt-nummer	Maschinen-seite	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Synchrone Einstellung		Einzelne Einstellung		Max. Dreh-zahl
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Ja	Nein	Ja	Nein	
C3-391.0750-30	02809726	C3	39,0 *1.535*	51,0 *2.008*	73,0 *2.874*	29,0 *1.142*	70,0 *2.756*	35,0 *1.378*	0,28 *0.620*	■		■		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*	0,52 *1.150*	■		■		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*	0,94 *2.070*	■		■		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*	1,88 *4.140*	■		■		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*	4,14 *9.130*	■		■		2500

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 562-566
Hinweis: Gewicht ohne Aufnahme

Ersatzteile

Für Kopf	Schraube	Schlüssel für Pratze	Antriebsschlüssel	Schlüssel (Quergriff)	Einstell-schlüssel
					
C3-...-30	90A75030	03HL05	H4B-T08P	DOUBLE-T	H2.0-2D
C4-...-40	90A75040	03HL05	H4B-T09P	DOUBLE-T	H2.5-2D
C5-...-50	90A75050	03HL06	–	DOUBLE-T	03M03C
C6-...-60	90A75060	03HL08	–	DOUBLE-T	H04-4
C8-...-70	90A75070	03HL10	–	DOUBLE-T	H04-4

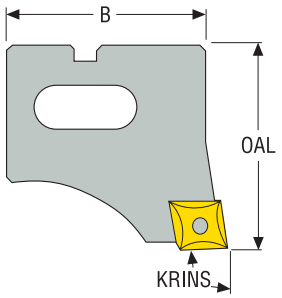
Zubehör

Einstelllehre

CAA75030
CAA75040
CAA75050
CAA75060
CAA75070

Zubehör, separat zu bestellen

90° Halter für WSP-Typ CC.. und CP..





- Für Schruppausdrehköpfe RB 750
- Symmetrischer Einsatz mit zwei Wendeschneidplatten-Haltern Typ A.
- Versetzter Einsatz mit einem Wendeschneidplatten-Halter Typ A und einem verlängerten Wendeschneidplatten-Halter Typ B.

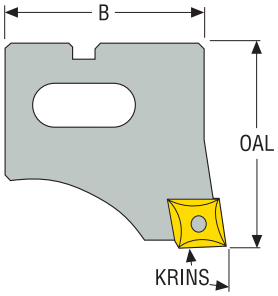
Bezeichnung	Produkt-nummer	WSP-Halter Typ	Für Kopf	Bereich DCN-DCX ∅		OAL	B	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
A75000CP0590	00026695	Standard Typ A	RB 75000	18,0 *0.709*	24,0 *0.945*	22,5 *0.886*	16,5 *0.650*	0,01 *0.020*	90	CP...0502...
A75010CC0690	00026696	Standard Typ A	RB 75010	23,0 *0.906*	31,0 *1.220*	26,5 *1.043*	21,5 *0.846*	0,02 *0.040*	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*	0,04 *0.090*	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*	0,08 *0.180*	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*	0,14 *0.310*	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*	0,25 *0.550*	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*	0,55 *1.210*	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*	0,55 *1.210*	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*	0,89 *1.960*	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 *1.980*	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*	1,18 *2.600*	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*	1,18 *2.600*	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 *4.410*	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 *4.410*	90	CC...1605...

Ersatzteile

Für WSP	Schlüssel für WSP	Schlüssel (Quergriff)	Schraube
			
CP...0502...	H4B-T07P	DOUBLE-T	C02245-T07P
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

Für Schruppausdrehen empfohlene Wendeschneidplatten, siehe Seite(n) 646

90° Halter für WSP-Typ CC.. und CP..





- Für Schruppausdrehköpfe RB 750
- Symmetrischer Einsatz mit zwei Wendeschneidplatten-Haltern Typ A.
- Versetzter Einsatz mit einem Wendeschneidplatten-Halter Typ A und einem verlängerten Wendeschneidplatten-Halter Typ B.

Bezeichnung	Produkt-nummer	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*	0,01 *0.020*	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*	0,02 *0.040*	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*	0,04 *0.090*	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*	0,08 *0.180*	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*	0,13 *0.290*	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 *0.550*	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*	0,55 *1.210*	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*	0,55 *1.210*	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*	0,91 *2.010*	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 *2.010*	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*	1,16 *2.560*	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 *2.560*	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 *4.410*	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*	2,01 *4.430*	90	CC...1605...

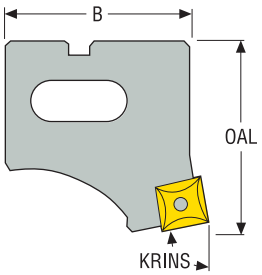
Ersatzteile

Für WSP	Schlüssel (Quergriff)	Schlüssel	Schraube
			
CP...0502...	DOUBLE-T	H4B-T07P	C02245-T07P
CC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
CC...09T3...	DOUBLE-T	–	C04008-T15P
CC...1204...	DOUBLE-T	–	C05012-T15P
CC...1605...	DOUBLE-T	–	C05012-T15P

Für Schruppausdrehen empfohlene Wendeschneidplatten, siehe Seite(n) 646

80° Halter für WSP-Typ SC..





- Für Schruppausdrehköpfe RB 750
- Symmetrischer Einsatz mit zwei Wendeschneidplatten-Haltern Typ A.
- Versetzter Einsatz mit einem Wendeschneidplatten-Halter Typ A und einem verlängerten Wendeschneidplatten-Halter Typ B.

Bezeichnung	Produkt-nummer	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*	0,01 *0.020*	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*	0,02 *0.040*	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*	0,04 *0.090*	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*	0,08 *0.180*	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*	0,03 *0.070*	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*	0,25 *0.550*	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 *1.230*	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 *1.230*	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*	0,94 *2.070*	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 *2.200*	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 *2.650*	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 *2.600*	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*	2,09 *4.610*	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 *4.630*	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 *0.020*	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 *0.040*	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 *0.090*	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 *0.180*	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*	0,14 *0.310*	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*	0,26 *0.570*	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 *1.260*	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 *1.260*	80	SC...1204...

Bezeichnung	Produkt-nummer	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*		
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 *2.120*	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 *2.120*	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*	1,21 *2.670*	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 *2.670*	80	SC...1505...
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 *4.760*	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 *4.720*	80	SC...1505...

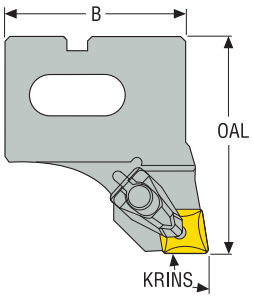
Ersatzteile

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...1204...	DOUBLE-T	–	C05012-T15P
SC...1505...	DOUBLE-T	–	C05012-T15P

Für Schruppausdrehen empfohlene Wendeschneidplatten, siehe Seite(n) 646

90° Haler für WSP-Typ CN..





- Für Schruppausdrehköpfe RB 750
- Symmetrischer Einsatz mit zwei Wendeschneidplatten-Haltern Typ A (Verlängerte Wendeschneidplatten-Halter Typ B für CN..-Wendeschneidplatte nicht verfügbar).
- GAMO = Spanwinkel = - 6°
- LAMS = Axialwinkel = - 6°

Bezeichnung	Produkt-nummer	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*	0,28 *0.620*	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*	0,58 *1.280*	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*	0,98 *2.160*	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*	1,25 *2.760*	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 *4.480*	90	CN...1204...

Ersatzteile

Für WSP	Schraube	Klemmkit	Auflageplatte	Schlüssel (Quergriff)
				
CN...1204...	CSC6312-T15P	CD12-S12	UCN120612	DOUBLE-T

Für Schruppausdrehen empfohlene Wendeschneidplatten, siehe Seite(n) 646

Empfohlene Zerspanungsbedingungen

Spindelleistung:

Da beim Schruppausdrehen eine hohe Maschinenleistung gefordert wird, empfehlen wir zu prüfen, ob die Maschine hierfür geeignet ist. Asymmetrische Bearbeitung ist eine Lösung, um die benötigte Leistung zu senken, da der Vorschub für die gesamte Schnitttiefe im Vergleich zur symmetrischen Bearbeitung durch zwei geteilt 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 können Sie auch auf www.secotools.com herunterladen.

Maximale Schnittgeschwindigkeiten für Schruppausdrehköpfe

Kopf	Durchmesserbereich mm	*Durchmesserbereich Zoll*	Max. Drehzahl	Angenommene max. Schnittgeschwindigkeit v_c im min. Bereich m/min *(sf/min)*	Angenommene max. Schnittgeschwindigkeit v_c im max. Bereich m/min *(sf/min)*
Schruppausdrehköpfe (mit zwei identischen Wendeplattenhaltern für symmetrischen Einsatz) 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)*
Schruppausdrehköpfe (mit zwei identischen Wendeplattenhaltern für symmetrischen Einsatz) 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)*

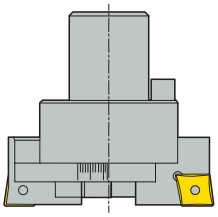
Hinweis: Die maximale Geschwindigkeit ist abhängig vom Design des Ausdrehkopfes und seiner Auswuchtqualität. Innerhalb dieser Grenzen müssen die Geschwindigkeiten auch im Hinblick auf Werkstoff, Schneidkanten Wendeschneidplatte), Werkzeuglänge, Maschinenspindel etc. angepasst werden. Bei Geschwindigkeiten ab ca. 8.000 U/min müssen die Aufnahmen und Zwischenelemente feinausgewuchtet sein.

Problembehandlung

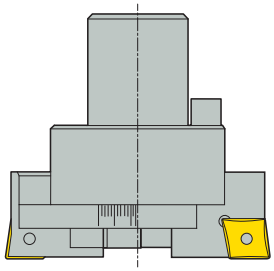
Position	Mögliche Ursache	Lösung
Keine Spankontrolle	Vorschub zu niedrig	Vorschub erhöhen
	Zu große Schnitttiefe	Versetzte Bearbeitung wählen
Rattern & Vibrationen	Zu hohe Geschwindigkeit	Geschwindigkeit, nicht Vorschub reduzieren
	Extremes Längen-Durchmesser-Verhältnis	Werkzeug kürzen, um Stabilität zu erhöhen
		Außendurchmesser der Aufnahme und des Zwischenstückes erhöhen
		Eine Steadyline-Bohrstange verwenden.
		Hart- oder Schwermetall-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

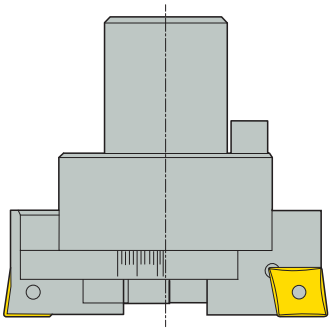
Graflex® Anschluss



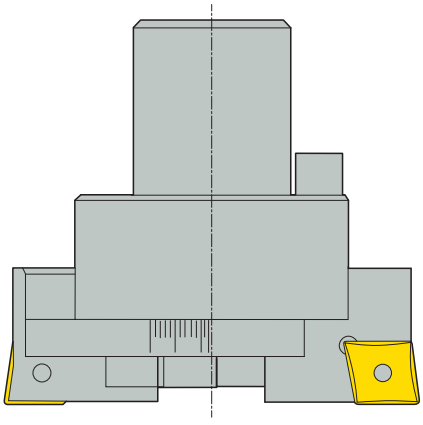
Ø 39–51 mm *(Ø 1.535–2.008")*



Ø 50–65 mm *(Ø 1.969–2.559")*

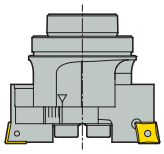


Ø 64–86 mm *(Ø 2.520–3.386")*

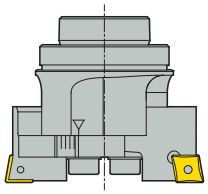


Ø 85–115 mm *(Ø 3.346–4.528")*

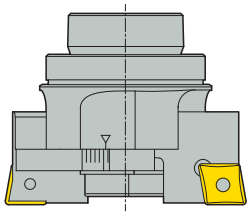
GL Anschluss



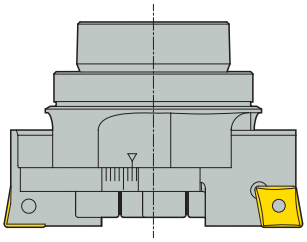
Ø 28–37 mm *(Ø 1.102–1.457")*



Ø 36–46 mm *(Ø 1.417–1.811")*

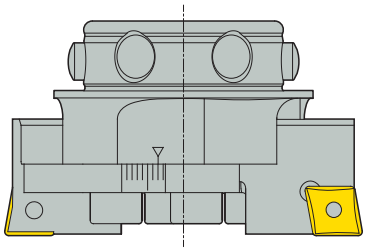


Ø 45–56 mm *(Ø 1.772–2.205")*

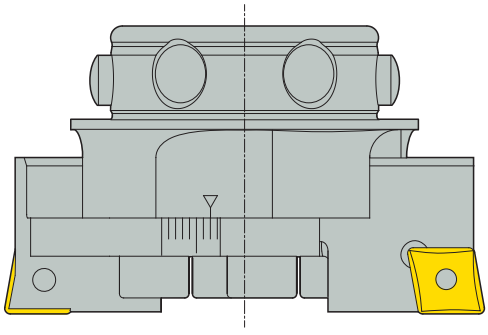


Ø 55–69 mm *(Ø 2.165–2.717")*

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.

Wendeschneidplatten-Halter

- 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")*
- 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 *(1.417 – 2.717")*
- 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

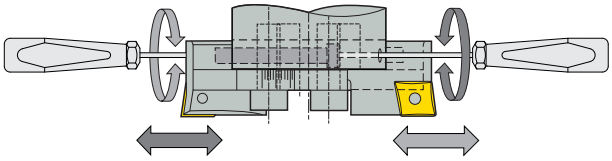
Symmetrische Bearbeitung:

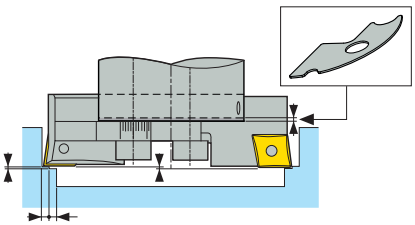
Bei der symmetrischen Bearbeitung werden beide Schneiden auf denselben Durchmesser eingestellt.

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.

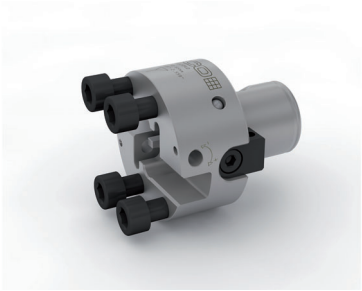
Bezeichnung Unterlegscheibe	Dicke (mm)	*Dicke (Zoll)*
AU6101003	0,2	*0.008*
AU6103003	0,4	*0.016*
AU6104003	0,5	*0.020*
AU6105003	0,6	*0.024*
AU6106003	0,6	*0.024*

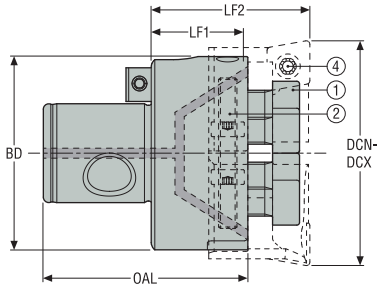




RB610

Graflex®





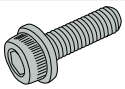
- Symmetrische oder asymmetrische Modi sind möglich.
- Individueller Einstellmechanismus für Wendeschneidplatten-Halter
- Interne Kühlschmierstoffzufuhr auf die Schneide

1. Spannschraube und Spannschlüssel
2 & 4. Schlüssel für Durchmessereinstellung und Spannung der Schraube der Wendeschneidplatte

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*	0,18 *0.400*	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*	0,27 *0.600*	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*	0,54 *1.190*	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*	0,93 *2.050*	3500

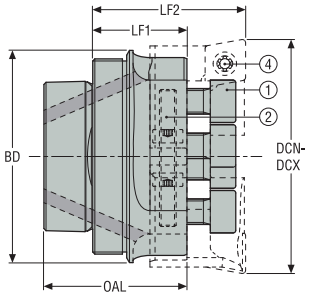
Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 575
* Max. Drehzahlen, siehe Anweisungen auf Seiten. Hinweis: Gewicht ohne Aufnahme

Ersatzteile

Für Kopf	Schraube	Schlüssel für Pratze	Schlüssel (Quergriff)	Auflageplatte, versetzte Bearbeitung	Mitnehmer
					
A61030	950DC0616	03HL05	DOUBLE-T	AU6103003	90M31
A61040	950D0616	03HL05	DOUBLE-T	AU6104003	90M41
A61050	950D0820	03HL06	DOUBLE-T	AU6105003	90M51
A61060	950D0822	03HL06	DOUBLE-T	AU6106003	90M61

RB610 Compact

GL





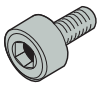
1. Spannschraube und Spannschlüssel
2 & 4. Schlüssel für Durchmessereinstellung und Spannung der Schraube der Wendeschneidplatte

- Ideal für GL25, GL32, GL40 und GL50 Steadyline-Bohrstangen
- Symmetrische oder asymmetrische Modi sind möglich.
- Individueller Einstellmechanismus für Wendeschneidplatten-Halter
- Interne Kühlschmierstoffzufuhr auf die Schneide

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*	
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 *0.220*	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 *0.220*	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 *0.440*	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 *0.660*	4500

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 575
* Max. Drehzahlen, siehe Anweisungen auf Seiten. Hinweis: Gewicht ohne Aufnahme

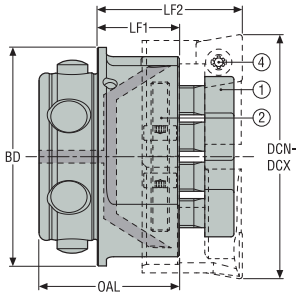
Ersatzteile

Für Kopf	Schraube	Schlüssel für Pratze	Schlüssel für WSP	Schlüssel (Quergriff)	Auflageplatte, versetzte Bearbeitung
					
GL25-0610-10	950D0410	03HL03	–	–	AU6101003
GL32-0610-20	950DC0412	03HL03	H4B-T07P	DOUBLE-T	AU6102003
GL40-0610-30	950DC0616	03HL05	–	DOUBLE-T	AU6103003
GL50-0610-40	950D0616	03HL05	–	DOUBLE-T	AU6104003

RB610

BA





- Ideal für BA60 und BA80 Steadyline-Bohrstangen
- Symmetrische oder asymmetrische Modi sind möglich.
- Individueller Einstellmechanismus für Wendeschneidplatten-Halter
- Interne Kühlschmierstoffzufuhr auf die Schneide

1. Spannschraube und Spannschlüssel
2 & 4. Schlüssel für Durchmessereinstellung und Spannung der Schraube der Wendeschneidplatte

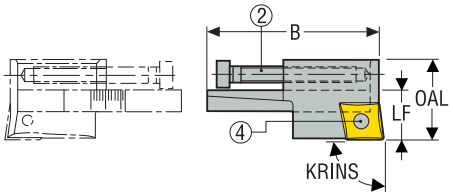
Bezeichnung	Produkt-nummer	Maschinen-seite BA Größe	Werkstückseite Bereich DCN-DCX		OAL	LF1	LF2	BD	Gewicht	Max. U/min*
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
BA060-RB610-50	03204092	BA060	66,0 *2.598*	88,0 *3.465*	38,5 *1.516*	22,5 *0.886*	39,8 *1.567*	60,0 *2.362*	0,8 *1.760*	4000
BA080-RB610-60	03204093	BA080	86,0 *3.386*	116,0 *4.567*	44,5 *1.752*	22,5 *0.886*	39,8 *1.567*	80,0 *3.150*	1,1 *2.430*	3000

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 575
* Max. Drehzahlen, siehe Anweisungen auf Seiten. Hinweis: Gewicht ohne Aufnahme

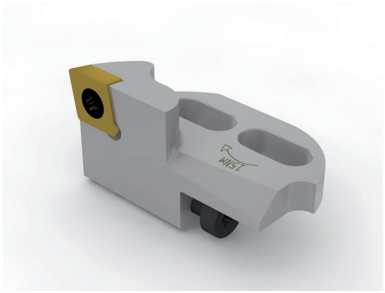
Ersatzteile

Für Kopf	Schlüssel für Pratze	Schraube für Pratze	Schlüssel (Quergriff)	Auflageplatte, versetzte Bearbeitung
				
BA060-RB610-50	03HL06	950D0820	DOUBLE-T	AU6105003
BA080-RB610-60	03HL06	950D0822	DOUBLE-T	AU6106003

WSP-Halter



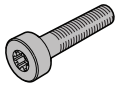
2. Einstellschraube
4. Klemmschraube für Wendeschneidplatte



- Passend für Ausdrehköpfe RB 610 mit Graflex® - BA- oder GL-Anschluss

Bezeichnung	Produkt-nummer	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*	15,1 *0.594*	15,1 *0.594*	21,75 *0.856*	0,1 *0.220*
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 *0.220*
A61030CC0990	02904461	RB 61030	39,0 *1.535*	56,0 *2.205*	17,6 *0.693*	12,9 *0.508*	33,0 *1.299*	0,1 *0.220*
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 *0.220*
A61050CC1290	02904463	RB 61050	64,0 *2.520*	86,0 *3.386*	22,5 *0.886*	17,3 *0.681*	57,4 *2.260*	0,2 *0.440*
A61060CC1290	02904464	RB 61060	85,0 *3.346*	115,0 *4.528*	27,5 *1.083*	18,8 *0.740*	75,0 *2.953*	0,3 *0.660*

Ersatzteile

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

Für Schruppausdrehen empfohlene Wendeschneidplatten, siehe Seite(n) 646
Hinweis: Der Schlüssel für die Wendeplattenklemmung ist im Lieferumfang des RB 610 Kopfes enthalten.

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 ist eine Lösung, um die benötigte Leistung zu senken, da der Vorschub für die gesamte Schnitttiefe im Vergleich zur symmetrischen Bearbeitung durch zwei geteilt wird. Sie erreichen beste Ergebnisse mit interner Kühlschmierstoffzufuhr (höhere Schnittdaten, bessere Oberflächengüte, bessere Spanabfuhr, längere Standzeit der Wendeschneidplatten).

Weitere Details finden Sie in der Gebrauchsanweisung, die mit der Steadyline®-Bohrstange geliefert wird. Diese Gebrauchsanweisung können Sie auch auf www.secotools.com herunterladen.

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 Schnittgeschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Maschinenbedingungen, zu bearbeitendem Werkstoff, Schneidkante (Wendeschneidplatte), Auskraglänge und Maschinenspindel getroffen 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®-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 Mikrozoll) und Bohrungen mit Toleranz IT6. 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 in tiefen Kavitäten und mit großen Auskragungen.

- FB 760 Axiabore Feinausdrehköpfe wurden für hohe Präzision und hohe Oberflächengüten bei kleinen Durchmessern entwickelt.
- FB 620/780/790 radiale Feinausdrehköpfe bieten höchste Bohrungsgeometrien bei großen Durchmessern (bis 205 mm).

Übersicht



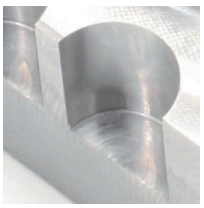




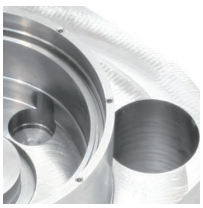
Zapfendrehen



Nutstechen

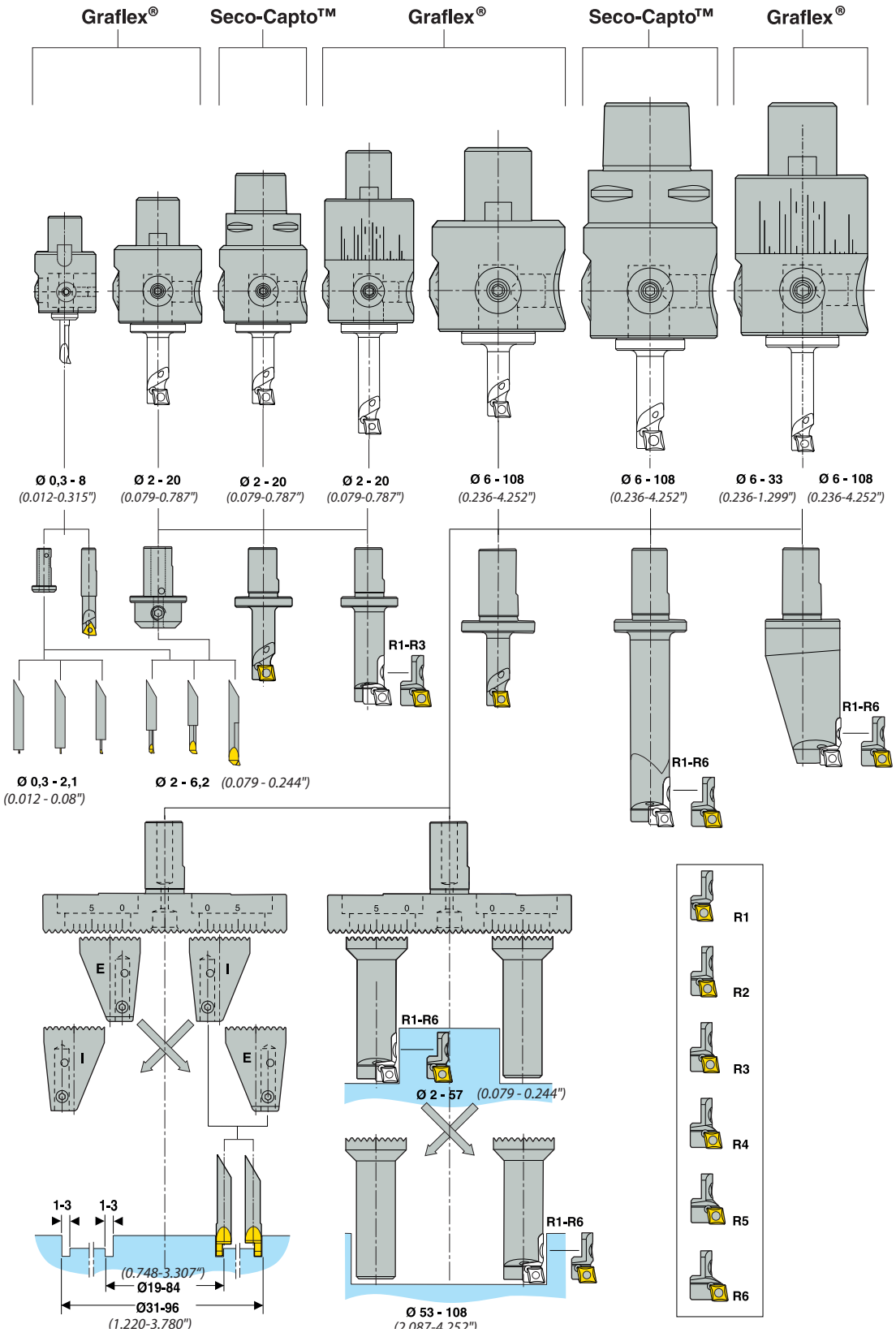


Ausdrehen im unterbrochenen Schnitt



Ausdrehen

Übersicht

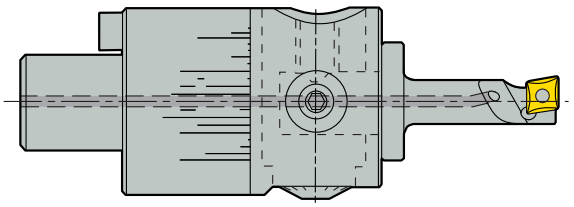

Graflex®
Seco-Capto™
Graflex®
Seco-Capto™
Graflex®
Ø 0,3 - 8
(0.012-0.315")
Ø 2 - 20
(0.079-0.787")
Ø 2 - 20
(0.079-0.787")
Ø 2 - 20
(0.079-0.787")
Ø 6 - 108
(0.236-4.252")
Ø 6 - 108
(0.236-4.252")
Ø 6 - 33
(0.236-1.299")
Ø 6 - 108
(0.236-4.252")
R1-R3
R1-R6
R1-R6
Ø 0,3 - 2,1
(0.012 - 0.08")
Ø 2 - 6,2 (0.079 - 0.244")
E
I
I
E
1-3
1-3
(0.748-3.307")
Ø19-84
Ø31-96
(1.220-3.780")
R1-R6
Ø 2 - 57 (0.079 - 0.244")
R1-R6
Ø 53 - 108
R1
R2
R3
R4
R5
R6

5 Feinausdrehköpfe Typ Axiabore™ für Durchmesserbereich 0,3-108 mm *(0.012-4.252”)*.

Ein Axiabore™-Ausdrehkopf besteht aus der Bohrstange und einem Grundkörper.

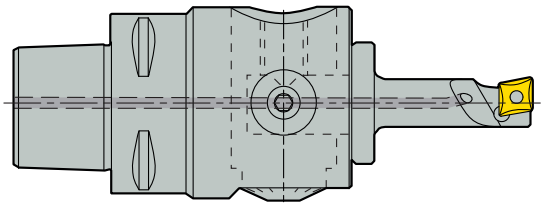
Kopfauswahl Axiabore™	Durchmesserbereich mm	*Durchmesserbereich Zoll*	HSM/Max. Geschw.	Bohrungs-geometrie	Wirtschaftlich	Mehrzweck
Nanobore™ A760 01	0,3-8	*0.012–0.315”*	30000 U/min	■■	■■	
Axiabore™ A760 02	2-20	*0.079–0.787”*	12000 U/min	■	■■	
Axiabore™ Plus - A760 03	6-108	*0.236–4.252”*	8000* U/min oder 1000 m/min	■	■■■	■■■
Axiabore™ Plus C5-391.0760-03	6-108	*0.236–4.252”*	8000* U/min	■	■■■	■■■
Axialibrabore™ Plus - A760 13	6-33	*0.236–1.299”*	20000 U/min oder 1500 m/min	■■	■	

Köpfe des Typs Axiabore™ gibt es mit Graflex® oder Seco-Capto™-Anschluss: 5 Axiabore™ Feinausdrehköpfe FB 760 mit Graflex®-Anschluss für Bohrungen im Durchmesserbereich von 0,3 bis 108 mm *(0.012–4.252”)*



Nanobore™ A760 01
Axiabore™ A760 02
Axialibrabore™ A760 12
Axiabore™ Plus - A760 03
Axialibrabore™ Plus - A760 13

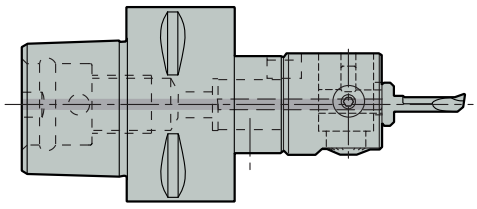
2 Axiabore™ Feinausdrehköpfe FB 760 mit Seco-Capto™ Anschluss für Bohrungen im Durchmesserbereich von 2 bis 108 mm *(0.079–4.252”)*



Axiabore™ C3-391.0760-02
Axiabore™ Plus- C5-391.0760-03

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.

Bohrstangen

Beachten Sie Folgendes: 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.

Grundkörper, 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 Werkzeuges 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 WSP-Halter zur Aufspannung auf die Aufnahme mit Hilfe der Auswahl-Tabelle “Zapfendrehen” (siehe nachfolgende Produkt-Seiten) auswählen.

- Zapfendreh-Kombination: Passenden WSP-Halter zur Aufspannung 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.

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 optimiert für schwierig zu erreichende Bohrungen.

Die Reduzierbuchsen 12 bis 4 mm *(0.472–0.157")* mit keilförmiger Verbindung und Stift zur Montage der Hartmetallbohrstangen 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. Nanobore® Ausdrehköpfe bevorzugt einsetzen.

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.

Axialibrabore™ Plus - Ausdrehkopf Produktnummer A76013

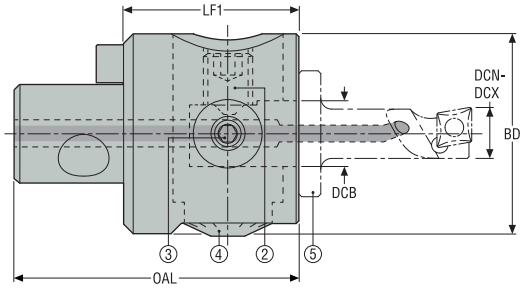


Auswuchtbarer Ausdrehkopf für Bohrungen mit 6 bis 33 mm *(0.236–1.299")* Durchmesser
Dieselben Merkmale wie der Axiabore™ Plus-Kopf, jedoch mit feinauswuchtbarer Länge des Kopfes 65 mm *(2.559")*.
Mit Graflex®-Größe G5
Feinauswuchtbare Köpfe erlauben höhere Geschwindigkeiten bis zu 20.000 U/min oder 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 Skalenringes 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-Werkzeuges oder eines MPA-Werkzeuges 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.

FB 760 – Axiabore™ Köpfe, nicht auswuchtbar

Graflex®



3. Klemmschraube
4. Mikrometrische Einstellschraube
2. Spannschraube
5. Werkzeug

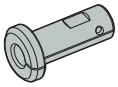


- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).
- Axiabore™ Plus – zum Ausdrehen, Zapfendrehen und Nutenstechen

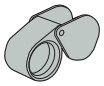
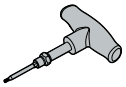
Bezeichnung	Produkt-nummer	Maschinen-seite Graflex Größe	Werkstückseite Bereich DCN-DCX		*	OAL	LF1	BD	DCB	Gewicht	Max Arbeitsgeschw.**		***
			mm *Zoll*	mm *Zoll*		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Max. U/min**	Max. m/min**	
A76001	02462575	G2	0,3 *0.012*	8,0 *0.315*	–	41,0 *1.614*	25,0 *0.984*	25,0 *0.984*	6,0 *0.236*	0,1 *0.220*	30000	1500,0	–
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*	0,29 *0.640*	12000	1500,0	–
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*	0,82 *1.810*	8000	1000,0	***

Hinweis: Gewicht ohne Aufnahme
Für Werkzeuge siehe Seite 586-588.
*Einsatzbereiche - Axiabore™ Plus - Ausdrehk. zum Ausdrehen von 6 - 108 mm, Zapfendrehen von 2 - 57 mm, Nutstechen 19 - 96 mm *(0.748-3.780")* .
**Maximale Geschwindigkeit, die zuerst ohne eine zu übertreffen erreicht wird.
***Max. 5 000 U/m bei Einsatz von MPA.

Ersatzteile

Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube	Reduzierbuchse	Dichtschrauben	Mitnehmer
							
A76001	–	DOUBLE-T	H4B-H2.0	19M4001A	05A7600604	950A0406	90M21
A76002	AU7601212	–	03M03C	19A71030	05A7601204	–	90M3A
A76003	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	–	–	90M5A

Zubehör

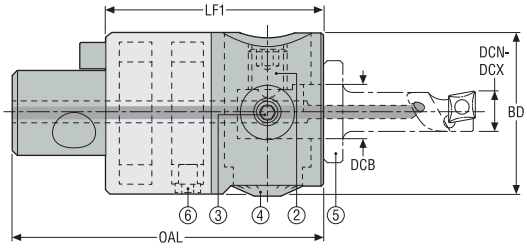
Für Kopf	Lupe	Aufbewahrungsbox	Drehmoment-schlüssel 1	Drehmoment-schlüssel 2
				
A76001	935L01	–	–	H00-2009
A76002	–	42M06	–	H00-3030
A76003	–	42M07	H00T-4060	**Zubehör,** separat zu bestellen

Drehmomentschlüssel 1 = Befestigungsschraube 2
Drehmomentschlüssel 2 = Schraube und Befestigungsschraube 1

FB 760 – Axiabore™ Köpfe, auswuchtbar

Graflex®





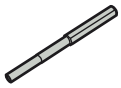
- LibraOne Auswuchtsystem mit nur einem Auswuchtring, keine Auswuchttabellen notwendig.
- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).

6. Klemmschraube 2
3. Klemmschraube 1
4. Mikrometrische Einstellschraube
2. Spannschraube
5. Werkzeug

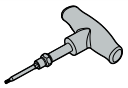
Bezeichnung	Produkt-nummer	Maschinen-seite Graflex Größe	Werkstückseite Bereich DCN-DCX		*	OAL	LF1	BD	DCB	Gewicht	Max Arbeitsgeschw.**	
			mm *Zoll*	mm *Zoll*		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	Max. U/min**	Max. m/min**
A76013	02594943	G5	6,0 *0.236*	33,0 *1.299*	*	95,0 *3.740*	65,0 *2.559*	54,0 *2.126*	16,0 *0.630*	1,16 *2.560*	20000	1500,0

Hinweis: Gewicht ohne Aufnahme
Für Werkzeuge siehe Seite 586-588
*Bereiche – Axialibrabore™ Plus-Kopf, mit Auswuchtung.
**Maximale Geschwindigkeit, die zuerst ohne eine zu übertreffen erreicht wird.

Ersatzteile

Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube 1	Befestigungs-schraube 2	Mitnehmer
						
A76013	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	AU7601318	90M5A1

Zubehör

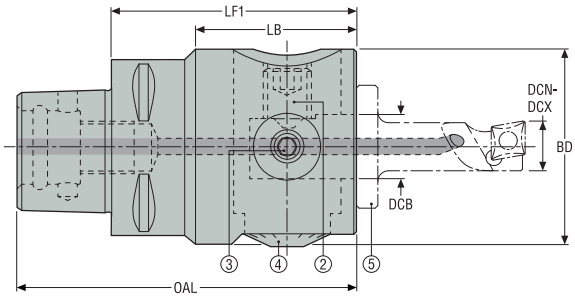
Für Kopf	Aufbewahrungsbox	Drehmoment-schlüssel 1	Drehmoment-schlüssel 2
			
A76013	42M07	H00-4020-60	H00T-4060

Drehmomentschlüssel 1 = Befestigungsschraube 2
Drehmomentschlüssel 2 = Schraube und Befestigungsschraube 1

Zubehör, separat zu bestellen

FB 760 – Axiabore™ Köpfe

Seco-Capto™



3. Pratze
4. Mikrometrische Einstellschraube
2. Spannschraube
5. Werkzeug



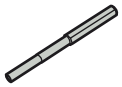
- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).
- Axiabore™ Plus – zum Ausdrehen, Zapfendrehen und Nutstechen

Bezeichnung	Produkt-nummer	Maschinen-seite	Werkstückseite Bereich DCN-DCX		*	OAL	LF1	LB	BD	DCB	Gewicht	Max Arbeitsgeschw.**	
			mm *Zoll*	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*	44,0 *1.732*	54,0 *2.126*	16,0 *0.630*	1,12 *2.470*	8000	1500,0

Hinweis: Gewicht ohne Aufnahme
Für Werkzeuge siehe Seite 586-588
*Max. 5 000 U/m bei Einsatz von MPA.
**Einsatzbereiche - Axiabore™ Plus - Ausdrehk. zum Ausdrehen von 6 - 108 mm, Zapfendrehen von 2 - 57 mm, Nutstechen 19 - 96 mm *(0.748-3.780")* .

Ersatzteile

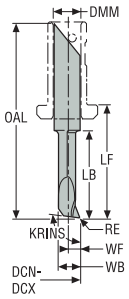
Zubehör

Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube	Drehmoment-schlüssel 2
					
C5-...-03	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	H00-3030

Drehmomentschlüssel 2 = Schraube und Befestigungsschraube 1
Zubehör, separat zu bestellen

Ausdrehwerkzeuge, Vollhartmetall, für FB 760 Köpfe





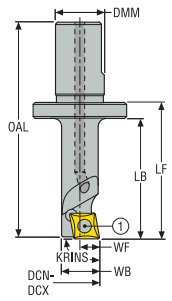
- KRINS 98°
- Schneidkantenausrichtung nach ISO
- Kühlung entlang des Werkzeuges

Bezeichnung	Produkt-nummer	Werkzeug-material*	Für Kopf	Bereich DCN-DCX mm***		OAL	LB	LF	DMM	WB	WF	RE	Empfohlene Schnittdaten** a_p	Empfohlene Schnittdaten** f	Gewicht	Aus-wuch-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	Voll-hartmetall	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 –	0,02 *0.001*	0,01 *0*	0,01 *0.020*	–
A761412	02462581	Voll-hartmetall	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 –	0,02 *0.001*	0,01 *0*	0,01 *0.020*	–
A761422	02462583	Voll-hartmetall	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*	0,01 *0.020*	–
A761432	02462584	Voll-hartmetall	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*	0,01 *0.020*	E13
A761442	02462586	Voll-hartmetall	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*	0,01 *0.020*	E14
A761452	02462587	Voll-hartmetall	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*	0,01 *0.020*	E15

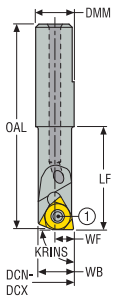
* Werkzeuge mit Schaftdurchmesser 4 mm erfordern den Einsatz einer Reduzierhülse, die mit den entsprechenden Köpfen und Kits geliefert wird.
** Schnittgeschwindigkeit, siehe Seite(n) 650-653
*** Vergrößerungsbereich bis zu + 0,1 mm möglich.

Bohrstangen, Wendeschneidplatten-Typ, für FB Köpfe

B



A



1 = Klemmschraube für Wendeschneidplatte



- Schneidkantenausrichtung nach ISO
- Interne Kühlmittelzufuhr
- Nur zwei Wendeschneidplatten-Größen für alle Werkzeuge.
- Werkzeug-Werkstoff* = Stahl, Wendeplatten-System
- Werkzeug-Werkstoff** = Hartmetall, Wendeplatten-System
- KRINS 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 *0.000*	16,0 *0.630*	6,0 *0.236*	5,5 *0.217*	2,9 *0.114*	0,01 *0.020*	A	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*	0,03 *0.070*	B	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*	0,07 *0.150*	B	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*	0,04 *0.090*	B	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*	0,08 *0.180*	B	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*	0,04 *0.090*	B	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*	0,08 *0.180*	B	CC..0602..	S33
A762201	02462591	**	FB 76001	6,0 *0.236*	8,0 *0.315*	41,7 *1.642*	0,0 *0.000*	26,0 *1.024*	6,0 *0.236*	5,5 *0.217*	2,9 *0.114*	0,02 *0.040*	A	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*	0,06 *0.130*	B	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*	0,13 *0.290*	B	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*	0,07 *0.150*	B	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*	0,14 *0.310*	B	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*	0,09 *0.200*	B	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*	0,17 *0.370*	B	CC..0602..	E33

Ersatzteile

Für WSP	Schraube für WSP
	
WB...0301..	C02035-T06P
CC...0602..	C02504-T07P

Zubehör

Schlüssel für WSP	Schlüssel (Quergriff)
	
H4B-T06P	DOUBLE-T
H4B-T07P	DOUBLE-T

** ** Vergrößerungsbereich bis zu +0,2 mm möglich.

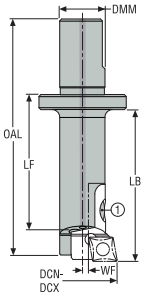
Zubehör, separat zu bestellen

Bohrstangen, für modulare Feinausdrehstangen, für FB 760 Köpfe

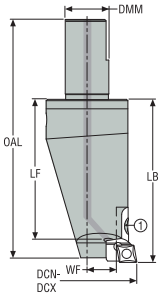


- Unterschiedliche Einsatzbereiche durch austauschbare Wendeschneidplatten-Halter.
- Stahlschäfte für kurze Bohrstangen, Hartmetall für lange Bohrstangen, Aluminium für große Durchmesser.
- Interne Kühlmittelzufuhr

A



B



1 = Klemmschraube

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*	0,06 *0.130*	A	
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 *0.220*	A	
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*	0,13 *0.290*	A	
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 *0.440*	A	
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*	0,21 *0.460*	A	
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 *0.660*	A	
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*	0,14 *0.310*	B	***
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*	0,34 *0.750*	B	***

Ersatzteile

Für Kopf	Befestigungs-schraube
	
A76002/12	C04008-T15P
A76003/13	C04008-T15P
A76003	C04008-T15P

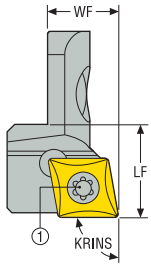
Zubehör

Schlüssel (Quergriff)

DOUBLE-T
DOUBLE-T
DOUBLE-T

** Vergrößerungsbereich bis zu +0,2 mm möglich.
*** Beim Einsatz mit A760 13, keine Feinauswuchtung möglich. Gewünschte Kombinationen von Schaft und Wendeplattenhalter mit Hilfe der Tabelle auswählen auf Seite(n) 590.
Hinweis: Gewicht ohne Aufnahme.
Zubehör, separat zu bestellen

Wendeplattenhalter, für modulare Feinausdrehstangen, für FB 760 Köpfe



1 = Klemmschraube für Wendeschneidplatte



- Nur eine Anschlussgröße für alle Bohrstangen (auch zum Zapfendrehen).
- Eine Wendeschneidplatten-Größe für alle Halter.

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*	0,01 *0.020*	CC..0602..	90
A765R2	02594983	10,0 *0.394*	6,2 *0.244*	0,01 *0.020*	CC..0602..	90
A765R3	02594984	10,0 *0.394*	7,45 *0.293*	0,01 *0.020*	CC..0602..	90
A765R4	02594987	10,0 *0.394*	8,7 *0.343*	0,01 *0.020*	CC..0602..	90
A765R5	02594989	10,0 *0.394*	9,97 *0.393*	0,01 *0.020*	CC..0602..	90
A765R6	02594990	10,0 *0.394*	11,2 *0.441*	0,01 *0.020*	CC..0602..	90

Ersatzteile

Für WSP Größe	Schraube für WSP
	
CC...0602...	C02504-T07P

Zubehör

Schlüssel für WSP	Schlüssel (Quergriff)
	
H4B-T07P	DOUBLE-T

Zubehör, separat zu bestellen

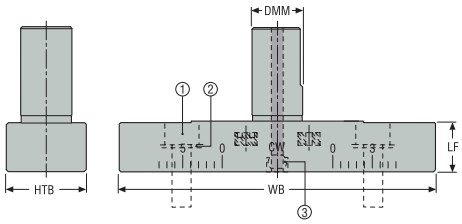
* WF beim Einsatz mit Wendeplatte Typ CC..060204.
Gewünschte Kombination von Schaft und Wendeplattenhalter auswählen mit Hilfe der Tabelle auf Seite(n) 590.

Tabelle:
Ausdrehwerkzeuge und Wendeschneidplatten-Halter für FB 760-Köpfe

Für Kopf	Ausdrehbereich Werkzeug-DCN-DCX mm	Zoll	Ausdreh-länge LB mm	Zoll	Bezeichnung Ausdreh-werkzeug	WSP-Halter	DMM mm	Zoll	Entspr. WSP-Größe	Werkzeug Typ
A760 01	0,3-0,6	0.012-0.024	1,2	0.047	A761402	–	4	0.157	–	Hartmetall
	0,5-1,1	0.020-0.043	2	0.078	A761412	–	4	0.157	–	Hartmetall
	1-2,1	0.039-0.083	-	-	A761422	–	4	0.157	–	Hartmetall
	2-3,2	0.079-0.126	8	0.315	A761432	–	4	0.157	–	Hartmetall
	3-4,7	0.118-0.185	10	0.394	A761442	–	4	0.157	–	Hartmetall
	4,5-6,2	0.177-0.244	15	0.591	A761452	–	4	0.157	–	Hartmetall
	6-8	0.236-0.315	16	0.630	A762001	–	6	0.236	WB..0301..	Stahl, Wendeschneidplatten-Typ
	6-8	0.236-0.315	26	1.024	A762201	–	6	0.236	WB..0301..	Hartmetall, Wendeplatten Typ
A760 02/ A760 12	2-3,2	0.079-0.126	8	0.315	A761432	–	4	0.157	–	Hartmetall
	3-4,7	0.118-0.185	10	0.394	A761442	–	4	0.157	–	Hartmetall
	4,5-6,2	0.177-0.244	15	0.591	A761452	–	4	0.157	–	Hartmetall
	6-8	0.236-0.315	16	0.630	A762002	–	12	0.472	WB..0301..	Stahl, Wendeschneidplatten-Typ
	6-8	0.236-0.315	27	1.063	A762202	–	12	0.472	WB..0301..	Hartmetall, Wendeplatten Typ
	8-10	0.315-0.394	22	0.866	A763002	–	12	0.472	WB..0301..	Stahl, Wendeschneidplatten-Typ
	8-10	0.315-0.394	37	1.457	A763202	–	12	0.472	WB..0301..	Hartmetall, Wendeplatten Typ
	10-13	0.394-0.512	30	1.181	A765002	–	12	0.472	CC..0602..	Stahl, Wendeschneidplatten-Typ
	10-13	0.394-0.512	55	2.165	A765202	–	12	0.472	CC..0602..	Hartmetall, Wendeplatten Typ
	13-15,5	0.512-0.610	40	1.575	A760S20	A765R1	12	0.472	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	13-15,5	0.512-0.610	60	2.362	A760E20	A765R1	12	0.472	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	15,5-18	0.610-0.709	40	1.575	A760S20	A765R2	12	0.472	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	15,5-18	0.610-0.709	60	2.362	A760E20	A765R2	12	0.472	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	18-20	0.709-0.787	40	1.575	A760S20	A765R3	12	0.472	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	18-20	0.709-0.787	60	2.362	A760E20	A765R3	12	0.472	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
A760 03/ A760 13	6-8	0.236-0.315	16	0.630	A762003	–	16	0.630	WB..0301..	Stahl, Wendeschneidplatten-Typ
	6-8	0.236-0.315	32	1.260	A762203	–	16	0.630	WB..0301..	Hartmetall, Wendeplatten Typ
	8-10	0.315-0.394	22	0.866	A763003	–	16	0.630	WB..0301..	Stahl, Wendeschneidplatten-Typ
	8-10	0.315-0.394	37	1.457	A763203	–	16	0.630	WB..0301..	Hartmetall, Wendeplatten Typ
	10-13	0.394-0.512	30	1.181	A765003	–	16	0.630	CC..0602..	Stahl, Wendeschneidplatten-Typ
	10-13	0.394-0.512	55	2.165	A765203	–	16	0.630	CC..0602..	Hartmetall, Wendeplatten Typ
	13-15,5	0.512-0.610	40	1.575	A760S30	A765R1	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	13-15,5	0.512-0.610	70	2.756	A760E30	A765R1	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	15,5-18	0.610-0.709	40	1.575	A760S30	A765R2	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	15,5-18	0.610-0.709	70	2.756	A760E30	A765R2	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	18-20,5	0.709-0.807	50	1.969	A760S31	A765R1	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	18-20,5	0.709-0.807	80	3.150	A760E31	A765R1	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	20,5-23	0.807-0.906	50	1.969	A760S31	A765R2	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	20,5-23	0.807-0.906	80	3.150	A760E31	A765R2	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	23-25,5	0.906-1.00	50	1.969	A760S31	A765R3	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	23-25,5	0.906-1.00	80	3.150	A760E31	A765R3	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	25,5-28	1.004-1.102	50	1.969	A760S31	A765R4	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	25,5-28	1.004-1.102	80	3.150	A760E31	A765R4	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	28-30,5	1.102-1.201	50	1.969	A760S31	A765R5	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	28-30,5	1.102-1.201	80	3.150	A760E31	A765R5	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	30,5-33	1.201-1.299	50	1.969	A760S31	A765R6	16	0.630	CC..0602..	Stahlschaft mit Wendeschneidplatten-Halter
	30,5-33	1.201-1.299	80	3.150	A760E31	A765R6	16	0.630	CC..0602..	Hartmetallschaft mit Wendeschneidplatten-Halter
	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

Siehe Abschnitt zu Vielzweck-Adaptern (MPA) für größere Durchmesser.
* Bei Verwendung auf A760 13 ist Feinauswuchten nicht möglich.

Vielzweck-Adapter (MPA), für FB 760 Köpfe



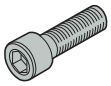
1. Spannschraube
2. Unterlegscheibe
3. Einstellbare Düse



- Nur für Axiabore™ Plus-Ausdrehkopf A760 03*.
- Für einen Schaft und ein Gegengewicht (zum Ausdrehen oder Zapfendrehen) oder zwei Einstechhalter (zum Nutstechen).
- Interne Kühlmittelzufuhr mit einstellbarer Düse (3)

Produkt-nummer	Bezeichnung	Bereich DCN-DCX ∅						HTB	LF	DMM	WB	Gewicht
		Zum Ausdrehen		Zum Zapfendrehen		Zum Nutenstechen						
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
02595014	BDA16BS25100	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*	0,28 *0.620*

Ersatzteile

Für Halter	Schraube	Unterlegscheibe
		
BDA16BS25100	950D0618	940ZC06

* Beim Einsatz mit Axialibrabore™ Plus Kopf A760 13 keine Feinauswuchtung möglich, siehe Seite(n) 582

Werkzeugkomponenten zum Ausspindeln, Zapfendrehen oder Nutenstechen mit Hilfe der folgenden Seiten auswählen: 595-606

Zubehör

Schlüssel für Pratze

03HL05

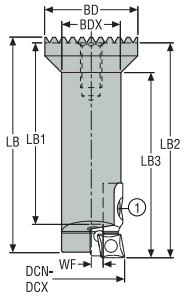
Zubehör, separat zu bestellen

Schaft und Gegengewicht zum Ausdrehen oder Zapfendrehen auf einem MPA für FB 760 Köpfe.

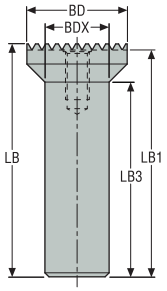


- Passend für MPA
- Der Schaft eignet sich für Ausdrehen und Zapfendrehen.
- Wendeschneidplatten-Halter wie bei modularen Bohrstangen.

A



B



1. Spannschraube

Produkt-nummer	Bezeichnung	Abb.	** Bereich DCN-DCX ∅				LB	LB1	LB2	LB3	WF	BDX	BD	Gewicht	Abb.
			Zum Ausdrehen		Zum Zapfendrehen										
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
02595019	BAS25MH1660	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 *0.220*	A
02595016	BAS25CW1660	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*	0,11 *0.240*	B

Ersatzteile

Für Halter	Schraube
	
BAS25MH1660	C04008-T15P
BAS25CW1660	–

Zubehör

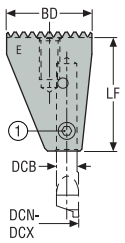
Schlüssel (Quergriff)

DOUBLE-T
–

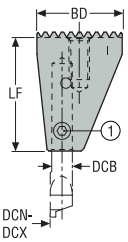
** Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 589
** Aus- und Zapfendrehbereich ist abhängig vom ausgewählten Wendeschneidplatten-Halter und der Einstellposition auf den Aufnahmen, siehe Tabelle auf Seite(n) 595-606
Zubehör, separat zu bestellen

Stechhalter, zum Nutstechen auf einem MPA, für FB 760 Köpfe

E



I



1. Klemmschraube



- Passend für MPA
- Ein Stechhalter kann sowohl als Stechwerkzeug als auch als Gegengewicht eingesetzt werden.

Produkt-nummer	Bezeichnung	Abb.	* Bereich DCN-DCX ∅		DCB	LF	BD	Gewicht	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	
02595021	BAS25FGI35	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 *0.220*	I (Innen)
02595020	BAS25FGE35	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 *0.220*	E (Außen)

Ersatzteile

Für Halter	Befestigungs-schraube
	
BAS25FGI35	950L0607T15P
BAS25FGE35	950L0607T15P

Zubehör

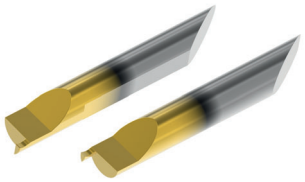
Schlüssel (Quergriff)

DOUBLE-T
DOUBLE-T

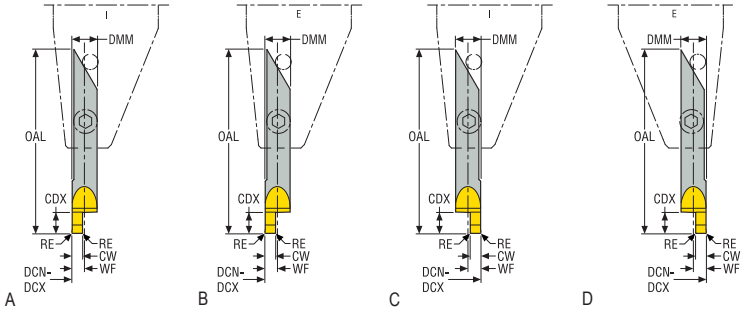
* Einstechwerkzeuge sind separat zu bestellen, siehe Seite(n) 594
* Einstechbereich ist abhängig vom ausgewählten Einstechwerkzeug, der Einstellposition sowie der Ausrichtung des Stechhalters, siehe Tabelle auf Seite(n) 595-606
Zubehör, separat zu bestellen

Einstechwerkzeuge

für FB 760 Köpfe



- Sowohl für Innen- als auch für Außen-Stechhalter geeignet, je nach Bereich.

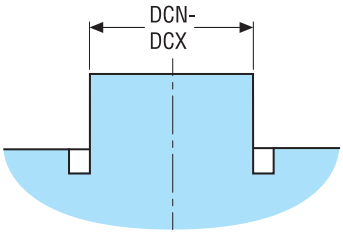


Produktnummer	Bezeichnung	Abb.	* Bereich DCN-DCX ∅ Ausführung A		Ausführung B		Ausführung C		Ausführung D		OAL	CW	RE	DMM	WF	Max. Einstechtiefe **	Gewicht
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
02595028	AFG0629101582	Nutstechen -innen-	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*
02595029	AFG0629151582	Nutstechen -innen-	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*
02595031	AFG0629201582	Nutstechen -innen-	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*	5,0 *0.197*	0,07 *0.150*
02595032	AFG0629251582	Nutstechen -innen-	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*	0,07 *0.150*
02595033	AFG0629301582	Nutstechen -innen-	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*	0,07 *0.150*
02595022	AFG0629101581	Nutstechen -außen-	–	–	–	–	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*	0,02 *0.040*
02595023	AFG0629151581	Nutstechen -außen-	–	–	–	–	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*
02595024	AFG0629201581	Nutstechen -außen-	–	–	–	–	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*	0,07 *0.150*
02595026	AFG0629251581	Nutstechen -außen-	–	–	–	–	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*	0,07 *0.150*
02595027	AFG0629301581	Nutstechen -außen-	–	–	–	–	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*	0,07 *0.150*

* Einstechbereich ist abhängig vom ausgewählten Einstechwerkzeug, der Einstellposition sowie der Ausrichtung des Stechhalters, siehe Tabelle auf Seite(n) 595-606
** Max. Einstechtiefe CDX

Ersatzteile

Stechwerkzeug, außen	Stechwerkzeug, innen



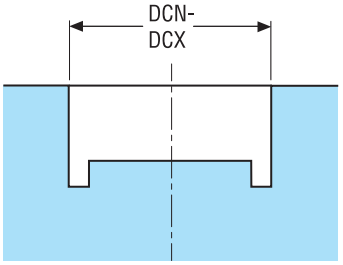
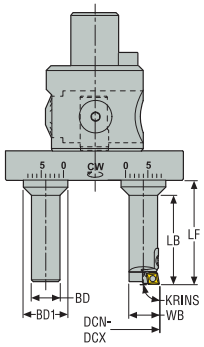


Tabelle:
Ausdrehwerkzeuge und Wendeschneidplatten-Halter für FB 760-Köpfe, Metrisch

Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.
Hinweis: Eine Ausdrehkombination besteht aus:
- einem Axiabore™ Plus-Kopf (A760 03)
- einem MPA (BDA16BS25100)
- einem Schaft (BAS25MH1660)
- einem Gegengewicht (BAS25CW1660)
- einem Wendeschneidplatten-Halter (A765R.) aus der Tabelle
- einer Wendeschneidplatte

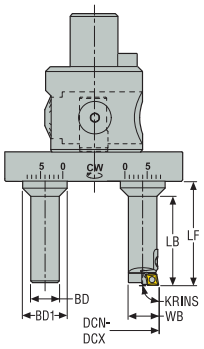


Bereich DCN-DCX mm*	WSP-Halter Bezeichnung	Schaft-position	Abmessungen in mm					Einstellwinkel KRINS°	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB		
53-55,5	A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
55,5-58	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
58-60,5	A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	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..

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich.
Mehr Informationen zu Wendeplattenhaltern finden Sie auf Seite(n) 589

Tabelle:
Ausdrehwerkzeuge und Wendeschneidplatten-Halter für FB 760-Köpfe, Zoll

Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.
Hinweis: Eine Ausdrehkombination besteht aus:
- einem Axiabore™ Plus-Kopf (A760 03)
- einem MPA (BDA16BS25100)
- einem Schaft (BAS25MH1660)
- einem Gegengewicht (BAS25CW1660)
- einem Wendeschneidplatten-Halter (A765R.) aus der Tabelle
- einer Wendeschneidplatte

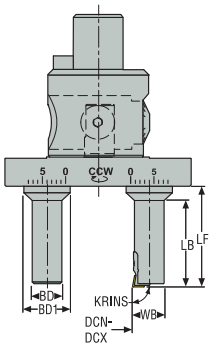


Bereich DCN-DCX Durchmesser Zoll*	WSP-Halter Bezeichnung	Schaft-position	Abmessungen in Zoll					Einstellwinkel KRINS°	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB		
2.087-2.185	A765 R1	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
2.185-2.283	A765 R2	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	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..

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich.
Mehr Informationen zu Wendeplattenhaltern finden Sie auf Seite(n) 589

Tabelle:
Wendeplattenhalter zum Zapfendrehen mit Vielzweck-Adaptern für FB 760-Köpfe, Metrisch

Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.
Hinweis: Eine Ausdrehkombination besteht aus:
- einem Axiabore™ Plus-Kopf (A760 03)
- einem MPA (BDA16BS25100)
- einem Schaft (BAS25MH1660)
- einem Gegengewicht (BAS25CW1660)
- einem Wendeschneidplatten-Halter (A765R.) aus der Tabelle
- einer Wendeschneidplatte

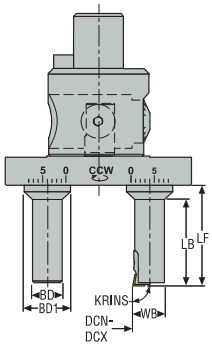


Bereich DCN-DCX mm*	WSP-Halter Bezeichnung	Schaft-position	Abmessungen in mm					Einstellwinkel KRINS°	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB		
2-4,5	A765 R6	0	16	25	58,5	50	23,2	90°	CC..0602..
4,5-7	A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
7-9,5	A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	0	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..

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich.
Mehr Informationen zu Wendeplattenhaltern finden Sie auf Seite(n) 589

Tabelle:
Wendeplattenhalter zum Zapfendrehen mit Vielzweck-Adaptern für FB 760-Köpfe, Zoll

Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.
Hinweis: Eine Ausdrehkombination besteht aus:
- einem Axiabore™ Plus-Kopf (A760 03)
- einem MPA (BDA16BS25100)
- einem Schaft (BAS25MH1660)
- einem Gegengewicht (BAS25CW1660)
- einem Wendeschneidplatten-Halter (A765R.) aus der Tabelle
- einer Wendeschneidplatte

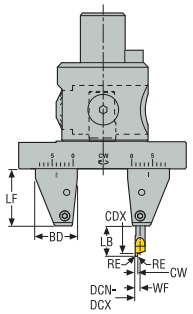


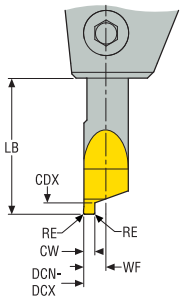
Bereich DCN-DCX Durchmesser Zoll*	WSP-Halter Bezeichnung	Schaft-position	Abmessungen in Zoll					Einstellwinkel KRINS°	Entspr. WSP-Größe
			BD	BD1	LF	LB	WB		
0.079-0.177	A765 R6	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
0.177-0.276	A765 R5	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	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..

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich.
Mehr Informationen zu Wendeplattenhaltern finden Sie auf Seite(n) 589

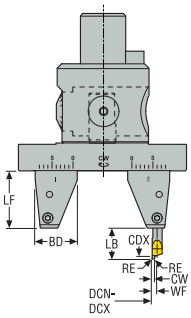
Tabelle:
Stechwerkzeug, außen, zum Nutstechen mit Vielzweck-Adaptern für FB 760-Köpfe, Metrisch

Montagemöglichkeit 1

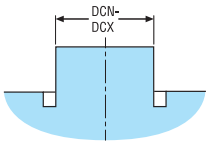




Montagemöglichkeit 2



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

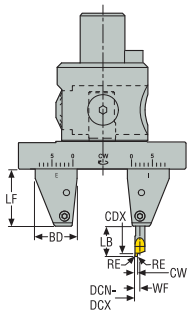
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...82) gemäß Nuttiefe und - durchmesser (siehe Tabelle)

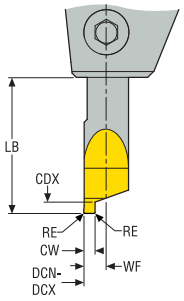
Bereich DCN-DCX mm*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in mm						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
19-24	AFG0629 10 1582	0-I	1	25	1	34	18	2,95	0,15	2,0
24-29		1-I	1	25	1	34	18	2,95	0,15	2,0
29-34		2-I	1	25	1	34	18	2,95	0,15	2,0
34-39		3-I	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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

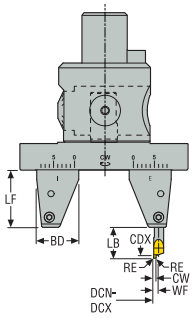
Tabelle:
Stechwerkzeug, außen, zum Nutstechen mit Vielzweck-Adaptern für FB 760-Köpfe, Zoll

Montagemöglichkeit 1

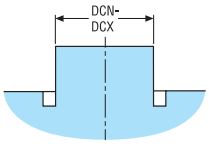




Montagemöglichkeit 2



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

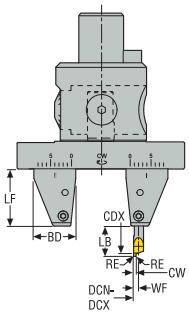
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...82) gemäß Nuttiefe und - durchmesser (siehe Tabelle)

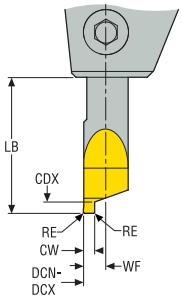
Bereich DCN-DCX Durchmesser Zoll*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in Zoll						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
0.748-0.945	AFG0629 10 1582	0-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
0.945-1.142		1-I	1	*0.984*	*0.0394*	*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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

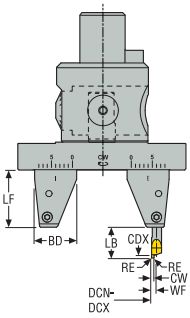
Tabelle:
Stechwerkzeug, außen, zum Nutstechen mit Vielzweck-Adaptern für FB 760-Köpfe, Metrisch

Montagemöglichkeit 1

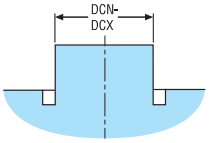




Montagemöglichkeit 2



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

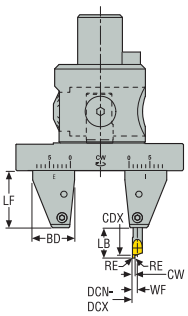
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...82) gemäß Nuttiefe und - durchmesser (siehe Tabelle)

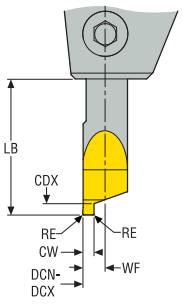
Bereich DCN-DCX mm*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in mm						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
19-24	AFG0629 25 1582	0-I	1	25	2,5	34	18	2,95	0,15	5,0
24-29		1-I	1	25	2,5	34	18	2,95	0,15	5,0
29-34		2-I	1	25	2,5	34	18	2,95	0,15	5,0
34-39		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
19-24	AFG0629 30 1582	0-I	1	25	3	34	18	2,95	0,15	6,0
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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

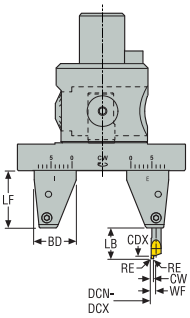
Tabelle:
Stechwerkzeug, außen, zum Nutstechen mit Vielzweck-Adaptern für FB 760-Köpfe, Zoll

Montagemöglichkeit 1

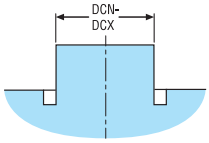




Montagemöglichkeit 2



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

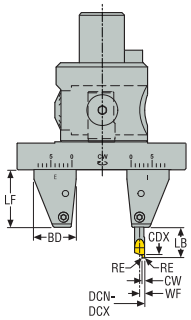
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...82) gemäß Nuttiefe und - durchmesser (siehe Tabelle)

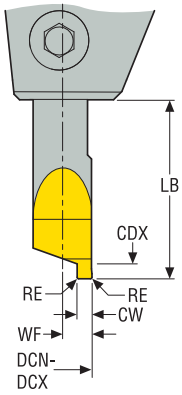
Bereich DCN-DCX Durchmesser Zoll*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in Zoll						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
0.748-0.945	AFG0629 25 1582	0-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
0.945-1.142		1-I	1	*0.984*	*0.0984*	*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
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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

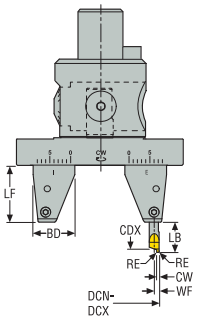
Tabelle:
Wendeschneidplatten-Halter zum Zapfendrehen mit Vielzweck-Adaptern für FB 760-Köpfe, Metrisch

Montagemöglichkeit 3

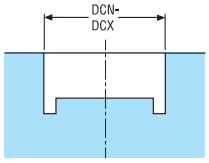




Montagemöglichkeit 4



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

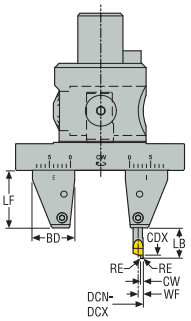
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...81) gemäß Nuttiefe und -durchmesser (siehe Tabelle)

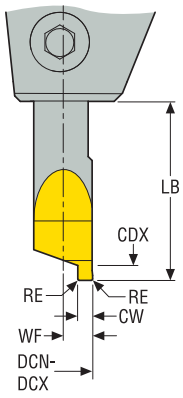
Bereich DCN-DCX mm*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in mm BD	CW	LF	LB	WF	RE	Max. Einstech-tiefe CDX
31-36	AFG0629 10 1581	0-I	3	25	1	34	18	2,95	0,15	2,0
36-41		1-I	3	25	1	34	18	2,95	0,15	2,0
41-46		2-I	3	25	1	34	18	2,95	0,15	2,0
46-51		3-I	3	25	1	34	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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

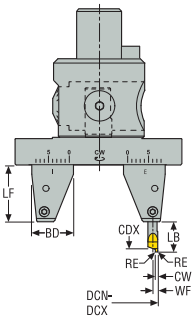
Tabelle:
Wendeschneidplatten-Halter zum Zapfendrehen mit Vielzweck-Adaptern für FB 760-Köpfe, Zoll

Montagemöglichkeit 3

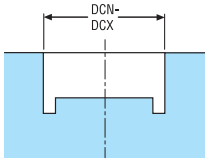




Montagemöglichkeit 4



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

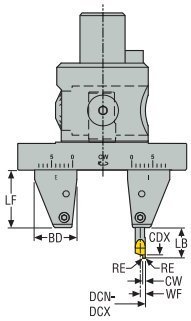
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...81) gemäß Nuttiefe und -durchmesser (siehe Tabelle)

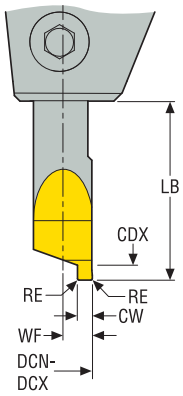
Bereich DCN-DCX Durchmesser Zoll*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in Zoll						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
1.220-1.417	AFG0629 10 1581	0-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.417-1.614		1-I	3	*0.984*	*0.0394*	*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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

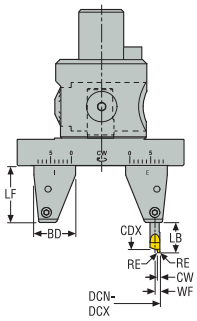
Tabelle:
Wendeschneidplatten-Halter zum Zapfendrehen mit Vielzweck-Adaptern für FB 760-Köpfe, Metrisch

Montagemöglichkeit 3

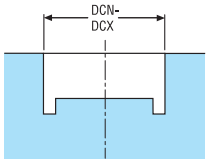




Montagemöglichkeit 4



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

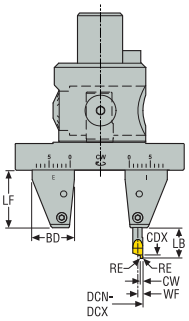
- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...81) gemäß Nuttiefe und -durchmesser (siehe Tabelle)

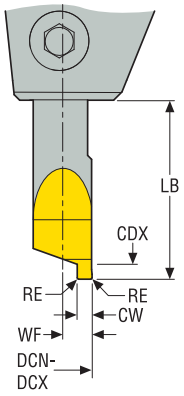
Bereich DCN-DCX mm*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in mm						Max. Einstech-tiefe CDX
				BD	CW	LF	LB	WF	RE	
31-36	AFG0629 25 1581	0-I	3	25	2,5	34	18	2,95	0,15	5,0
36-41		1-I	3	25	2,5	34	18	2,95	0,15	5,0
41-46		2-I	3	25	2,5	34	18	2,95	0,15	5,0
46-51		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
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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

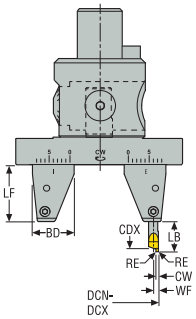
Tabelle: Wendeschneidplatten-Halter zum Zapfendrehen mit Vielzweck-Adaptern für FB 760-Köpfe, Zoll

Montagemöglichkeit 3

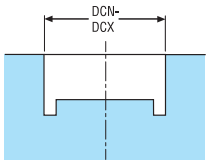




Montagemöglichkeit 4



Einen geeigneten Wendeschneidplatten-Halter auswählen und die Schaftposition für den geforderten Bohrungsbereich auf dem Vielzweck-Adapter (MPA) einstellen.



Hinweis: Stechwerkzeuge für Außenbearbeitung bestehen aus:

- einem Axiabore™ Plus-Kopf (A760 03)
- einem Vielzweck-Adapter (MPA) (BDA16BS25100)
- einem Einstechhalter I (innen) und einem Einstechhalter E (außen) (BAS25FGI35 und BAS25FGE35) zur Aufnahme eines Stechwerkzeuges oder als Gegengewicht (siehe Einstellpositionen in der Grafik)
- einem Stechwerkzeug für Außenbearbeitung (AFG...81) gemäß Nuttiefe und -durchmesser (siehe Tabelle)

Bereich DCN-DCX Durchmesser Zoll*	Bezeichnung Nutstech-werkzeug außen	Position Stechwerkzeug-halter**	Abb.	Abmessungen in Zoll BD	CW	LF	LB	WF	RE	Max. Einstech-tiefe CDX
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
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

* Vergrößerungsbereich bis zu + 0,2 mm *(0.008")* möglich. **Empfohlene Werte sind **fett** gedruckt.
Weitere Informationen zu Nutenstechwerkzeugen, siehe Seite(n) 594

Maximale Schnittgeschwindigkeiten - Ausdrehköpfe des Typs Axiabore™

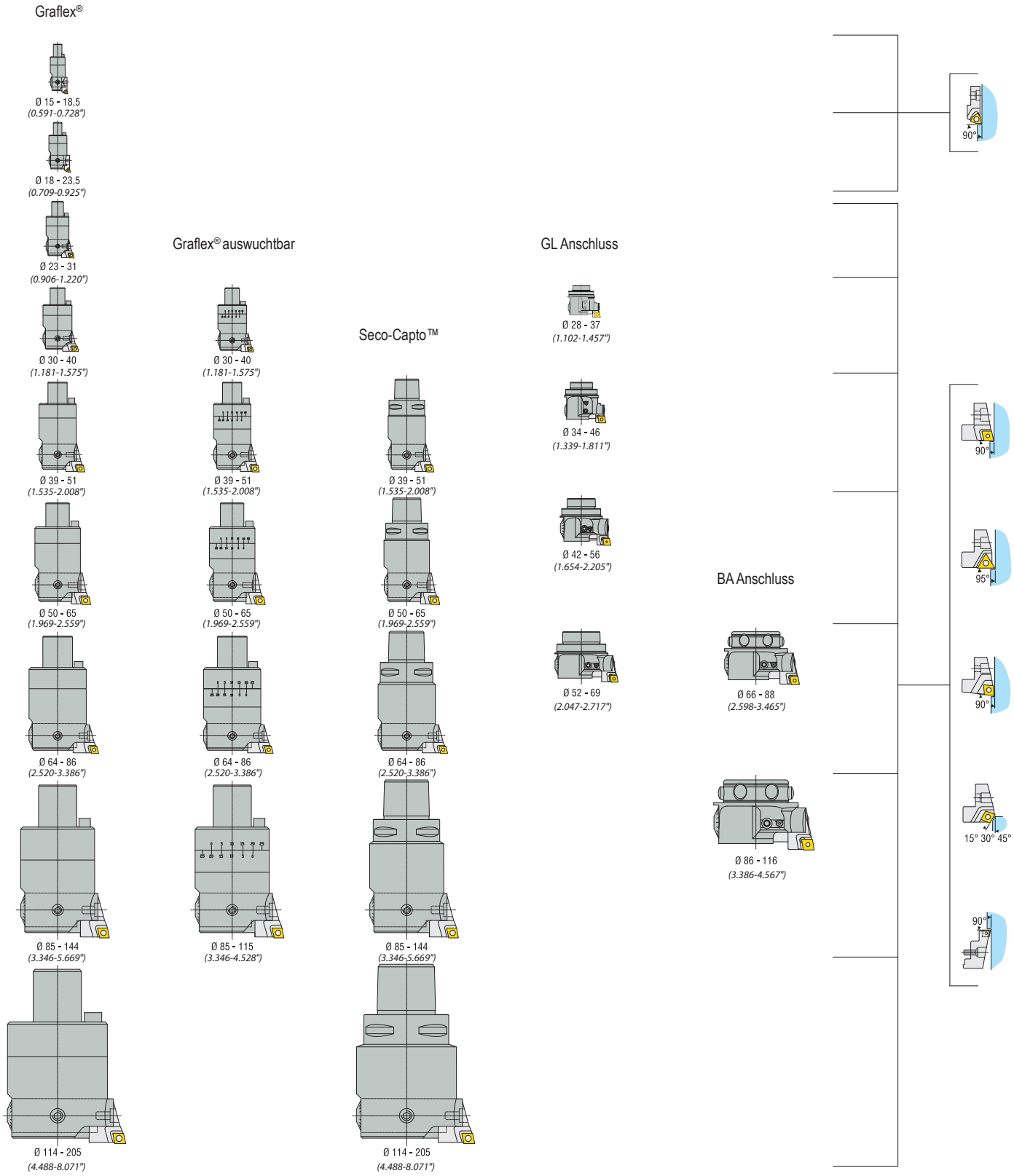
Weitere Informationen finden Sie in der Gebrauchsanweisung, die mit den Köpfen und den GL-Stangen geliefert wird.					
Kopf	**Durchmesserbereich mm *(Zoll)***	**Max. Drehzahl mit Werkzeug (U/min)**	**Max. Drehzahl mit MPA (U/min)**	**Max. Schnitt-geschwindigkeit v_c bei min. Kap. m/min *(sf/min)***	**Max. Schnitt-geschwindigkeit v_c bei min. Kap. 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 maximale Geschwindigkeit ist abhängig vom Design des Ausdrehkopfes und seiner Auswuchtqualität. Innerhalb dieser Grenzen müssen die Geschwindigkeiten auch im Hinblick auf Werkstoff, Schneidkanten (Wendeschneidplatte), Werkzeuglänge, Maschinenspindel etc. angepasst werden. Bei Geschwindigkeiten ab ca. 8.000 U/min müssen die Aufnahmen und Zwischenelemente feinausgewuchtet sein. Auswuchtbare Köpfe und feinausgewuchtete Aufnahmen verbessern Werkzeugstandzeit und Bohrungsqualität auch bei geringeren Geschwindigkeiten.
* Einschließlich maximaler Schnittgeschwindigkeit mit maximalen U/min
** Nicht mit allen Werkzeugen erreichbar, siehe ***.
*** Die maximale 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 & 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 Ausdrehwerkzeuges	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
Geringe 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



- Einstellung der Wendeschneidplatten-Halter 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.

Beachten Sie Folgendes: 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")*.

Beachten Sie Folgendes: Der kleinste Durchmesser, der mit dem Seco-Capto™ Feinausdrehkopf mit C3-Anschluss zu erzielen ist, beträgt 39 mm *(1.535")*. Setzen Sie für Durchmesser von 15 bis 40 mm *(0.591–1.575")* Graflex®-Ausdrehköpfe mit Anschlussgröße G0 bis G2 in Verbindung mit dem passenden Seco-Capto™/ Graflex® Adapter ein. 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")* 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

Beachten Sie: Verwenden Sie einen Einstellwinkel von 95° beim Ausspindeln von Grundlochbohrungen.

Wendeschneidplatten-Halter zum Anfasen, Durchmesserbereich von 23 bis 160 mm *(0.906–6.299")*

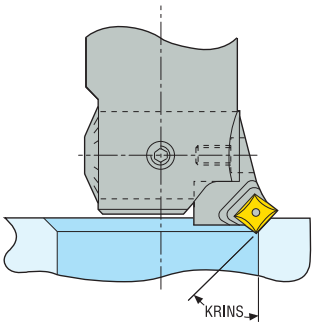
FBIH 729 ist mit 15°, 30° oder 45° Einstellwinkel für CC-Wendeschneidplatten verfügbar.

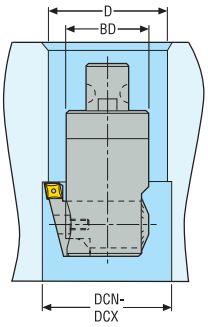
Libraflex® Auswuchtung ist auch für Wendeschneidplatten-Halter zum Anfasen zu erzielen.

Wendeschneidplatten-Halter zum Rückwärtssenken, Durchmesserbereich von 26,5 bis 164 mm *(1.043–6.457")*

FBIH A789 mit Einstellwinkel 90° für CC-Wendeschneidplatten verfügbar.

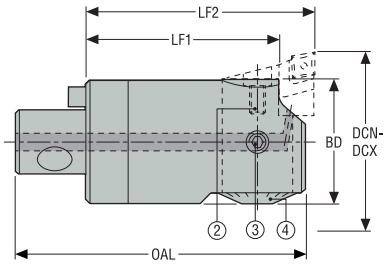
Beim Einsatz von Wendeschneidplatten-Haltern zum Hinterdrehen ist eine Libraflex®-Auswuchtung nicht möglich. Hier wird die höchste Unwuchtreduzierung erzielt, indem man beide Wuchtringe auf die höchste Skalierung stellt.





FB780

Graflex®



2. Spannschraube
3. Klemmschraube
4. Mikrometrische Einstellschraube

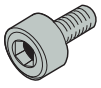


- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).

Produkt-nummer	Bezeichnung	Maschinenseite 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*	
00056632	A78008	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 *0.220*	09
00056633	A78009	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 *0.220*	09
00072991	A78010	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*	0,11 *0.240*	10
00072992	A78020	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*	0,22 *0.490*	20
00072993	A78030	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*	0,5 *1.100*	30
00072995	A78040	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*	0,8 *1.760*	40
00072996	A78050	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*	1,49 *3.280*	50
00056551	A78060	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*	3,1 *6.830*	60/65
00056552	A78070	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*	6,3 *13.890*	70/75

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 618, 619-621
Hinweis: Gewicht ohne Aufnahme

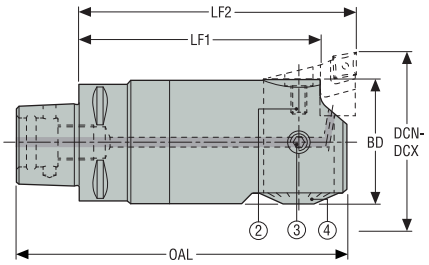
Ersatzteile

Für Halter	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube	Mitnehmer
					
A78008	960D30050S	DOUBLE-T	H4B-H2.0	19A7100403	90M01
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

FB780

Seco-Capto™





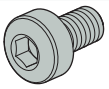
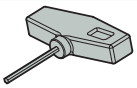
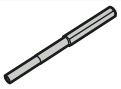
- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).

2. Spannschraube
3. Klemmschraube
4. Mikrometrische Einstellschraube

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*	0,48 *1.060*	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*	0,89 *1.960*	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*	1,62 *3.570*	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 *7.280*	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*	7,15 *15.760*	70

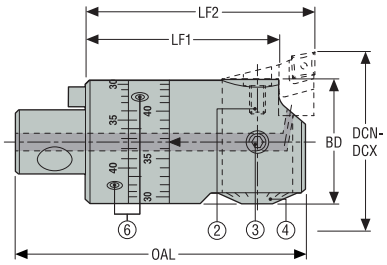
Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 618, 619-621
Hinweis: Gewicht ohne Aufnahme

Ersatzteile

Für Halter	Schraube	Schlüssel	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube
					
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

FB780 Libraflex® auswuchtbar

Graflex®





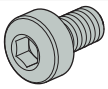
6. Klemmschraube 2
2. Spannschraube
3. Klemmschraube 1
4. Mikrometrische Einstellschraube

- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).
- Auswuchtung durch zwei Skalenringe.
- Für Schnittgeschwindigkeiten v_c bis 1 495 m/min und mehr, siehe Seite(n) 622

Produkt-nummer	Bezeichnung	Maschinenseite 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*	
00055932	A79020	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*	0,19 *0.420*	20
00056005	A79030	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*	0,45 *0.990*	30
00056006	A79040	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*	0,78 *1.720*	40
00056007	A79050	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*	1,42 *3.130*	50
00001451	A79060	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*	2,87 *6.330*	60

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 618, 619-621
Hinweis: Gewicht ohne Aufnahme

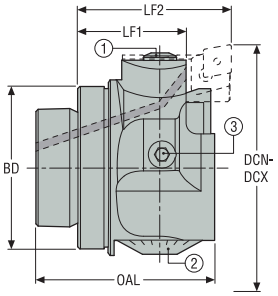
Ersatzteile

Für Kopf	Schraube	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube 1	Befestigungs-schraube 2	Mitnehmer
						
A79020	19TB0305	DOUBLE-T	H4B-H2.0	950L0406	960D30045S	90M2
A79030	19TB04075	–	03M03C	950L0608	AU7901030	90M3
A79040	19TB04075	–	03M03C	950L0612	AU7901040	90M4
A79050	950D0410	–	03M03C	950L0616	AU7901050	90M51
A79060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	AU7901060	90M6

FB 620 GL – Feinausdrehköpfe – kompakt – GL-Anschluss

GL





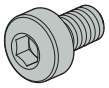
- Ideal für GL25, GL32, GL40 und GL50 Steadyline-Bohrstangen
- Interne Kühlschmierstoffzufuhr auf die Schneide
- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).

1. Spannschraube
2. Mikrometrische Einstellschraube
3. Klemmschraube

Bezeichnung	Produkt-nummer	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-FB620-10	03307855	GL25	27,0 *1.063*	35,0 *1.378*	29,5 *1.161*	17,7 *0.697*	28,0 *1.102*	25,0 *0.984*	0,1 *0.220*	9000
GL32-0620-20	02904469	GL32	34,0 *1.339*	46,0 *1.811*	35,2 *1.386*	23,75 *0.935*	32,1 *1.264*	32,0 *1.260*	0,13 *0.290*	7000
GL40-0620-30	02904470	GL40	42,0 *1.654*	56,0 *2.205*	40,7 *1.602*	24,75 *0.974*	35,1 *1.382*	40,0 *1.575*	0,22 *0.490*	5600
GL50-0620-40	02904471	GL50	52,0 *2.047*	69,0 *2.717*	43,7 *1.720*	25,75 *1.014*	36,1 *1.421*	50,0 *1.969*	0,32 *0.710*	4800

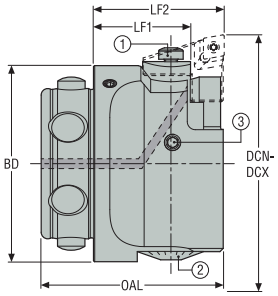
Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 618, 619-621
** Max. Drehzahlen, siehe Anweisungen auf Seiten.
Hinweis: Gewicht ohne Aufnahme

Ersatzteile

Für Kopf	Schraube	Schlüssel für Pratze	Schlüssel (Quergriff)	Befestigungs-schraube
				
GL25-FB620-10	19TB0305	H2.0-2D	–	19A71000
GL32-FB620-20	19TB0305	H4B-H2.0	DOUBLE-T	950L0406
GL40-FB620-30	19TB04075	03M03C	–	950L0608
GL50-FB620-40	19TB04075	03M03C	–	950L0608

FB 620 BA – Feinausdrehköpfe – BA-Anschluss

BA



1. Spannschraube
2. Mikrometrische Einstellschraube
3. Klemmschraube

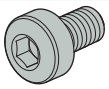
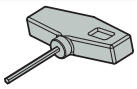
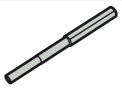


- Ideal für BA60 und BA80 Steadyline-Bohrstangen
- Interne Kühlschmierstoffzufuhr auf die Schneide
- Einstellung durch Mikrometerspindel (in Stufen von 0,01 mm) und Nonius (jeder Teilstrich entspricht 2,5 µm im Durchmesser).

Bezeichnung	Produkt-nummer	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-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 *1.540*	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*	1,1 *2.430*	3000

Wendeschneidplatten-Halter sind separat zu bestellen, siehe Seite(n) 576
** Max. Drehzahlen, siehe Anweisungen auf Seiten.
Hinweis: Gewicht ohne Aufnahme

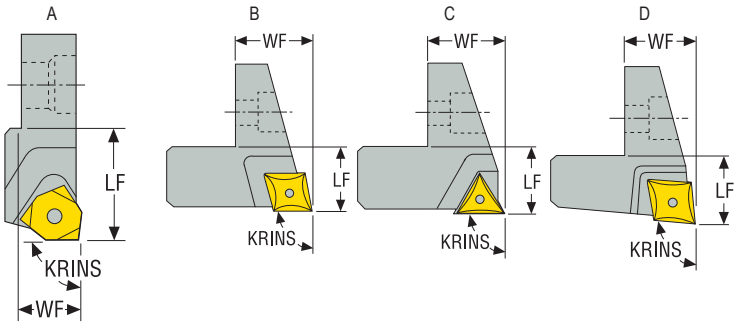
Ersatzteile

Für Kopf	Schraube	Schlüssel	Schlüssel (Quergriff)	Schlüssel	Befestigungs-schraube
					
BA060-FB620-50	19TB04075	03M03C	–	–	950L0608
BA080-FB620-60	950D0514	–	DOUBLE-T	H6B-H5.0L	950L0608

Wendeschneidplatten-Halter

für Ausdrehkopf FB 620/ 780/ 790



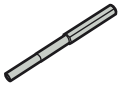


- Passend für radiale Ausdrehköpfe FB 620/ 780/ 790
- ** Eine Präzisionsauswuchtung der FB-Ausdrehköpfe Typ A790 ist bei Einsatz der großen Wendeplattenhalter nicht möglich.

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*	0,01 *0.020*	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*	0,01 *0.020*	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*	0,02 *0.040*	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*	0,02 *0.040*	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*	0,02 *0.040*	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*	0,02 *0.040*	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*	0,05 *0.110*	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*	0,08 *0.180*	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*	0,09 *0.200*	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*	0,09 *0.200*	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*	0,12 *0.260*	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*	0,01 *0.020*	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*	0,02 *0.040*	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*	0,02 *0.040*	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*	0,08 *0.180*	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*	0,09 *0.200*	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*	0,1 *0.220*	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*	0,13 *0.290*	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*	0,01 *0.020*	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*	0,01 *0.020*	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*	0,01 *0.020*	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*	0,02 *0.040*	FB 78040 / FB 79040/ FB 62040	95	–	40	CC...0602...	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*						
A72650	00056594	95° für CC-WSP	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,5 *0.492*	0,02 *0.040*	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*	0,07 *0.150*	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*	0,09 *0.200*	FB 78060 / FB 79060 / FB 731S500	95	**	65	CC...09T3...	D
A72670	00056598	95° für CC-WSP	114,0 *4.488*	160,0 *6.299*	16,5 *0.650*	18,9 *0.744*	0,09 *0.200*	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*	0,12 *0.260*	FB 78070	95	–	75	CC...09T3...	D

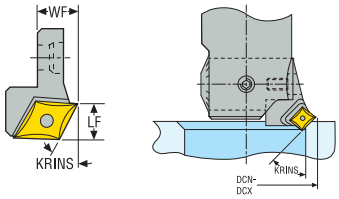
Ersatzteile

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 Anfassen

für Ausdrehkopf FB 620/ 780/ 790





- Passend für radiale Ausdrehköpfe FB 620/ 780/ 790

Produkt-nummer	Bezeichnung	Für Kopf	WSP-Halter Größe	Bereich DCN-DCX ∅		LF	WF	Gewicht	KRINS°	Entspr. WSP-Größe
				mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
00086885	A72910CC0630	FB 78010	10	23,0 *0.906*	31,0 *1.220*	10,8 *0.425*	4,5 *0.177*	0,01 *0.020*	30	CC...0602...
00086888	A72920CC0630	FB 78020 / FB 79020/ GL32-0620-20	20	30,0 *1.181*	36,0 *1.417*	10,0 *0.394*	4,9 *0.193*	0,01 *0.020*	30	CC...0602...
00086891	A72930CC0630	FB 78030 / FB 79030 / FB 62030	30	39,0 *1.535*	56,0 *2.205*	10,5 *0.413*	8,1 *0.319*	0,01 *0.020*	30	CC...0602...
00086894	A72940CC0630	FB 78040 / FB 79040 / FB 62040	40	50,0 *1.969*	69,0 *2.717*	10,5 *0.413*	9,5 *0.374*	0,02 *0.040*	30	CC...0602...
00086897	A72950CC0630	FB 78050 / FB 79050	50	64,0 *2.520*	86,0 *3.386*	10,5 *0.413*	12,5 *0.492*	0,02 *0.040*	30	CC...0602...
00086900	A72960CC0930	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	CC...09T3...
00086903	A72970CC0930	FB 78070	70	114,0 *4.488*	160,0 *6.299*	16,4 *0.646*	18,8 *0.740*	0,09 *0.200*	30	CC...09T3...
00086886	A72910CC0645	FB 78010	10	23,0 *0.906*	31,0 *1.220*	11,5 *0.453*	4,5 *0.177*	0,01 *0.020*	45	CC...0602...
00086889	A72920CC0645	FB 78020 / FB 79020 / FB 62020	20	30,0 *1.181*	46,0 *1.811*	10,0 *0.394*	5,0 *0.197*	0,01 *0.020*	45	CC...0602...
00086892	A72930CC0645	FB 78030 / FB 79030 / FB 62030	30	39,0 *1.535*	56,0 *2.205*	10,5 *0.413*	8,1 *0.319*	0,01 *0.020*	45	CC...0602...
00086895	A72940CC0645	FB 78040 / FB 79040 / FB 62040	40	50,0 *1.969*	69,0 *2.717*	10,5 *0.413*	9,5 *0.374*	0,02 *0.040*	45	CC...0602...
00086898	A72950CC0645	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	CC...0602...
00086901	A72960CC0945	FB 78060 / FB 79060 / A731S500	60	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	19,1 *0.752*	0,07 *0.150*	45	CC...09T3...
00086904	A72970CC0945	FB 78070	70	114,0 *4.488*	160,0 *6.299*	16,4 *0.646*	18,8 *0.740*	0,09 *0.200*	45	CC...09T3...

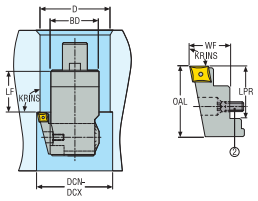
Ersatzschrauben und -schlüssel für Wendeschneidplatten, siehe Seite(n) 654
** Bereich DC mit Jumbo- und Brückenwerkzeugen, siehe Seite(n) 630

Ersatzteile

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 Ausdrehkopf FB 620/ 780/ 790





- Passend für radiale Ausdrehköpfe FB 620/ 780/ 790
- Bei Verwendung von Wendeschneidplatten-Haltern zum Rückwärtssenken für Ausdrehköpfe FB 790 ist eine Präzisionsauswuchtung nicht möglich.
- KRINS 90°
- Geeignete WSP-Größe: 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 A731S500	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)*

* Rückwärtssenkbereich DC mit Jumbo- und Brückenwerkzeugen, siehe Seite 634
Ersatzschrauben und -schlüssel für Wendeschneidplatten, siehe Seite(n) 654
Der Lieferumfang der Wendeschneidplatten-Halter zum Rückwärtssenken umfasst eine spezifische Spannschraube für Wendeschneidplatten-Halter, die anstelle der Standardspannschrauben verwendet wird.

DCN/DCX mini = D+BD / 2 + 0,5 mm *(0.02")* im Durchmesserbereich von 39,5 bis 47,5 *(1.555" bis 1.870")*
DCB/DCX mini = D+BD / 2 + 1 mm *(0.039")* im Durchmesserbereich von 46 bis 64 *(1.811" bis 2.520")*

Ersatzteile

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	950F0620	C02504-T07P	DOUBLE-T	H4B-T07P
A789X70CC0690	950F0620	C02504-T07P	DOUBLE-T	H4B-T07P

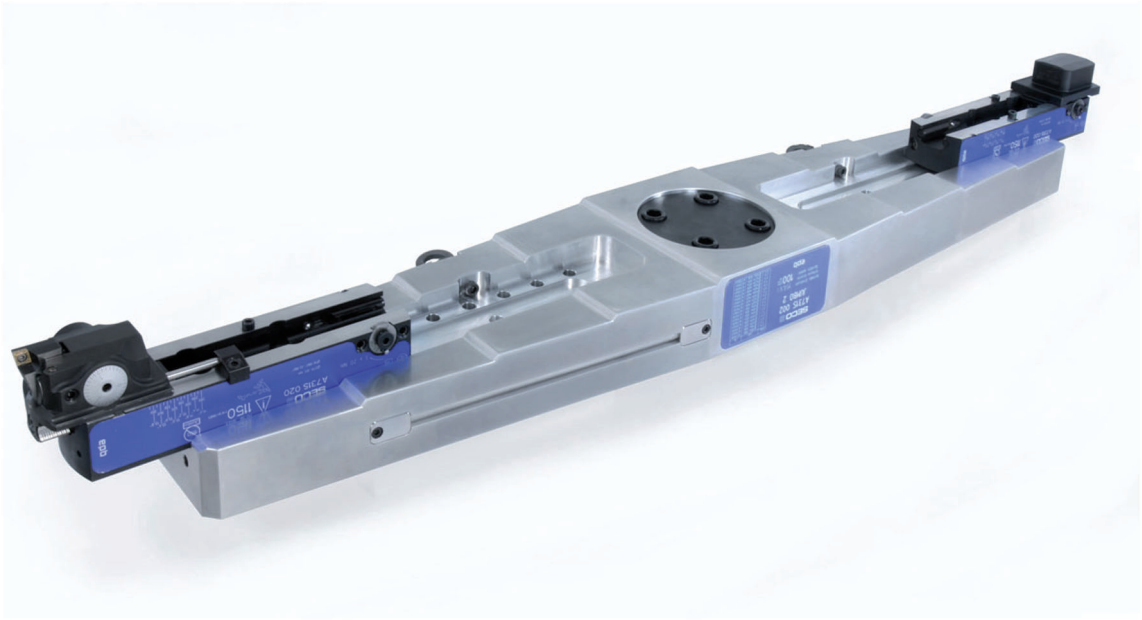
FB 780/ 790 Feinausdrehköpfe

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 Schnittgeschwindigkeiten innerhalb dieser Grenzen müssen in Bezug auf Maschinenbedingungen, zu bearbeitendem Werkstoff, Schneidkante (Wendeschneidplatte), Auskraglänge und Maschinenspindel getroffen 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 Bohrstangen mit Wendeschneidplatten-Haltern oder Wendeschneidplatten-Haltern zum 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	Bereich Durchmesser mm *(Zoll)*	Max. Drehzahl	Angenommene max. Schnittgeschwindigkeit v_c im min. Bereich m/min *(sf/min)*	Angenommene max. Schnittgeschwindigkeit v_c im max. Bereich m/min *(sf/min)*
FB 620 Feinausdrehköpfe mit GL- und BA-Anschluss maschinenseitig, für schwingungsdämpfende Steadyline-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 maximale Geschwindigkeit ist abhängig vom Design des Ausdrehkopfes und seiner Auswuchtqualität. Innerhalb dieser Grenzen müssen die Geschwindigkeiten auch im Hinblick auf Werkstoff, Schneidkanten Wendeschneidplatte), Werkzeuglänge, Maschinenspindel etc. angepasst werden. Bei Geschwindigkeiten ab ca. 8.000 U/min müssen die Aufnahmen und Zwischenelemente feinausgewuchtet sein.

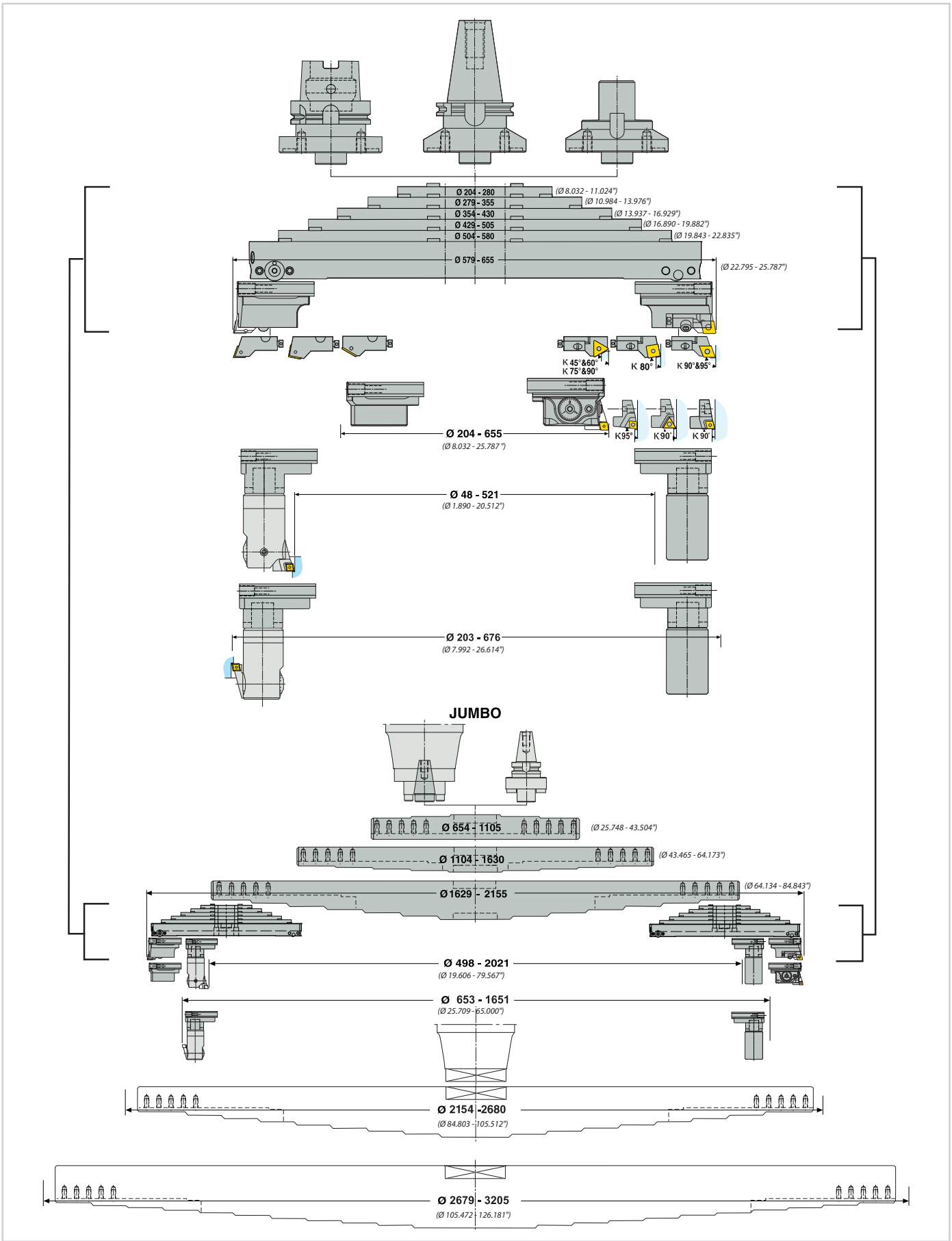


Brückenwerkzeuge

Seco Tools bietet ein umfassendes Produktprogramm an Brückenwerkzeugen und Jumbo-Brückenwerkzeugen.

- Brückenwerkzeuge bieten ein hohes Maß an Flexibilität. Sie sind im Standard im Durchmesserbereich von 204 bis 655 mm (8.03 - 25.78”) erhältlich.
- Seco Jumbo Brückenwerkzeuge bestehen aus hochfestem Aluminium mit Stahl-Schnittstellen. Sie sind im Durchmesserbereich von 654 bis 2155 mm (25.75 - 84.843”) erhältlich.

Übersicht


Ø 204 - 280
Ø 279 - 355
Ø 354 - 430
Ø 429 - 505
Ø 504 - 580
Ø 579 - 655
(Ø 8.032 - 11.024")
(Ø 10.984 - 13.976")
(Ø 13.937 - 16.929")
(Ø 16.890 - 19.882")
(Ø 19.843 - 22.835")
(Ø 22.795 - 25.787")
K 45°&60°
K 75°&90°
K 80°
K 90°&95°
K95°
K90°
K90°
Ø 204 - 655
(Ø 8.032 - 25.787 ")
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")
Ø1629 - 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

5 Brückenwerkzeuge zum Ausdrehen

Durchmesserbereich von 654 bis 3205 mm *(25.748–126.181")*, **Zapfendrehen im Durchmesserbereich von 498 bis 3071 mm** *(19.606–120.906")* **und Rückwärtssenken im Durchmesserbereich von 653 bis 3226 mm** *(25.709–127.008")*.

Jumbo-Brückenwerkzeuge aus hochfestem Aluminium sind so konzipiert, dass sie zwei Standard-Brücken aufnehmen können.

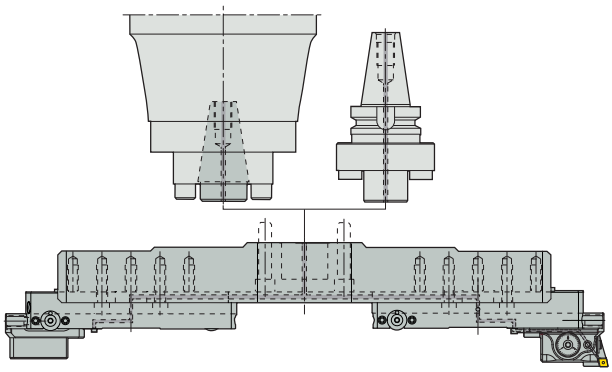
Für die Größen A731S001, 002, 003 erfolgt die Lieferung mit 4 Spannschrauben zur Montage auf eine Fräsaufnahme Typ 569, Zapfendurchmesser 60 mm *(Ø 2.362")* oder zur Montage direkt auf die Spindel (Stirnseite DIN 2079/50). Jumbo-Brückenwerkzeuge werden mit zwei Umsetzringen geliefert.

Größen A731S004-...* und A731S005-...* sind verfügbar auf Anfrage, für standardmäßige oder spezielle Montagemöglichkeiten der Spindel, je nach Maschine:

Durchmesserbereich (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")*	*	*

* Bezeichnung und Abmessungen ergeben sich aus der Spindelbefestigung.

Hauptmerkmale Jumbo Brückenwerkzeuge



Jumbo Brückenwerkzeuge Typ 'S' zeichnen sich durch interne Kühlschmierstoffzufuhr von der Aufnahme zu den beiden Standardbrücken aus. Sie sind mit einer zusätzlichen Befestigungsschraube auf den beiden Standardbrücken versehen.

Beachten Sie Folgendes: Diese neuen Jumbo Brückenwerkzeuge Typ 'S' können sowohl die neuen Brückenwerkzeuge als auch die bisherigen aufnehmen: Bei Einsatz der bisherigen kann die zusätzliche Feststellschraube nicht verwendet werden. Interne Kühlschmierstoffzufuhr auf die Schneide ist nur möglich beim Einsatz der Jumbo- oder Standard-Brückenwerkzeuge des "S"-Typs. Neue und vorherige Brückenwerkzeuge dürfen aus Wuchtgründen nicht miteinander kombiniert werden.

Merkmale

6 Brückenwerkzeuge zum Ausdrehen

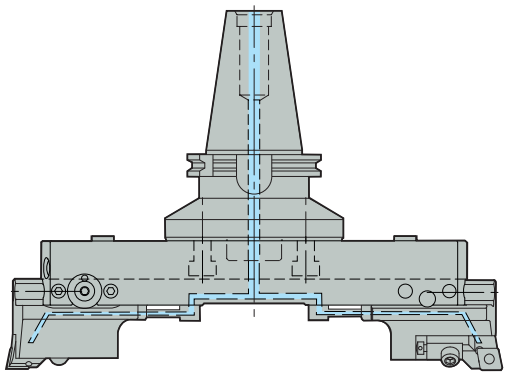
Durchmesserbereich von 204 bis 655 mm *(8.032–25.787")*, **Zapfendrehen im Durchmesserbereich von 48 bis 521 mm** *(1.890–20.512")* **und Rückwärtssenken.**

Brückenwerkzeuge haben Maschinenanschlüsse mit Durchmessern von 130 mm *(5.118")* zur direkten Montage auf Aufnahmen (SK und HSK) oder mittels Graflex®-Adapter.

Durch Einsatz eines Graflex®-Adapters der Größe 7 und eines Flansches kann die Auskraglänge vergrößert werden, siehe Graflex® modulares System. Die Brücken sind einstellbar in Schritten von 30° auf den Aufnahmen der Graflex®-Adapter passend für Werkzeugmagazine.

Die Brücken 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 *(1.496")* im Radius) mit Hilfe der Einstellschraube des Blocks, die mit dem Mitnehmer des Brückenwerkzeuges verbunden ist.

Kühlschmierstoffzufuhr über das Brückenwerkzeug und die Ausdrehblöcke, direkt auf die Schneide.



Auswahl der Brückenwerkzeuge hinsichtlich des Bohrungsdurchmessers zum Ausdrehen oder Zapfendrehen, siehe Tabellen auf Seite(n) 629-634.

Max. Drehzahl, siehe Seite(n) 640.

Beachten Sie Folgendes: Diese Brückenwerkzeuge (Produktnummer A731S0_0) können nicht zusammen mit den vorherigen Ausdrehblöcken (Produktnummer A731 _00 -ohne S-) eingesetzt werden.

Merkmale

Schruppausdrehblock

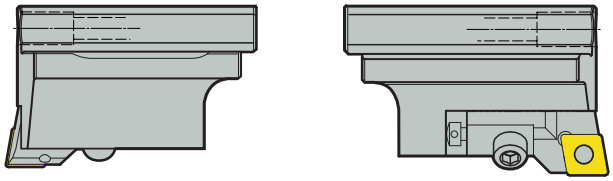
Zwei gleiche Ausdrehköpfe sind erforderlich, um ein Schruppwerkzeug zusammenzustellen. Jeder Ausdrehkopf ist mit einem Kurzklemmhalter versehen. Die Schruppausdrehblöcke bieten interne Kühlschmierstoffzufuhr direkt auf die Schneide.

Durch Einsatz eines Graflex®-Adapters der Größe 7 und eines Flansches kann die Auskraglänge vergrößert werden, siehe Graflex® modulares System.

Die Brücken sind einstellbar in Schritten von 30° auf den Aufnahmen der Graflex®-Adapter passend für Werkzeugmagazine.

Die Brücken können Schrupp- und Feinausdrehköpfe sowie Gegengewichte oder Graflex®-Ausdrehblöcke aufnehmen.

Kassetten



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.
- Weitere Kassetten ISO5611/h1 = 16 mm *(0.629")* Anschlussgröße sind ebenfalls geeignet.

ANMERKUNG: Beide Kurzklemmhalter können sowohl axial vorstehen als auch asymmetrisch eingestellt werden. Ein Distanzstück zur Anhebung der voreilenden Schneide ist als Zubehör verfügbar (Bezeichnung 18LS0316). Montage und Einstellung, siehe Seite(n) 629-634.

Feinausdrehblock und Gegengewichtsblock

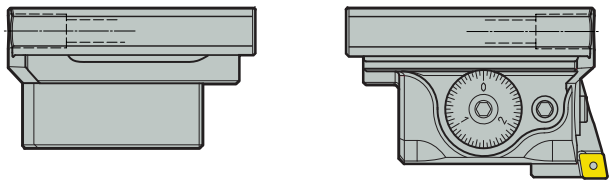
Ein Feinausdrehkopf und ein Gegengewicht sind erforderlich, um ein Werkzeug zusammenzustellen.

Einstellung des Durchmessers durch eine Mikrometerspindel (1 Teilstrich = 5 µm *(197 µin)* auf den Durchmesser).
Das Einstellsystem ist abgedichtet und lebenslang geschmiert.

Die hohe Präzision ermöglicht eine exakte Wiederholgenauigkeit.
Die seitliche Mikrometerspindel ist leicht zugänglich.

Feinausdrehblöcke mit interner Kühlschmierstoffzufuhr, direkt auf die Schneide.

Passende Wendeschneidplatten-Halter A72460, A72560 oder A72660



Passende Wendeschneidplatten-Halter A72460, A72560 oder A72660 sind separat zu bestellen. Sie sind identisch mit den Wendeschneidplatten-Haltern für radiale Feinausdrehköpfe, siehe Seite(n) 618, 619.

Montage und Einstellung, siehe Seite(n) 629-634.

Merkmale

Graflex® Ausdrehblock, zum Zapfendrehen oder Rückwärtssenken

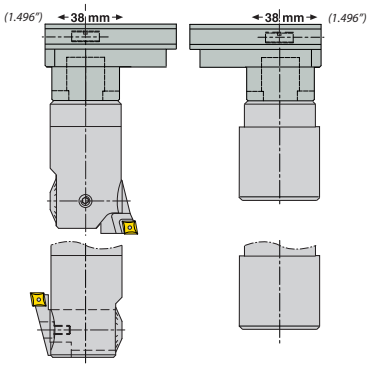
Dieser Ausdrehkopf besitzt eine Graflex®-Verbindung der Größe G5.

Alle Graflex®-Elemente der Größe G5, Spezial oder Standard, können auf ein Brückenwerkzeug montiert werden. Beispiel: Zapfendrehen oder Rückwärtssenken mit zwei Graflex®-Ausdrehblöcken mit einem Graflex®-Feinausdrehkopf A78050 mit Wendeschneidplatten-Halter (z. B. A72550 zum Rückwärtssenken), einem Wendeschneidplatten-Halter zum Rückwärtssenken (z. B. A789X30CC0690) und einem Graflex®-Gegengewicht (z. B. BM050W78050).

Das Graflex®-Element kann an zwei Positionen auf der Brücke montiert werden, da es zweimal zwei Positionen für die Kugelschrauben und zwei Mitnehmernuten um 180° versetzt gibt. Die Schruppausdrehblöcke bieten interne Kühlschmierstoffzufuhr direkt auf die Schneide.

Montage und Einstellung, siehe Seite(n) 629-634.

Graflex® Ausdrehblock, zum Zapfendrehen oder Rückwärtssenken



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.

Neue und vorherige Brückenwerkzeuge dürfen aus Wuchtgründen nicht miteinander kombiniert werden.

ANMERKUNG: Diese Ausdrehblöcke sind auch mit den vorherigen Brückenwerkzeugen einsetzbar.

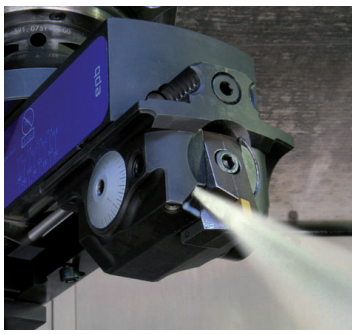
Hinweise zur Auswahl des Zubehörs für interne Kühlschmierstoffzufuhr

Schruppen (Brückenwerkzeug mit zwei Schruppausdrehblöcken):

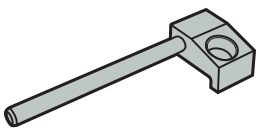
Für eine direkte Kühlschmierstoffzufuhr auf beide Schneiden sind 2 Kühlrohrverbindungen (Produktnummer AU731S00700) zur Montage auf das Brückenwerkzeug und 2 Kühldüsen-Sets (Produktnummer AU731S40700) zur Montage auf jeden Schruppausdrehblock erforderlich. Verwenden Sie für interne Kühlschmierstoffzufuhr durch den Kühlmittelkanal des Ausdrehblocks 2 Kühlrohrverbindungen (Bezeichnung AU731S00700) zur Montage auf dem Brückenwerkzeug.

Feinausdrehen (Brückenwerkzeug mit 1 Feinausdrehblock und 1 Gegengewicht)

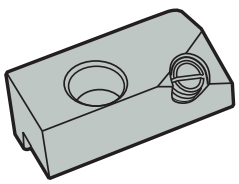
Verwenden Sie 1 Kühlrohrverbindung (Bezeichnung AU731S00700) zur Montage auf dem Brückenwerkzeug zur Verbindung mit dem Feinausdrehblock. Da der Feinausdrehblock bereits standardmäßig eine Kühlmitteldüse aufweist, wird damit eine zielgerichtete Kühlschmierstoffzufuhr erreicht.
Zapfendrehen (z. B. Brückenwerkzeug mit 2 Graflex®-Ausdrehblöcken, mit einem Feinausdrehkopf und einem Gegengewicht) 1 Kühlrohrverbindung (Bezeichnung 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
(Bezeichnung 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*.

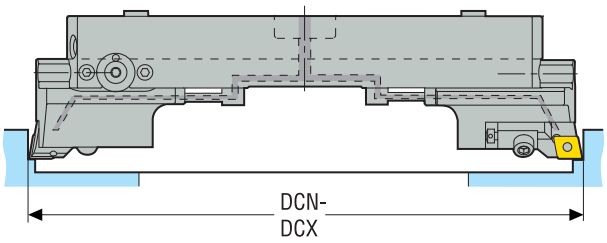


Abb. 1

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).**

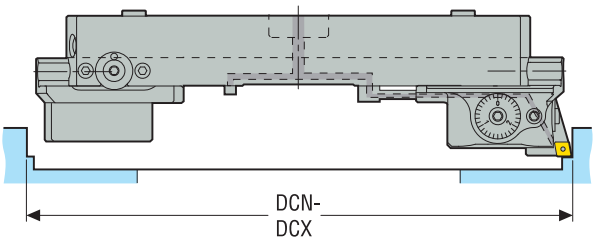


Abb. 2

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*.

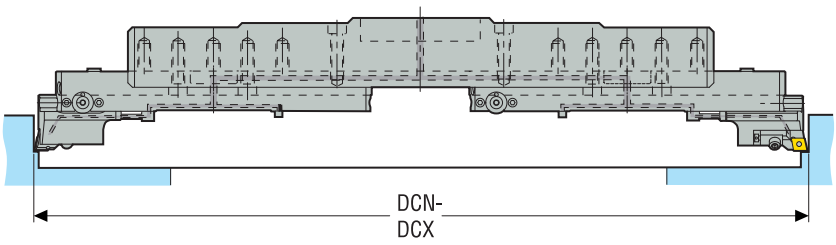


Abb. 3

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).**

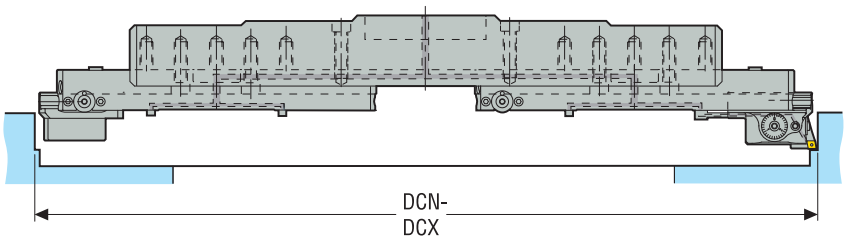


Abb. 4

* Kassetten müssen separat bestellt werden.
** Wendeschneidplatten-Halter müssen separat bestellt werden.

Brückenwerkzeugkombinationen zum Ausdrehen: Brückenwerkzeugauswahl für den gewünschten Ausdrehdurchmesser

Ausdrehen DCN-DCX mm	*Ausdrehen DCN-DCX Zoll*	Jumbo Brückenwerkzeug	Klassische Brückenwerkzeuge	Schruppausdrehen		Feinausdrehen	
					Abb.		Abb.
204-280	*8.031-11.024*	–	A731S 010	2x A731S 400 + 2 Einbauhalter	1	A731S 500 + 1 WSP-Halter + 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 Einbauhalter	3	A731S 500 + 1 WSP-Halter + 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 Einbauhalter	3	A731S 500 + 1 WSP-Halter + 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 Einbauhalter	3	A731S 500 + 1 WSP-Halter + 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 Einbauhalter	3	A731S 500 + 1 WSP-Halter + 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 Einbauhalter	3	A731S 500 + 1 WSP-Halter + 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).

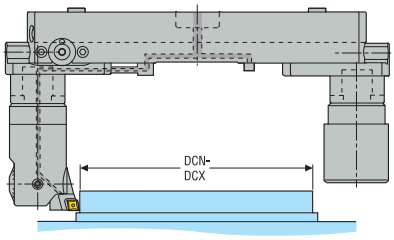


Abb. 1

Eine Feinausdrehkombination für Durchmesser bis zu 3205 mm *(Ø 120.906")* besteht aus: 1 Jumbo-Brückenwerkzeug (A731S 00_) + 2 Brückenwerkzeuge (A731S 0_0) + 2 Schrupp-ausdrehblöcke (2x A731S 400) mit 2 Kurzklemmhaltern*.

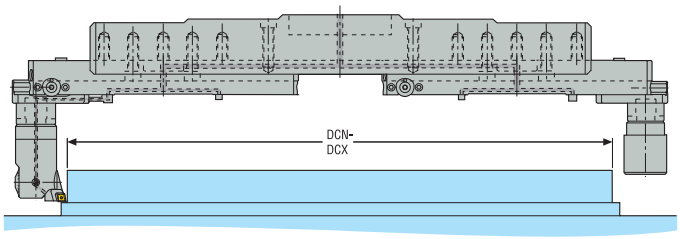


Abb. 2

* Wendeschneidplatten-Halter müssen separat bestellt werden.

Brückenwerkzeugkombinationen zum Zapfendrehen: Brückenwerkzeugauswahl für den gewünschten Zapfendrehdurchmesser

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 WSP-Halter + 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 WSP-Halter + 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 WSP-Halter + 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 WSP-Halter + 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 WSP-Halter + 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 WSP-Halter + 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 Rückwärtssenken:

Eine Feinausdrehkombination zum Rückwärtssenken für Durchmesser bis zu 676 mm (Ø 26.614") besteht aus: Brückenwerkzeug (A731S 0_0) + 2 Graflex® Blöcke (2 x A731S 40128) + z. B. 1 Feinausdrehkopf (A780 50) mit 1 Wendeschneidplatten-Halter Größe 50* + 1 Gegengewicht (BM050W78050).

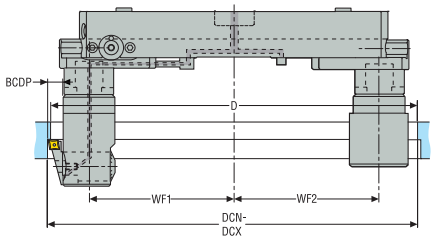


Abb. 1

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).

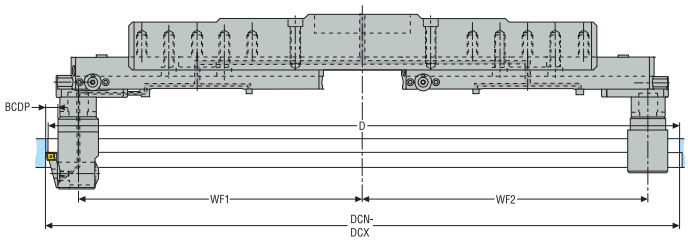


Abb. 2

* 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).

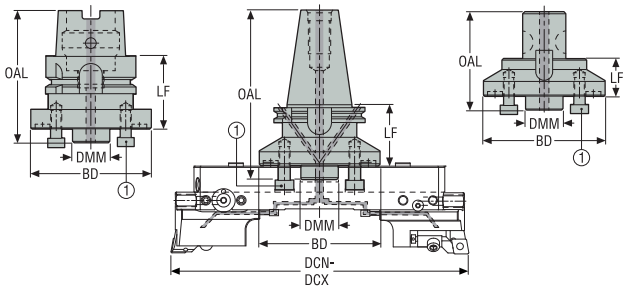
Zwei extreme Beispiele:

	D min = DCN - 2,5
Ausdrehkopf A78050 auf Mindest-Bereich eingestellt:	D min = DCN - 2,5
Ausdrehkopf A78050 auf maximalen Bereich eingestellt:	D min = DCX -13,5
	D min = DCX -13,5

Brückenwerkzeugkombinationen zum Rückwärtssenken: Brückenwerkzeugauswahl für den gewünschten Rückwärtssenkdurchmesser

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 WSP-Halter 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 WSP-Halter 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 WSP-Halter 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 WSP-Halter 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 WSP-Halter 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 WSP-Halter 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		

ABB 731 200 – Aufnahmen und Adapter für Brückenwerkzeuge



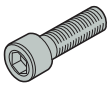
1. Klemmschraube



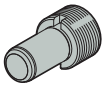
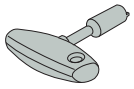
- HSK- und SK-Aufnahmen für kurze Auskraglängen.
- Graflex® Adapter für große Auskraglängen.
- Orientierungsmöglichkeit der Brücke alle 30°.
- Mit Dichtring für den Zapfen Durchmesser 58×3 mm.

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*	5,74 *12.650*
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 *12.430*
E9306731200	02417268	ISO 12164-1/ DIN 69893-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*	4,72 *10.410*
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*	3,78 *8.330*

Ersatzteile

Für Halter	Schraube	Schlüssel	Dichtschrauben	Mitnehmer
				
E3471731200	950D1230	10SMS795	950A0606	–
E3416731200	950D1230	10SMS795	950A0606	–
E9306731200	950D1230	10SMS795	–	–
A731200	950D1230	10SMS795	–	90M7

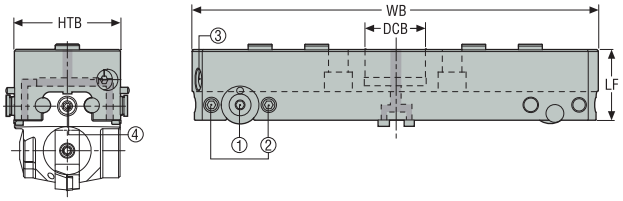
Zubehör

Für Halter	Kühlmittelrohr	Dicht-stopfen	Spann-schlüssel
			
E3471731200	–	–	–
E3416731200	–	–	–
E9306731200	20E9306	02E9306	03E9306
A731200	–	–	–

Drehmoment 80 Nm. Einzelheiten zum Einsatz, siehe Anweisungen im Lieferumfang der Brückenwerkzeuge und Ausdrehblöcke.
Zubehör, separat zu bestellen

BB 731S0x0 – Brückenwerkzeuge



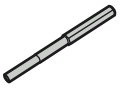


1. Klemmschraube mit Stopfen
2. Klemmschraube
3. Mitnehmer
4. Durchmessereinstellung

- Interne Kühlschmierstoffzufuhr durch das Brückenwerkzeug

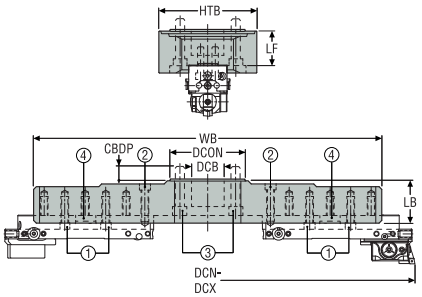
Bezeichnung	Produkt-nummer	Werkstückseite DCN-DCX		HTB	WB	DCB	LF	Gewicht
		mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*
A731S010	02753664	204,0 *8.031*	280,0 *11.024*	70,0 *2.756*	195,0 *7.677*	40,0 *1.575*	47,0 *1.850*	3,43 *7.560*
A731S020	02753668	279,0 *10.984*	355,0 *13.976*	70,0 *2.756*	269,0 *10.591*	40,0 *1.575*	47,0 *1.850*	4,92 *10.850*
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*	6,4 *14.110*
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 *17.420*
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*	10,4 *22.930*
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 *27.120*

Ersatzteile

Für DCN-DCX	Schlüssel (Quergriff)	Schlüssel	Spannschlüssel	Befestigungs-schraube
				
204-655	DOUBLE-T	H6B-H5.0L	03HL05	19A71060

Anzugsmoment 20 Nm für Spannschraube (2) und Klemmschraube mit Stopfen (1). Vor Verriegelung prüfen, ob der Mitnehmer eingerastet ist. Einzelheiten zum Einsatz, siehe Anweisungen im Lieferumfang der Brückenwerkzeuge und Ausdrehblöcke.
Maximale Drehzahl, siehe Seite (n) 640 * Zapfendreh-Bereich, siehe Guide Seite(n) 631-632
Für größere Durchmesser, siehe Jumbo Brückenwerkzeuge Seite(n) 637

JBB 731S00 – Jumbo Brückenwerkzeuge



1. Spannschraube
2. Klemmschraube
3. Klemmschraube
4. Dichtstopfen



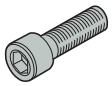
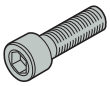
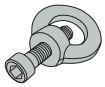
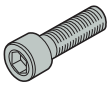
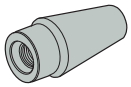
- Jumbo Brückenwerkzeuge sind so konzipiert, dass sie zwei Standard-Brückenwerkzeuge aufnehmen können.
- Jumbo Brückenwerkzeuge mit interner Kühlschmierstoffzufuhr

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 *44.640*	–
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 *76.060*	–
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*	58,0 *127.870*	**

Ausdreh- und Zapfendreh-Bereich für Jumbo- und Brückenwerkzeug-Kombinationen, siehe Seite(n) 629-634
** Größere Größen A731S004-… (Durchmesser 2154-2680 mm) und A731S005-… (Durchmesser 2679-3205 mm) verfügbar auf Anfrage, siehe Guide Seite(n) 625
Zubehör, separat zu bestellen

Ersatzteile

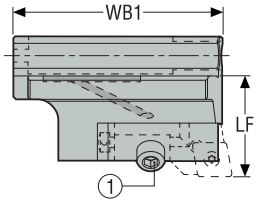
Zubehör

Für DCN-DCX	Schraube	Feststellschraube	Schraube für Hebel	Befestigungs-schraube	O-Ring	Dicht-stopfen	Zentrierzapfen
							
654-1105	950D1240	950D1670	90AS03	950D1250	90JT02	AU731S01100	E447153960
1104-1630	950D1240	950D1680	90AS03	950D1250	90JT02	AU731S01100	E447153960
1629-2155	950D1240	950D16120	90AS03	950D1250	90JT02	AU731S01100	E447153960

Ein Satz O-Ring-Dichtungen enthält 6 O-Ring-Dichtungen à 6 mm (0.236") Durchmesser für die Kühlmittelkanäle und 1 O-Ring-Dichtung à 60 mm (2.362") Durchmesser für die Haltebohrung der Jumbo Brückenwerkzeuge.

BBB 731S0xx – Ausdrehblöcke für Brückenwerkzeuge



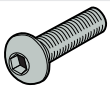
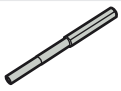


1. Spannschraube

- Zur Montage auf Brückenwerkzeugen
- Interne Kühlschmierstoffzufuhr für Schrupp-, Schlicht- und Graflex-Ausdrehblöcke: siehe Zubehör

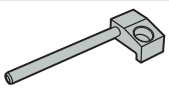
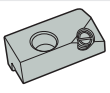
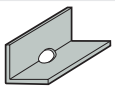
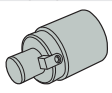
Produkt-nummer	Bezeichnung	Ausdrehblock Typ	Werkstückseite Bereich DCN-DCX		DCB	BD	WB1	WB2	LF	LF1	HTB	Gewicht	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*	–
02753679	A731S400	Schruppausdrehblock*	204,0 *8.031*	2155,0 *84.843*	–	–	97,0 *3.819*	–	47,0 *1.850*	–	70,0 *2.756*	1,33 *2.930*	A
02753680	A731S500	Feinausdrehblock**	204,0 *8.031*	2155,0 *84.843*	–	–	97,0 *3.819*	–	47,0 *1.850*	–	70,0 *2.756*	1,41 *3.110*	B
02753682	A731S600	Gegengewicht	204,0 *8.031*	2155,0 *84.843*	–	–	97,0 *3.819*	–	–	–	70,0 *2.756*	1,49 *3.280*	C
02753687	A731S40128	Graflex Größe G5***	48,0 *1.890*	2021,0 *79.567*	28,0 *1.102*	50,0 *1.969*	97,0 *3.819*	30,0 *1.181*	38,0 *1.496*	25,0 *0.984*	70,0 *2.756*	0,98 *2.160*	D

Ersatzteile

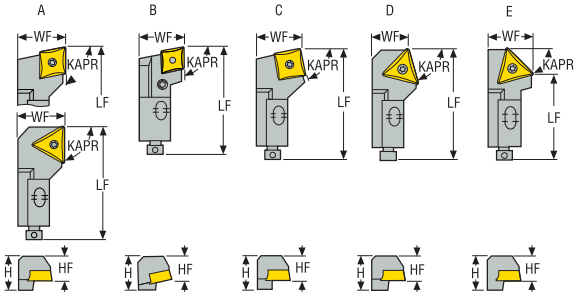
Für Halter	Schraube	Klemmschraube für Trommel	Schlüssel (Quergriff)	Schlüssel	Spannschlüssel	O-Ring
						
A731S400	950CB0830	–	DOUBLE-T	H6B-H5.0L	–	90JT01
A731S500	950D0612	950L1016	DOUBLE-T	H6B-H5.0L	–	90JT01
A731S600	–	–	DOUBLE-T	H6B-H5.0L	–	–
A731S40128	90F5	–	DOUBLE-T	H6B-H5.0L	03H05	90JT01

* Einbauhalter sind separat zu bestellen, siehe Seite(n) 639
** Wendeschneidplatten-Halter Größe 60 sind separat zu bestellen, siehe Seiten 618, 619
*** Für Ausdrehkopf A78050 Gegengewicht BM050W78050 verwenden, siehe nachstehendes Zubehör.
Ein Satz O-Ring-Dichtungen enthält 6 O-Ring-Dichtungen à 6 mm (0.236") Durchmesser für die Kühlmittelkanäle und 1 O-Ring-Dichtung à 60 mm (2.362") Durchmesser für die Haltebohrung der Jumbo Brückenwerkzeuge.
Zubehör, separat zu bestellen

Zubehör

Für Halter	Verbindungsrohr	Kühlkit	Winkelblech	Gegengewicht
				
A731S400	AU731S00700	AU731S40700	18LS0316	–
A731S500	AU731S00700	–	–	–
A731S600	–	–	–	–
A731S40128	AU731S00700	–	–	BM050W78050

Einbauhalter, für Ausdrehblock A731S400 zum Schruppen





- Zur Montage auf den Schruppausdrehblock

Bezeichnung	Produkt-nummer	KAPR°	LF	WF	H	HF	Gewicht	Entspr. WSP-Größe	Abb.
			mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	kg *lbs*		
SCGCL16CA-16	00039871	90	55,0 *2.165*	25,0 *0.984*	20,0 *0.787*	16,0 *0.630*	0,2 *0.440*	CC..16..	A
STGCL16CA-16	00009197	90	63,0 *2.480*	24,96 *0.983*	25,0 *0.984*	16,0 *0.630*	0,2 *0.440*	TC..16T3..	A
STGCL16CA-22	02600181	90	55,0 *2.165*	25,0 *0.984*	20,0 *0.787*	16,0 *0.630*	0,2 *0.440*	TC..2204..	A
PCGNL16CA-12	02484356	90	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	16,0 *0.630*	0,2 *0.440*	CN..12..	B
SSRCL16CA-15	00039872	75	63,0 *2.480*	25,0 *0.984*	20,0 *0.787*	16,0 *0.630*	0,2 *0.440*	SC..15..	C
STRCL16CA-16	00008750	75	63,0 *2.480*	24,96 *0.983*	25,0 *0.984*	16,0 *0.630*	0,2 *0.440*	TC..16T3..	D
STRCL16CA-22	02585320	75	63,0 *2.480*	25,0 *0.984*	20,0 *0.787*	16,0 *0.630*	0,2 *0.440*	TC..2204..	D
STTCL16CA-16	00009194	60	63,0 *2.480*	14,96 *0.589*	25,0 *0.984*	16,0 *0.630*	0,2 *0.440*	TC..16T3..	D
STSCL16CA-16	00009193	45	53,0 *2.087*	24,96 *0.983*	25,0 *0.984*	16,0 *0.630*	0,2 *0.440*	TC..16T3..	E

Ersatzteile für Kurzklemmhalter, siehe Katalog Drehen

Empfohlene Zerspanungsbedingungen

Beste Ergebnisse erzielen Sie mit interner Kühlschmierstoffzufuhr (höhere Schnittdaten, höhere Oberflächengüte, bessere Spanabfuhr).

Schruppausdrehen hängt von zwei Prioritäten ab: Für höhere Vorschübe oder höhere Zeitspanvolumen wählen Sie eine symmetrische Einstellung der Kurzklemmhalter (das meistgenutzte Verfahren, doppelter Vorschub im Vergleich zu asymmetrischer Bearbeitung) oder asymmetrische Bearbeitung (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 Gebrauchsanweisung, die mit der Steadyline®-Bohrstange geliefert wird. Diese Gebrauchsanweisung können Sie auch auf www.secotools.com herunterladen.

Herausforderung

Siehe Kapitel „Herausforderungen“ im Kapitel Schruppausdrehen, Seite 568 oder Feinausdrehen, Seite 608. Die Auswuchtung erfolgt durch Einstellung der beiden Skalenringe in Abstimmung mit dem zu bearbeitenden Durchmesser (keine Auswuchttabelle notwendig).

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 (Bezeichnung A731S 0_0) Schruppausdreh-, Feinausdreh- und Gegengewichtsblöcke (Bezeichnung A731S _00) sowie Jumbo-Brückenwerkzeuge (Bezeichnung A731 00_). Informationen zu anderen Kombinationen erhalten Sie von Ihrem zuständigen Seco Ansprechpartner.

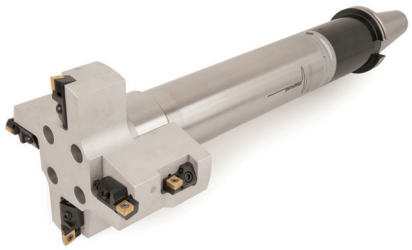
ANMERKUNG: Bei Verwendung neuer Ausdrehblöcke (Produktnummer A731S 400, A731S 500, A731S 600, A731S 40128) auf vorherigen Brückenwerkzeugen (Produktnummer A731 0_0 -ohne S-), ist die zu berücksichtigende Drehzahl, die für die vorherigen Brückenwerkzeuge. Neue und vorherige Brückenwerkzeuge dürfen aus Wuchtgründen nicht miteinander kombiniert werden.

Kopf basiert auf	Bereich Durchmesser mm *(Zoll)*	Max. Drehzahl	Angenommene max. Schnittgeschwindigkeit v_c im min. Bereich m/min *(sf/min)*	Angenommene max. Schnittgeschwindigkeit v_c im max. Bereich 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 maximale Geschwindigkeit ist abhängig vom Design des Ausdrehkopfes und seiner Auswuchtqualität. Innerhalb dieser Grenzen müssen die Geschwindigkeiten auch im Hinblick auf Werkstoff, Schneidkanten (Wendeschneidplatte), Werkzeuglänge, Maschinenspindel etc. angepasst werden.

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.

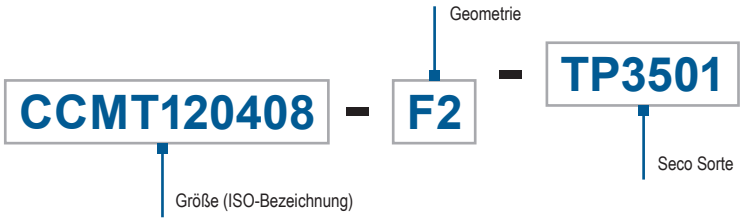
Weitere Informationen erhalten Sie auf Anfrage und auf www.secotools.com.

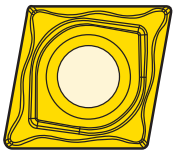
Wendeschneidplatten zum Ausdrehen – Auswahl

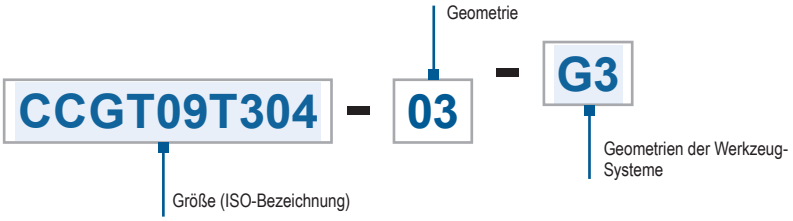
Die hier aufgeführten Wendeschneidplatten aus dem kompletten Seco Programm eignen sich ideal zum Ausdrehen. Die Wendeschneidplatten-Größen entsprechen dem Programm der Ausdrehköpfe.
Wendeschneidplatten zum Schruppausdrehen weisen hohe Zähigkeit und überwiegend positive Geometrien auf, um ein hohes Zeitspanvolumen 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



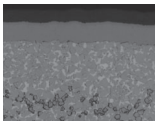
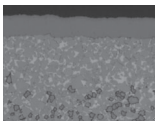
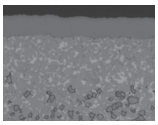
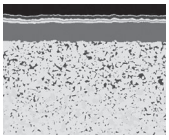
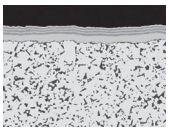
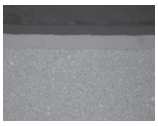
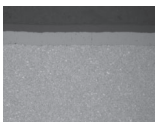
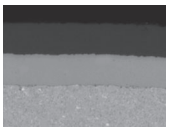




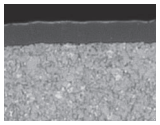
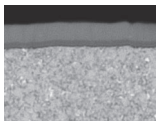
Schneidstoffe nach ISO-Werkstoff-Klassifizierung

		P						M					K					N				S				H			
		P01	P10	P20	P30	P40	P50	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	N30	S01	S10	S20	S30	H01	H10	H20	H30
CVD	TP1501																												
	TP2501																												
	TP3501																												
	TP200																												
	TP40																												
	TK1501																												
	TK0501																												
	TH1500																												
	25																												
PVD	TS2000																												
	TH1000																												
	CP500																												
	26																												
Un-beschichtet	KX																												
	HX																												
	03																												
Cermet	TP1020																												
	TP1030																												
	51																												
PCBN	CBN10																												
	CBN010																												
	CBN200																												
	81																												
	CBN060K																												
PCD	PCD20																												
	91																												

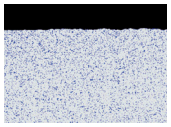
Schneidstoffempfehlung zum Ausdrehen – CVD-beschichtete Sorten

TP1501		Sorte mit **Duratomic®** -Beschichtungstechnologie. Äußerst wärme- und verschleißbeständige Sorte, sehr gut geeignet für produktive, allgemeine Drehbearbeitungen in Stahl sowie eine wertvolle Unterstützung in vielen anderen Werkstoffen. Ti(C,N) + Al_2O_3
TP2501		Sorte mit **Duratomic®** -Beschichtungstechnologie. Mit hoher Leistungsfähigkeit und Kantenstabilität, einsetzbar in einem breiten Anwendungsbereich der Stahldrehbearbeitung sowie in vielen unterschiedlichen Rostfrei- und Gusswerkstoffen. Ti(C,N) + Al_2O_3
TP3501		TP3501 eignet sich hervorragend für Ausdrehbearbeitungen in Stahl und Rostfrei, wo Zähigkeit und Zuverlässigkeit an erster Stelle stehen. Ti(C,N) + Al_2O_3 DURATOMIC®
TP200		TP200 ist eine universelle Sorte mit hoher Flexibilität, Universell einsetzbar in einem breiten Anwendungsbereich für die mittlere Zerspanung von Stahl, leicht zerspanbarem Rostfrei und Guss. Ti(C,N) + Al_2O_3 + TiN
TP40		Sehr zähe Sorte für die Rohbearbeitung von Stahl, für Guss- und Schmiedeteile sowie für die Bearbeitung von hochlegiertem Rostfrei. TiC/Ti(C,N) + TiN
TK0501		Sorte mit **Duratomic®** -Beschichtungstechnologie. Extrem verschleißfeste, optimierte Sorte für die Bearbeitung von Grauguss und leichter zu bearbeitenden duktilen Gusswerkstoffen. Ti(C,N) + Al_2O_3
TK1501		Sorte mit **Duratomic®** -Beschichtungstechnologie. Hochverschleißfeste Sorte für Guss im Allgemeinen und für Stahl; die Sorte ist besonders leistungsfähig bei der Bearbeitung von duktilen (Sphäro-) Gusswerkstoffen, auch bei anspruchsvolleren Aufspannungen und bei Schnittunterbrechungen. Ti(C,N) + Al_2O_3
TH1500		Sorte mit **Duratomic®**-Beschichtungstechnologie. Eine extrem harte, Super-Feinstkornsorte für die Bearbeitung von teilweise gehärtetem Stahl, auch als Alternative zum Schlichten von Guss. Ti(C,N) + Al_2O_3
25		Universalsorte. Sehr gute Sorte für ein weites Anwendungsspektrum beim Drehen von Stahl, Rostfrei und Guss. Ausgezeichnete Kombination von Verschleißfestigkeit und Zähigkeit. Ti (C, N) + Al2O3.

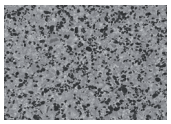
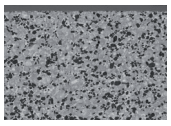
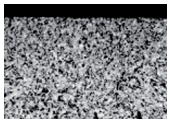
Schneidstoffempfehlung zum Ausdrehen – PVD-beschichtete Sorten

TS2000		Harte Feinkornsorte, hauptsächlich für die Feinbearbeitung von Super- sowie Titanlegierungen. Ebenso für die Feinbearbeitung von Rostfrei geeignet. (Ti,Al)N + TiN
CP500 & 26G6		Sehr zähe Feinkornsorte für die Fein- und mittlere Bearbeitung von Rostfrei, gut geeignet bei Schnittunterbrechungen. CP500 ist auch eine Alternative für Aluminiumlegierungen. (Ti,Al)N + TiN
TH1000		Sehr harte Feinstkornsorte für teilweise gehärtete Stahlwerkstücke sowie allgemeine Werkstoffe wie Superlegierungen. Dank der exzellenten Kantenzähigkeit ebenfalls hochleistungsfähig bei Schnittunterbrechungen und bei der Entfernung von harten Oberflächen.

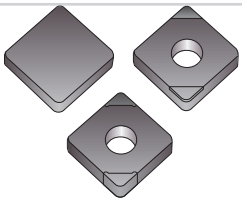
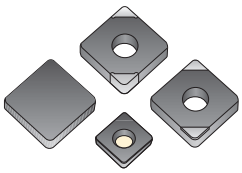
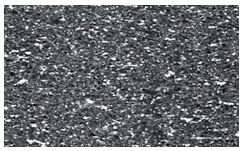
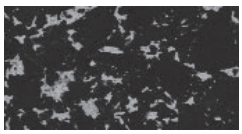
Unbeschichtete Sorten, zum Ausdrehen

KX & 03G3		Feinkornsorte für die Bearbeitung von Aluminium und andere NE-Metallen.
HX		Universelle unbeschichtete Sorte für die Bearbeitung von Guss und gehärtetem Stahl, auch gut geeignet für den Einsatz in NE-Metallen.

Cermet, zum Ausdrehen

TP1020		Cermet mit sehr hoher Verschleißfestigkeit für höchste Oberflächengüte, wenn Bearbeitungen mit begrenzten Schnitten und Schnittdaten hauptsächlich in Stahl und Rostfrei zuverlässig und kontrolliert durchgeführt werden müssen.
TP1030		PVD-beschichtetes Cermet mit sehr hoher Verschleißfestigkeit für hohe Anforderungen an Oberflächengüte und Produktivität mit zuverlässiger Standzeit, hauptsächlich in Stahl und Rostfrei. Ti-Al-Si-N nanolaminierte Beschichtung
51G1		Cermet mit sehr hoher Verschleißfestigkeit. Für die Feinbearbeitung von Stahl, wenn besonders hohe Oberflächengüten gefordert sind.

CBN- und PKD-Sorten, zum Feinausdrehen

CBN010		Format: Massiv oder gelötet (ein- oder doppelseitig) Zusammensetzung: Sorte mit 50 % CBN-Gehalt mit einer durchschnittlichen Korngröße von 2 µm und einem TiC-keramischen Binder. Beschichtung: Unbeschichtet
CBN10 & 81B1		CBN-Sorte zum Feinausdrehen in gehärtetem Stahl (Seco Werkstoff Gruppe 7) für leichte bis mittlere Schnitt-unterbrechungen.
CBN060K		Massiv, gelötet (ein- oder doppelseitig) oder gesintert Erste Wahl für glatten bis moderat unterbrochenen Schnitt in gehärtetem Stahl (a_p < 0,020 Zoll). Neue (Ti, Si) N PVD Beschichtung, speziell für die Hochgeschwindigkeitsbearbeitung entwickelt. Neuartige Bindephase auf TiCN-Basis.
CBN200		CBN-Sorte zum Feinausdrehen von perlitischem Grauguss und Sintereisen.
PCD20 & 91J3		PKD-Sorte zum Feinausdrehen von Aluminium und Al-Legierungen, Kupfer, Messing, Bronze und synthetischen Werkstoffen (Seco Werkstoff-Gruppen 16 –17).

Wendeschneidplatten empfohlen zum Schruppausdrehen, mit Schnittdaten

Bezeichnung	Beschichtet, Spanbrecher, linksschneidend			Beschichtet gepresster Spanbrecher					Beschichtet, Spanbrecher, linksschneidend	Schnitttiefe APMXS mm *(Zoll)*	Vorschub f mm *(Zoll)*
	KX	HX	03D3	TP2501	TP3501	TP40	25C4	TK1501	CP500		
CPGT050204			02434654				02434652			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	74004572			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)*

Schnittdatenempfehlungen, siehe Seite 650-653

CN.. Wendeschneidplatten, empfohlen für Schruppausdrehen (doppelseitig)

Bezeichnung	Beschichtet gepresster Spanbrecher				Schnitttiefe APMXS mm *(Zoll)*	Vorschub f mm *(Zoll)*
	TP3500	TP40	TM4000	TP200		
CNMG120408-M3					4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF3		74030598			4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF4					4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF1					4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MR7		74017309			4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*

Schnittdatenempfehlungen, siehe Seite 650-653

Wendeschneidplatten empfohlen zum Feinausdrehen, mit Schnittdaten

Bezeichnung	Beschichtet							Cermet			Schnitttiefe APMXS mm *(Zoll)*	Vorschub 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	02825859		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	02731808		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	02731809			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)*

Fortsetzung der Tabelle auf der folgenden Seite.

Schnittdatenempfehlungen, siehe Seite 650-653

Wendeschneidplatten empfohlen zum Feinausdrehen, mit Schnittdaten

Bezeichnung	CBN				PCD		Schnitttiefe APMXS mm *(Zoll)*	Vorschub 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)*

Schnittdatenempfehlungen, siehe Seite 650-653

Schnittdatenempfehlungen zum Ausdrehen (je nach Werkstoff und Schneidstoff-Sorte) – 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 Richtwerte.

Schnittdatenempfehlungen zum Ausdrehen (je nach Werkstoff und Schneidstoff-Sorte) – *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 Richtwerte.

Schnittdatenempfehlungen zum Ausdrehen (je nach Werkstoff und Schneidstoff-Sorte) – 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 Richtwerte.

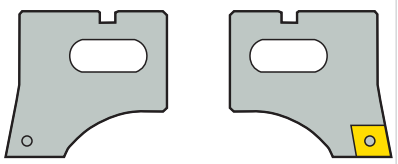
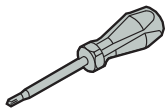
Schnittdatenempfehlungen zum Ausdrehen (je nach Werkstoff und Schneidstoff-Sorte) – *Zoll*

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													

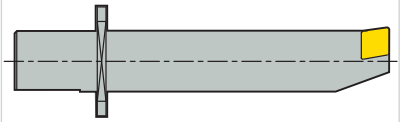
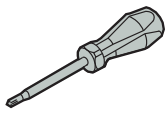
SMG = Seco Werkstoff-Gruppe v_c = m/min (sf/min) Alle Schnittdaten sind Richtwerte.

Auf dieser Seite finden Sie alle Schlüssel und Schrauben für Wendeschneidplatten-Halter sowie für Kassetten für Ausdrehwerkzeuge.

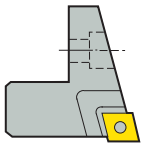
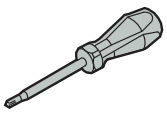
Klemm-Sets für CN..-Wendeschneidplatten finden Sie auf den Produktseiten der Wendeschneidplatten-Halter. Ersatzteile für Wendeschneidplatten-Halter RB 610 finden Sie auf den Seiten für Wendeschneidplatten-Halter, Köpfe RB 610, Seite 575.
Hinweis: Ersatzteile sind im Lieferumfang enthalten, Zubehör ist nicht im Lieferumfang enthalten; Zubehör muss separat bestellt werden.

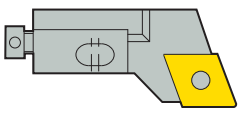
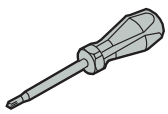
		Zubehör		Im Lieferumfang enthaltene Ersatzteile	
		Torx-Schlüssel*		Schlüssel	
					
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Schrupp-ausdrehköpfe	CP...0502	T07P-3	07	C02245-T07P	07
	CC...0602	T07P-3	07	C02504-T07P	07
	CC...09T3	T15P-3	15	C04008-T15P	15
	CC...1204	T15P-3	15	C05012-T15P	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 ist jedem Schruppausdrehkopf beigefügt.

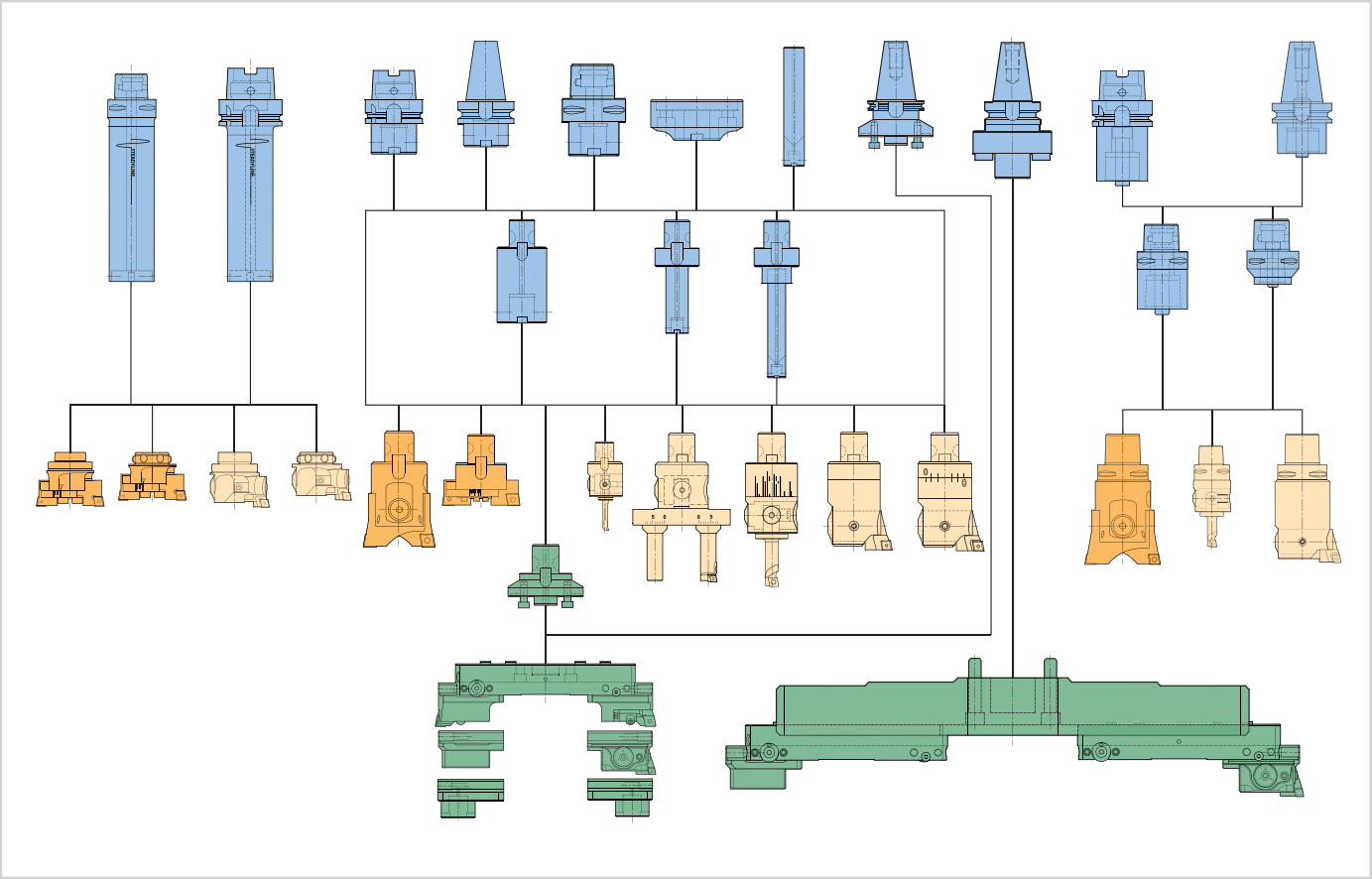
		Zubehör		Im Lieferumfang enthaltene Ersatzteile	
		Torx-Schlüssel*		Schlüssel	
					
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Axiabore™ Typ	WB...0301...	T06P-3	06	C02035-T06P	06
	CC...0602...	T07P-3	07	C02504-T07P	07
	–	T15P-3	15	C04008-T15P	15

Ersatzteile für Wendeschneidplatten-Halter

		Im Lieferumfang enthaltene Ersatzteile			
		Schlüssel		Klemmschraube für Wendeschneidplatte	
					
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Wendeschneidplatten-Halter zum Feinausdrehen, Anfasen und Rückwärtssenken	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-Schlüssel*		Schlüssel	
					
	Für WSP Größe	Bezeichnung	Torx Plus	Bezeichnung	Torx Plus
Für Einbauhalter	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

Aufnahmen 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.

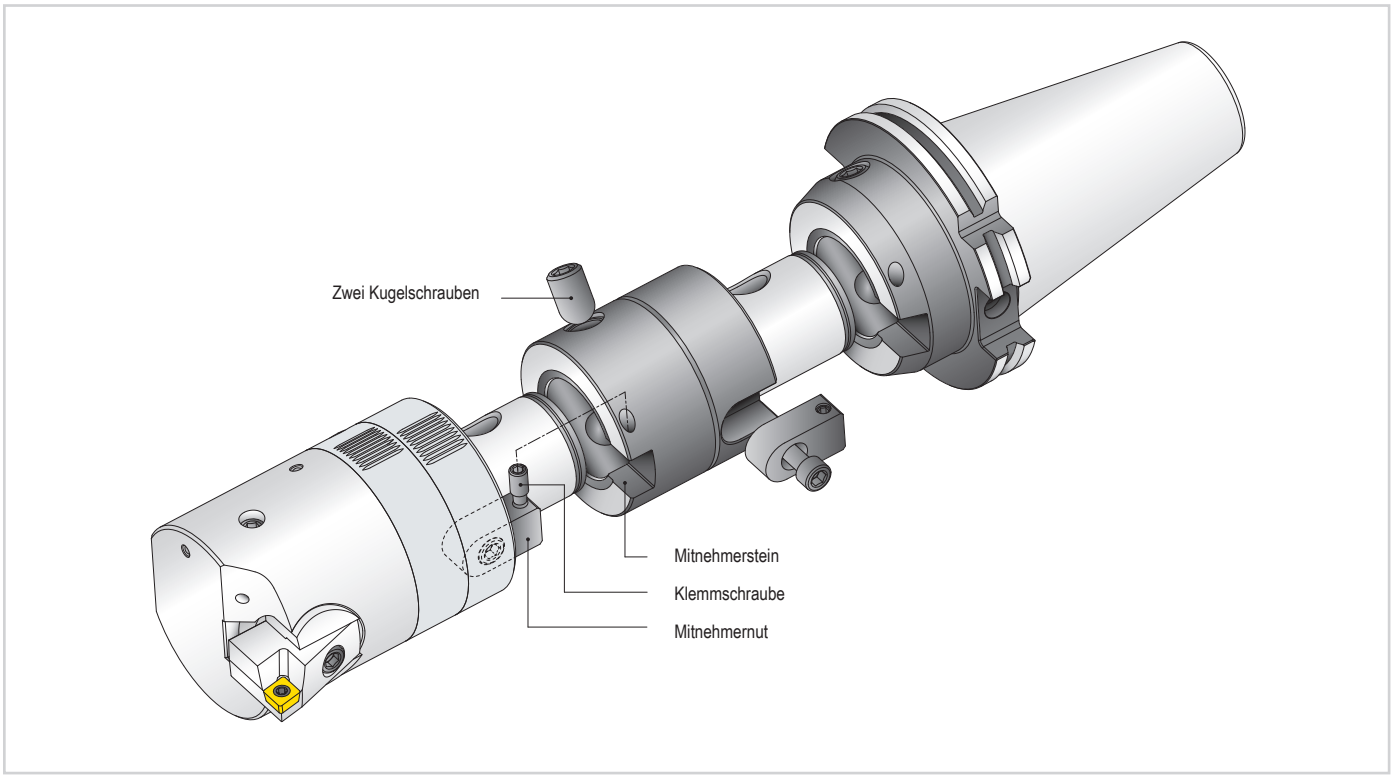
Wählen Sie für Ausdrehköpfe mit maschinenseitigem GL-Anschluss mit Steadyline® die kürzeste Steadyline®-Bohrstange aus dem Katalog Werkzeug-Systeme. Diese Bohrstangen sind maschinenseitig mit HSK-T/A und Seco-Capto™ verfügbar. Andere Spindelarten können mithilfe der kürzesten Seco-Capto™-Adapter angeschlossen 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 635.

Beachten Sie Folgendes: Jumbo Brückenwerkzeuge können auf Fräseraufnahmen oder direkt frontseitig auf die Maschinenspindel montiert werden.

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.

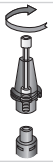
Ausführliche Hinweise für die Graflex® Verbindung finden Sie im Seco Katalog Werkzeug-Systeme



Für Seco-Capto™ Anschlüsse Typ C bei Ausdrehköpfen müssen keine besonderen Maßnahmen beachtet werden. Für Ausdrehköpfe, beachten Sie die folgenden allgemeinen Hinweise.

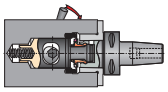
Drehmomente für Verbindungen mit Seco-Capto™-Aufnahmen mit axialen Anzugsschrauben (Grundaufnahmen, Zwischenelemente).

Seco-Capto Größe	Drehmoment Axiale Anzugsschrauben (Nm)	Drehmoment Axiale Anzugsschrauben (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	Drehmoment für Antriebsräder (Nm)	Drehmoment für Antriebsräder (ft/lbs)
C3	35	26
C4	50	37
C5	70	52
C6	90	66
C8	130	96

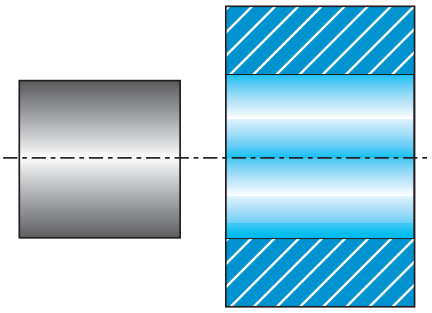


Die Seco-Capto™-Verbindung verfügt über einen selbsthemmenden Kegel. Beim Einsatz des zentralen Anzugsbolzens lösen Sie den zentralen Bolzen, bis sich die Anlagefläche löst, wodurch die Kegelverbindung getrennt wird. Beim seitlichen Exzenteranzugssystem wird durch Lösen des Exzenterbolzens die Verbindung getrennt.

ISO Standard Toleranzen – Bohrungen und Wellen

Die Position der Wellentoleranz wird mit **kleinen Buchstaben** bezeichnet.

Die Position der Bohrungstoleranz wird mit **GROSSBUCHSTABEN** bezeichnet.



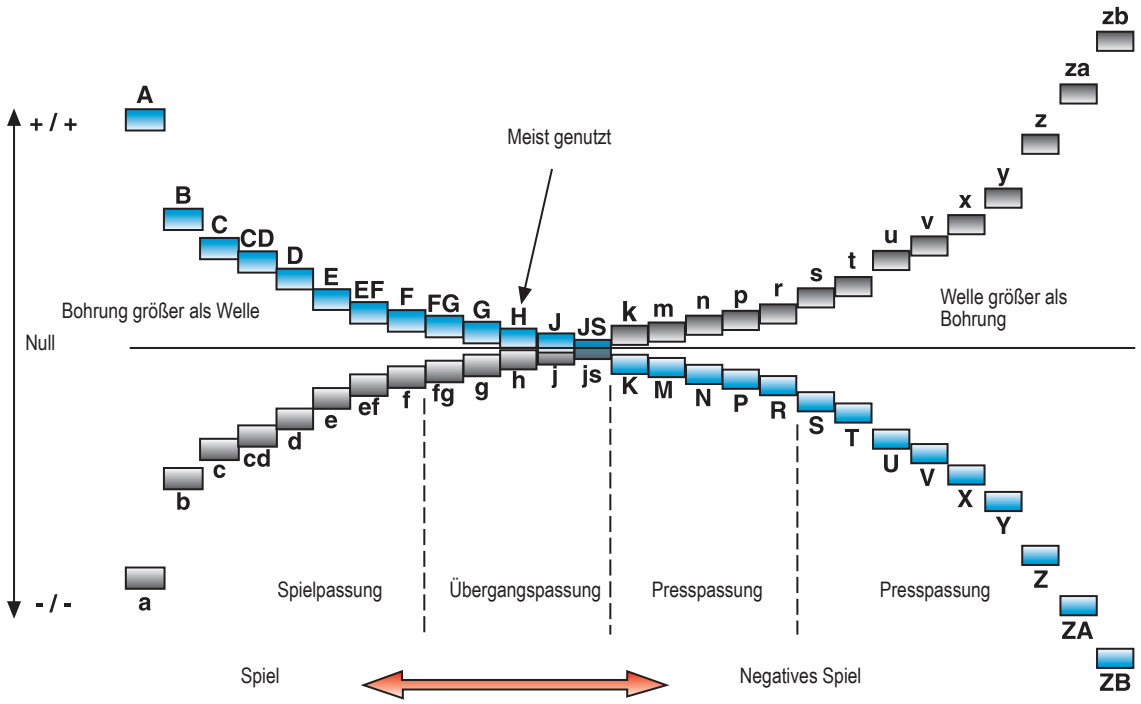


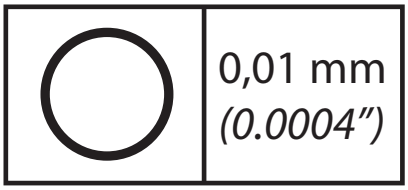
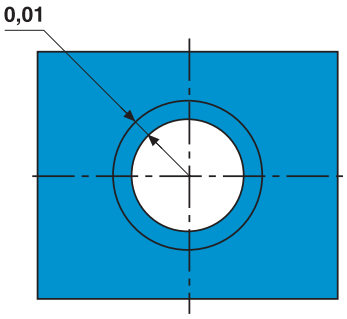
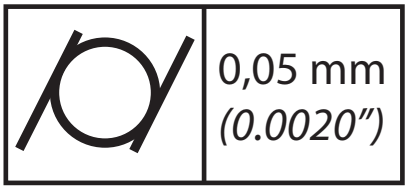
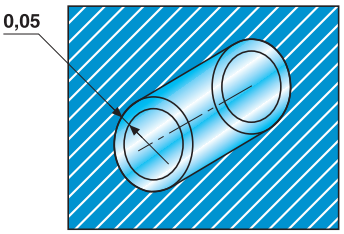
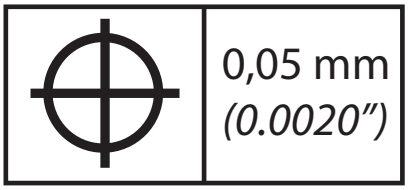
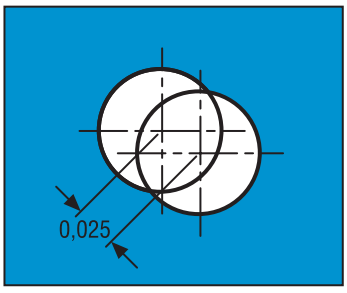
Tabelle ISO-Toleranzen

ISO-Toleranzen für Bohrungen (µm)													
Bohrungsdurchmesser Durchmesser mm (Zoll)	**D10**	**E9**	**F7**	**F8**	**G7**	**G9**	**H6**	**H7**	**H8**	**H9**	**H10**	**H11**	**H12**
≤ 3 *(0.118")*	+60 +20	+39 +14	+16 +6	+20 +6	+12 +2	+27 +2	+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	+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	+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	+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	+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	+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	-	+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	-	+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	-	+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	-	+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	-	+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	-	+36 0	+57 0	+89 0	+140 0	+230 0	+360 0	+570 0
355 ≥ 400 *(15.748")*													

Tabelle ISO-Toleranzen

ISO-Toleranzen für Bohrungen (µm)												
Bohrungsdurchmesser Durchmesser 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")*												

Geometrische Toleranzen

	Zeichnungssymbol	Toleranzbereich
Zirkularität		
Zylindrizität		
Positionierung		

Stahl, ferritische und martensitisch rostfreie Stähle

SMG	Beschreibung	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 Vergütungsstähle	$520 < R_m < 1200$	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	Beschreibung	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	Beschreibung	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, Kugelgrafitguss (SGI)		EN-GJS-500-7	1160	0,37
K5	Wärmebehandelter Kugelgrafitguss (ADI)		EN-GJS-1000-5		
K6	Austenitischer Guss mit Lamellengrafit		EN-GJLA-XNiCuCr15-6-2		
K7	Austenitischer Sphäroguss		EN-GJSA-XNiMn23-4		

Nicht-Eisen-Metalle

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
N1	Aluminiumlegierungen, Si < 9%		AW-7075		
N2	Aluminiumlegierungen, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Aluminiumlegierungen, Si >16%		AlSi17Cu5		
N11	Kupferlegierungen		CW614N	740	0,26

Superlegierungen und Titan

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
S1	Superlegierungen auf Fe-Basis		Discalloy		
S2	Superlegierungen auf Co-Basis		Stellite 21		
S3	Superlegierungen auf Ni-Basis		Inconel 718	2530	0,21
S11	Titan, niedrig legiert, (α)		Ti		
S12	Titan, mittlere Legierung, (α+β)		TiAl6V4	1500	0,24
S13	Titan, hoch legiert, (nahe β und β)		Ti10V2Fe3Al		

Harte Werkstoffe

SMG	Beschreibung	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		
H31	Weißhartguss	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

Andere Werkstoffe

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
PM1	Niedrig legierte Pulvermetall-Werkstoffe		F-0008 Fe-0.7C		
PM2	PM-Werkstofflegierungen im mittleren Bereich		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	Hoch legierte PM-Werkstoffe Werkstoffe für Abgasventilsitze, etc.				
HF1	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Legierungen auf Eisen-Basis				
HF2	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Kobalt- und Nickel-basis-Legierungen				
CC1	Gesintertes Wolfram-Hartmetall		G50		

Kunststoffe und Composite

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
TS1	Duroplaste		Urea Formaldehyde (UF)		
TS2	Duroplastische Kohlenstoff-faser-Verbundwerkstoffe		T300 T700 T800 HTA-S IMA - Epoxy (M21)...		
TS3	Duroplastische Glasfaser-Verbundwerkstoffe		Epoxy - HX..(42..)/E-Glas (7781...)...		
TS4	Duroplastische Aramidfaser-Verbundwerkstoffe		Kevlar 49		
TP1	Thermoplastische Polymere		Polycarbonat (PC)		
TP2	Thermoplastische Kohlenstoff-faser-Verbundwerkstoffe		PPS/PEEK - T300..		
TP3	Thermoplastische Glasfaser-Verbundwerkstoffe		PPS/PEEK - E-Glas oder A-Glas...		
TP4	Thermoplastische Aramidfaser-Verbundwerkstoffe				

Grafit

SMG	Beschreibung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
GR1	Grafit		R 8500		

SMG

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		

SMG

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

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

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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

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	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
K1	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	
	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
K2	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
	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
K4	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
										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
K5	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
	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
K7	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
	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
N1	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
	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
N2	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
	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
N11			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

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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

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

SMG

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

Sorte	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	■		■	■	■				■			■	■	■	■	■		
DP3000	■	■	■	■	■				■	■		■	■	■	■	■		
DS2050	■				■	■			■			■	■		■			■
DS4050	■				■	■			■			■	■		■			■
F15M	■				■	■			■			■	■		■			
F25M	■	■	■	■	■				■			■	■		■			
F30M	■				■	■			■			■	■		■			
F40M	■				■	■			■			■	■		■			
HX	■		■		■				■									
H02	■		■		■	■			■									
H15	■				■	■			■									
H25	■				■	■			■									
KX	■				■	■			■									
MH1000	■				■	■			■			■	■		■			
MK1500	■		■		■				■			■	■	■	■	■		
MK2050	■		■		■	■			■			■	■		■		■	
MM4500	■				■	■			■			■	■	■	■	■		
MP1501	■		■	■	■				■			■	■	■	■	■		
MP2050	■				■						■	■	■		■		■	
MP2501	■		■	■	■				■			■	■	■	■	■		
MP3000	■				■	■			■			■	■		■			
MS2500	■		■	■	■				■			■	■	■	■	■		
MS2050	■				■	■			■			■	■		■			■
RX1500	■		■		■		■	■	■			■	■		■			
RX2000	■		■		■	■			■			■	■		■			
RM2020	■				■				■			■						
RM2090	■				■	■			■			■	■				■	
RN2010	■				■	■			■									
RS2090	■				■	■			■			■	■				■	
T350M	■		■	■	■				■			■	■	■	■	■		
T25M	■		■	■	■				■			■		■	■			
TGH1050	■				■	■			■			■	■		■		■	
TGK1500	■		■		■				■			■	■	■	■	■		
TGP25	■	■	■	■	■				■			■	■	■	■	■		
TGP35	■		■	■	■				■			■	■	■	■	■		
TGP45	■		■	■	■				■			■	■	■	■	■		
TGS2050	■				■	■			■			■	■		■		■	
TH1000	■				■	■			■			■	■		■		■	
TH1500	■				■	■			■			■	■	■	■	■		
TK0501	■				■	■			■			■	■	■	■	■		
TK1501	■		■		■	■			■			■	■	■	■	■		
TM1501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TM2000	■	■	■	■	■				■	■		■	■	■	■	■		
TM2501	■	■	■	■	■				■	■		■	■	■	■	■		
TM3501	■				■				■			■	■	■	■	■		
TM4000	■	■	■	■	■				■	■		■	■	■	■	■		
TP0501	■	■	■	■	■	■			■			■	■	■	■	■		
TP1020	■	■	■	■	■				■	■								
TP1030	■	■	■	■	■				■	■		■	■		■		■	
TP1501	■	■	■	■	■				■	■		■	■	■	■	■		
TP25	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP200	■	■	■	■	■				■	■		■	■	■	■	■		
TP2501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP3501	■	■	■	■	■				■	■		■	■	■	■	■		
TP40	■		■	■	■				■			■		■	■			
TS2000	■				■	■			■			■	■		■			
TS2050	■				■	■			■			■	■		■		■	
TS2500	■		■		■				■			■	■		■			
TTP2050	■				■	■			■			■	■		■		■	
T250D	■				■	■			■			■	■		■			
T400D	■				■	■			■			■	■		■			
T100R	■		■		■	■			■			■	■		■			
T60M	■	■	■	■	■				■			■	■		■			
883	■		■		■				■									
890	■				■	■			■									

In dieser Broschüre stellt Ihnen Seco Tools technische Informationen zur Metallzerspanung zur Verfügung. Für spezifische Bearbeitungsaufgaben empfehlen wir die Kontaktaufnahme mit Ihren zuständigen Beratern.

Seco Tools weist jegliche Zusicherungen oder Gewährleistungen, seien sie ausdrücklich oder stillschweigend, zurück, einschließlich beispielsweise der Gewährleistung, der Marktfähigkeit und Eignung für einen bestimmten Zweck. Seco Tools oder seine Mitarbeiter haften nicht für einen direkten, indirekten, konkreten oder Folgeschaden aus dem Gebrauch der Information, auch wenn Seco Tools oder seine Mitarbeiter auf mögliche Schäden hingewiesen wurden.

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