

# KATALÓGUS ÉS MŰSZAKI SEGÉDLET 2021.2



## FURATKÉSZÍTÉS

# >30000

TERMÉK



# >75

ORSZÁG



# >4100

ELHIVATOTT MUNKATÁRS



A vállalat központja Fagerstaban, Svédországban van, és több mint 75 országban van jelen. A Seco Tools a világ legjobb fémforgácsolási megoldásait nyújtja marás, esztergálás, furatkészítés és szerszámbefogás terén.

A cég több mint 80 éve biztosítja a gyártó vállalatoknak a legnagyobb termelékenységet és nyereséget biztosító technológiákat, folyamatokat és támogatást.

A Seco minden iparág gyártóinak sikert garantáló innovatív termékeiről és szakmai támogatásáról weblapunkon, a [www.secotools.com](http://www.secotools.com) címen tudhat meg többet.

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## Lapkák

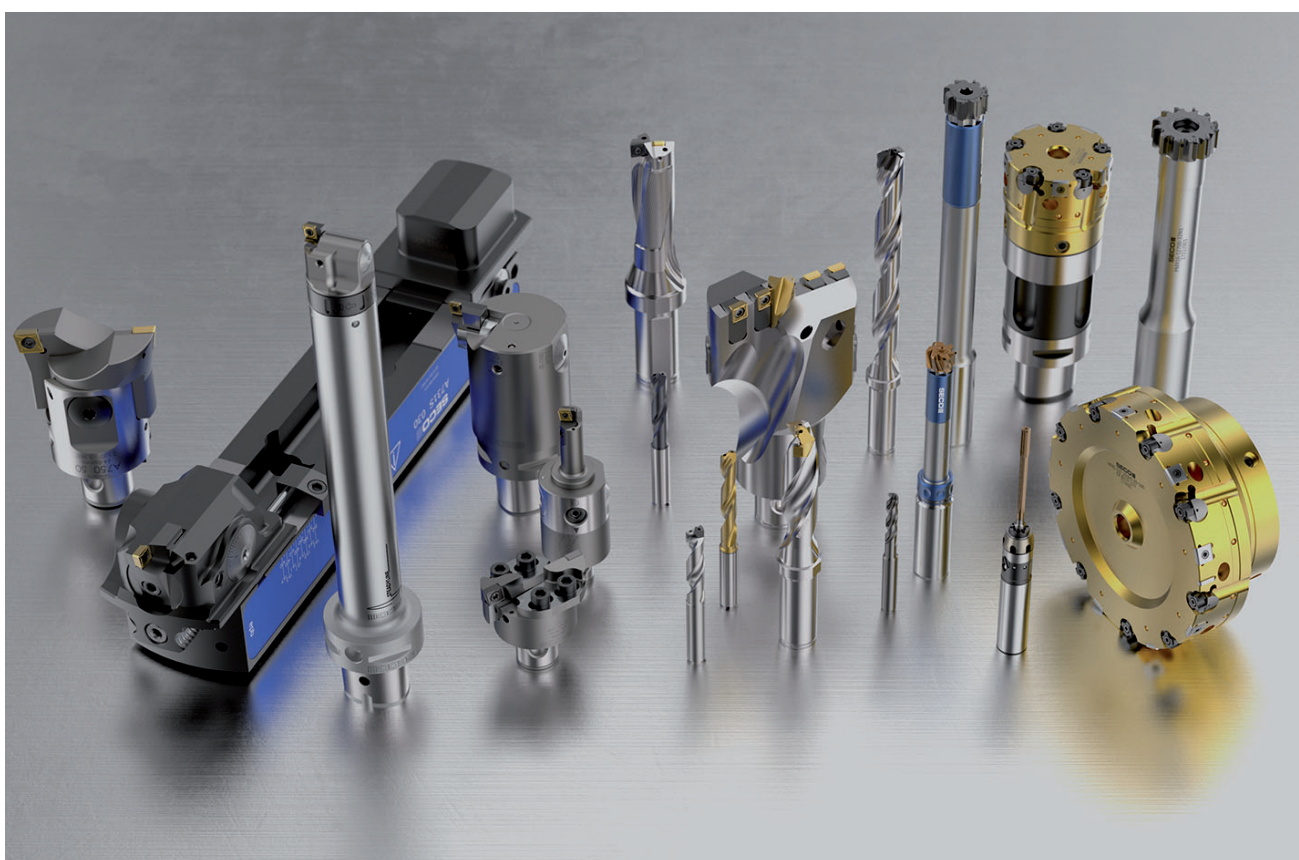
|          |              |
|----------|--------------|
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## Bármilyen furatkészítési kihívás leküldése

A furatkészítés jelentheti a különbséget a nyereség és a selejt alkatrészek között, és a sikerhez a legkiválóbb minőségű szerszámokra van szükség a termelékenység legnagyobb mértékű növelése és a költségcsökkentési lehetőségek érdekében. Az ilyen szintű siker eléréséhez a gyártóknak szükségük van egy partnerre, aki segít kipróbálni az eljárásokat és tesztelni az új megoldásokat. Egy partner, aki megfelel minden egyedi kihívásnak a fúró, maró, kiesztergáló és menetkészítő szerszámok valóban átfogó választékával.

A Seco Tools az Ön általános szolgáltatója az átfogó furatkészítési megoldásokhoz. Többéves tapasztalattal rendelkezünk a furatkészítési megoldások fejlesztésében ügyfeink kihívást jelentő alkalmazásaihoz, rendelkezünk K + F és fémforgácsolási szakértelemmel, hogy segítsük a gyártókat a tökéletesen optimális folyamatok elérésében.

Elkötelezettek vagyunk ügyfeink furatkészítési termelékenységével. Ez azt jelenti, hogy szerszámokat vásárolhat, műszaki támogatást kaphat, konzultálhat szakértőkkel és megoldásokat dolgozhat ki mindössze egyetlen szolgáltató bevonásával, és hozzáférhet az iparág legátfogóbb váltólapkás és tömör fúróhoz, dörzsáraihoz, menetkészítő és kiesztergáló fejeihez.





## Mire van szüksége a furat elkészítéshez?

|             | Fúrás                           |                             |                    | Dörzsárazás           |                       |                       |                       | Kiesztérgálás         |                       |   | Menetkészítés                             |                                      |  |
|-------------|---------------------------------|-----------------------------|--------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|---|---|--------------------------------------|--|
|             | Seco Universal<br>Seco Feedmax™ | Crownloc®<br>Crownloc® Plus | Perfo-max®         | Precimaster™ Plus     | Nanofix™              | Bifix®                | Xfix™                 | Nagyoló kiesztérgálás | Simító kiesztérgálás  | Threadmaster™                               | Threadmaster™ Taps                        | Menet marás<br>396.18/19/20          |  |
| Oldal       | 25-173 old.                     | 174-227 old.                | 228-323 old.       | 329-367 old.          | 368-397 old.          | 398-424 old.          | 425-465 old.          | 555-576 old.          | 577-622 old.          | Lásd a Menetkészítés katalógust             |   |                                      |  |
|             |                                 |                             |                    |                       |                       |                       |                       |                       |                       |   |   |                                      |  |
| IT          | 7-9                             | 9-10                        | 12                 | 6-8                   | 6-8                   | 6-7                   | 6-7                   | 9-10                  | 5-6                   | -   | -   | -                                    |  |
|             | 0,02 mm<br>(0.0008")            | 0,05 mm<br>(0.002")         | -                  | Kövesse az előfúrást  | Kövesse az előfúrást  | Kövesse az előfúrást  | Kövesse az előfúrást  | 0,005 mm<br>(0.0002") | 0,005 mm<br>(0.0002") | -   | Kövesse az előfúrást                      | Kövesse az előfúrást                 |  |
|             | 0,02 mm<br>(0.0008")            | 0,05 mm<br>(0.002")         | -                  | 0,007 mm<br>(0.0003") | 0,007 mm<br>(0.0003") | 0,005 mm<br>(0.0002") | 0,005 mm<br>(0.0002") | 0,02 mm<br>(0.0008")  | 0,01 mm<br>(0.0004")  | -   | -   | -                                    |  |
|             | 1,0 μm<br>(39 μin)              | 1,6 μm<br>(63 μin)          | 2,0 μm<br>(79 μin) | 0,6 μm<br>(24 μin)    | 0,6 μm<br>(24 μin)    | 0,25 μm<br>(10 μin)   | 0,8 μm<br>(31 μin)    | 1,0 μm<br>(39 μin)    | 0,6 μm<br>(24 μin)    | -   | -   | -                                    |  |
| TCTR        | -                               | -                           | -                  | -                     | -                     | -                     | -                     | -                     | -                     | -   | 6H<br>6HX<br>6G<br>2B<br>Normal           | 5HX<br>2BX<br>Normal-X<br>6HX<br>6GX |  |
| Menet forma | -                               | -                           | -                  | -                     | -                     | -                     | -                     | -                     | -                     | M<br>MF<br>UNC<br>UNF<br>NPT<br>NPTF<br>BSP | M<br>MF<br>UNC<br>UNF<br>G<br>NPT<br>NPTF | M<br>MF<br>UNC<br>UNF<br>G           |  |


**Pozicionálási pontosság**

A Seco Feedmax, A750 nagyoló kiesztérgáló fejek és a simító kiesztérgáló fejek teljes palettája alkotja azon szerszámok összességét, amelyek a legjobb pozicionálási pontosságot biztosítják.


**Furat geometria**

A kiváló furatminőség eléréséhez, mint például a körköröség és egyenesség, a Seco fúró, dörzsárazó és kiesztérgáló szerszámjai mind használhatóak. A Seco kiesztérgáló fejek garantálják a legjobb eredményt az egytengelyűségben.


**Felületminőség**

Kimagasló felületi minőség elérése érdekében az elsődleges választás a Bifix, továbbá a simító kiesztérgáló fejek.

**TCTR** = Menettűrési osztály

**IT** = Furat tűrés

## Szerszám áttekintés

A Feedmax, a Crownloc és a Performax 0,1–160 mm (0.004–6.299") átmérőjű furatok készítésére alkalmas IT7 és IT12 közötti tűréssel.

Az előtűtött furatokhoz gyakran nagyoló kiesztárgálást vagy elősimítást alkalmaznak a nagy átmérőkhöz való Bridge és Jumbo Bridge hidrudakkal.

Végül, a magas minőségű furatokat dörzsárákkal és simító kiesztárgáló fejekkel simítják, akár IT5 vagy IT6 tűrést is elérve.

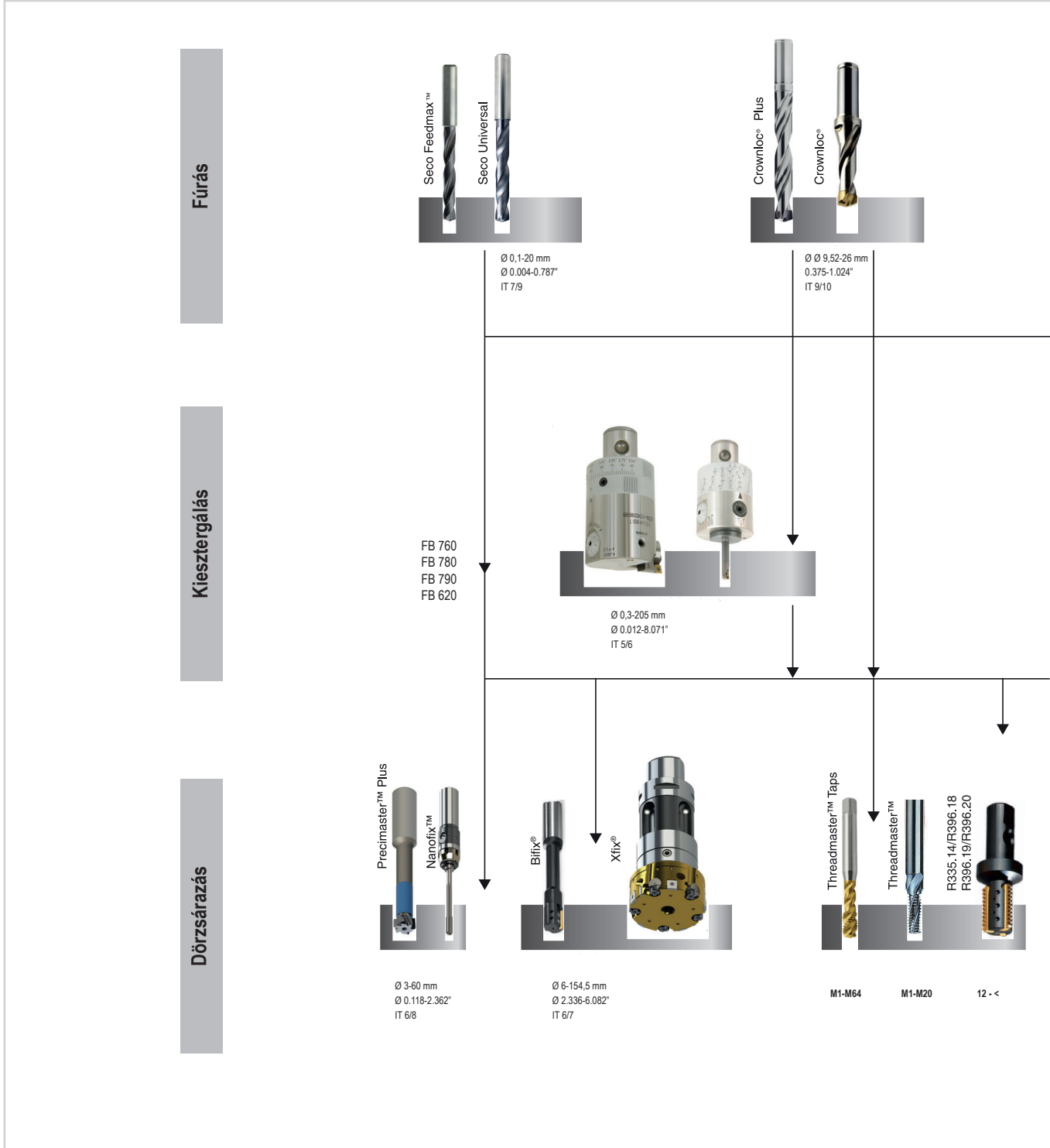
\* Nagyoló, IT9/10, \*\* Simító, IT 5/6

Threadmaster DTM, TM, TM2, 396.18 és 396.19;

Ugyanaz a maró használható jobbos és balos menetek készítéséhez. Metrikus és UN kivitelek kizárólag belső menetmaráshoz. A különböző tűrésű menetek ugyan azzal a maróval elkészíthetők.

Threadmaster Menetfúró:

Megtalálhatóak a leggyakrabban használt menet típusok és tűrések, menetfúrók és menetformázók formájában is.



Öntött furatok



Perfomax®  
SD602

Ø 15-85 mm  
Ø 0.591-3.346"  
IT 12

Ø 60-160 mm  
Ø 2.362-6.299"  
IT 12

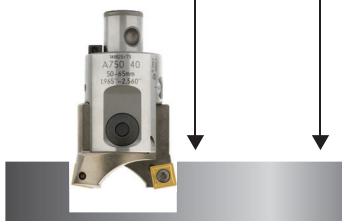
RB 750  
RB 610



Ø 18-205 mm  
Ø 0.709-8.071"  
IT 9/10

Nagyoló késztergálás

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

Simító késztergálás

FB 760  
FB 780  
FB 790  
FB 620



Ø 0.3-205 mm  
Ø 0.012-8.071"  
IT 5/10

# FÚRÁS



## PERFOMAX® FÚRÓ, ERŐS, STABIL ÉS PRECÍZ

A Perfomax® váltólapkás fúrócsalád természetes választás a nagy átmérőjű furatokhoz. A fúrók nagy forgácsolási sebességekre és előtolásra képesek, mivel egyesítik az erős, merev kialakítást és a rendelkezésre álló lapkák széles skáláját.

### BŐVÍTETT VÁLASZTÉK

- 2xD, 3xD, 4xD és 5xD
- A leggyakoribb szártípusokkal kapható
- Átmérőtartomány 15–160 mm (0.590–6.299 inch)

### A FÚRÓTEST KIVÁLÓSÁGA

- Új kialakítású horony
- Hullámos mintázat a horonyban
- Polírozott fúrótest
- Lézerrel edzett

### A KÜLÖNBÖZŐ MUNKADARAB ANYAGOKHOZ OPTIMALIZÁLT MINŐSÉGEK ÉS GEOMETRIÁK HOSSZÚ, KISZÁMÍTHATÓ ÉLETTARTAMOT BIZTOSÍTANAK A SZERSZÁMNAK

- Négyzet alakú, négy élű lapkák
- Erős kivitel
- Nagy előtolásokkal használhatók



## Fúró választék - fúrókiválasztás

## Seco Feedmax™ tömör keményfém fúrók

**TERMELÉKENYSÉG**

- Nagy előtolás és vágósebesség
- Szűktűrésű furatok
- Nagy stabilitású alkalmazásokhoz
- Minden munkadarab anyaghoz

## Crownloc® &amp; Crownloc®Plus cserélhető hegyű fúrók

**FLEXIBILITÁS**

- Cserélhető keményfém fejek
- Geometriák különböző munkadarab anyagokhoz
- Nincs újraélezés
- Többféle fej átmérő egy fúrótesthez

## Perfomax® váltólapkás fúrók

**KÖLTSÉGHATÉKONYSÁG**

- Minőségek és geometriák minden munkadarab anyaghoz
- Négyélű lapkák az alacsony költség/furat arányért
- Fúrás, axiális marás, keresztező furatok, ferde be- vagy kimenettel, kiesztergálás stb.
- Magas alkalmazási biztonság

## SMG – Bevezetés

Példaként az EN C45E az SMG P4, az EN 42 CrMo 4 referenciaanyag pedig az SMG P5 és az SMG H5 kategóriába is beletartozik, további részletekért lásd a következő táblázatokat. A munkadarab anyagok SMG-besorolása egy speciális anyagszabványt is alkalmaz referenciaként, meghatározott feltételek mellett, amely lehetővé teszi a forgácsolási paraméterek egyszerű és egyértelmű beállítását bármely tényleges anyaghoz, a Seco referenciaanyaggal összevetve. Példaként az EN C45E az SMG P4, az EN 42 CrMo 4 pedig az SMG P5 és az SMG H5 kategóriába is beletartozik az alábbi 1. táblázat szerint, ami jelzi az anyagtulajdonságok referenciaszintjét is.

Az SMG alapja a munkadarab anyagok típus szerinti, nem pedig a relatív megmunkálhatóság alapján való osztályozása, következésképpen olyan munkadarab anyagokat is tartalmaz, mint a kompozitok. Kellően átfogó, de mégis könnyű azonosítani, hogy az adott anyag melyik SMG-hez tartozik. Mindegyik SMG külön anyagszabvánnyal rendelkezik egy adott állapotban, amely referenciaként van hozzárendelve, hogy lehetővé tegye a forgácsolási paraméterek egyszerű beállítását bármely tényleges anyaghoz, összehasonlítva bármely Seco referenciaanyaggal, lásd az alábbi oldalakat: 662–673 old..

| SMG | Leírás  | Tulajdonságok               | Hivatkozás  |
|-----|---|-----------------------------|---|
| P4  | Gyengén ötvözött szerkezeti acélok, 0,25% < C < 0,67% wt<br>Gyengén ötvözött edzett és temperált acélok | 520 < R <sub>m</sub> < 1200 | C 45E<br>R <sub>m</sub> = 660 N/mm <sup>2</sup>     |
| P5  | Szerkezeti acélok, 0,25% < C < 0,67%wt<br>Edzett és temperált acélok                                    | 550 < R <sub>m</sub> < 1200 | 42 CrMo 4<br>R <sub>m</sub> = 700 N/mm <sup>2</sup> |

| SMG | Leírás                     | Tulajdonságok | Hivatkozás  |
|-----|----------------------------|---------------|---|
| H5  | Edzett és temperált acélok | 38 < HRC < 56 | 42 CrMo 4<br>R <sub>m</sub> = 700 N/mm <sup>2</sup> |

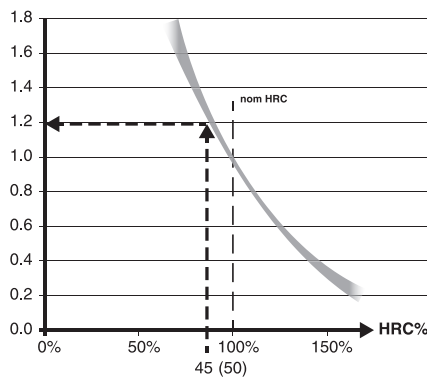
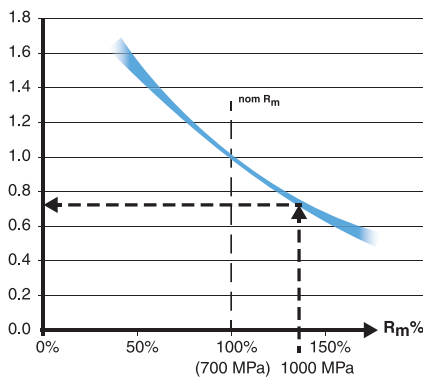
Kifejeztem a nemesített EN 42 CrMo 4 anyag tekintetében a végső R<sub>m</sub> szakítószilárdság jellemzően R<sub>m</sub> = 630 N/mm<sup>2</sup> és R<sub>m</sub> = 780 N/mm<sup>2</sup> kötött alakul, ami az SMG P5 referenciaszintet jelenti.

Az Edzett és temperált feltétel esetén a végső szakítószilárdság jellemzően R<sub>m</sub> = 900 N/mm<sup>2</sup> és R<sub>m</sub> = 1100 N/mm<sup>2</sup> között alakul, így még az SMG P5 kategóriába tartozik. R<sub>m</sub> = 1200 N/mm<sup>2</sup> keménység fölött ugyanakkor már SMG H5 a kategóriája.

| SMG | EN        | W.-Nr  | AFNOR   | BS       | UNI       | JIS         | AISI / ASTM | GOST | Állapot            | R <sub>m</sub> nom | HRC <sub>nom</sub> |
|-----|-----------|--------|---------|----------|-----------|-------------|-------------|------|--------------------|--------------------|--------------------|
| P4  | 42 CrMo 4 | 1.1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140  | 38HM | lágított           | 700                |                    |
|     | 42 CrMo 4 | 1.1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140  | 38HM | Edzett & Temperált | 1000               |                    |
| H5  | 42 CrMo 4 | 1.1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140  | 38HM | Edzett & Temperált |                    | 45                 |
|     | 42 CrMo 4 | 1.1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140  | 38HM | Edzett & Temperált |                    | 50                 |

Az EN 42CrMo4 edzett és temperált acél segítségével jól bemutatható az anyagfeltétel szerinti megmunkálhatóság.

Az alábbi grafikonok azt mutatják, hogyan lehet a névleges anyagfeltételekre vonatkozó sebességi ajánlásokat az R<sub>m</sub> értékhez (a bal oldali ábra az ISO-P-re vonatkozik) és a HRC értékhez (az ISO-H-ra vonatkozik) igazítani.



Hogy jobban szemléltessük, miként állítható be az SMG P5 névleges v<sub>c</sub> értéke egy pontosabb ajánlott v<sub>c</sub> értékre, szükségünk van a végső szakítószilárdság R<sub>m</sub>-adataira. Esetünkben az EN 42 CrMo 4-et használjuk R<sub>m</sub> = 1000 N/mm<sup>2</sup> értékűre edzve és temperálva a fenti táblázat szerint (vastag kék nyílak). Feltételezzük, hogy úgy találjuk, az SMG P5 névleges v<sub>c</sub> = 280 m/perc adott termék és megmunkálás mellett.

Tételezzük fel, hogy az SMG H5 esetében a névleges v<sub>c</sub> = 50 m/perc adott termékénél, és a megmunkálás bevonatos keményfém szerszámmal történik, így az aktuális javasolt v<sub>c</sub> = 50 m/perc x 1,2 = 60 m/perc.

Így az aktuális ajánlott v<sub>c</sub> = 280 m/perc x 0,75 = 210 m/perc. Következésképpen az SMG H5-ben a névleges v<sub>c</sub> az edzett EN 42 CrMo 4 használatával HRC 45-nél (kisebb szürke nyílak) kiigazítható.

További munkadarab anyagok tekintetében részleteket az alábbi oldalakon talál: 662–673 old., a javasolt forgácsolási paramétereket pedig megtalálja a megfelelő oldalakon. A forgácsolási paraméterek kényelmesebb kezelése érdekében a My pages megfelelő oldalait javasoljuk – Javaslat a [www.secotools.com](http://www.secotools.com) oldalán

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## ISO jellemzők

| ISO jellemző | Magyarázat                            |
|--------------|---------------------------------------|
| ADJLN        | Minimális állíthatósági határérték    |
| ADJLX        | Maximális állíthatósági határérték    |
| ADJRG        | Állíthatósági tartomány               |
| AN           | Fő hátszög                            |
| APMX         | Maximális forgácsolási mélység        |
| AZ           | Maximális süllyesztési mélység        |
| B            | Szár szélessége                       |
| BD           | Test átmérője                         |
| BD1          | 1. test átmérő                        |
| BD2          | 2. test átmérő                        |
| BDX          | Test maximális átmérője               |
| BHTA         | Test félkúpszöge                      |
| BLQ          | Kiegyensúlyozási minőség kód          |
| BN           | Homloktelület szélessége              |
| CBDP         | Csatlakozási furat mélysége           |
| CDX          | Maximális forgácsolási mélység        |
| CEDC         | Élek száma                            |
| CHA          | Keresztező furat szöge                |
| CHW          | Élletörés szélessége                  |
| CNT          | Hűtőközeg-bevezetés menetmérete       |
| CW           | Maró szélesség                        |
| CZC          | Csatlakozó méret kód                  |
| D1           | Rögzítőfurat átmérője                 |
| DC           | Maró átmérő                           |
| DCB          | Csatlakozási furat átmérője           |
| DCBN         | Csatlakozási furat minimális átmérője |
| DCBX         | Csatlakozási furat maximális átmérője |
| DCB1         | Csatlakozási furat 1. átmérője        |
| DCC          | Tervezési konfiguráció stílus kód     |
| DCINN        | Minimális belső forgácsolási átmérő   |
| DCINX        | Maximális belső forgácsolási átmérő   |
| DCN          | Minimális maró átmérő                 |
| DCON         | Szármérő                              |
| DCX          | Maximális forgácsolási átmérő         |
| DF           | Peremátmérő                           |
| DMM          | Szár átmérő                           |
| FLGW         | Peremszélesség                        |
| GAN          | Lapka dőlésszöge                      |
| GB           | Sík felület szöge                     |
| HTB          | Testmagasság                          |
| IC           | Befoglaló kör átmérője                |
| INSD         | Lapka átmérő                          |
| INSL         | Lapkahossz                            |
| KRINS        | Elsődleges élszög                     |
| L            | Vágóél hossza                         |
| LB           | Testhossz                             |
| LB1          | 1. testhossz                          |
| LCF          | Forgácsolóhoronyhossz                 |
| LE           | Vágóél effektív hossza                |
| LF           | Működési hossz                        |
| LFS          | Másodlagos működési hossz             |
| LH           | Fejhossz                              |
| LPR          | Túlnyúlási hossz                      |
| LS           | Szár hossz                            |
| LSC          | Rögzítési hossz                       |
| LU           | Használható hossz                     |
| LUX          | Maximális használható hossz           |
| M            | M-méret                               |
| OAL          | Teljes hossz                          |
| RE           | Csúcsrádiusz                          |
| S            | Lapkavastagság                        |
| TDZ          | Menetátmérő mérete                    |
| WB           | Testszélesség                         |
| WF           | Működési szélesség                    |

# Nagy teljesítményű és univerzális megoldások

Mit keres a keményfém fúrási műveleteihez?

## Universal – Sokoldalú általános teljesítményű keményfém fúró

Az Universal egy több célú, általános teljesítményű keményfém fúró, ami az anyagok és megmunkálások széles területén alkalmazható minden ipari szegmensben. Köszönhetően a tervezésnek, egy erős 140°-os önközpontozó, polirozott forgácsoló, kiváló minőségű fúró - nagy kapacitású, alkalmazás biztonsággal és sokoldalúsággal rendelkező fúró, nagyon alacsony áron.

Az Univerzállal csökkentheti raktározási költségeit és nagy megmunkálási rugalmasságot biztosít, ami csökkenti a beállítási időt. Az Universal a Feedmax™ alternatívája az olyan műveleteknél, amikor a sokoldalúság, flexibilitás és a csökkentett készletezési költségek a fő célok.

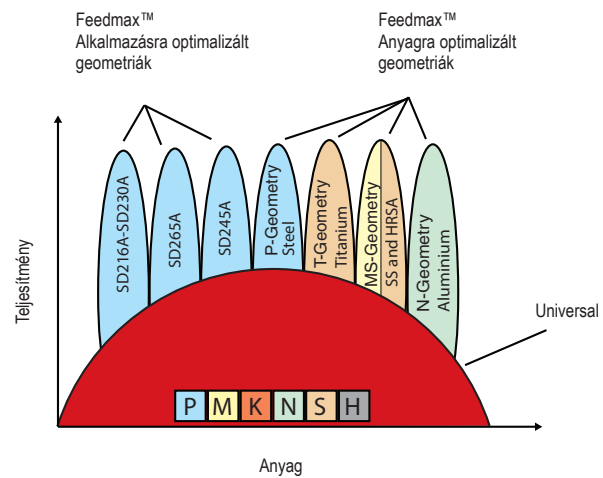
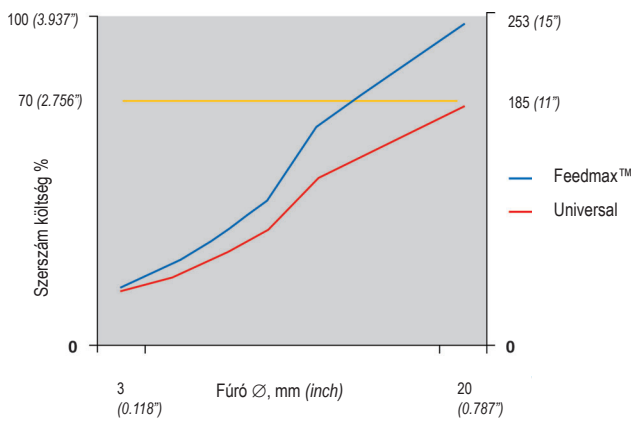
## Feedmax™ – Termelékeny nagy teljesítményű keményfém fúró

A Feedmax™ a keményfém, bevonat és geometria különleges kombinációja.

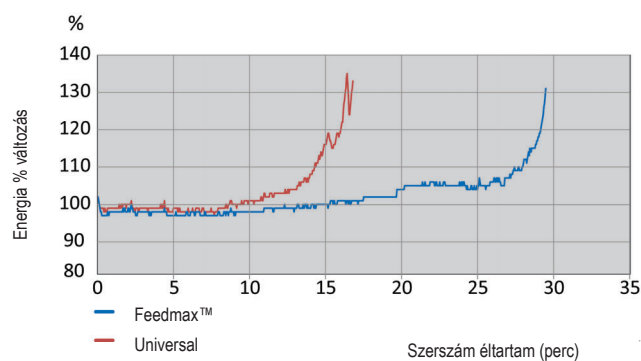
A Seco Feedmax™ a nagy termelékenységhez és az alacsony költség/furathoz lett tervezve nagy, akár 0,70 mm/ford. (0.028 in/ford) előtolásokhoz, és magas, akár 220 m/perc (720 sf/ford) forgácsolási sebességekhez. Kiváló központosító képesség - kiváló furatminőség érhető el, nincs szükség központosítási műveletre. A modern bevonat nagy meleg keménységének, az erős vágóél védő sarok letöréseknek, a nagy szilárdságú keményfémnek, kiváló forgácsolótávoltó képességnek és a kiváló élmínőségnek köszönhetően hosszú és tervezhető szerszámelettartam érhető el.

A Feedmax™ az optimalizált geometriának köszönhetően jól alkalmazható a különböző anyagok és alkalmazások széles területén, jó minőségű furatok eléréséhez a legalacsonyabb költségek mellett.

MRR, fémeltávolítás (cm³ / perc)



## Szerszám élettartam, alacsonyabb forgácsolási paraméterek



Első furat, mint referencia, 100% főorsó teljesítmény  
 Forgácsolási paraméterek  
 $v_c = 90$  m/perc  
 $f = 0,15$  mm/ford

$v_c = 295$  sf/perc  
 $f = 0.006$  in/ford

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

## Szerszám élettartam, magas forgácsolási paraméterek



Első furat, mint referencia, 100% főorsó teljesítmény  
 Forgácsolási paraméterek  
 $v_c = 160$  m/perc  
 $f = 0,24$  mm/ford

$v_c = 525$  sf/perc  
 $f = 0.009$  in/ford

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

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## Választék áttekintés

| Universal   | ∅ Választék               | Fúrési mélység | Fúró ∅ túrése | Furat túrés (1) | Felületi minőség (2)         |
|---|---------------------------|----------------|---------------|-----------------|------------------------------|
| <b>SD1103</b><br><br>Oldal 26, 27, 28, 29, 30, 31 old.           | 3-20 mm<br>(0.118-0.787") | ~ 3 x D        | m7            | IT 8-9          | Ra 1-2 μm<br>(Ra 39-79 μin)  |
| <b>SD1103A</b><br><br>Oldal 32, 33, 34, 35, 36, 37 old.          | 3-20 mm<br>(0.118-0.787") | ~ 3 x D        | m7            | IT 8-9          | Ra 1-2 μm<br>(Ra 39-79 μin)  |
| <b>SD1105A</b><br><br>Oldal 38, 39, 40, 41, 42, 43, 44, 45 old. | 3-20 mm<br>(0.118-0.787") | ~ 5 x D        | m7            | IT 8-9          | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD1108A</b><br><br>Oldal 46, 47, 48, 49, 50 old.            | 3-20 mm<br>(0.118-0.787") | ~ 8 x D        | m7            | IT 9            | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD1112A</b><br><br>Oldal 51, 52, 53, 54 old.                | 3-20 mm<br>(0.118-0.787") | ~ 12 x D       | m7            | IT 9            | Ra 1-3 μm<br>(Ra 39-118 μin) |

- 1) Eltérések a munkadarab anyagtól és az alkalmazott forgácsolási paraméterektől függően adódhatnak.  
 2) A fúrési mélység, forgácsolási adatok, hűtőfolyadék nyomás és anyagminőség befolyásolhatja a felületi minőséget.





## Választék áttekintés

| Feedmax™  | ∅ Választék                  | Fúrési mélység | Fúró ∅ tűrése | Furat tűrés (1) | Felületi minőség (2)         |
|---|------------------------------|----------------|---------------|-----------------|------------------------------|
| <b>SD203A-P</b><br><br>Oldal 56, 57, 58, 59, 60, 61, 62 old.     | 2-20 mm<br>(0.078-0.787")    | ~ 3 x D        | m7            | IT 8-9          | Ra 1-2 µm<br>(Ra 39-79 µin)  |
| <b>SD205A-P</b><br><br>Oldal 63, 64, 65, 66, 67, 68, 69, 70 old. | 2-20 mm<br>(0.078-0.787")    | ~ 5 x D        | m7            | IT 8-9          | Ra 1-2 µm<br>(Ra 39-79 µin)  |
| <b>SD206, SD206A</b><br><br>Oldal 71, 72 old.                  | 0,7-2,0 mm<br>(0.027-0.078") | ~ 6 x D        | h6            | IT 9            | Ra 1-2 µm<br>(Ra 39-79 µin)  |
| <b>SD207A-P</b><br><br>Oldal 73, 74, 75 old.                   | 3-20 mm<br>(0.118-0.787")    | ~ 7 x D        | m7            | IT 9            | Ra 1-3 µm<br>(Ra 39-118 µin) |
| <b>SD216A</b><br><br>Oldal 76 old.                             | 3-12 mm<br>(0.118-0.472")    | ~ 16 x D       | m7            | IT 9            | Ra 1-3 µm<br>(Ra 39-118 µin) |
| <b>SD230A</b><br><br>Oldal 77 old.                             | 4-10 mm<br>(0.157-0.393")    | ~ 30 x D       | m7            | IT 9            | Ra 1-3 µm<br>(Ra 39-118 µin) |

1) Eltérések a munkadarab anyagtól és az alkalmazott forgácsolási paramétereiktől függően adódhatnak.





2) A fúrési mélység, forgácsolási adatok, hűtőfolyadék nyomás és anyagminőség befolyásolhatja a felületi minőséget.

## Választék áttekintés

| Feedmax™  | ∅ Választék               | Fúrési mélység | Fúró ∅ túrése | Furat túrés (1) | Felületi minőség (2)        |
|---|---------------------------|----------------|---------------|-----------------|-----------------------------|
| SD245A<br>                     | 5-14 mm<br>(0.196-0.551") | ~ 5 x D        | m7            | IT 8            | Ra 1-2 µm<br>(Ra 39-79 µin) |
| Oldal 79, 80 old.   |                           |                |               |                 |                             |
| SD265A<br>                     | 6-16 mm<br>(0.236-0.630") | ~ 5 x D        | js6           | IT 7            | Ra 1-2 µm<br>(Ra 39-79 µin) |
| Oldal 82 old.   |                           |                |               |                 |                             |
| SD203A-MS<br>                | 2-20 mm<br>(0.079-0.551") | ~ 3 x D        | m7            | IT 8-9          | Ra 1-2 µm<br>(Ra 39-79 µin) |
| Oldal 89, 90, 91, 92, 93 old.   |                           |                |               |                 |                             |
| SD205A-MS<br>                | 2-20 mm<br>(0.079-0.551") | ~ 5 x D        | m7            | IT 8-9          | Ra 1-2 µm<br>(Ra 39-79 µin) |
| Oldal 94, 95, 96, 97 old.   |                           |                |               |                 |                             |
| SD203A-M Szuperötvezetek<br> | 3-20 mm<br>(0.098-0.551") | ~ 3 x D        | m7            | IT 8-9          | Ra 1-2 µm<br>(Ra 39-79 µin) |
| Oldal 98, 99, 100 old.  |                           |                |               |                 |                             |
| SD205A-M Szuperötvezetek<br> | 3-20 mm<br>(0.098-0.551") | ~ 5 x D        | m7            | IT 8-9          | Ra 1-2 µm<br>(Ra 39-79 µin) |
| Oldal 101, 102, 103 old.  |                           |                |               |                 |                             |

- 1) Eltérések a munkadarab anyagtól és az alkalmazott forgácsolási paraméterektől függően adódhatnak.  
2) A fúrési mélység, forgácsolási adatok, hűtőfolyadék nyomás és anyagminőség befolyásolhatja a felületi minőséget.

## Választék áttekintés

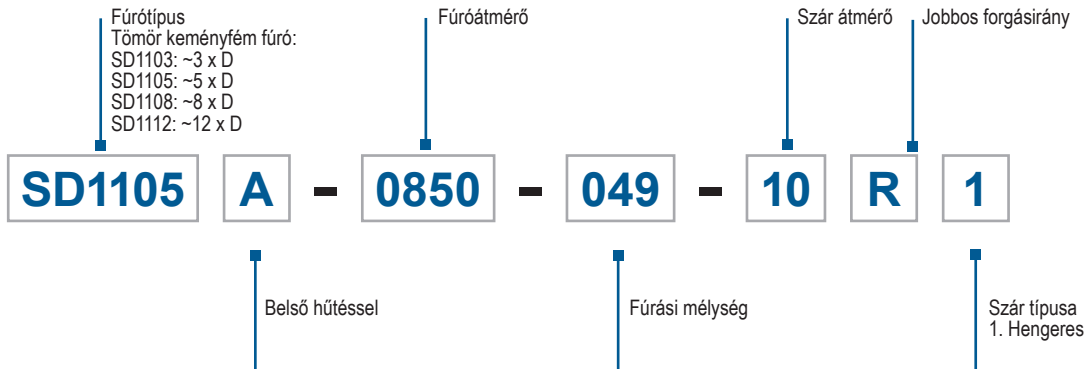
| Feedmax™   | ∅ Választék                    | Fúrési mélység   | Fúró ∅ tűrése              | Furat tűrés (1) | Felületi minőség (2)        |
|--|--------------------------------|------------------|----------------------------|-----------------|-----------------------------|
| <b>SD203A-T, SD205A-T</b><br><br>Oldal 104, 105 old.                  | 3-20 mm<br>(0.118-0.787")      | ~ 3 x D, ~ 5 x D | m7                         | IT 8-9          | Ra 1-2 μm<br>(Ra 39-79 μin) |
| <b>SD203A-N</b><br><br>Oldal 112, 113 old.                            | 3-20 mm<br>(0.118-0.787")      | ~ 3 x D          | m7                         | IT 8-9          | Ra 1-2 μm<br>(Ra 39-79 μin) |
| <b>SD205A-C1, -C2</b><br><br>Oldal 114-116 old.                      | 3.2-12.7 mm<br>(0.125-0.500")  | ~ 5 x D          | m7                         | IT 9            | -                           |
| <b>SD203-CX1, -CX2, SD205-CX31</b><br><br>Oldal 94, 95, 96, 97 old. | 3.26-9.53 mm<br>(0.128-0.375") | ~ 5 x D          | m7                         | IT 9            | -                           |
| <b>SD22</b><br><br>Oldal 118, 119, 120, 121, 122, 123, 124 old.     | 0.1-2.0 mm<br>(0.004-0.079")   | ~ 2 x D          | 0,005/0 mm<br>(+0.0002"/0) | -               | -                           |
| <b>SD26</b><br><br>Oldal 125, 126, 127, 128, 129, 130, 131 old.     | 0.1-2.0 mm<br>(0.004-0.079")   | ~ 6 x D          | 0-0,04 mm<br>(0/-0.0016")  | -               | -                           |

1) Eltérések a munkadarab anyagtól és az alkalmazott forgácsolási paramétereiktől függően adódhatnak.

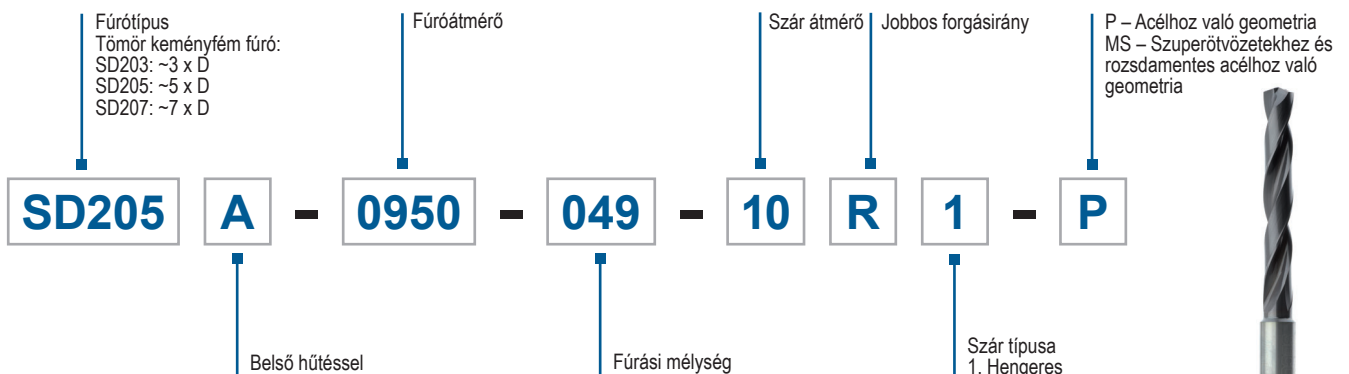
2) A fúrési mélység, forgácsolási adatok, hűtőfolyadék nyomás és anyagminőség befolyásolhatja a felületi minőséget.

Jelmagyarázat

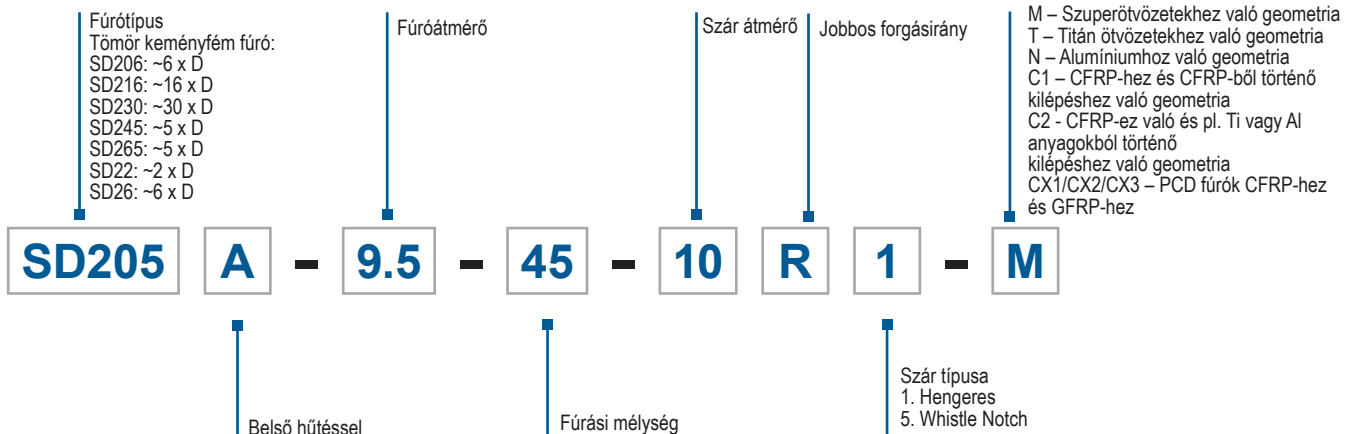
Universal



Feedmax™



Feedmax™



## Beállítás

### Befogás/kifutás

A hengeres szárú fúrókat használhatja Shrinkfit befogóval, patronnal vagy hidraulikus befogóval. Tartsa a fúró ütését 0,04 mm-en (0.0016") belül, a főorsóban mérve.  
A legjobb eredmény érdekében tartson 0,02 mm-es (0.0008") ütést.

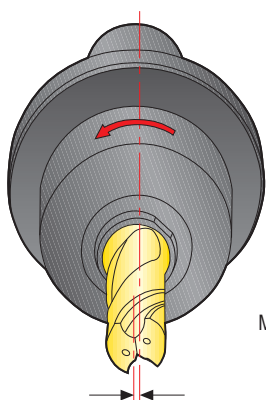
### Stabilitás

Az alkalmazás stabilitása igen fontos a legjobb szerszám-élettartam és furatpontosság eléréséhez. Ellenőrizze a gép főorsóját, a készüléket és a munkadarab megfogását a maximális stabilitás és merevség eléréséhez. Az instabil feltételek szerszámtöréshez vezethetnek.

### Szerszám élettartam

A fúrókat 0,1–0,3 mm-es (0.004–0.012") legnagyobb kopásnál nem szabad tovább használni.

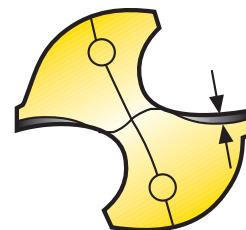
## Javasolt befogók



Max. 0,04 mm (0,0016")

A legjobb eredmény eléréséhez használja a következő befogókat:  
5603 típus - DIN típusú zsugorbefogó  
5834 típus - hidraulikus befogó  
5672 típus - precíziós patronos befogó  
További információ a Felszerszámozás katalógusban

0,1–0,3 mm (0.004–0.012")



### Zsugor befogó

(csak hengeres, R1 szárhoz)



### Hidraulikus befogó

(csak hengeres, R1 szárhoz)

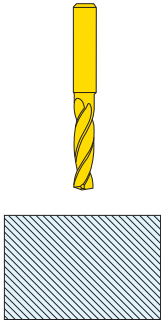

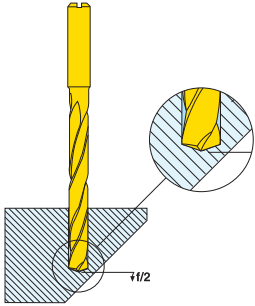
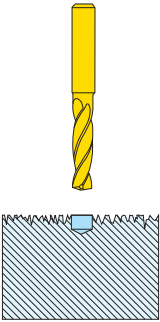
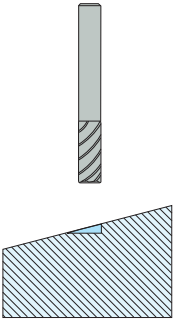
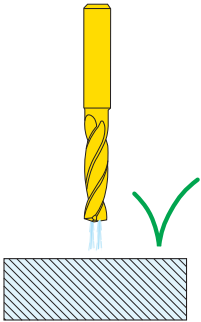
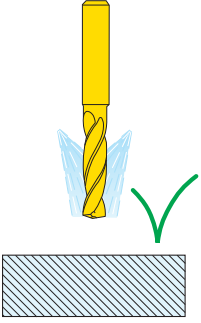


### Nagy pontosságú patronos befogók

(csak hengeres, R1 szárhoz)



## Megmunkálási módszerek

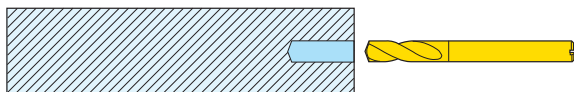
| Javasolt befogók   |  | Szögben kilépő furat  |
|--|--|---|
| <p>3-15 x D</p>  <p>Nem szükséges előfúrás vagy belépési előtolás</p>   | <p>&gt; 16 x D</p>  <p>Ha hosszabb fúrót használ, ajánlott vezetőfurat készítése.</p>   | <p>Furatból kilépés előtt csökkentse a fordulatonkénti előtolást 50%-kal</p>  <p>Vagy használjon SD245A fúrót.</p>   |
| Szabálytalan/szög alatti furat belépés   |  |   |
| <p>Szabálytalan vagy ferde felületnél előmegmunkálás szükséges</p>  <p>Normál furat belépés</p> <p>Előfúrás rövid standard Feedmax fúróval.</p> | <p>Előmegmunkálási alternatívák</p>  <p>Szög alatti furatbelépés</p> <p>Sík felület megmunkálása szármaróval a Seco választékból..</p> |   |
| Hűtési javaslatok  |  |   |
| <p>1.</p>  <p>Elsődleges választás</p>  | <p>2.</p>  <p>≤ 5 x D</p>   | <p>1. Hűtőfolyadék-nyomás*<br/>                     Minimális ajánlott nyomás 10 bar, ha a fúrási mélység ≤ 5 x D<br/>                     Minimális ajánlott nyomás 30 bar, ha a fúrási mélység &gt; 5 x D<br/>                     Minimális ajánlott nyomás 40 bar, ha a fúrási mélység &gt; 16 x D<br/>                     2. Hűtő-kenő folyadék keverék<br/>                     Ajánlott emulziókeverék 6–8%.<br/>                     Rozsdamentes acél, szuperötvezetek és nagy szilárdságú acél fúrása esetén a javasolt keverék 10%.</p> |

\* Alacsonyabb hűtőfolyadék-nyomással használva csökkentse a forgácsolási paramétereit.

## Megmunkálási módszerek

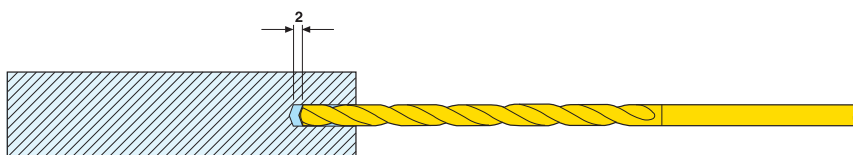
### SD216A (16 x D)-tól fel SD230A (30 x D)-ig – LÉPÉSRŐL LÉPÉSRE

1.



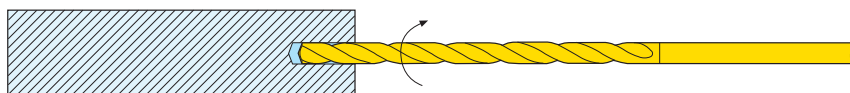
1. Fúrjon egy 2-3 x D mélységű próbafuratot. Használjon azonos átmérőjű szabványos fúrót, pl. SD203A vagy SD1103 (140°-os csúcshézag)

2.



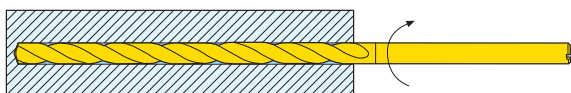
2. Belépés a furatba a gépfőrső megállításával vagy alacsony (500) fordulatszámmal. Álljon meg 2 mm-rel (0.080") a vezetőfurat mélysége fölött.

3.



3. Indítsa be a szerszám fúróorsóját és a hűtést, és fúrjon az ajánlott forgácsolási adatokkal. (Ne kiemelésez fúrásokkal.)

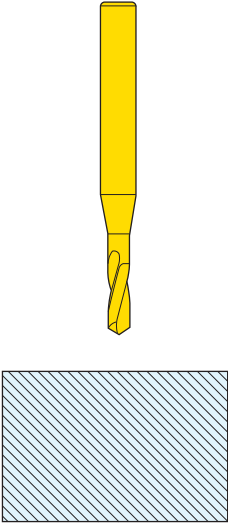
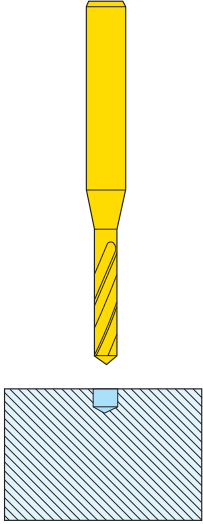
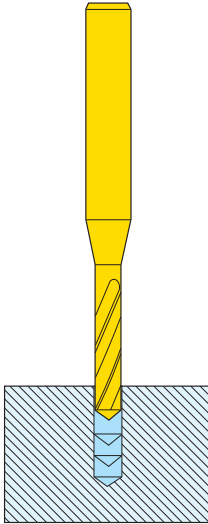
4.



4. Mikor eléri a teljes mélységet, csökkentse a fordulatszámot 500-ra és úgy húzza vissza a fúrót 4-szeres előtolási sebességgel, így elkerüli a visszahúzási nyomokat.



## Megmunkálási módszerek – Mikro fúrók

| Vezetőfurat   |   |
|---|---|
|    | <p><b>SD22</b></p> <p>Az optimális furattűrés és -pozíció érdekében használjon azonos átmérőjű SD22 előfúrót.</p>           |
|   | <p><b>SD26</b></p> <p>1 mm (0.039") átmérő alatt nyomtatékosan ajánlott az előfúró használata.</p>                          |
| Mélyfúrás   |   |
|  | <p>Hosszú forgácsot adó anyagoknál a mélyfúró ciklust ajánljuk. Fúrás ajánlott megszakítása 1 x D fúrási mélységenként.</p> |

## Élletőrő modul felszerelési útmutató

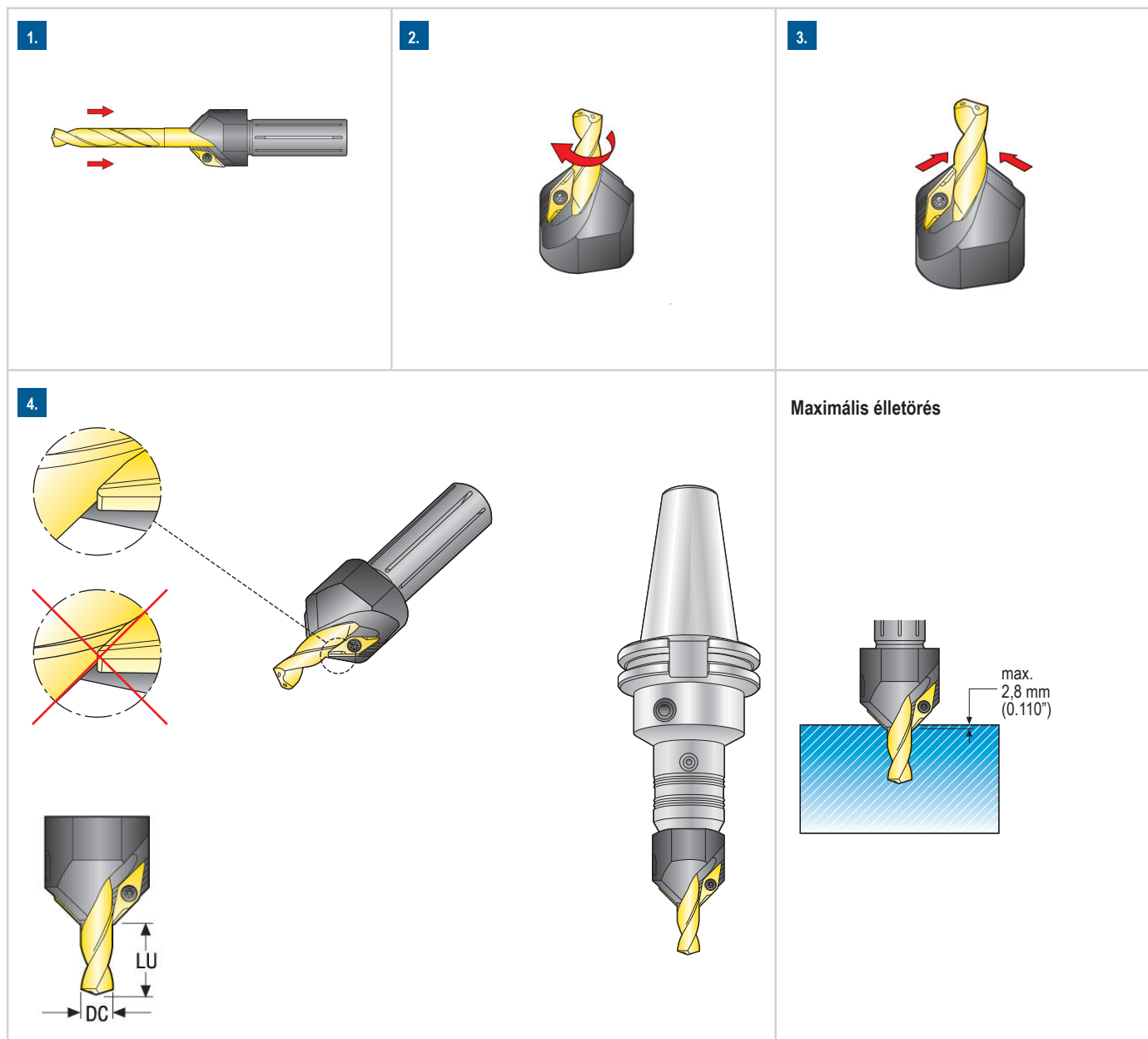
Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet



| Fúró átmérő DC |           | LU fúrási mélység (min-max) |            |                 |             |        |             |
|----------------|-----------|-----------------------------|------------|-----------------|-------------|--------|-------------|
|                |           | SD1103 / SD203A             |            | SD1105 / SD205A |             | SD207A |             |
| mm             | inch      | mm                          | inch       | mm              | inch        | mm     | inch        |
| 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 |

Csak hengeres szárral használható (R-1).



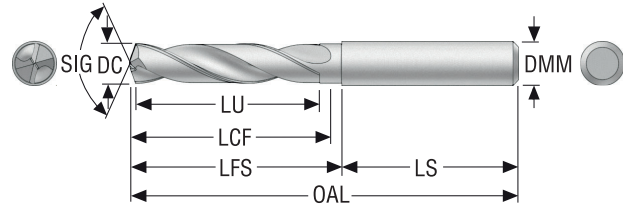
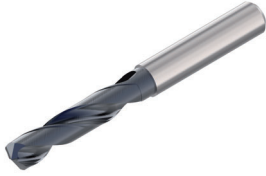
## Seco Universal – Egy átmérőjű fúrók

A Seco Universal tömör keményfém fúrók költséghatékony és sokoldalú megoldást jelentve tökéletesen kiszolgálják a kis és közepes darabszámú gyártást. A Seco Universal fúrók a legtöbb alkalmazásra megfelelnek minden ipari szegmensben.

- A több-funkciós, 4 él pontos geometria kiváló központosítást nyújt
- A rendkívül kopásálló TiAIN bevonat hosszú szerszámélettartamot biztosít
- Együtt használható a Threadmaster™ menetfúróval, előfúrási alkalmazásoknál pedig a Precimaster™ Plus típusal

## SD1103

Fúrási mélység ~ 3 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Külső hűtés
- Forgácsolási adatokat lásd a 142 old.
- Köztes átmérők a Custom Design szoftverben.

| Megnevezés                                  | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1103-0300-014-06R1<br>SD_DRILL_3.0MM_3XD  | 02898974 | 3,0<br>0.118   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0310-014-06R1<br>SD_DRILL_3.1MM_3XD  | 02898975 | 3,1<br>0.122   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0318-014-06R1<br>SD_DRILL_1/8_3XD    | 02898976 | 3,175<br>0.125 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0320-014-06R1<br>SD_DRILL_3.2MM_3XD  | 02898977 | 3,2<br>0.126   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0325-014-06R1<br>SD_DRILL_3.25MM_3XD | 02898978 | 3,25<br>0.128  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0330-014-06R1<br>SD_DRILL_3.3MM_3XD  | 02898979 | 3,3<br>0.130   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0340-014-06R1<br>SD_DRILL_3.4MM_3XD  | 02898980 | 3,4<br>0.134   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0350-014-06R1<br>SD_DRILL_3.5MM_3XD  | 02898981 | 3,5<br>0.138   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0357-014-06R1<br>SD_DRILL_9/64_3XD   | 02898982 | 3,572<br>0.141 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0360-014-06R1<br>SD_DRILL_3.6MM_3XD  | 02898983 | 3,6<br>0.142   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0365-014-06R1<br>SD_DRILL_3.65MM_3XD | 02898984 | 3,65<br>0.144  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0370-014-06R1<br>SD_DRILL_3.7MM_3XD  | 02898985 | 3,7<br>0.146   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0380-017-06R1<br>SD_DRILL_3.8MM_3XD  | 02898986 | 3,8<br>0.150   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0390-017-06R1<br>SD_DRILL_3.9MM_3XD  | 02898987 | 3,9<br>0.154   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0397-017-06R1<br>SD_DRILL_5/32_3XD   | 02898988 | 3,969<br>0.156 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0400-017-06R1<br>SD_DRILL_4.0MM_3XD  | 02898989 | 4,0<br>0.157   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0410-017-06R1<br>SD_DRILL_4.1MM_3XD  | 02898990 | 4,1<br>0.161   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0420-017-06R1<br>SD_DRILL_4.2MM_3XD  | 02898991 | 4,2<br>0.165   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0430-017-06R1<br>SD_DRILL_4.3MM_3XD  | 02898992 | 4,3<br>0.169   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0437-017-06R1<br>SD_DRILL_11/64_3XD  | 02898993 | 4,366<br>0.172 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0440-017-06R1<br>SD_DRILL_4.4MM_3XD  | 02898994 | 4,4<br>0.173   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |

| Megnevezés                                  | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat típus |
|---|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1103-0450-017-06R1<br>SD_DRILL_4.5MM_3XD  | 02898995 | 4,5<br>0.177   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0460-017-06R1<br>SD_DRILL_4.6MM_3XD  | 02898996 | 4,6<br>0.181   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0465-017-06R1<br>SD_DRILL_4.65MM_3XD | 02898997 | 4,65<br>0.183  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0470-017-06R1<br>SD_DRILL_4.7MM_3XD  | 02898998 | 4,7<br>0.185   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0476-020-06R1<br>SD_DRILL_3/16_3XD   | 02898999 | 4,763<br>0.188 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0480-020-06R1<br>SD_DRILL_4.8MM_3XD  | 02899000 | 4,8<br>0.189   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0490-020-06R1<br>SD_DRILL_4.9MM_3XD  | 02899001 | 4,9<br>0.193   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0500-020-06R1<br>SD_DRILL_5.0MM_3XD  | 02899002 | 5,0<br>0.197   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0510-020-06R1<br>SD_DRILL_5.1MM_3XD  | 02899003 | 5,1<br>0.201   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0516-020-06R1<br>SD_DRILL_13/64_3XD  | 02899004 | 5,159<br>0.203 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0520-020-06R1<br>SD_DRILL_5.2MM_3XD  | 02899005 | 5,2<br>0.205   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0530-020-06R1<br>SD_DRILL_5.3MM_3XD  | 02899006 | 5,3<br>0.209   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0540-020-06R1<br>SD_DRILL_5.4MM_3XD  | 02899007 | 5,4<br>0.213   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0550-020-06R1<br>SD_DRILL_5.5MM_3XD  | 02899008 | 5,5<br>0.217   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0555-020-06R1<br>SD_DRILL_5.55MM_3XD | 02899009 | 5,55<br>0.219  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0556-020-06R1<br>SD_DRILL_7/32_3XD   | 02899010 | 5,556<br>0.219 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0560-020-06R1<br>SD_DRILL_5.6MM_3XD  | 02899011 | 5,6<br>0.220   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0570-020-06R1<br>SD_DRILL_5.7MM_3XD  | 02899012 | 5,7<br>0.224   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0580-020-06R1<br>SD_DRILL_5.8MM_3XD  | 02899013 | 5,8<br>0.228   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0590-020-06R1<br>SD_DRILL_5.9MM_3XD  | 02899014 | 5,9<br>0.232   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0595-020-06R1<br>SD_DRILL_15/64_3XD  | 02899015 | 5,953<br>0.234 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0600-020-06R1<br>SD_DRILL_6.0MM_3XD  | 02899016 | 6,0<br>0.236   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103-0610-024-08R1<br>SD_DRILL_6.1MM_3XD  | 02899017 | 6,1<br>0.240   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0620-024-08R1<br>SD_DRILL_6.2MM_3XD  | 02899018 | 6,2<br>0.244   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0630-024-08R1<br>SD_DRILL_6.3MM_3XD  | 02899019 | 6,3<br>0.248   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0635-024-08R1<br>SD_DRILL_1/4_3XD    | 02899020 | 6,35<br>0.250  | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0640-024-08R1<br>SD_DRILL_6.4MM_3XD  | 02899021 | 6,4<br>0.252   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0650-024-08R1<br>SD_DRILL_6.5MM_3XD  | 02899022 | 6,5<br>0.256   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0660-024-08R1<br>SD_DRILL_6.6MM_3XD  | 02899024 | 6,6<br>0.260   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0675-024-08R1<br>SD_DRILL_17/64_3XD  | 02899025 | 6,747<br>0.266 | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103-0680-024-08R1<br>SD_DRILL_6.8MM_3XD  | 02899026 | 6,8<br>0.268   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |

| Megnevezés                                  | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|----------------|---------------|---------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103-0690-024-08R1<br>SD_DRILL_6.9MM_3XD  | 02899027 | 6,9<br>0.272   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0700-024-08R1<br>SD_DRILL_7.0MM_3XD  | 02899028 | 7,0<br>0.276   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0710-029-08R1<br>SD_DRILL_7.1MM_3XD  | 02899029 | 7,1<br>0.280   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0714-029-08R1<br>SD_DRILL_9/32_3XD   | 02899030 | 7,144<br>0.281 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0720-029-08R1<br>SD_DRILL_7.2MM_3XD  | 02899031 | 7,2<br>0.283   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0730-029-08R1<br>SD_DRILL_7.3MM_3XD  | 02899032 | 7,3<br>0.287   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0740-029-08R1<br>SD_DRILL_7.4MM_3XD  | 02899033 | 7,4<br>0.291   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0750-029-08R1<br>SD_DRILL_7.5MM_3XD  | 02899034 | 7,5<br>0.295   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0754-029-08R1<br>SD_DRILL_19/64_3XD  | 02899035 | 7,541<br>0.297 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0755-029-08R1<br>SD_DRILL_7.55MM_3XD | 02899036 | 7,55<br>0.297  | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0760-029-08R1<br>SD_DRILL_7.6MM_3XD  | 02899037 | 7,6<br>0.299   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0770-029-08R1<br>SD_DRILL_7.7MM_3XD  | 02899038 | 7,7<br>0.303   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0780-029-08R1<br>SD_DRILL_7.8MM_3XD  | 02899040 | 7,8<br>0.307   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0790-029-08R1<br>SD_DRILL_7.9MM_3XD  | 02899041 | 7,9<br>0.311   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0794-029-08R1<br>SD_DRILL_5/16_3XD   | 02899042 | 7,938<br>0.313 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0800-029-08R1<br>SD_DRILL_8.0MM_3XD  | 02899043 | 8,0<br>0.315   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103-0810-035-10R1<br>SD_DRILL_8.1MM_3XD  | 02899044 | 8,1<br>0.319   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0820-035-10R1<br>SD_DRILL_8.2MM_3XD  | 02899045 | 8,2<br>0.323   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0830-035-10R1<br>SD_DRILL_8.3MM_3XD  | 02899046 | 8,3<br>0.327   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0833-035-10R1<br>SD_DRILL_21/64_3XD  | 02899047 | 8,334<br>0.328 | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0840-035-10R1<br>SD_DRILL_8.4MM_3XD  | 02899048 | 8,4<br>0.331   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0850-035-10R1<br>SD_DRILL_8.5MM_3XD  | 02899049 | 8,5<br>0.335   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0860-035-10R1<br>SD_DRILL_8.6MM_3XD  | 02899050 | 8,6<br>0.339   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0870-035-10R1<br>SD_DRILL_8.7MM_3XD  | 02899051 | 8,7<br>0.343   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0873-035-10R1<br>SD_DRILL_11/32_3XD  | 02899052 | 8,731<br>0.344 | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0880-035-10R1<br>SD_DRILL_8.8MM_3XD  | 02899053 | 8,8<br>0.346   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0890-035-10R1<br>SD_DRILL_8.9MM_3XD  | 02899054 | 8,9<br>0.350   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0900-035-10R1<br>SD_DRILL_9.0MM_3XD  | 02899055 | 9,0<br>0.354   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0910-035-10R1<br>SD_DRILL_9.1MM_3XD  | 02899056 | 9,1<br>0.358   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0913-035-10R1<br>SD_DRILL_23/64_3XD  | 02899058 | 9,128<br>0.359 | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0920-035-10R1<br>SD_DRILL_9.2MM_3XD  | 02899059 | 9,2<br>0.362   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |

| Megnevezés                                   | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat típus |
|--|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103-0930-035-10R1<br>SD_DRILL_9.3MM_3XD   | 02899060 | 9,3<br>0.366    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0940-035-10R1<br>SD_DRILL_9.4MM_3XD   | 02899061 | 9,4<br>0.370    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0950-035-10R1<br>SD_DRILL_9.5MM_3XD   | 02899062 | 9,5<br>0.374    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0953-035-10R1<br>SD_DRILL_3/8_3XD     | 02899063 | 9,525<br>0.375  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0955-035-10R1<br>SD_DRILL_9.55MM_3XD  | 02899064 | 9,55<br>0.376   | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0960-035-10R1<br>SD_DRILL_9.6MM_3XD   | 02899065 | 9,6<br>0.378    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0970-035-10R1<br>SD_DRILL_9.7MM_3XD   | 02899066 | 9,7<br>0.382    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0980-035-10R1<br>SD_DRILL_9.8MM_3XD   | 02899067 | 9,8<br>0.386    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0990-035-10R1<br>SD_DRILL_9.9MM_3XD   | 02899068 | 9,9<br>0.390    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-0992-035-10R1<br>SD_DRILL_25/64_3XD   | 02899069 | 9,922<br>0.391  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-1000-035-10R1<br>SD_DRILL_10.0MM_3XD  | 02899070 | 10,0<br>0.394   | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103-1020-040-12R1<br>SD_DRILL_10.2MM_3XD  | 02899071 | 10,2<br>0.402   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1032-040-12R1<br>SD_DRILL_13/32_3XD   | 02899072 | 10,319<br>0.406 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1040-040-12R1<br>SD_DRILL_10.4MM_3XD  | 02899073 | 10,4<br>0.409   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1050-040-12R1<br>SD_DRILL_10.5MM_3XD  | 02899074 | 10,5<br>0.413   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1060-040-12R1<br>SD_DRILL_10.6MM_3XD  | 02899075 | 10,6<br>0.417   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1072-040-12R1<br>SD_DRILL_27/64_3XD   | 02899076 | 10,716<br>0.422 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1080-040-12R1<br>SD_DRILL_10.8MM_3XD  | 02899077 | 10,8<br>0.425   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1090-040-12R1<br>SD_DRILL_10.9MM_3XD  | 02899078 | 10,9<br>0.429   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1100-040-12R1<br>SD_DRILL_11.0MM_3XD  | 02899079 | 11,0<br>0.433   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1110-040-12R1<br>SD_DRILL_11.1MM_3XD  | 02899080 | 11,1<br>0.437   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1111-040-12R1<br>SD_DRILL_7/16_3XD    | 02899081 | 11,113<br>0.438 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1120-040-12R1<br>SD_DRILL_11.2MM_3XD  | 02899082 | 11,2<br>0.441   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1130-040-12R1<br>SD_DRILL_11.3MM_3XD  | 02899083 | 11,3<br>0.445   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1140-040-12R1<br>SD_DRILL_11.4MM_3XD  | 02899084 | 11,4<br>0.449   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1150-040-12R1<br>SD_DRILL_11.5MM_3XD  | 02899085 | 11,5<br>0.453   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1151-040-12R1<br>SD_DRILL_29/64_3XD   | 02899086 | 11,509<br>0.453 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1155-040-12R1<br>SD_DRILL_11.55MM_3XD | 02899087 | 11,55<br>0.455  | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1160-040-12R1<br>SD_DRILL_11.6MM_3XD  | 02899088 | 11,6<br>0.457   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1170-040-12R1<br>SD_DRILL_11.7MM_3XD  | 02899089 | 11,7<br>0.461   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1180-040-12R1<br>SD_DRILL_11.8MM_3XD  | 02899090 | 11,8<br>0.465   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |

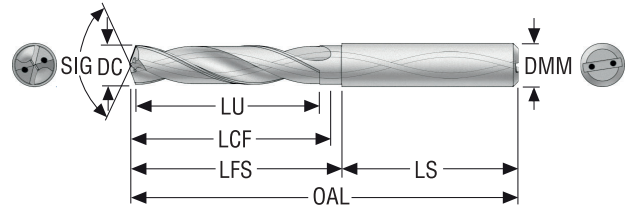
| Megnevezés                                   | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103-1190-040-12R1<br>SD_DRILL_11.9MM_3XD  | 02899091 | 11,9<br>0.469   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1191-040-12R1<br>SD_DRILL_15/32_3XD   | 02899092 | 11,906<br>0.469 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1200-040-12R1<br>SD_DRILL_12.0MM_3XD  | 02899093 | 12,0<br>0.472   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103-1210-043-14R1<br>SD_DRILL_12.1MM_3XD  | 02899094 | 12,1<br>0.476   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1220-043-14R1<br>SD_DRILL_12.2MM_3XD  | 02899095 | 12,2<br>0.480   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1230-043-14R1<br>SD_DRILL_31/64_3XD   | 02899096 | 12,303<br>0.484 | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1240-043-14R1<br>SD_DRILL_12.4MM_3XD  | 02899097 | 12,4<br>0.488   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1250-043-14R1<br>SD_DRILL_12.5MM_3XD  | 02899098 | 12,5<br>0.492   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1260-043-14R1<br>SD_DRILL_12.6MM_3XD  | 02899099 | 12,6<br>0.496   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1270-043-14R1<br>SD_DRILL_1/2_3XD     | 02899100 | 12,7<br>0.500   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1275-043-14R1<br>SD_DRILL_12.75MM_3XD | 02899101 | 12,75<br>0.502  | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1280-043-14R1<br>SD_DRILL_12.8MM_3XD  | 02899102 | 12,8<br>0.504   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1290-043-14R1<br>SD_DRILL_12.9MM_3XD  | 02899103 | 12,9<br>0.508   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1300-043-14R1<br>SD_DRILL_13.0MM_3XD  | 02899104 | 13,0<br>0.512   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1310-043-14R1<br>SD_DRILL_33/64_3XD   | 02899105 | 13,1<br>0.516   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1320-043-14R1<br>SD_DRILL_13.2MM_3XD  | 02899106 | 13,2<br>0.520   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1330-043-14R1<br>SD_DRILL_13.3MM_3XD  | 02899107 | 13,3<br>0.524   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1340-043-14R1<br>SD_DRILL_13.4MM_3XD  | 02899108 | 13,4<br>0.528   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1349-043-14R1<br>SD_DRILL_17/32_3XD   | 02899109 | 13,494<br>0.531 | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1350-043-14R1<br>SD_DRILL_13.5MM_3XD  | 02899110 | 13,5<br>0.531   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1360-043-14R1<br>SD_DRILL_13.6MM_3XD  | 02899111 | 13,6<br>0.535   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1370-043-14R1<br>SD_DRILL_13.7MM_3XD  | 02899112 | 13,7<br>0.539   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1380-043-14R1<br>SD_DRILL_13.8MM_3XD  | 02899113 | 13,8<br>0.543   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1390-043-14R1<br>SD_DRILL_35/64_3XD   | 02899114 | 13,9<br>0.547   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1400-043-14R1<br>SD_DRILL_14.0MM_3XD  | 02899115 | 14,0<br>0.551   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103-1420-045-16R1<br>SD_DRILL_14.2MM_3XD  | 02899116 | 14,2<br>0.559   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1429-045-16R1<br>SD_DRILL_9/16_3XD    | 02899117 | 14,288<br>0.563 | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1450-045-16R1<br>SD_DRILL_14.5MM_3XD  | 02899119 | 14,5<br>0.571   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1470-045-16R1<br>SD_DRILL_14.7MM_3XD  | 02899120 | 14,7<br>0.579   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1475-045-16R1<br>SD_DRILL_14.75MM_3XD | 02899121 | 14,75<br>0.581  | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1480-045-16R1<br>SD_DRILL_14.8MM_3XD  | 02899122 | 14,8<br>0.583   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |



| Megnevezés                                  | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103-1500-045-16R1<br>SD_DRILL_15.0MM_3XD | 02899123 | 15,0<br>0.591   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1510-045-16R1<br>SD_DRILL_15.1MM_3XD | 02899124 | 15,1<br>0.594   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1530-045-16R1<br>SD_DRILL_15.3MM_3XD | 02899125 | 15,3<br>0.602   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1550-045-16R1<br>SD_DRILL_15.5MM_3XD | 02899126 | 15,5<br>0.610   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1570-045-16R1<br>SD_DRILL_15.7MM_3XD | 02899127 | 15,7<br>0.618   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1580-045-16R1<br>SD_DRILL_15.8MM_3XD | 02899128 | 15,8<br>0.622   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1588-045-16R1<br>SD_DRILL_5/8_3XD    | 02899129 | 15,875<br>0.625 | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1600-045-16R1<br>SD_DRILL_16.0MM_3XD | 02899130 | 16,0<br>0.630   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103-1650-051-18R1<br>SD_DRILL_16.5MM_3XD | 02899131 | 16,5<br>0.650   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103-1700-051-18R1<br>SD_DRILL_17.0MM_3XD | 02899132 | 17,0<br>0.669   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103-1750-051-18R1<br>SD_DRILL_17.5MM_3XD | 02899133 | 17,5<br>0.689   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103-1800-051-18R1<br>SD_DRILL_18.0MM_3XD | 02899134 | 18,0<br>0.709   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103-1850-055-20R1<br>SD_DRILL_18.5MM_3XD | 02899135 | 18,5<br>0.728   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103-1900-055-20R1<br>SD_DRILL_19.0MM_3XD | 02899136 | 19,0<br>0.748   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103-1905-055-20R1<br>SD_DRILL_3/4_3XD    | 02899137 | 19,05<br>0.750  | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103-1950-055-20R1<br>SD_DRILL_19.5MM_3XD | 02899138 | 19,5<br>0.768   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103-2000-055-20R1<br>SD_DRILL_20.0MM_3XD | 02899139 | 20,0<br>0.787   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |

## SD1103A

Fúrási mélység ~ 3 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Forgácsolási adatokat lásd a 143 old.
- Köztés átmérők a Custom Design szoftverben.

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1103A-0300-014-06R1<br>SD_DRILL_3.0MM_3XD_A  | 02898244 | 3,0<br>0.118   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0310-014-06R1<br>SD_DRILL_3.1MM_3XD_A  | 02898245 | 3,1<br>0.122   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0318-014-06R1<br>SD_DRILL_1/8_3XD_A    | 02898246 | 3,175<br>0.125 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0320-014-06R1<br>SD_DRILL_3.2MM_3XD_A  | 02898247 | 3,2<br>0.126   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0325-014-06R1<br>SD_DRILL_3.25MM_3XD_A | 02898248 | 3,25<br>0.128  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0330-014-06R1<br>SD_DRILL_3.3MM_3XD_A  | 02898249 | 3,3<br>0.130   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0340-014-06R1<br>SD_DRILL_3.4MM_3XD_A  | 02898250 | 3,4<br>0.134   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0350-014-06R1<br>SD_DRILL_3.5MM_3XD_A  | 02898251 | 3,5<br>0.138   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0357-014-06R1<br>SD_DRILL_9/64_3XD_A   | 02898252 | 3,572<br>0.141 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0360-014-06R1<br>SD_DRILL_3.6MM_3XD_A  | 02898253 | 3,6<br>0.142   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0365-014-06R1<br>SD_DRILL_3.65MM_3XD_A | 02898254 | 3,65<br>0.144  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0370-014-06R1<br>SD_DRILL_3.7MM_3XD_A  | 02898255 | 3,7<br>0.146   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0380-017-06R1<br>SD_DRILL_3.8MM_3XD_A  | 02898256 | 3,8<br>0.150   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0390-017-06R1<br>SD_DRILL_3.9MM_3XD_A  | 02898257 | 3,9<br>0.154   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0397-017-06R1<br>SD_DRILL_5/32_3XD_A   | 02898258 | 3,969<br>0.156 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0400-017-06R1<br>SD_DRILL_4.0MM_3XD_A  | 02898259 | 4,0<br>0.157   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0410-017-06R1<br>SD_DRILL_4.1MM_3XD_A  | 02898260 | 4,1<br>0.161   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0420-017-06R1<br>SD_DRILL_4.2MM_3XD_A  | 02898261 | 4,2<br>0.165   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0430-017-06R1<br>SD_DRILL_4.3MM_3XD_A  | 02898262 | 4,3<br>0.169   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0437-017-06R1<br>SD_DRILL_11/64_3XD_A  | 02898263 | 4,366<br>0.172 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0450-017-06R1<br>SD_DRILL_4.5MM_3XD_A  | 02898264 | 4,5<br>0.177   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat típus |
|--|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1103A-0460-017-06R1<br>SD_DRILL_4.6MM_3XD_A  | 02898265 | 4,6<br>0.181   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0465-017-06R1<br>SD_DRILL_4.65MM_3XD_A | 02898266 | 4,65<br>0.183  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0470-017-06R1<br>SD_DRILL_4.7MM_3XD_A  | 02898267 | 4,7<br>0.185   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0476-020-06R1<br>SD_DRILL_3/16_3XD_A   | 02898268 | 4,763<br>0.188 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0480-020-06R1<br>SD_DRILL_4.8MM_3XD_A  | 02898269 | 4,8<br>0.189   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0490-020-06R1<br>SD_DRILL_4.9MM_3XD_A  | 02898270 | 4,9<br>0.193   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0500-020-06R1<br>SD_DRILL_5.0MM_3XD_A  | 02898271 | 5,0<br>0.197   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0510-020-06R1<br>SD_DRILL_5.1MM_3XD_A  | 02898272 | 5,1<br>0.201   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0516-020-06R1<br>SD_DRILL_13/64_3XD_A  | 02898273 | 5,159<br>0.203 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0520-020-06R1<br>SD_DRILL_5.2MM_3XD_A  | 02898275 | 5,2<br>0.205   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0530-020-06R1<br>SD_DRILL_5.3MM_3XD_A  | 02898276 | 5,3<br>0.209   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0540-020-06R1<br>SD_DRILL_5.4MM_3XD_A  | 02898277 | 5,4<br>0.213   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0550-020-06R1<br>SD_DRILL_5.5MM_3XD_A  | 02898278 | 5,5<br>0.217   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0555-020-06R1<br>SD_DRILL_5.55MM_3XD_A | 02898279 | 5,55<br>0.219  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0556-020-06R1<br>SD_DRILL_7/32_3XD_A   | 02898280 | 5,556<br>0.219 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0560-020-06R1<br>SD_DRILL_5.6MM_3XD_A  | 02898281 | 5,6<br>0.220   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0570-020-06R1<br>SD_DRILL_5.7MM_3XD_A  | 02898282 | 5,7<br>0.224   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0580-020-06R1<br>SD_DRILL_5.8MM_3XD_A  | 02898283 | 5,8<br>0.228   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0590-020-06R1<br>SD_DRILL_5.9MM_3XD_A  | 02898284 | 5,9<br>0.232   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0595-020-06R1<br>SD_DRILL_15/64_3XD_A  | 02898285 | 5,953<br>0.234 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0600-020-06R1<br>SD_DRILL_6.0MM_3XD_A  | 02898286 | 6,0<br>0.236   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1103A-0610-024-08R1<br>SD_DRILL_6.1MM_3XD_A  | 02898287 | 6,1<br>0.240   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0620-024-08R1<br>SD_DRILL_6.2MM_3XD_A  | 02898288 | 6,2<br>0.244   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0630-024-08R1<br>SD_DRILL_6.3MM_3XD_A  | 02898289 | 6,3<br>0.248   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0635-024-08R1<br>SD_DRILL_1/4_3XD_A    | 02898290 | 6,35<br>0.250  | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0640-024-08R1<br>SD_DRILL_6.4MM_3XD_A  | 02898291 | 6,4<br>0.252   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0650-024-08R1<br>SD_DRILL_6.5MM_3XD_A  | 02898292 | 6,5<br>0.256   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0660-024-08R1<br>SD_DRILL_6.6MM_3XD_A  | 02898293 | 6,6<br>0.260   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0670-024-08R1<br>SD_DRILL_6.7MM_3XD_A  | 02898294 | 6,7<br>0.264   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0675-024-08R1<br>SD_DRILL_17/64_3XD_A  | 02898295 | 6,747<br>0.266 | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1103A-0680-024-08R1<br>SD_DRILL_6.8MM_3XD_A  | 02898296 | 6,8<br>0.268   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|----------------|---------------|---------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103A-0690-024-08R1<br>SD_DRILL_6.9MM_3XD_A  | 02898297 | 6,9<br>0.272   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0700-024-08R1<br>SD_DRILL_7.0MM_3XD_A  | 02898298 | 7,0<br>0.276   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0710-029-08R1<br>SD_DRILL_7.1MM_3XD_A  | 02898299 | 7,1<br>0.280   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0714-029-08R1<br>SD_DRILL_9/32_3XD_A   | 02898300 | 7,144<br>0.281 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0720-029-08R1<br>SD_DRILL_7.2MM_3XD_A  | 02898301 | 7,2<br>0.283   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0730-029-08R1<br>SD_DRILL_7.3MM_3XD_A  | 02898302 | 7,3<br>0.287   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0740-029-08R1<br>SD_DRILL_7.4MM_3XD_A  | 02898303 | 7,4<br>0.291   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0750-029-08R1<br>SD_DRILL_7.5MM_3XD_A  | 02898304 | 7,5<br>0.295   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0754-029-08R1<br>SD_DRILL_19/64_3XD_A  | 02898305 | 7,541<br>0.297 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0755-029-08R1<br>SD_DRILL_7.55MM_3XD_A | 02898306 | 7,55<br>0.297  | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0760-029-08R1<br>SD_DRILL_7.6MM_3XD_A  | 02898307 | 7,6<br>0.299   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0770-029-08R1<br>SD_DRILL_7.7MM_3XD_A  | 02898308 | 7,7<br>0.303   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0780-029-08R1<br>SD_DRILL_7.8MM_3XD_A  | 02898309 | 7,8<br>0.307   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0790-029-08R1<br>SD_DRILL_7.9MM_3XD_A  | 02898310 | 7,9<br>0.311   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0794-029-08R1<br>SD_DRILL_5/16_3XD_A   | 02898311 | 7,938<br>0.313 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0800-029-08R1<br>SD_DRILL_8.0MM_3XD_A  | 02898312 | 8,0<br>0.315   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1103A-0810-035-10R1<br>SD_DRILL_8.1MM_3XD_A  | 02898313 | 8,1<br>0.319   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0820-035-10R1<br>SD_DRILL_8.2MM_3XD_A  | 02898314 | 8,2<br>0.323   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0830-035-10R1<br>SD_DRILL_8.3MM_3XD_A  | 02898315 | 8,3<br>0.327   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0833-035-10R1<br>SD_DRILL_21/64_3XD_A  | 02898316 | 8,334<br>0.328 | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0840-035-10R1<br>SD_DRILL_8.4MM_3XD_A  | 02898317 | 8,4<br>0.331   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0850-035-10R1<br>SD_DRILL_8.5MM_3XD_A  | 02898318 | 8,5<br>0.335   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0860-035-10R1<br>SD_DRILL_8.6MM_3XD_A  | 02898319 | 8,6<br>0.339   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0870-035-10R1<br>SD_DRILL_8.7MM_3XD_A  | 02898320 | 8,7<br>0.343   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0873-035-10R1<br>SD_DRILL_11/32_3XD_A  | 02898321 | 8,731<br>0.344 | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0880-035-10R1<br>SD_DRILL_8.8MM_3XD_A  | 02898322 | 8,8<br>0.346   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0890-035-10R1<br>SD_DRILL_8.9MM_3XD_A  | 02898323 | 8,9<br>0.350   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0900-035-10R1<br>SD_DRILL_9.0MM_3XD_A  | 02898324 | 9,0<br>0.354   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0910-035-10R1<br>SD_DRILL_9.1MM_3XD_A  | 02898325 | 9,1<br>0.358   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0913-035-10R1<br>SD_DRILL_23/64_3XD_A  | 02898326 | 9,128<br>0.359 | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0920-035-10R1<br>SD_DRILL_9.2MM_3XD_A  | 02898327 | 9,2<br>0.362   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |

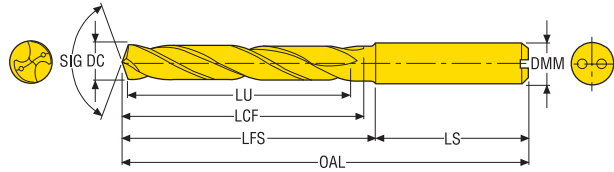
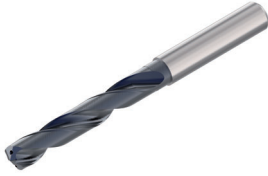
| Megnevezés                                      | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat típus |
|---|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103A-0930-035-10R1<br>SD_DRILL_9.3MM_3XD_A   | 02898328 | 9,3<br>0.366    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0940-035-10R1<br>SD_DRILL_9.4MM_3XD_A   | 02898329 | 9,4<br>0.370    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0950-035-10R1<br>SD_DRILL_9.5MM_3XD_A   | 02898330 | 9,5<br>0.374    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0953-035-10R1<br>SD_DRILL_3/8_3XD_A     | 02898331 | 9,525<br>0.375  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0955-035-10R1<br>SD_DRILL_9.55MM_3XD_A  | 02898332 | 9,55<br>0.376   | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0960-035-10R1<br>SD_DRILL_9.6MM_3XD_A   | 02898333 | 9,6<br>0.378    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0970-035-10R1<br>SD_DRILL_9.7MM_3XD_A   | 02898334 | 9,7<br>0.382    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0980-035-10R1<br>SD_DRILL_9.8MM_3XD_A   | 02898335 | 9,8<br>0.386    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0990-035-10R1<br>SD_DRILL_9.9MM_3XD_A   | 02898336 | 9,9<br>0.390    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-0992-035-10R1<br>SD_DRILL_25/64_3XD_A   | 02898337 | 9,922<br>0.391  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-1000-035-10R1<br>SD_DRILL_10.0MM_3XD_A  | 02898338 | 10,0<br>0.394   | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1103A-1020-040-12R1<br>SD_DRILL_10.2MM_3XD_A  | 02898339 | 10,2<br>0.402   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1032-040-12R1<br>SD_DRILL_13/32_3XD_A   | 02898340 | 10,319<br>0.406 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1040-040-12R1<br>SD_DRILL_10.4MM_3XD_A  | 02898341 | 10,4<br>0.409   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1050-040-12R1<br>SD_DRILL_10.5MM_3XD_A  | 02898342 | 10,5<br>0.413   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1060-040-12R1<br>SD_DRILL_10.6MM_3XD_A  | 02898343 | 10,6<br>0.417   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1072-040-12R1<br>SD_DRILL_27/64_3XD_A   | 02898344 | 10,716<br>0.422 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1080-040-12R1<br>SD_DRILL_10.8MM_3XD_A  | 02898345 | 10,8<br>0.425   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1090-040-12R1<br>SD_DRILL_10.9MM_3XD_A  | 02898346 | 10,9<br>0.429   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1100-040-12R1<br>SD_DRILL_11.0MM_3XD_A  | 02898347 | 11,0<br>0.433   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1110-040-12R1<br>SD_DRILL_11.1MM_3XD_A  | 02898348 | 11,1<br>0.437   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1111-040-12R1<br>SD_DRILL_7/16_3XD_A    | 02898349 | 11,113<br>0.438 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1120-040-12R1<br>SD_DRILL_11.2MM_3XD_A  | 02898350 | 11,2<br>0.441   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1130-040-12R1<br>SD_DRILL_11.3MM_3XD_A  | 02898351 | 11,3<br>0.445   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1140-040-12R1<br>SD_DRILL_11.4MM_3XD_A  | 02898352 | 11,4<br>0.449   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1150-040-12R1<br>SD_DRILL_11.5MM_3XD_A  | 02898353 | 11,5<br>0.453   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1151-040-12R1<br>SD_DRILL_29/64_3XD_A   | 02898354 | 11,509<br>0.453 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1155-040-12R1<br>SD_DRILL_11.55MM_3XD_A | 02898355 | 11,55<br>0.455  | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1160-040-12R1<br>SD_DRILL_11.6MM_3XD_A  | 02898356 | 11,6<br>0.457   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1170-040-12R1<br>SD_DRILL_11.7MM_3XD_A  | 02898357 | 11,7<br>0.461   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1180-040-12R1<br>SD_DRILL_11.8MM_3XD_A  | 02898358 | 11,8<br>0.465   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |

| Megnevezés                                      | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103A-1190-040-12R1<br>SD_DRILL_11.9MM_3XD_A  | 02898359 | 11,9<br>0.469   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1191-040-12R1<br>SD_DRILL_15/32_3XD_A   | 02898360 | 11,906<br>0.469 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1200-040-12R1<br>SD_DRILL_12.0MM_3XD_A  | 02898361 | 12,0<br>0.472   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1103A-1210-043-14R1<br>SD_DRILL_12.1MM_3XD_A  | 02898362 | 12,1<br>0.476   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1220-043-14R1<br>SD_DRILL_12.2MM_3XD_A  | 02898363 | 12,2<br>0.480   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1230-043-14R1<br>SD_DRILL_31/64_3XD_A   | 02898364 | 12,303<br>0.484 | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1240-043-14R1<br>SD_DRILL_12.4MM_3XD_A  | 02898365 | 12,4<br>0.488   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1250-043-14R1<br>SD_DRILL_12.5MM_3XD_A  | 02898366 | 12,5<br>0.492   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1260-043-14R1<br>SD_DRILL_12.6MM_3XD_A  | 02898367 | 12,6<br>0.496   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1270-043-14R1<br>SD_DRILL_1/2_3XD_A     | 02898368 | 12,7<br>0.500   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1275-043-14R1<br>SD_DRILL_12.75MM_3XD_A | 02898369 | 12,75<br>0.502  | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1280-043-14R1<br>SD_DRILL_12.8MM_3XD_A  | 02898370 | 12,8<br>0.504   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1290-043-14R1<br>SD_DRILL_12.9MM_3XD_A  | 02898371 | 12,9<br>0.508   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1300-043-14R1<br>SD_DRILL_13.0MM_3XD_A  | 02898372 | 13,0<br>0.512   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1310-043-14R1<br>SD_DRILL_33/64_3XD_A   | 02898373 | 13,1<br>0.516   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1320-043-14R1<br>SD_DRILL_13.2MM_3XD_A  | 02898374 | 13,2<br>0.520   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1330-043-14R1<br>SD_DRILL_13.3MM_3XD_A  | 02898375 | 13,3<br>0.524   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1340-043-14R1<br>SD_DRILL_13.4MM_3XD_A  | 02898376 | 13,4<br>0.528   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1349-043-14R1<br>SD_DRILL_17/32_3XD_A   | 02898377 | 13,494<br>0.531 | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1350-043-14R1<br>SD_DRILL_13.5MM_3XD_A  | 02898378 | 13,5<br>0.531   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1360-043-14R1<br>SD_DRILL_13.6MM_3XD_A  | 02898379 | 13,6<br>0.535   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1370-043-14R1<br>SD_DRILL_13.7MM_3XD_A  | 02898380 | 13,7<br>0.539   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1380-043-14R1<br>SD_DRILL_13.8MM_3XD_A  | 02898381 | 13,8<br>0.543   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1390-043-14R1<br>SD_DRILL_13.9MM_3XD_A  | 02898382 | 13,9<br>0.547   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1400-043-14R1<br>SD_DRILL_14.0MM_3XD_A  | 02898383 | 14,0<br>0.551   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1103A-1420-045-16R1<br>SD_DRILL_14.2MM_3XD_A  | 02898384 | 14,2<br>0.559   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1429-045-16R1<br>SD_DRILL_9/16_3XD_A    | 02898385 | 14,288<br>0.563 | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1450-045-16R1<br>SD_DRILL_14.5MM_3XD_A  | 02898386 | 14,5<br>0.571   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1470-045-16R1<br>SD_DRILL_14.7MM_3XD_A  | 02898387 | 14,7<br>0.579   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1475-045-16R1<br>SD_DRILL_14.75MM_3XD_A | 02898388 | 14,75<br>0.581  | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1480-045-16R1<br>SD_DRILL_14.8MM_3XD_A  | 02898389 | 14,8<br>0.583   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat típus |
|--|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1103A-1500-045-16R1<br>SD_DRILL_15.0MM_3XD_A | 02898390 | 15,0<br>0.591   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1510-045-16R1<br>SD_DRILL_15.1MM_3XD_A | 02898391 | 15,1<br>0.594   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1530-045-16R1<br>SD_DRILL_15.3MM_3XD_A | 02898392 | 15,3<br>0.602   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1550-045-16R1<br>SD_DRILL_15.5MM_3XD_A | 02898393 | 15,5<br>0.610   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1570-045-16R1<br>SD_DRILL_15.7MM_3XD_A | 02898394 | 15,7<br>0.618   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1580-045-16R1<br>SD_DRILL_15.8MM_3XD_A | 02898395 | 15,8<br>0.622   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1588-045-16R1<br>SD_DRILL_5/8_3XD_A    | 02898396 | 15,875<br>0.625 | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1600-045-16R1<br>SD_DRILL_16.0MM_3XD_A | 02898397 | 16,0<br>0.630   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1103A-1650-051-18R1<br>SD_DRILL_16.5MM_3XD_A | 02898398 | 16,5<br>0.650   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103A-1700-051-18R1<br>SD_DRILL_17.0MM_3XD_A | 02898399 | 17,0<br>0.669   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103A-1750-051-18R1<br>SD_DRILL_17.5MM_3XD_A | 02898400 | 17,5<br>0.689   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103A-1800-051-18R1<br>SD_DRILL_18.0MM_3XD_A | 02898401 | 18,0<br>0.709   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1103A-1850-055-20R1<br>SD_DRILL_18.5MM_3XD_A | 02898402 | 18,5<br>0.728   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103A-1900-055-20R1<br>SD_DRILL_19.0MM_3XD_A | 02898403 | 19,0<br>0.748   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103A-1905-055-20R1<br>SD_DRILL_3/4_3XD_A    | 02898404 | 19,05<br>0.750  | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103A-1950-055-20R1<br>SD_DRILL_19.5MM_3XD_A | 02898405 | 19,5<br>0.768   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1103A-2000-055-20R1<br>SD_DRILL_20.0MM_3XD_A | 02898406 | 20,0<br>0.787   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |

## SD-1105A

Fúrási mélység ~ 5 x D



- Hengeres szár DIN 6537A
- Belső hűtés
- Forgácsolási adatokat lásd a 144 old.
- Köztés átmérők a Custom Design szoftverben.

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



| Megnevezés                                     | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat típus |
|--|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1105A-0460-029-06R1<br>SD_DRILL_4.6MM_5XD_A  | 02897867 | 4,6<br>0.181   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 36,0<br>1.417 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0465-029-06R1<br>SD_DRILL_4.65MM_5XD_A | 02897868 | 4,65<br>0.183  | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 36,0<br>1.417 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0470-029-06R1<br>SD_DRILL_4.7MM_5XD_A  | 02897869 | 4,7<br>0.185   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 36,0<br>1.417 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0476-035-06R1<br>SD_DRILL_3/16_5XD_A   | 02897870 | 4,763<br>0.188 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0480-035-06R1<br>SD_DRILL_4.8MM_5XD_A  | 02897871 | 4,8<br>0.189   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0490-035-06R1<br>SD_DRILL_4.9MM_5XD_A  | 02897872 | 4,9<br>0.193   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0500-035-06R1<br>SD_DRILL_5.0MM_5XD_A  | 02897873 | 5,0<br>0.197   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0510-035-06R1<br>SD_DRILL_5.1MM_5XD_A  | 02897874 | 5,1<br>0.201   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0516-035-06R1<br>SD_DRILL_13/64_5XD_A  | 02897875 | 5,159<br>0.203 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0520-035-06R1<br>SD_DRILL_5.2MM_5XD_A  | 02897876 | 5,2<br>0.205   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0530-035-06R1<br>SD_DRILL_5.3MM_5XD_A  | 02897877 | 5,3<br>0.209   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0540-035-06R1<br>SD_DRILL_5.4MM_5XD_A  | 02897878 | 5,4<br>0.213   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0550-035-06R1<br>SD_DRILL_5.5MM_5XD_A  | 02897879 | 5,5<br>0.217   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0555-035-06R1<br>SD_DRILL_5.55MM_5XD_A | 02897880 | 5,55<br>0.219  | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0556-035-06R1<br>SD_DRILL_7/32_5XD_A   | 02897881 | 5,566<br>0.219 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0560-035-06R1<br>SD_DRILL_5.6MM_5XD_A  | 02897882 | 5,6<br>0.220   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0570-035-06R1<br>SD_DRILL_5.7MM_5XD_A  | 02897883 | 5,7<br>0.224   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0580-035-06R1<br>SD_DRILL_5.8MM_5XD_A  | 02897884 | 5,8<br>0.228   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0590-035-06R1<br>SD_DRILL_5.9MM_5XD_A  | 02897885 | 5,9<br>0.232   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0595-035-06R1<br>SD_DRILL_15/64_5XD_A  | 02897886 | 5,953<br>0.234 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0600-035-06R1<br>SD_DRILL_6.0MM_5XD_A  | 02897887 | 6,0<br>0.236   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1105A-0610-043-08R1<br>SD_DRILL_6.1MM_5XD_A  | 02897888 | 6,1<br>0.240   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0620-043-08R1<br>SD_DRILL_6.2MM_5XD_A  | 02897889 | 6,2<br>0.244   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0630-043-08R1<br>SD_DRILL_6.3MM_5XD_A  | 02897890 | 6,3<br>0.248   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0635-043-08R1<br>SD_DRILL_1/4_5XD_A    | 02897891 | 6,35<br>0.250  | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0640-043-08R1<br>SD_DRILL_6.4MM_5XD_A  | 02897892 | 6,4<br>0.252   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0650-043-08R1<br>SD_DRILL_6.5MM_5XD_A  | 02897893 | 6,5<br>0.256   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0660-043-08R1<br>SD_DRILL_6.6MM_5XD_A  | 02897894 | 6,6<br>0.260   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0670-043-08R1<br>SD_DRILL_6.7MM_5XD_A  | 02897895 | 6,7<br>0.264   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0675-043-08R1<br>SD_DRILL_17/64_5XD_A  | 02897896 | 6,747<br>0.266 | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1105A-0680-043-08R1<br>SD_DRILL_6.8MM_5XD_A  | 02897897 | 6,8<br>0.268   | 43,0<br>1.693 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1105A-0690-043-08R1<br>SD_DRILL_6.9MM_5XD_A  | 02897898 | 6,9<br>0.272   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0700-043-08R1<br>SD_DRILL_7.0MM_5XD_A  | 02897899 | 7,0<br>0.276   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0710-043-08R1<br>SD_DRILL_7.1MM_5XD_A  | 02897900 | 7,1<br>0.280   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0714-043-08R1<br>SD_DRILL_9/32_5XD_A   | 02897901 | 7,144<br>0.281 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0720-043-08R1<br>SD_DRILL_7.2MM_5XD_A  | 02897902 | 7,2<br>0.283   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0730-043-08R1<br>SD_DRILL_7.3MM_5XD_A  | 02897903 | 7,3<br>0.287   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0740-043-08R1<br>SD_DRILL_7.4MM_5XD_A  | 02897904 | 7,4<br>0.291   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0750-043-08R1<br>SD_DRILL_7.5MM_5XD_A  | 02897905 | 7,5<br>0.295   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0754-043-08R1<br>SD_DRILL_19/64_5XD_A  | 02897906 | 7,541<br>0.297 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0755-043-08R1<br>SD_DRILL_7.55MM_5XD_A | 02897907 | 7,55<br>0.297  | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0760-043-08R1<br>SD_DRILL_7.6MM_5XD_A  | 02897908 | 7,6<br>0.299   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0770-043-08R1<br>SD_DRILL_7.7MM_5XD_A  | 02897909 | 7,7<br>0.303   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0780-043-08R1<br>SD_DRILL_7.8MM_5XD_A  | 02897910 | 7,8<br>0.307   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0790-043-08R1<br>SD_DRILL_7.9MM_5XD_A  | 02897911 | 7,9<br>0.311   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0794-043-08R1<br>SD_DRILL_5/16_5XD_A   | 02897912 | 7,938<br>0.313 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0800-043-08R1<br>SD_DRILL_8.0MM_5XD_A  | 02897913 | 8,0<br>0.315   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1105A-0810-049-10R1<br>SD_DRILL_8.1MM_5XD_A  | 02897914 | 8,1<br>0.319   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0820-049-10R1<br>SD_DRILL_8.2MM_5XD_A  | 02897915 | 8,2<br>0.323   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0830-049-10R1<br>SD_DRILL_8.3MM_5XD_A  | 02897916 | 8,3<br>0.327   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0833-049-10R1<br>SD_DRILL_21/64_5XD_A  | 02897917 | 8,334<br>0.328 | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0840-049-10R1<br>SD_DRILL_8.4MM_5XD_A  | 02897918 | 8,4<br>0.331   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0850-049-10R1<br>SD_DRILL_8.5MM_5XD_A  | 02897919 | 8,5<br>0.335   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0860-049-10R1<br>SD_DRILL_8.6MM_5XD_A  | 02897920 | 8,6<br>0.339   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0870-049-10R1<br>SD_DRILL_8.7MM_5XD_A  | 02897921 | 8,7<br>0.343   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0873-049-10R1<br>SD_DRILL_11/32_5XD_A  | 02897922 | 8,731<br>0.344 | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0880-049-10R1<br>SD_DRILL_8.8MM_5XD_A  | 02897923 | 8,8<br>0.346   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0890-049-10R1<br>SD_DRILL_8.9MM_5XD_A  | 02897924 | 8,9<br>0.350   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0900-049-10R1<br>SD_DRILL_9.0MM_5XD_A  | 02897925 | 9,0<br>0.354   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0910-049-10R1<br>SD_DRILL_9.1MM_5XD_A  | 02897926 | 9,1<br>0.358   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0913-049-10R1<br>SD_DRILL_23/64_5XD_A  | 02897927 | 9,128<br>0.359 | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0920-049-10R1<br>SD_DRILL_9.2MM_5XD_A  | 02897928 | 9,2<br>0.362   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |

| Megnevezés                                      | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat típus |
|---|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1105A-0930-049-10R1<br>SD_DRILL_9.3MM_5XD_A   | 02897929 | 9,3<br>0.366    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0940-049-10R1<br>SD_DRILL_9.4MM_5XD_A   | 02897930 | 9,4<br>0.370    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0950-049-10R1<br>SD_DRILL_9.5MM_5XD_A   | 02897931 | 9,5<br>0.374    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0953-049-10R1<br>SD_DRILL_3/8_5XD_A     | 02897932 | 9,525<br>0.375  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0955-049-10R1<br>SD_DRILL_9.55MM_5XD_A  | 02897933 | 9,55<br>0.376   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0960-049-10R1<br>SD_DRILL_9.6MM_5XD_A   | 02897934 | 9,6<br>0.378    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0970-049-10R1<br>SD_DRILL_9.7MM_5XD_A   | 02897935 | 9,7<br>0.382    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0980-049-10R1<br>SD_DRILL_9.8MM_5XD_A   | 02897936 | 9,8<br>0.386    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0990-049-10R1<br>SD_DRILL_9.9MM_5XD_A   | 02897937 | 9,9<br>0.390    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-0992-049-10R1<br>SD_DRILL_25/64_5XD_A   | 02897938 | 9,922<br>0.391  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-1000-049-10R1<br>SD_DRILL_10.0MM_5XD_A  | 02897939 | 10,0<br>0.394   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1105A-1010-056-12R1<br>SD_DRILL_10.1MM_5XD_A  | 02897940 | 10,1<br>0.398   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1020-056-12R1<br>SD_DRILL_10.2MM_5XD_A  | 02897941 | 10,2<br>0.402   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1030-056-12R1<br>SD_DRILL_10.3MM_5XD_A  | 02897942 | 10,3<br>0.406   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1032-056-12R1<br>SD_DRILL_13/32_5XD_A   | 02897943 | 10,319<br>0.406 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1040-056-12R1<br>SD_DRILL_10.4MM_5XD_A  | 02897944 | 10,4<br>0.409   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1050-056-12R1<br>SD_DRILL_10.5MM_5XD_A  | 02897945 | 10,5<br>0.413   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1060-056-12R1<br>SD_DRILL_10.6MM_5XD_A  | 02897946 | 10,6<br>0.417   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1070-056-12R1<br>SD_DRILL_10.7MM_5XD_A  | 02897947 | 10,7<br>0.421   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1072-056-12R1<br>SD_DRILL_27/64_5XD_A   | 02897948 | 10,716<br>0.422 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1080-056-12R1<br>SD_DRILL_10.8MM_5XD_A  | 02897949 | 10,8<br>0.425   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1090-056-12R1<br>SD_DRILL_10.9MM_5XD_A  | 02897951 | 10,9<br>0.429   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1100-056-12R1<br>SD_DRILL_11.0MM_5XD_A  | 02897952 | 11,0<br>0.433   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1110-056-12R1<br>SD_DRILL_11.1MM_5XD_A  | 02897953 | 11,1<br>0.437   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1111-056-12R1<br>SD_DRILL_7/16_5XD_A    | 02897954 | 11,113<br>0.438 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1120-056-12R1<br>SD_DRILL_11.2MM_5XD_A  | 02897955 | 11,2<br>0.441   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1130-056-12R1<br>SD_DRILL_11.3MM_5XD_A  | 02897956 | 11,3<br>0.445   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1140-056-12R1<br>SD_DRILL_11.4MM_5XD_A  | 02897957 | 11,4<br>0.449   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1150-056-12R1<br>SD_DRILL_11.5MM_5XD_A  | 02897958 | 11,5<br>0.453   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1151-056-12R1<br>SD_DRILL_29/64_5XD_A   | 02897959 | 11,509<br>0.453 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1155-056-12R1<br>SD_DRILL_11.55MM_5XD_A | 02897960 | 11,55<br>0.455  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |

| Megnevezés                                      | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1105A-1160-056-12R1<br>SD_DRILL_11.6MM_5XD_A  | 02897961 | 11,6<br>0.457   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1170-056-12R1<br>SD_DRILL_11.7MM_5XD_A  | 02897962 | 11,7<br>0.461   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1180-056-12R1<br>SD_DRILL_11.8MM_5XD_A  | 02897963 | 11,8<br>0.465   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1190-056-12R1<br>SD_DRILL_11.9MM_5XD_A  | 02897964 | 11,9<br>0.469   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1191-056-12R1<br>SD_DRILL_15/32_5XD_A   | 02897965 | 11,906<br>0.469 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1200-056-12R1<br>SD_DRILL_12.0MM_5XD_A  | 02897966 | 12,0<br>0.472   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1105A-1210-060-14R1<br>SD_DRILL_12.1MM_5XD_A  | 02897967 | 12,1<br>0.476   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1220-060-14R1<br>SD_DRILL_12.2MM_5XD_A  | 02897968 | 12,2<br>0.480   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1225-060-14R1<br>SD_DRILL_12.25MM_5XD_A | 02897969 | 12,25<br>0.482  | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1230-060-14R1<br>SD_DRILL_31/64_5XD_A   | 02897970 | 12,303<br>0.484 | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1240-060-14R1<br>SD_DRILL_12.4MM_5XD_A  | 02897972 | 12,4<br>0.488   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1250-060-14R1<br>SD_DRILL_12.5MM_5XD_A  | 02897973 | 12,5<br>0.492   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1260-060-14R1<br>SD_DRILL_12.6MM_5XD_A  | 02897974 | 12,6<br>0.496   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1270-060-14R1<br>SD_DRILL_1/2_5XD_A     | 02897950 | 12,7<br>0.500   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1275-060-14R1<br>SD_DRILL_12.75MM_5XD_A | 02897976 | 12,75<br>0.502  | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1280-060-14R1<br>SD_DRILL_12.8MM_5XD_A  | 02897977 | 12,8<br>0.504   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1290-060-14R1<br>SD_DRILL_12.9MM_5XD_A  | 02897978 | 12,9<br>0.508   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1300-060-14R1<br>SD_DRILL_13.0MM_5XD_A  | 02897979 | 13,0<br>0.512   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1310-060-14R1<br>SD_DRILL_33/64_5XD_A   | 02897980 | 13,1<br>0.516   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1320-060-14R1<br>SD_DRILL_13.2MM_5XD_A  | 02897981 | 13,2<br>0.520   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1330-060-14R1<br>SD_DRILL_13.3MM_5XD_A  | 02897982 | 13,3<br>0.524   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1340-060-14R1<br>SD_DRILL_13.4MM_5XD_A  | 02897983 | 13,4<br>0.528   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1349-060-14R1<br>SD_DRILL_17/32_5XD_A   | 02897984 | 13,494<br>0.531 | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1350-060-14R1<br>SD_DRILL_13.5MM_5XD_A  | 02897985 | 13,5<br>0.531   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1360-060-14R1<br>SD_DRILL_13.6MM_5XD_A  | 02897986 | 13,6<br>0.535   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1370-060-14R1<br>SD_DRILL_13.7MM_5XD_A  | 02897987 | 13,7<br>0.539   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1380-060-14R1<br>SD_DRILL_13.8MM_5XD_A  | 02897988 | 13,8<br>0.543   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1390-060-14R1<br>SD_DRILL_35/64_5XD_A   | 02897989 | 13,9<br>0.547   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1400-060-14R1<br>SD_DRILL_14.0MM_5XD_A  | 02897990 | 14,0<br>0.551   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1105A-1410-063-16R1<br>SD_DRILL_14.1MM_5XD_A  | 02897991 | 14,1<br>0.555   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1420-063-16R1<br>SD_DRILL_14.2MM_5XD_A  | 02897992 | 14,2<br>0.559   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |

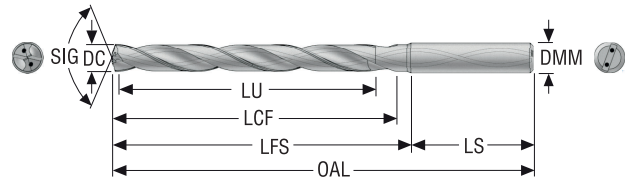
| Megnevezés                                      | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat típus |
|---|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1105A-1429-063-16R1<br>SD_DRILL_9/16_5XD_A    | 02897993 | 14,288<br>0.563 | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1430-063-16R1<br>SD_DRILL_14.3MM_5XD_A  | 02897994 | 14,3<br>0.563   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1440-063-16R1<br>SD_DRILL_14.4MM_5XD_A  | 02897995 | 14,4<br>0.567   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1450-063-16R1<br>SD_DRILL_14.5MM_5XD_A  | 02897996 | 14,5<br>0.571   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1460-063-16R1<br>SD_DRILL_14.6MM_5XD_A  | 02897997 | 14,6<br>0.575   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1470-063-16R1<br>SD_DRILL_14.7MM_5XD_A  | 02897998 | 14,7<br>0.579   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1475-063-16R1<br>SD_DRILL_14.75MM_5XD_A | 02897999 | 14,75<br>0.581  | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1480-063-16R1<br>SD_DRILL_14.8MM_5XD_A  | 02898000 | 14,8<br>0.583   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1490-063-16R1<br>SD_DRILL_14.9MM_5XD_A  | 02898001 | 14,9<br>0.587   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1500-063-16R1<br>SD_DRILL_15.0MM_5XD_A  | 02898002 | 15,0<br>0.591   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1510-063-16R1<br>SD_DRILL_15.1MM_5XD_A  | 02898003 | 15,1<br>0.594   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1520-063-16R1<br>SD_DRILL_15.2MM_5XD_A  | 02898004 | 15,2<br>0.598   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1530-063-16R1<br>SD_DRILL_15.3MM_5XD_A  | 02898005 | 15,3<br>0.602   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1540-063-16R1<br>SD_DRILL_15.4MM_5XD_A  | 02898006 | 15,4<br>0.606   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1550-063-16R1<br>SD_DRILL_15.5MM_5XD_A  | 02898007 | 15,5<br>0.610   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1560-063-16R1<br>SD_DRILL_15.6MM_5XD_A  | 02898008 | 15,6<br>0.614   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1570-063-16R1<br>SD_DRILL_15.7MM_5XD_A  | 02898009 | 15,7<br>0.618   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1580-063-16R1<br>SD_DRILL_15.8MM_5XD_A  | 02898010 | 15,8<br>0.622   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1588-063-16R1<br>SD_DRILL_5/8_5XD_A     | 02898011 | 15,875<br>0.625 | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1590-063-16R1<br>SD_DRILL_15.9MM_5XD_A  | 02898012 | 15,9<br>0.626   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1600-063-16R1<br>SD_DRILL_16.0MM_5XD_A  | 02898013 | 16,0<br>0.630   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1105A-1610-071-18R1<br>SD_DRILL_16.1MM_5XD_A  | 02898014 | 16,1<br>0.634   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1620-071-18R1<br>SD_DRILL_16.2MM_5XD_A  | 02898015 | 16,2<br>0.638   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1630-071-18R1<br>SD_DRILL_16.3MM_5XD_A  | 02898016 | 16,3<br>0.642   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1640-071-18R1<br>SD_DRILL_16.4MM_5XD_A  | 02898017 | 16,4<br>0.646   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1650-071-18R1<br>SD_DRILL_16.5MM_5XD_A  | 02898018 | 16,5<br>0.650   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1660-071-18R1<br>SD_DRILL_16.6MM_5XD_A  | 02898019 | 16,6<br>0.654   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1670-071-18R1<br>SD_DRILL_16.7MM_5XD_A  | 02898020 | 16,7<br>0.657   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1675-071-18R1<br>SD_DRILL_16.75MM_5XD_A | 02898021 | 16,75<br>0.659  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1680-071-18R1<br>SD_DRILL_16.8MM_5XD_A  | 02898022 | 16,8<br>0.661   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1690-071-18R1<br>SD_DRILL_16.9MM_5XD_A  | 02898023 | 16,9<br>0.665   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL            | LFS            | LS            | LCF            | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|----------------|---------------|----------------|----------------|---------------|----------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |             |         |             |
| SD1105A-1700-071-18R1<br>SD_DRILL_17.0MM_5XD_A | 02898024 | 17,0<br>0.669  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1710-071-18R1<br>SD_DRILL_17.1MM_5XD_A | 02898025 | 17,1<br>0.673  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1720-071-18R1<br>SD_DRILL_17.2MM_5XD_A | 02898026 | 17,2<br>0.677  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1730-071-18R1<br>SD_DRILL_17.3MM_5XD_A | 02898027 | 17,3<br>0.681  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1740-071-18R1<br>SD_DRILL_17.4MM_5XD_A | 02898028 | 17,4<br>0.685  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1750-071-18R1<br>SD_DRILL_17.5MM_5XD_A | 02898029 | 17,5<br>0.689  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1760-071-18R1<br>SD_DRILL_17.6MM_5XD_A | 02898030 | 17,6<br>0.693  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1770-071-18R1<br>SD_DRILL_17.7MM_5XD_A | 02898031 | 17,7<br>0.697  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1780-071-18R1<br>SD_DRILL_17.8MM_5XD_A | 02898032 | 17,8<br>0.701  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1790-071-18R1<br>SD_DRILL_17.9MM_5XD_A | 02898033 | 17,9<br>0.705  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1800-071-18R1<br>SD_DRILL_18.0MM_5XD_A | 02898034 | 18,0<br>0.709  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1105A-1810-077-20R1<br>SD_DRILL_18.1MM_5XD_A | 02898035 | 18,1<br>0.713  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1820-077-20R1<br>SD_DRILL_18.2MM_5XD_A | 02898036 | 18,2<br>0.717  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1830-077-20R1<br>SD_DRILL_18.3MM_5XD_A | 02898037 | 18,3<br>0.720  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1840-077-20R1<br>SD_DRILL_18.4MM_5XD_A | 02898038 | 18,4<br>0.724  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1850-077-20R1<br>SD_DRILL_18.5MM_5XD_A | 02898039 | 18,5<br>0.728  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1860-077-20R1<br>SD_DRILL_18.6MM_5XD_A | 02898040 | 18,6<br>0.732  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1870-077-20R1<br>SD_DRILL_18.7MM_5XD_A | 02898041 | 18,7<br>0.736  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1880-077-20R1<br>SD_DRILL_18.8MM_5XD_A | 02898042 | 18,8<br>0.740  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1890-077-20R1<br>SD_DRILL_18.9MM_5XD_A | 02898043 | 18,9<br>0.744  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1900-077-20R1<br>SD_DRILL_19.0MM_5XD_A | 02898044 | 19,0<br>0.748  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1905-077-20R1<br>SD_DRILL_3/4_5XD_A    | 02898045 | 19,05<br>0.750 | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1910-077-20R1<br>SD_DRILL_19.1MM_5XD_A | 02898046 | 19,1<br>0.752  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1920-077-20R1<br>SD_DRILL_19.2MM_5XD_A | 02898047 | 19,2<br>0.756  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1930-077-20R1<br>SD_DRILL_19.3MM_5XD_A | 02898048 | 19,3<br>0.760  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1940-077-20R1<br>SD_DRILL_19.4MM_5XD_A | 02898049 | 19,4<br>0.764  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1950-077-20R1<br>SD_DRILL_19.5MM_5XD_A | 02898050 | 19,5<br>0.768  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1960-077-20R1<br>SD_DRILL_19.6MM_5XD_A | 02898051 | 19,6<br>0.772  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1970-077-20R1<br>SD_DRILL_19.7MM_5XD_A | 02898052 | 19,7<br>0.776  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1105A-1980-077-20R1<br>SD_DRILL_19.8MM_5XD_A | 02898053 | 19,8<br>0.780  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC                | LU                | OAL               | LFS               | LS                | LCF               | DMM               | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------|---------|-------------|
|  |          | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> |             |         |             |
| SD1105A-1990-077-20R1<br>SD_DRILL_19.9MM_5XD_A | 02898054 | 19,9<br>0.783     | 77,0<br>3.031     | 153,0<br>6.024    | 103,0<br>4.055    | 50,0<br>1.969     | 101,0<br>3.976    | 20,0<br>0.787     | 140°        | TiAIN   | IT9         |
| SD1105A-2000-077-20R1<br>SD_DRILL_20.0MM_5XD_A | 02898055 | 20,0<br>0.787     | 77,0<br>3.031     | 153,0<br>6.024    | 103,0<br>4.055    | 50,0<br>1.969     | 101,0<br>3.976    | 20,0<br>0.787     | 140°        | TiAIN   | IT9         |

## SD1108A

Fúrási mélység ~ 8 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Forgácsolási adatokat lásd a 145 old.
- Köztes átmérők a Custom Design szoftverben.

| Megnevezés                                    | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1108A-0300-028-06R1<br>SD_DRILL_3.0MM_8XD_A | 03295178 | 3,0<br>0.118   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0310-028-06R1<br>SD_DRILL_3.1MM_8XD_A | 03295179 | 3,1<br>0.122   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0318-028-06R1<br>SD_DRILL_1/8_8XD_A   | 03323680 | 3,175<br>0.125 | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0320-028-06R1<br>SD_DRILL_3.2MM_8XD_A | 03295180 | 3,2<br>0.126   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0330-028-06R1<br>SD_DRILL_3.3MM_8XD_A | 03295181 | 3,3<br>0.130   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0340-028-06R1<br>SD_DRILL_3.4MM_8XD_A | 03295182 | 3,4<br>0.134   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0350-028-06R1<br>SD_DRILL_3.5MM_8XD_A | 03295183 | 3,5<br>0.138   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0357-028-06R1<br>SD_DRILL_9/64_8XD_A  | 03323681 | 3,572<br>0.141 | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0360-028-06R1<br>SD_DRILL_3.6MM_8XD_A | 03295184 | 3,6<br>0.142   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0370-028-06R1<br>SD_DRILL_3.7MM_8XD_A | 03295185 | 3,7<br>0.146   | 28,0<br>1.102 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0380-037-06R1<br>SD_DRILL_3.8MM_8XD_A | 03295186 | 3,8<br>0.150   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0390-037-06R1<br>SD_DRILL_3.9MM_8XD_A | 03295187 | 3,9<br>0.154   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0397-037-06R1<br>SD_DRILL_5/32_8XD_A  | 03323682 | 3,969<br>0.156 | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0400-037-06R1<br>SD_DRILL_4.0MM_8XD_A | 03295188 | 4,0<br>0.157   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0410-037-06R1<br>SD_DRILL_4.1MM_8XD_A | 03295189 | 4,1<br>0.161   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0420-037-06R1<br>SD_DRILL_4.2MM_8XD_A | 03295190 | 4,2<br>0.165   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0430-037-06R1<br>SD_DRILL_4.3MM_8XD_A | 03295191 | 4,3<br>0.169   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0437-037-06R1<br>SD_DRILL_11/64_8XD_A | 03323683 | 4,366<br>0.172 | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0440-037-06R1<br>SD_DRILL_4.4MM_8XD_A | 03295192 | 4,4<br>0.173   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0450-037-06R1<br>SD_DRILL_4.5MM_8XD_A | 03295193 | 4,5<br>0.177   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0460-037-06R1<br>SD_DRILL_4.6MM_8XD_A | 03295194 | 4,6<br>0.181   | 37,0<br>1.457 | 85,0<br>3.346 | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |



| Megnevezés                                    | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat típus |
|---|----------|----------------|---------------|----------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1108A-0470-037-06R1<br>SD_DRILL_4.7MM_8XD_A | 03295195 | 4,7<br>0.185   | 37,0<br>1.457 | 85,0<br>3.346  | 49,0<br>1.929 | 36,0<br>1.417 | 45,0<br>1.772 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0476-048-06R1<br>SD_DRILL_3/16_8XD_A  | 03323684 | 4,763<br>0.188 | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0480-048-06R1<br>SD_DRILL_4.8MM_8XD_A | 03295197 | 4,8<br>0.189   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0490-048-06R1<br>SD_DRILL_4.9MM_8XD_A | 03295198 | 4,9<br>0.193   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0500-048-06R1<br>SD_DRILL_5.0MM_8XD_A | 03295199 | 5,0<br>0.197   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0510-048-06R1<br>SD_DRILL_5.1MM_8XD_A | 03295200 | 5,1<br>0.201   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0516-048-06R1<br>SD_DRILL_13/64_8XD_A | 03323685 | 5,159<br>0.203 | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0520-048-06R1<br>SD_DRILL_5.2MM_8XD_A | 03295201 | 5,2<br>0.205   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0530-048-06R1<br>SD_DRILL_5.3MM_8XD_A | 03295202 | 5,3<br>0.209   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0540-048-06R1<br>SD_DRILL_5.4MM_8XD_A | 03295203 | 5,4<br>0.213   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0550-048-06R1<br>SD_DRILL_5.5MM_8XD_A | 03295204 | 5,5<br>0.217   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0556-048-06R1<br>SD_DRILL_7/32_8XD_A  | 03295206 | 5,556<br>0.219 | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0560-048-06R1<br>SD_DRILL_5.6MM_8XD_A | 03295207 | 5,6<br>0.220   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0570-048-06R1<br>SD_DRILL_5.7MM_8XD_A | 03295208 | 5,7<br>0.224   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0580-048-06R1<br>SD_DRILL_5.8MM_8XD_A | 03295012 | 5,8<br>0.228   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0590-048-06R1<br>SD_DRILL_5.9MM_8XD_A | 03295013 | 5,9<br>0.232   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0595-048-06R1<br>SD_DRILL_15/64_8XD_A | 03323686 | 5,953<br>0.234 | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0600-048-06R1<br>SD_DRILL_6.0MM_8XD_A | 03295014 | 6,0<br>0.236   | 48,0<br>1.890 | 97,0<br>3.819  | 61,0<br>2.402 | 36,0<br>1.417 | 57,0<br>2.244 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1108A-0610-055-08R1<br>SD_DRILL_6.1MM_8XD_A | 03295015 | 6,1<br>0.240   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0620-055-08R1<br>SD_DRILL_6.2MM_8XD_A | 03295016 | 6,2<br>0.244   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0630-055-08R1<br>SD_DRILL_6.3MM_8XD_A | 03295017 | 6,3<br>0.248   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0635-055-08R1<br>SD_DRILL_1/4_8XD_A   | 03295018 | 6,35<br>0.250  | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0640-055-08R1<br>SD_DRILL_6.4MM_8XD_A | 03295019 | 6,4<br>0.252   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0650-055-08R1<br>SD_DRILL_6.5MM_8XD_A | 03295020 | 6,5<br>0.256   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0660-055-08R1<br>SD_DRILL_6.6MM_8XD_A | 03295021 | 6,6<br>0.260   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0670-055-08R1<br>SD_DRILL_6.7MM_8XD_A | 03295022 | 6,7<br>0.264   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0675-055-08R1<br>SD_DRILL_17/64_8XD_A | 03323687 | 6,747<br>0.266 | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0680-055-08R1<br>SD_DRILL_6.8MM_8XD_A | 03295023 | 6,8<br>0.268   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0690-055-08R1<br>SD_DRILL_6.9MM_8XD_A | 03295024 | 6,9<br>0.272   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0700-055-08R1<br>SD_DRILL_7.0MM_8XD_A | 03295025 | 7,0<br>0.276   | 55,0<br>2.165 | 106,0<br>4.173 | 70,0<br>2.756 | 36,0<br>1.417 | 66,0<br>2.598 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1108A-0710-064-08R1<br>SD_DRILL_7.1MM_8XD_A | 03295026 | 7,1<br>0.280   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |

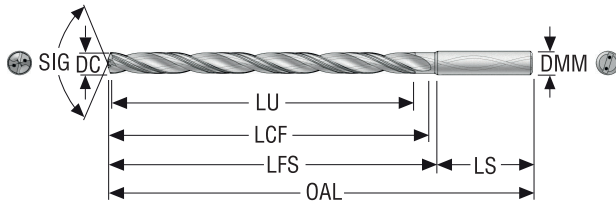
| Megnevezés                                    | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|---|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |             |         |             |
| SD1108A-0714-064-08R1<br>SD_DRILL_9/32_8XD_A  | 03323688 | 7,144<br>0.281 | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0730-064-08R1<br>SD_DRILL_7.3MM_8XD_A | 03323689 | 7,3<br>0.287   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0740-064-08R1<br>SD_DRILL_7.4MM_8XD_A | 03295027 | 7,4<br>0.291   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0750-064-08R1<br>SD_DRILL_7.5MM_8XD_A | 03295028 | 7,5<br>0.295   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0754-064-08R1<br>SD_DRILL_19/64_8XD_A | 03323690 | 7,541<br>0.297 | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0760-064-08R1<br>SD_DRILL_7.6MM_8XD_A | 03323691 | 7,6<br>0.299   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0770-064-08R1<br>SD_DRILL_7.7MM_8XD_A | 03295029 | 7,7<br>0.303   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0780-064-08R1<br>SD_DRILL_7.8MM_8XD_A | 03295030 | 7,8<br>0.307   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0790-064-08R1<br>SD_DRILL_7.9MM_8XD_A | 03295031 | 7,9<br>0.311   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0794-064-08R1<br>SD_DRILL_5/16_8XD_A  | 03323692 | 7,938<br>0.313 | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0800-064-08R1<br>SD_DRILL_8.0MM_8XD_A | 03295032 | 8,0<br>0.315   | 64,0<br>2.520 | 116,0<br>4.567 | 80,0<br>3.150 | 36,0<br>1.417 | 76,0<br>2.992 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1108A-0810-080-10R1<br>SD_DRILL_8.1MM_8XD_A | 03295033 | 8,1<br>0.319   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0820-080-10R1<br>SD_DRILL_8.2MM_8XD_A | 03295034 | 8,2<br>0.323   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0830-080-10R1<br>SD_DRILL_8.3MM_8XD_A | 03295035 | 8,3<br>0.327   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0833-080-10R1<br>SD_DRILL_21/64_8XD_A | 03323693 | 8,334<br>0.328 | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0840-080-10R1<br>SD_DRILL_8.4MM_8XD_A | 03295036 | 8,4<br>0.331   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0850-080-10R1<br>SD_DRILL_8.5MM_8XD_A | 03295037 | 8,5<br>0.335   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0860-080-10R1<br>SD_DRILL_8.6MM_8XD_A | 03295038 | 8,6<br>0.339   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0870-080-10R1<br>SD_DRILL_8.7MM_8XD_A | 03295039 | 8,7<br>0.343   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0873-080-10R1<br>SD_DRILL_11/32_8XD_A | 03323694 | 8,731<br>0.344 | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0880-080-10R1<br>SD_DRILL_8.8MM_8XD_A | 03295040 | 8,8<br>0.346   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0900-080-10R1<br>SD_DRILL_9.0MM_8XD_A | 03295041 | 9,0<br>0.354   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0910-080-10R1<br>SD_DRILL_9.1MM_8XD_A | 03295042 | 9,1<br>0.358   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0913-080-10R1<br>SD_DRILL_23/64_8XD_A | 03323695 | 9,128<br>0.359 | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0930-080-10R1<br>SD_DRILL_9.3MM_8XD_A | 03295043 | 9,3<br>0.366   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0940-080-10R1<br>SD_DRILL_9.4MM_8XD_A | 03295044 | 9,4<br>0.370   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0950-080-10R1<br>SD_DRILL_9.5MM_8XD_A | 03295045 | 9,5<br>0.374   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0953-080-10R1<br>SD_DRILL_3/8_8XD_A   | 03323696 | 9,525<br>0.375 | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0970-080-10R1<br>SD_DRILL_9.7MM_8XD_A | 03295046 | 9,7<br>0.382   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0980-080-10R1<br>SD_DRILL_9.8MM_8XD_A | 03295047 | 9,8<br>0.386   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-0990-080-10R1<br>SD_DRILL_9.9MM_8XD_A | 03295048 | 9,9<br>0.390   | 80,0<br>3.150 | 139,0<br>5.472 | 99,0<br>3.898 | 40,0<br>1.575 | 95,0<br>3.740 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC              | LU             | OAL            | LFS            | LS            | LCF            | DMM           | Csúcs szög: | Bevonat | Furat típus |
|--|----------|-----------------|----------------|----------------|----------------|---------------|----------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |             |         |             |
| SD1108A-0992-080-10R1<br>SD_DRILL_25/64_8XD_A  | 03323697 | 9,922<br>0.391  | 80,0<br>3.150  | 139,0<br>5.472 | 99,0<br>3.898  | 40,0<br>1.575 | 95,0<br>3.740  | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-1000-080-10R1<br>SD_DRILL_10.0MM_8XD_A | 03295049 | 10,0<br>0.394   | 80,0<br>3.150  | 139,0<br>5.472 | 99,0<br>3.898  | 40,0<br>1.575 | 95,0<br>3.740  | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1108A-1020-096-12R1<br>SD_DRILL_10.2MM_8XD_A | 03295050 | 10,2<br>0.402   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1030-096-12R1<br>SD_DRILL_10.3MM_8XD_A | 03295051 | 10,3<br>0.406   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1032-096-12R1<br>SD_DRILL_13/32_8XD_A  | 03323698 | 10,319<br>0.406 | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1040-096-12R1<br>SD_DRILL_10.4MM_8XD_A | 03295053 | 10,4<br>0.409   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1050-096-12R1<br>SD_DRILL_10.5MM_8XD_A | 03295054 | 10,5<br>0.413   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1070-096-12R1<br>SD_DRILL_10.7MM_8XD_A | 03295055 | 10,7<br>0.421   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1072-096-12R1<br>SD_DRILL_27/64_8XD_A  | 03323699 | 10,716<br>0.422 | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1080-096-12R1<br>SD_DRILL_10.8MM_8XD_A | 03295056 | 10,8<br>0.425   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1100-096-12R1<br>SD_DRILL_11.0MM_8XD_A | 03295057 | 11,0<br>0.433   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1111-096-12R1<br>SD_DRILL_7/16_8XD_A   | 03323700 | 11,113<br>0.438 | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1120-096-12R1<br>SD_DRILL_11.2MM_8XD_A | 03295058 | 11,2<br>0.441   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1130-096-12R1<br>SD_DRILL_11.3MM_8XD_A | 03295059 | 11,3<br>0.445   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1150-096-12R1<br>SD_DRILL_11.5MM_8XD_A | 03295060 | 11,5<br>0.453   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1170-096-12R1<br>SD_DRILL_11.7MM_8XD_A | 03295061 | 11,7<br>0.461   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1180-096-12R1<br>SD_DRILL_11.8MM_8XD_A | 03295062 | 11,8<br>0.465   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1190-096-12R1<br>SD_DRILL_11.9MM_8XD_A | 03295063 | 11,9<br>0.469   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1191-096-12R1<br>SD_DRILL_15/32_8XD_A  | 03323701 | 11,906<br>0.469 | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1200-096-12R1<br>SD_DRILL_12.0MM_8XD_A | 03295064 | 12,0<br>0.472   | 96,0<br>3.780  | 163,0<br>6.417 | 118,0<br>4.646 | 45,0<br>1.772 | 114,0<br>4.488 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1108A-1230-119-14R1<br>SD_DRILL_31/64_8XD_A  | 03295065 | 12,3<br>0.484   | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1250-119-14R1<br>SD_DRILL_12.5MM_8XD_A | 03295066 | 12,5<br>0.492   | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1270-119-14R1<br>SD_DRILL_1/2_8XD_A    | 03295067 | 12,7<br>0.500   | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1300-119-14R1<br>SD_DRILL_13.0MM_8XD_A | 03295068 | 13,0<br>0.512   | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1349-119-14R1<br>SD_DRILL_17/32_8XD_A  | 03323702 | 13,494<br>0.531 | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1350-119-14R1<br>SD_DRILL_13.5MM_8XD_A | 03295069 | 13,5<br>0.531   | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1400-119-14R1<br>SD_DRILL_14.0MM_8XD_A | 03295070 | 14,0<br>0.551   | 119,0<br>4.685 | 182,0<br>7.165 | 137,0<br>5.394 | 45,0<br>1.772 | 133,0<br>5.236 | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1108A-1429-136-16R1<br>SD_DRILL_9/16_8XD_A   | 03295071 | 14,288<br>0.563 | 136,0<br>5.354 | 204,0<br>8.031 | 156,0<br>6.142 | 48,0<br>1.890 | 152,0<br>5.984 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1108A-1450-136-16R1<br>SD_DRILL_14.5MM_8XD_A | 03295072 | 14,5<br>0.571   | 136,0<br>5.354 | 204,0<br>8.031 | 156,0<br>6.142 | 48,0<br>1.890 | 152,0<br>5.984 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1108A-1500-136-16R1<br>SD_DRILL_15.0MM_8XD_A | 03295073 | 15,0<br>0.591   | 136,0<br>5.354 | 204,0<br>8.031 | 156,0<br>6.142 | 48,0<br>1.890 | 152,0<br>5.984 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1108A-1550-136-16R1<br>SD_DRILL_15.5MM_8XD_A | 03295074 | 15,5<br>0.610   | 136,0<br>5.354 | 204,0<br>8.031 | 156,0<br>6.142 | 48,0<br>1.890 | 152,0<br>5.984 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC              | LU             | OAL            | LFS            | LS            | LCF            | DMM           | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|-----------------|----------------|----------------|----------------|---------------|----------------|---------------|-------------|---------|-------------|
|  |          | mm<br>Inch      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |             |         |             |
| SD1108A-1588-136-16R1<br>SD_DRILL_5/8_8XD_A    | 03295075 | 15,875<br>0.625 | 136,0<br>5.354 | 204,0<br>8.031 | 156,0<br>6.142 | 48,0<br>1.890 | 152,0<br>5.984 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1108A-1600-136-16R1<br>SD_DRILL_16.0MM_8XD_A | 03295076 | 16,0<br>0.630   | 136,0<br>5.354 | 204,0<br>8.031 | 156,0<br>6.142 | 48,0<br>1.890 | 152,0<br>5.984 | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1108A-1650-153-18R1<br>SD_DRILL_16.5MM_8XD_A | 03295077 | 16,5<br>0.650   | 153,0<br>6.024 | 223,0<br>8.780 | 175,0<br>6.890 | 48,0<br>1.890 | 171,0<br>6.732 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1108A-1700-153-18R1<br>SD_DRILL_17.0MM_8XD_A | 03295078 | 17,0<br>0.669   | 153,0<br>6.024 | 223,0<br>8.780 | 175,0<br>6.890 | 48,0<br>1.890 | 171,0<br>6.732 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1108A-1750-153-18R1<br>SD_DRILL_17.5MM_8XD_A | 03295079 | 17,5<br>0.689   | 153,0<br>6.024 | 223,0<br>8.780 | 175,0<br>6.890 | 48,0<br>1.890 | 171,0<br>6.732 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1108A-1800-153-18R1<br>SD_DRILL_18.0MM_8XD_A | 03295080 | 18,0<br>0.709   | 153,0<br>6.024 | 223,0<br>8.780 | 175,0<br>6.890 | 48,0<br>1.890 | 171,0<br>6.732 | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1108A-1850-170-20R1<br>SD_DRILL_18.5MM_8XD_A | 03295081 | 18,5<br>0.728   | 170,0<br>6.693 | 244,0<br>9.606 | 194,0<br>7.638 | 50,0<br>1.969 | 190,0<br>7.480 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1108A-1900-170-20R1<br>SD_DRILL_19.0MM_8XD_A | 03295082 | 19,0<br>0.748   | 170,0<br>6.693 | 244,0<br>9.606 | 194,0<br>7.638 | 50,0<br>1.969 | 190,0<br>7.480 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1108A-1905-170-20R1<br>SD_DRILL_3/4_8XD_A    | 03323703 | 19,05<br>0.750  | 170,0<br>6.693 | 244,0<br>9.606 | 194,0<br>7.638 | 50,0<br>1.969 | 190,0<br>7.480 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1108A-1950-170-20R1<br>SD_DRILL_19.5MM_8XD_A | 03295083 | 19,5<br>0.768   | 170,0<br>6.693 | 244,0<br>9.606 | 194,0<br>7.638 | 50,0<br>1.969 | 190,0<br>7.480 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1108A-2000-170-20R1<br>SD_DRILL_20.0MM_8XD_A | 03295084 | 20,0<br>0.787   | 170,0<br>6.693 | 244,0<br>9.606 | 194,0<br>7.638 | 50,0<br>1.969 | 190,0<br>7.480 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |

# SD1112A

Fúrási mélység ~ 12 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Forgácsolási adatokat lásd a 146 old.
- Köztes átmérők a Custom Design szoftverben.

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM          | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|----------------|---------------|----------------|---------------|---------------|---------------|--------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |             |         |             |
| SD1112A-0300-048-06R1<br>SD_DRILL_3.0MM_12XD_A | 03295085 | 3,0<br>0.118   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0310-048-06R1<br>SD_DRILL_3.1MM_12XD_A | 03295086 | 3,1<br>0.122   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0318-048-06R1<br>SD_DRILL_1/8_12XD_A   | 03323704 | 3,175<br>0.125 | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0320-048-06R1<br>SD_DRILL_3.2MM_12XD_A | 03295087 | 3,2<br>0.126   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0330-048-06R1<br>SD_DRILL_3.3MM_12XD_A | 03295088 | 3,3<br>0.130   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0340-048-06R1<br>SD_DRILL_3.4MM_12XD_A | 03295089 | 3,4<br>0.134   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0350-048-06R1<br>SD_DRILL_3.5MM_12XD_A | 03295090 | 3,5<br>0.138   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0357-048-06R1<br>SD_DRILL_9/64_12XD_A  | 03323705 | 3,572<br>0.141 | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0360-048-06R1<br>SD_DRILL_3.6MM_12XD_A | 03295091 | 3,6<br>0.142   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0370-048-06R1<br>SD_DRILL_3.7MM_12XD_A | 03295092 | 3,7<br>0.146   | 48,0<br>1.890 | 92,0<br>3.622  | 56,0<br>2.205 | 36,0<br>1.417 | 54,0<br>2.126 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0380-056-06R1<br>SD_DRILL_3.8MM_12XD_A | 03295093 | 3,8<br>0.150   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0390-056-06R1<br>SD_DRILL_3.9MM_12XD_A | 03295094 | 3,9<br>0.154   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0397-056-06R1<br>SD_DRILL_5/32_12XD_A  | 03323706 | 3,969<br>0.156 | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0400-056-06R1<br>SD_DRILL_4.0MM_12XD_A | 03295095 | 4,0<br>0.157   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0410-056-06R1<br>SD_DRILL_4.1MM_12XD_A | 03295096 | 4,1<br>0.161   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0420-056-06R1<br>SD_DRILL_4.2MM_12XD_A | 03295097 | 4,2<br>0.165   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0430-056-06R1<br>SD_DRILL_4.3MM_12XD_A | 03295098 | 4,3<br>0.169   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0437-056-06R1<br>SD_DRILL_11/64_12XD_A | 03323707 | 4,366<br>0.172 | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0440-056-06R1<br>SD_DRILL_4.4MM_12XD_A | 03295099 | 4,4<br>0.173   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0450-056-06R1<br>SD_DRILL_4.5MM_12XD_A | 03295100 | 4,5<br>0.177   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0460-056-06R1<br>SD_DRILL_4.6MM_12XD_A | 03295101 | 4,6<br>0.181   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598 | 36,0<br>1.417 | 64,0<br>2.520 | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |

| Megnevezés                                     | Cikkszám | DC             | LU            | OAL            | LFS            | LS            | LCF            | DMM          | Csúcs szög: | Bevonat | Furat tűrés |
|--|----------|----------------|---------------|----------------|----------------|---------------|----------------|--------------|-------------|---------|-------------|
|  |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch   |             |         |             |
| SD1112A-0470-056-06R1<br>SD_DRILL_4.7MM_12XD_A | 03295102 | 4,7<br>0.185   | 56,0<br>2.205 | 102,0<br>4.016 | 66,0<br>2.598  | 36,0<br>1.417 | 64,0<br>2.520  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0476-074-06R1<br>SD_DRILL_3/16_12XD_A  | 03323708 | 4,763<br>0.188 | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0480-074-06R1<br>SD_DRILL_4.8MM_12XD_A | 03295103 | 4,8<br>0.189   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0490-074-06R1<br>SD_DRILL_4.9MM_12XD_A | 03295104 | 4,9<br>0.193   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0500-074-06R1<br>SD_DRILL_5.0MM_12XD_A | 03295105 | 5,0<br>0.197   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0510-074-06R1<br>SD_DRILL_5.1MM_12XD_A | 03295106 | 5,1<br>0.201   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0516-074-06R1<br>SD_DRILL_13/64_12XD_A | 03323709 | 5,159<br>0.203 | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0520-074-06R1<br>SD_DRILL_5.2MM_12XD_A | 03295107 | 5,2<br>0.205   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0530-074-06R1<br>SD_DRILL_5.3MM_12XD_A | 03295108 | 5,3<br>0.209   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0540-074-06R1<br>SD_DRILL_5.4MM_12XD_A | 03295109 | 5,4<br>0.213   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0550-074-06R1<br>SD_DRILL_5.5MM_12XD_A | 03295110 | 5,5<br>0.217   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0556-074-06R1<br>SD_DRILL_7/32_12XD_A  | 03295111 | 5,556<br>0.219 | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0560-074-06R1<br>SD_DRILL_5.6MM_12XD_A | 03295112 | 5,6<br>0.220   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0570-074-06R1<br>SD_DRILL_5.7MM_12XD_A | 03295113 | 5,7<br>0.224   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0580-074-06R1<br>SD_DRILL_5.8MM_12XD_A | 03295114 | 5,8<br>0.228   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0590-074-06R1<br>SD_DRILL_5.9MM_12XD_A | 03295115 | 5,9<br>0.232   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0600-074-06R1<br>SD_DRILL_6.0MM_12XD_A | 03295116 | 6,0<br>0.236   | 74,0<br>2.913 | 121,0<br>4.764 | 85,0<br>3.346  | 36,0<br>1.417 | 83,0<br>3.268  | 6,0<br>0.236 | 140°        | TiAIN   | IT9         |
| SD1112A-0610-098-08R1<br>SD_DRILL_6.1MM_12XD_A | 03295117 | 6,1<br>0.240   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0620-098-08R1<br>SD_DRILL_6.2MM_12XD_A | 03295118 | 6,2<br>0.244   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0630-098-08R1<br>SD_DRILL_6.3MM_12XD_A | 03295119 | 6,3<br>0.248   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0635-098-08R1<br>SD_DRILL_1/4_12XD_A   | 03295120 | 6,35<br>0.250  | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0640-098-08R1<br>SD_DRILL_6.4MM_12XD_A | 03295121 | 6,4<br>0.252   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0650-098-08R1<br>SD_DRILL_6.5MM_12XD_A | 03295122 | 6,5<br>0.256   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0660-098-08R1<br>SD_DRILL_6.6MM_12XD_A | 03295123 | 6,6<br>0.260   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0670-098-08R1<br>SD_DRILL_6.7MM_12XD_A | 03295124 | 6,7<br>0.264   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0675-098-08R1<br>SD_DRILL_17/64_12XD_A | 03323710 | 6,747<br>0.266 | 98,0<br>3.858 | 148,0<br>5.827 | 128,0<br>5.039 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0680-098-08R1<br>SD_DRILL_6.8MM_12XD_A | 03295125 | 6,8<br>0.268   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0690-098-08R1<br>SD_DRILL_6.9MM_12XD_A | 03295126 | 6,9<br>0.272   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0700-098-08R1<br>SD_DRILL_7.0MM_12XD_A | 03295127 | 7,0<br>0.276   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0710-098-08R1<br>SD_DRILL_7.1MM_12XD_A | 03295128 | 7,1<br>0.280   | 98,0<br>3.858 | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |
| SD1112A-0714-098-08R1<br>SD_DRILL_9/32_12XD_A  | 03323711 | 7,144<br>0.281 | 98,0<br>3.858 | 148,0<br>5.827 | 128,0<br>5.039 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315 | 140°        | TiAIN   | IT9         |

| Megnevezés                                      | Cikkszám | DC              | LU             | OAL            | LFS            | LS            | LCF            | DMM           | Csúcs szög: | Bevonat | Furat típus |
|---|----------|-----------------|----------------|----------------|----------------|---------------|----------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |             |         |             |
| SD1112A-0730-098-08R1<br>SD_DRILL_7.3MM_12XD_A  | 03323712 | 7,3<br>0.287    | 98,0<br>3.858  | 148,0<br>5.827 | 128,0<br>5.039 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0740-098-08R1<br>SD_DRILL_7.4MM_12XD_A  | 03295129 | 7,4<br>0.291    | 98,0<br>3.858  | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0750-098-08R1<br>SD_DRILL_7.5MM_12XD_A  | 03295130 | 7,5<br>0.295    | 98,0<br>3.858  | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0754-098-08R1<br>SD_DRILL_19/64_12XD_A  | 03323713 | 7,541<br>0.297  | 98,0<br>3.858  | 148,0<br>5.827 | 128,0<br>5.039 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0780-098-08R1<br>SD_DRILL_7.8MM_12XD_A  | 03295131 | 7,8<br>0.307    | 98,0<br>3.858  | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0790-098-08R1<br>SD_DRILL_7.9MM_12XD_A  | 03295132 | 7,9<br>0.311    | 98,0<br>3.858  | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0794-098-08R1<br>SD_DRILL_5/16_12XD_A   | 03323714 | 7,938<br>0.313  | 98,0<br>3.858  | 148,0<br>5.827 | 128,0<br>5.039 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0800-098-08R1<br>SD_DRILL_8.0MM_12XD_A  | 03295133 | 8,0<br>0.315    | 98,0<br>3.858  | 148,0<br>5.827 | 112,0<br>4.409 | 36,0<br>1.417 | 110,0<br>4.331 | 8,0<br>0.315  | 140°        | TiAIN   | IT9         |
| SD1112A-0810-123-10R1<br>SD_DRILL_8.1MM_12XD_A  | 03295135 | 8,1<br>0.319    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0820-123-10R1<br>SD_DRILL_8.2MM_12XD_A  | 03295136 | 8,2<br>0.323    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0830-123-10R1<br>SD_DRILL_8.3MM_12XD_A  | 03295137 | 8,3<br>0.327    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0840-123-10R1<br>SD_DRILL_8.4MM_12XD_A  | 03295138 | 8,4<br>0.331    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0850-123-10R1<br>SD_DRILL_8.5MM_12XD_A  | 03295139 | 8,5<br>0.335    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0860-123-10R1<br>SD_DRILL_8.6MM_12XD_A  | 03295140 | 8,6<br>0.339    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0870-123-10R1<br>SD_DRILL_8.7MM_12XD_A  | 03295141 | 8,7<br>0.343    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0873-123-10R1<br>SD_DRILL_11/32_12XD_A  | 03323715 | 8,731<br>0.344  | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0880-123-10R1<br>SD_DRILL_8.8MM_12XD_A  | 03295142 | 8,8<br>0.346    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0900-123-10R1<br>SD_DRILL_9.0MM_12XD_A  | 03295143 | 9,0<br>0.354    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0913-123-10R1<br>SD_DRILL_23/64_12XD_A  | 03323716 | 9,128<br>0.359  | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0930-123-10R1<br>SD_DRILL_9.3MM_12XD_A  | 03295144 | 9,3<br>0.366    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0950-123-10R1<br>SD_DRILL_9.5MM_12XD_A  | 03295145 | 9,5<br>0.374    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0953-123-10R1<br>SD_DRILL_3/8_12XD_A    | 03323717 | 9,525<br>0.375  | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0970-123-10R1<br>SD_DRILL_9.7MM_12XD_A  | 03295146 | 9,7<br>0.382    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0980-123-10R1<br>SD_DRILL_9.8MM_12XD_A  | 03295147 | 9,8<br>0.386    | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-0992-123-10R1<br>SD_DRILL_25/64_12XD_A  | 03323718 | 9,922<br>0.391  | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-1000-123-10R1<br>SD_DRILL_10.0MM_12XD_A | 03295148 | 10,0<br>0.394   | 123,0<br>4.843 | 180,0<br>7.087 | 140,0<br>5.512 | 40,0<br>1.575 | 138,0<br>5.433 | 10,0<br>0.394 | 140°        | TiAIN   | IT9         |
| SD1112A-1020-140-12R1<br>SD_DRILL_10.2MM_12XD_A | 03295149 | 10,2<br>0.402   | 140,0<br>5.512 | 206,0<br>8.110 | 161,0<br>6.339 | 45,0<br>1.772 | 158,0<br>6.220 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1030-140-12R1<br>SD_DRILL_10.3MM_12XD_A | 03295150 | 10,3<br>0.406   | 140,0<br>5.512 | 206,0<br>8.110 | 161,0<br>6.339 | 45,0<br>1.772 | 158,0<br>6.220 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1032-140-12R1<br>SD_DRILL_13/32_12XD_A  | 03323719 | 10,319<br>0.406 | 140,0<br>5.512 | 206,0<br>8.110 | 161,0<br>6.339 | 45,0<br>1.772 | 158,0<br>6.220 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1050-140-12R1<br>SD_DRILL_10.5MM_12XD_A | 03295151 | 10,5<br>0.413   | 140,0<br>5.512 | 206,0<br>8.110 | 161,0<br>6.339 | 45,0<br>1.772 | 158,0<br>6.220 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1072-140-12R1<br>SD_DRILL_27/64_12XD_A  | 03323720 | 10,716<br>0.422 | 140,0<br>5.512 | 206,0<br>8.110 | 161,0<br>6.339 | 45,0<br>1.772 | 158,0<br>6.220 | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |

| Megnevezés                                      | Cikkszám | DC              | LU             | OAL             | LFS             | LS            | LCF             | DMM           | Csúcs szög: | Bevonat | Furat tőrés |
|---|----------|-----------------|----------------|-----------------|-----------------|---------------|-----------------|---------------|-------------|---------|-------------|
|   |          | mm<br>Inch      | mm<br>Inch     | mm<br>Inch      | mm<br>Inch      | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    |             |         |             |
| SD1112A-1080-140-12R1<br>SD_DRILL_10.8MM_12XD_A | 03295152 | 10,8<br>0.425   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1100-140-12R1<br>SD_DRILL_11.0MM_12XD_A | 03295153 | 11,0<br>0.433   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1111-140-12R1<br>SD_DRILL_7/16_12XD_A   | 03323722 | 11,113<br>0.438 | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1120-140-12R1<br>SD_DRILL_11.2MM_12XD_A | 03295154 | 11,2<br>0.441   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1150-140-12R1<br>SD_DRILL_11.5MM_12XD_A | 03295155 | 11,5<br>0.453   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1170-140-12R1<br>SD_DRILL_11.7MM_12XD_A | 03295156 | 11,7<br>0.461   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1180-140-12R1<br>SD_DRILL_11.8MM_12XD_A | 03295157 | 11,8<br>0.465   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1191-140-12R1<br>SD_DRILL_15/32_12XD_A  | 03323723 | 11,906<br>0.469 | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1200-140-12R1<br>SD_DRILL_12.0MM_12XD_A | 03295158 | 12,0<br>0.472   | 140,0<br>5.512 | 206,0<br>8.110  | 161,0<br>6.339  | 45,0<br>1.772 | 158,0<br>6.220  | 12,0<br>0.472 | 140°        | TiAIN   | IT9         |
| SD1112A-1220-168-14R1<br>SD_DRILL_12.2MM_12XD_A | 03295159 | 12,2<br>0.480   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1230-168-14R1<br>SD_DRILL_31/64_12XD_A  | 03295160 | 12,3<br>0.484   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1250-168-14R1<br>SD_DRILL_12.5MM_12XD_A | 03295161 | 12,5<br>0.492   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1270-168-14R1<br>SD_DRILL_1/2_12XD_A    | 03295162 | 12,7<br>0.500   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1300-168-14R1<br>SD_DRILL_13.0MM_12XD_A | 03295163 | 13,0<br>0.512   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1349-168-14R1<br>SD_DRILL_17/32_12XD_A  | 03323724 | 13,494<br>0.531 | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1350-168-14R1<br>SD_DRILL_13.5MM_12XD_A | 03295164 | 13,5<br>0.531   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1400-168-14R1<br>SD_DRILL_14.0MM_12XD_A | 03295165 | 14,0<br>0.551   | 168,0<br>6.614 | 230,0<br>9.055  | 185,0<br>7.283  | 45,0<br>1.772 | 182,0<br>7.165  | 14,0<br>0.551 | 140°        | TiAIN   | IT9         |
| SD1112A-1429-192-16R1<br>SD_DRILL_9/16_12XD_A   | 03295166 | 14,288<br>0.563 | 192,0<br>7.559 | 260,0<br>10.236 | 212,0<br>8.346  | 48,0<br>1.890 | 208,0<br>8.189  | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1112A-1450-192-16R1<br>SD_DRILL_14.5MM_12XD_A | 03295167 | 14,5<br>0.571   | 192,0<br>7.559 | 260,0<br>10.236 | 212,0<br>8.346  | 48,0<br>1.890 | 208,0<br>8.189  | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1112A-1500-192-16R1<br>SD_DRILL_15.0MM_12XD_A | 03295168 | 15,0<br>0.591   | 192,0<br>7.559 | 260,0<br>10.236 | 212,0<br>8.346  | 48,0<br>1.890 | 208,0<br>8.189  | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1112A-1550-192-16R1<br>SD_DRILL_15.5MM_12XD_A | 03295169 | 15,5<br>0.610   | 192,0<br>7.559 | 260,0<br>10.236 | 212,0<br>8.346  | 48,0<br>1.890 | 208,0<br>8.189  | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1112A-1588-192-16R1<br>SD_DRILL_5/8_12XD_A    | 03295170 | 15,875<br>0.625 | 192,0<br>7.559 | 260,0<br>10.236 | 212,0<br>8.346  | 48,0<br>1.890 | 208,0<br>8.189  | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1112A-1600-192-16R1<br>SD_DRILL_16.0MM_12XD_A | 03295171 | 16,0<br>0.630   | 192,0<br>7.559 | 260,0<br>10.236 | 212,0<br>8.346  | 48,0<br>1.890 | 208,0<br>8.189  | 16,0<br>0.630 | 140°        | TiAIN   | IT9         |
| SD1112A-1650-216-18R1<br>SD_DRILL_16.5MM_12XD_A | 03295172 | 16,5<br>0.650   | 216,0<br>8.504 | 285,0<br>11.220 | 237,0<br>9.331  | 48,0<br>1.890 | 234,0<br>9.213  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1112A-1700-216-18R1<br>SD_DRILL_17.0MM_12XD_A | 03295173 | 17,0<br>0.669   | 216,0<br>8.504 | 285,0<br>11.220 | 237,0<br>9.331  | 48,0<br>1.890 | 234,0<br>9.213  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1112A-1750-216-18R1<br>SD_DRILL_17.5MM_12XD_A | 03295174 | 17,5<br>0.689   | 216,0<br>8.504 | 285,0<br>11.220 | 237,0<br>9.331  | 48,0<br>1.890 | 234,0<br>9.213  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1112A-1800-216-18R1<br>SD_DRILL_18.0MM_12XD_A | 03295175 | 18,0<br>0.709   | 216,0<br>8.504 | 285,0<br>11.220 | 237,0<br>9.331  | 48,0<br>1.890 | 234,0<br>9.213  | 18,0<br>0.709 | 140°        | TiAIN   | IT9         |
| SD1112A-1900-238-20R1<br>SD_DRILL_19.0MM_12XD_A | 03295176 | 19,0<br>0.748   | 238,0<br>9.370 | 310,0<br>12.205 | 260,0<br>10.236 | 50,0<br>1.969 | 258,0<br>10.157 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |
| SD1112A-2000-238-20R1<br>SD_DRILL_20.0MM_12XD_A | 03295177 | 20,0<br>0.787   | 238,0<br>9.370 | 310,0<br>12.205 | 260,0<br>10.236 | 50,0<br>1.969 | 258,0<br>10.157 | 20,0<br>0.787 | 140°        | TiAIN   | IT9         |





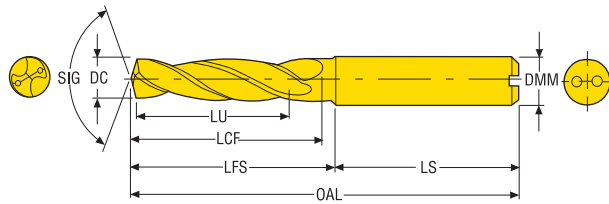
## Feedmax -P – egy átmérőjű fúrók

Nagy termelékenységre és alacsony furatonkénti költségekre tervezve, a legmodernebb keménymet-, bevonat- és geometria-technológia egyedülálló kombinációjával.

- Központosító geometria a központosító fúrési művelet szükségessége nélkül is kiváló minőségű furatokhoz.
- A speciális TiAlN bevonat nagy meleg keménységet biztosít a Seco Feedmax fúrók számára, mely az erős vágóéllel hosszú és kiszámítható élettartamot nyújt

## SD203A-P

Fúrási mélység ~ 3 x D – Metrikus



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 147-163 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés             | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD203A-0200-007-04R1-P | 03045918 | 2,0<br>0.079   | 7,0<br>0.276  | 41,0<br>1.614 | 14,0<br>0.551 | 27,0<br>1.063 | 11,0<br>0.433 | 4,0<br>0.157 |
| SD203A-0210-007-04R1-P | 03045919 | 2,1<br>0.083   | 7,0<br>0.276  | 41,0<br>1.614 | 14,0<br>0.551 | 27,0<br>1.063 | 11,0<br>0.433 | 4,0<br>0.157 |
| SD203A-0220-007-04R1-P | 03045920 | 2,2<br>0.087   | 7,0<br>0.276  | 41,0<br>1.614 | 14,0<br>0.551 | 27,0<br>1.063 | 11,0<br>0.433 | 4,0<br>0.157 |
| SD203A-0230-008-04R1-P | 03045921 | 2,3<br>0.091   | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0235-008-04R1-P | 03138154 | 2,35<br>0.093  | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0238-008-04R1-P | 03120476 | 2,381<br>0.094 | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0240-008-04R1-P | 03045922 | 2,4<br>0.094   | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0250-008-04R1-P | 03045923 | 2,5<br>0.098   | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0260-008-04R1-P | 03045924 | 2,6<br>0.102   | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0270-009-04R1-P | 03045925 | 2,7<br>0.106   | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0278-009-04R1-P | 03120495 | 2,778<br>0.109 | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0280-009-04R1-P | 03045926 | 2,8<br>0.110   | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0290-009-04R1-P | 03045927 | 2,9<br>0.114   | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0300-014-06R1-P | 03045928 | 3,0<br>0.118   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0310-014-06R1-P | 03045929 | 3,1<br>0.122   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0318-014-06R1-P | 03046061 | 3,175<br>0.125 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0320-014-06R1-P | 03045930 | 3,2<br>0.126   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0325-014-06R1-P | 03045931 | 3,25<br>0.128  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0330-014-06R1-P | 03045932 | 3,3<br>0.130   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0340-014-06R1-P | 03045933 | 3,4<br>0.134   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |

| Megnevezés             | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD203A-0350-014-06R1-P | 03045934 | 3,5<br>0.138   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0357-014-06R1-P | 03046062 | 3,572<br>0.141 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0360-014-06R1-P | 03045935 | 3,6<br>0.142   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0365-014-06R1-P | 03045936 | 3,65<br>0.144  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0370-014-06R1-P | 03045937 | 3,7<br>0.146   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0380-017-06R1-P | 03045938 | 3,8<br>0.150   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0390-017-06R1-P | 03045939 | 3,9<br>0.154   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0397-017-06R1-P | 03046063 | 3,97<br>0.156  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0400-017-06R1-P | 03045940 | 4,0<br>0.157   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0410-017-06R1-P | 03045941 | 4,1<br>0.161   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0420-017-06R1-P | 03045942 | 4,2<br>0.165   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0430-017-06R1-P | 03045943 | 4,3<br>0.169   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0437-017-06R1-P | 03046064 | 4,366<br>0.172 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0450-017-06R1-P | 03045944 | 4,5<br>0.177   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0460-017-06R1-P | 03045945 | 4,6<br>0.181   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0465-017-06R1-P | 03045946 | 4,65<br>0.183  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0470-017-06R1-P | 03045947 | 4,7<br>0.185   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0476-020-06R1-P | 03046065 | 4,763<br>0.188 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0480-020-06R1-P | 03045948 | 4,8<br>0.189   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0490-020-06R1-P | 03045949 | 4,9<br>0.193   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0500-020-06R1-P | 03045950 | 5,0<br>0.197   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0510-020-06R1-P | 03045951 | 5,1<br>0.201   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0516-020-06R1-P | 03046066 | 5,159<br>0.203 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0520-020-06R1-P | 03045952 | 5,2<br>0.205   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0530-020-06R1-P | 03045953 | 5,3<br>0.209   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0540-020-06R1-P | 03045954 | 5,4<br>0.213   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0550-020-06R1-P | 03045955 | 5,5<br>0.217   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0555-020-06R1-P | 03045956 | 5,55<br>0.219  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0556-020-06R1-P | 03046067 | 5,556<br>0.219 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0560-020-06R1-P | 03045957 | 5,6<br>0.220   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0570-020-06R1-P | 03045958 | 5,7<br>0.224   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |

| Megnevezés             | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-0580-020-06R1-P | 03045959 | 5,8<br>0.228   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-0590-020-06R1-P | 03045960 | 5,9<br>0.232   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-0595-020-06R1-P | 03046068 | 5,953<br>0.234 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-0600-020-06R1-P | 03045961 | 6,0<br>0.236   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-0610-024-08R1-P | 03045962 | 6,1<br>0.240   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0620-024-08R1-P | 03045963 | 6,2<br>0.244   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0630-024-08R1-P | 03045964 | 6,3<br>0.248   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0635-024-08R1-P | 03046069 | 6,35<br>0.250  | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0640-024-08R1-P | 03045965 | 6,4<br>0.252   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0650-024-08R1-P | 03045966 | 6,5<br>0.256   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0660-024-08R1-P | 03045967 | 6,6<br>0.260   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0670-024-08R1-P | 03045968 | 6,7<br>0.264   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0675-024-08R1-P | 03046070 | 6,747<br>0.266 | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0680-024-08R1-P | 03045969 | 6,8<br>0.268   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0690-024-08R1-P | 03045970 | 6,9<br>0.272   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0700-024-08R1-P | 03045971 | 7,0<br>0.276   | 24,0<br>0.945 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0710-029-08R1-P | 03045972 | 7,1<br>0.280   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0714-029-08R1-P | 03046071 | 7,144<br>0.281 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0720-029-08R1-P | 03045973 | 7,2<br>0.283   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0730-029-08R1-P | 03045974 | 7,3<br>0.287   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0740-029-08R1-P | 03045975 | 7,4<br>0.291   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0750-029-08R1-P | 03045976 | 7,5<br>0.295   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0754-029-08R1-P | 03046072 | 7,541<br>0.297 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0755-029-08R1-P | 03045977 | 7,55<br>0.297  | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0760-029-08R1-P | 03045978 | 7,6<br>0.299   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0770-029-08R1-P | 03045979 | 7,7<br>0.303   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0780-029-08R1-P | 03045980 | 7,8<br>0.307   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0790-029-08R1-P | 03045981 | 7,9<br>0.311   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0794-029-08R1-P | 03046073 | 7,938<br>0.313 | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0800-029-08R1-P | 03045982 | 8,0<br>0.315   | 29,0<br>1.142 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0810-035-10R1-P | 03045983 | 8,1<br>0.319   | 35,0<br>1.378 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |

| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-0820-035-10R1-P | 03045984 | 8,2<br>0.323    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0830-035-10R1-P | 03045985 | 8,3<br>0.327    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0833-035-10R1-P | 03046074 | 8,334<br>0.328  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0840-035-10R1-P | 03045986 | 8,4<br>0.331    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0850-035-10R1-P | 03045987 | 8,5<br>0.335    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0860-035-10R1-P | 03045988 | 8,6<br>0.339    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0870-035-10R1-P | 03045989 | 8,7<br>0.343    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0873-035-10R1-P | 03046075 | 8,731<br>0.344  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0880-035-10R1-P | 03045990 | 8,8<br>0.346    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0890-035-10R1-P | 03045991 | 8,9<br>0.350    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0900-035-10R1-P | 03045992 | 9,0<br>0.354    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0910-035-10R1-P | 03045993 | 9,1<br>0.358    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0913-035-10R1-P | 03046076 | 9,128<br>0.359  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0920-035-10R1-P | 03045994 | 9,2<br>0.362    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0930-035-10R1-P | 03045995 | 9,3<br>0.366    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0940-035-10R1-P | 03045996 | 9,4<br>0.370    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0950-035-10R1-P | 03045997 | 9,5<br>0.374    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0953-035-10R1-P | 03046077 | 9,525<br>0.375  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0955-035-10R1-P | 03045998 | 9,55<br>0.376   | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0960-035-10R1-P | 03045999 | 9,6<br>0.378    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0970-035-10R1-P | 03046000 | 9,7<br>0.382    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0980-035-10R1-P | 03046001 | 9,8<br>0.386    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0990-035-10R1-P | 03046002 | 9,9<br>0.390    | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0992-035-10R1-P | 03046078 | 9,922<br>0.391  | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-1000-035-10R1-P | 03046003 | 10,0<br>0.394   | 35,0<br>1.378 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-1020-040-12R1-P | 03046004 | 10,2<br>0.402   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1032-040-12R1-P | 03046079 | 10,319<br>0.406 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1040-040-12R1-P | 03046005 | 10,4<br>0.409   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1050-040-12R1-P | 03046006 | 10,5<br>0.413   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1060-040-12R1-P | 03046007 | 10,6<br>0.417   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1072-040-12R1-P | 03046080 | 10,716<br>0.422 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |

| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-1080-040-12R1-P | 03046008 | 10,8<br>0.425   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1090-040-12R1-P | 03046009 | 10,9<br>0.429   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1100-040-12R1-P | 03046010 | 11,0<br>0.433   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1110-040-12R1-P | 03046011 | 11,1<br>0.437   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1111-040-12R1-P | 03046081 | 11,113<br>0.438 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1120-040-12R1-P | 03046012 | 11,2<br>0.441   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1130-040-12R1-P | 03046013 | 11,3<br>0.445   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1140-040-12R1-P | 03046014 | 11,4<br>0.449   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1150-040-12R1-P | 03046015 | 11,5<br>0.453   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1151-040-12R1-P | 03046082 | 11,509<br>0.453 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1155-040-12R1-P | 03046016 | 11,55<br>0.455  | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1160-040-12R1-P | 03046017 | 11,6<br>0.457   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1170-040-12R1-P | 03046018 | 11,7<br>0.461   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1180-040-12R1-P | 03046019 | 11,8<br>0.465   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1190-040-12R1-P | 03046020 | 11,9<br>0.469   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1191-040-12R1-P | 03046083 | 11,906<br>0.469 | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1200-040-12R1-P | 03046021 | 12,0<br>0.472   | 40,0<br>1.575 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1210-043-14R1-P | 03046022 | 12,1<br>0.476   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1220-043-14R1-P | 03046023 | 12,2<br>0.480   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1230-043-14R1-P | 03046084 | 12,303<br>0.484 | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1240-043-14R1-P | 03046024 | 12,4<br>0.488   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1250-043-14R1-P | 03046025 | 12,5<br>0.492   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1260-043-14R1-P | 03046026 | 12,6<br>0.496   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1270-043-14R1-P | 03046085 | 12,7<br>0.500   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1275-043-14R1-P | 03046027 | 12,75<br>0.502  | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1280-043-14R1-P | 03046028 | 12,8<br>0.504   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1290-043-14R1-P | 03046029 | 12,9<br>0.508   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1300-043-14R1-P | 03046030 | 13,0<br>0.512   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1310-043-14R1-P | 03046031 | 13,1<br>0.516   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1320-043-14R1-P | 03046032 | 13,2<br>0.520   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1330-043-14R1-P | 03046033 | 13,3<br>0.524   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |

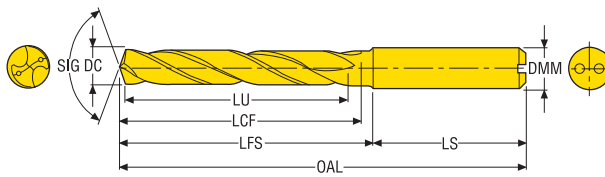
| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-1340-043-14R1-P | 03046034 | 13,4<br>0.528   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1349-043-14R1-P | 03046086 | 13,494<br>0.531 | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1350-043-14R1-P | 03046035 | 13,5<br>0.531   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1360-043-14R1-P | 03046036 | 13,6<br>0.535   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1370-043-14R1-P | 03046037 | 13,7<br>0.539   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1380-043-14R1-P | 03046038 | 13,8<br>0.543   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1390-043-14R1-P | 03046039 | 13,9<br>0.547   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1400-043-14R1-P | 03046040 | 14,0<br>0.551   | 43,0<br>1.693 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1420-045-16R1-P | 03046041 | 14,2<br>0.559   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1425-045-16R1-P | 03138155 | 14,25<br>0.561  | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1429-045-16R1-P | 03046087 | 14,288<br>0.563 | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1450-045-16R1-P | 03046042 | 14,5<br>0.571   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1470-045-16R1-P | 03046043 | 14,7<br>0.579   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1475-045-16R1-P | 03046044 | 14,75<br>0.581  | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1480-045-16R1-P | 03046045 | 14,8<br>0.583   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1500-045-16R1-P | 03046046 | 15,0<br>0.591   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1510-045-16R1-P | 03046047 | 15,1<br>0.594   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1530-045-16R1-P | 03046048 | 15,3<br>0.602   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1550-045-16R1-P | 03046049 | 15,5<br>0.610   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1570-045-16R1-P | 03046050 | 15,7<br>0.618   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1580-045-16R1-P | 03046051 | 15,8<br>0.622   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1588-045-16R1-P | 03046088 | 15,875<br>0.625 | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1600-045-16R1-P | 03046052 | 16,0<br>0.630   | 45,0<br>1.772 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1650-051-18R1-P | 03046053 | 16,5<br>0.650   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1700-051-18R1-P | 03046054 | 17,0<br>0.669   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1750-051-18R1-P | 03046055 | 17,5<br>0.689   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1800-051-18R1-P | 03046056 | 18,0<br>0.709   | 51,0<br>2.008 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1850-055-20R1-P | 03046057 | 18,5<br>0.728   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-1900-055-20R1-P | 03046058 | 19,0<br>0.748   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-1905-055-20R1-P | 03046089 | 19,05<br>0.750  | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-1950-055-20R1-P | 03046059 | 19,5<br>0.768   | 55,0<br>2.165 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |

| Megnevezés             | Cikkszám | DC                | LU                | OAL               | LFS               | LS                | LCF               | DMM               |
|------------------------|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
|                        |          | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> |
| SD203A-1980-055-20R1-P | 03138156 | 19,8<br>0.780     | 55,0<br>2.165     | 131,0<br>5.157    | 81,0<br>3.189     | 50,0<br>1.969     | 79,0<br>3.110     | 20,0<br>0.787     |
| SD203A-2000-055-20R1-P | 03046060 | 20,0<br>0.787     | 55,0<br>2.165     | 131,0<br>5.157    | 81,0<br>3.189     | 50,0<br>1.969     | 79,0<br>3.110     | 20,0<br>0.787     |



## SD205A-P

Fúrási mélység ~ 5 x D – Metrikus



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 149-165 old.
- Kőzetes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés             | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD205A-0200-012-04R1-P | 03046131 | 2,0<br>0.079   | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0210-012-04R1-P | 03046132 | 2,1<br>0.083   | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0220-012-04R1-P | 03046133 | 2,2<br>0.087   | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0230-012-04R1-P | 03046134 | 2,3<br>0.091   | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0238-013-04R1-P | 03120477 | 2,381<br>0.094 | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0240-013-04R1-P | 03046135 | 2,4<br>0.094   | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0250-013-04R1-P | 03046136 | 2,5<br>0.098   | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0260-013-04R1-P | 03046137 | 2,6<br>0.102   | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0270-015-04R1-P | 03046138 | 2,7<br>0.106   | 15,0<br>0.591 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 20,5<br>0.807 | 4,0<br>0.157 |
| SD205A-0278-015-04R1-P | 03120496 | 2,778<br>0.109 | 15,0<br>0.591 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 20,5<br>0.807 | 4,0<br>0.157 |
| SD205A-0280-015-04R1-P | 03046139 | 2,8<br>0.110   | 15,0<br>0.591 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 20,5<br>0.807 | 4,0<br>0.157 |
| SD205A-0290-015-04R1-P | 03046141 | 2,9<br>0.114   | 15,0<br>0.591 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 20,5<br>0.807 | 4,0<br>0.157 |
| SD205A-0300-023-06R1-P | 03046142 | 3,0<br>0.118   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0310-023-06R1-P | 03046143 | 3,1<br>0.122   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0318-023-06R1-P | 03046327 | 3,175<br>0.125 | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0320-023-06R1-P | 03046144 | 3,2<br>0.126   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0325-023-06R1-P | 03046145 | 3,25<br>0.128  | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0330-023-06R1-P | 03046146 | 3,3<br>0.130   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0340-023-06R1-P | 03046147 | 3,4<br>0.134   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0350-023-06R1-P | 03046148 | 3,5<br>0.138   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |

| Megnevezés             | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD205A-0357-023-06R1-P | 03046328 | 3,572<br>0.141 | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0360-023-06R1-P | 03046149 | 3,6<br>0.142   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0365-023-06R1-P | 03046150 | 3,65<br>0.144  | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0370-023-06R1-P | 03046151 | 3,7<br>0.146   | 23,0<br>0.906 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0380-029-06R1-P | 03046152 | 3,8<br>0.150   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0390-029-06R1-P | 03046153 | 3,9<br>0.154   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0397-029-06R1-P | 03046329 | 3,97<br>0.156  | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0400-029-06R1-P | 03046154 | 4,0<br>0.157   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0410-029-06R1-P | 03046155 | 4,1<br>0.161   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0420-029-06R1-P | 03046157 | 4,2<br>0.165   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0430-029-06R1-P | 03046158 | 4,3<br>0.169   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0437-029-06R1-P | 03046330 | 4,366<br>0.172 | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0440-029-06R1-P | 03046159 | 4,4<br>0.173   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0450-029-06R1-P | 03046160 | 4,5<br>0.177   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0460-029-06R1-P | 03046161 | 4,6<br>0.181   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0465-029-06R1-P | 03046162 | 4,65<br>0.183  | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0470-029-06R1-P | 03046163 | 4,7<br>0.185   | 29,0<br>1.142 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0476-035-06R1-P | 03046331 | 4,763<br>0.188 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0480-035-06R1-P | 03046164 | 4,8<br>0.189   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0490-035-06R1-P | 03046165 | 4,9<br>0.193   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0500-035-06R1-P | 03046166 | 5,0<br>0.197   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0510-035-06R1-P | 03046167 | 5,1<br>0.201   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0516-035-06R1-P | 03046332 | 5,159<br>0.203 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0520-035-06R1-P | 03046168 | 5,2<br>0.205   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0530-035-06R1-P | 03046169 | 5,3<br>0.209   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0540-035-06R1-P | 03046170 | 5,4<br>0.213   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0550-035-06R1-P | 03046171 | 5,5<br>0.217   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0555-035-06R1-P | 03046172 | 5,55<br>0.219  | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0556-035-06R1-P | 03046333 | 5,556<br>0.219 | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0560-035-06R1-P | 03046173 | 5,6<br>0.220   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0570-035-06R1-P | 03046174 | 5,7<br>0.224   | 35,0<br>1.378 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |

| Megnevezés             | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-0580-035-06R1-P | 03046175 | 5,8<br>0.228   | 35,0<br>1.378 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-0590-035-06R1-P | 03046176 | 5,9<br>0.232   | 35,0<br>1.378 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-0595-035-06R1-P | 03046334 | 5,953<br>0.234 | 35,0<br>1.378 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-0600-035-06R1-P | 03046177 | 6,0<br>0.236   | 35,0<br>1.378 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-0610-043-08R1-P | 03046179 | 6,1<br>0.240   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0620-043-08R1-P | 03046180 | 6,2<br>0.244   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0630-043-08R1-P | 03046181 | 6,3<br>0.248   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0635-043-08R1-P | 03046335 | 6,35<br>0.250  | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0640-043-08R1-P | 03046182 | 6,4<br>0.252   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0650-043-08R1-P | 03046183 | 6,5<br>0.256   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0660-043-08R1-P | 03046184 | 6,6<br>0.260   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0670-043-08R1-P | 03046185 | 6,7<br>0.264   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0675-043-08R1-P | 03046336 | 6,747<br>0.266 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0680-043-08R1-P | 03046186 | 6,8<br>0.268   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0690-043-08R1-P | 03046187 | 6,9<br>0.272   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0700-043-08R1-P | 03046188 | 7,0<br>0.276   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0710-043-08R1-P | 03046190 | 7,1<br>0.280   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0714-043-08R1-P | 03046337 | 7,144<br>0.281 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0720-043-08R1-P | 03046191 | 7,2<br>0.283   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0730-043-08R1-P | 03046192 | 7,3<br>0.287   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0740-043-08R1-P | 03046193 | 7,4<br>0.291   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0750-043-08R1-P | 03046194 | 7,5<br>0.295   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0754-043-08R1-P | 03046338 | 7,541<br>0.297 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0755-043-08R1-P | 03046195 | 7,55<br>0.297  | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0760-043-08R1-P | 03046196 | 7,6<br>0.299   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0770-043-08R1-P | 03046197 | 7,7<br>0.303   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0780-043-08R1-P | 03046198 | 7,8<br>0.307   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0790-043-08R1-P | 03046199 | 7,9<br>0.311   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0794-043-08R1-P | 03046339 | 7,938<br>0.313 | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0800-043-08R1-P | 03046200 | 8,0<br>0.315   | 43,0<br>1.693 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0810-049-10R1-P | 03046201 | 8,1<br>0.319   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |

| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-0820-049-10R1-P | 03046202 | 8,2<br>0.323    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0830-049-10R1-P | 03046203 | 8,3<br>0.327    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0833-049-10R1-P | 03046340 | 8,334<br>0.328  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0840-049-10R1-P | 03046204 | 8,4<br>0.331    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0850-049-10R1-P | 03046205 | 8,5<br>0.335    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0860-049-10R1-P | 03046206 | 8,6<br>0.339    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0870-049-10R1-P | 03046207 | 8,7<br>0.343    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0873-049-10R1-P | 03046341 | 8,731<br>0.344  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0880-049-10R1-P | 03046208 | 8,8<br>0.346    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0890-049-10R1-P | 03046209 | 8,9<br>0.350    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0900-049-10R1-P | 03046210 | 9,0<br>0.354    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0910-049-10R1-P | 03046211 | 9,1<br>0.358    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0913-049-10R1-P | 03046342 | 9,128<br>0.359  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0920-049-10R1-P | 03046212 | 9,2<br>0.362    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0930-049-10R1-P | 03046213 | 9,3<br>0.366    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0940-049-10R1-P | 03046214 | 9,4<br>0.370    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0950-049-10R1-P | 03046215 | 9,5<br>0.374    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0953-049-10R1-P | 03046343 | 9,525<br>0.375  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0955-049-10R1-P | 03046216 | 9,55<br>0.376   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0960-049-10R1-P | 03046217 | 9,6<br>0.378    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0970-049-10R1-P | 03046218 | 9,7<br>0.382    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0980-049-10R1-P | 03046219 | 9,8<br>0.386    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0990-049-10R1-P | 03046220 | 9,9<br>0.390    | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0992-049-10R1-P | 03046344 | 9,922<br>0.391  | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-1000-049-10R1-P | 03046221 | 10,0<br>0.394   | 49,0<br>1.929 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-1010-056-12R1-P | 03046222 | 10,1<br>0.398   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1020-056-12R1-P | 03046223 | 10,2<br>0.402   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1030-056-12R1-P | 03046224 | 10,3<br>0.406   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1032-056-12R1-P | 03046345 | 10,319<br>0.406 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1040-056-12R1-P | 03046225 | 10,4<br>0.409   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1050-056-12R1-P | 03046226 | 10,5<br>0.413   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |

| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-1060-056-12R1-P | 03046227 | 10,6<br>0.417   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1070-056-12R1-P | 03046228 | 10,7<br>0.421   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1072-056-12R1-P | 03046346 | 10,716<br>0.422 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1080-056-12R1-P | 03046229 | 10,8<br>0.425   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1090-056-12R1-P | 03046230 | 10,9<br>0.429   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1100-056-12R1-P | 03046231 | 11,0<br>0.433   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1110-056-12R1-P | 03046232 | 11,1<br>0.437   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1111-056-12R1-P | 03046347 | 11,113<br>0.438 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1120-056-12R1-P | 03046233 | 11,2<br>0.441   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1130-056-12R1-P | 03046234 | 11,3<br>0.445   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1140-056-12R1-P | 03046235 | 11,4<br>0.449   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1150-056-12R1-P | 03046236 | 11,5<br>0.453   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1151-056-12R1-P | 03046348 | 11,509<br>0.453 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1155-056-12R1-P | 03046237 | 11,55<br>0.455  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1160-056-12R1-P | 03046238 | 11,6<br>0.457   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1170-056-12R1-P | 03046239 | 11,7<br>0.461   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1180-056-12R1-P | 03046240 | 11,8<br>0.465   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1190-056-12R1-P | 03046241 | 11,9<br>0.469   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1191-056-12R1-P | 03046349 | 11,906<br>0.469 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1200-056-12R1-P | 03046242 | 12,0<br>0.472   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1210-060-14R1-P | 03046243 | 12,1<br>0.476   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1220-060-14R1-P | 03046244 | 12,2<br>0.480   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1225-060-14R1-P | 03046245 | 12,25<br>0.482  | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1230-060-14R1-P | 03138157 | 12,3<br>0.484   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1240-060-14R1-P | 03046246 | 12,4<br>0.488   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1250-060-14R1-P | 03046247 | 12,5<br>0.492   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1260-060-14R1-P | 03046248 | 12,6<br>0.496   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1270-060-14R1-P | 03120497 | 12,7<br>0.500   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1275-060-14R1-P | 03046249 | 12,75<br>0.502  | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1280-060-14R1-P | 03046250 | 12,8<br>0.504   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1290-060-14R1-P | 03046251 | 12,9<br>0.508   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |

| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-1300-060-14R1-P | 03046252 | 13,0<br>0.512   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1310-060-14R1-P | 03046253 | 13,1<br>0.516   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1320-060-14R1-P | 03046254 | 13,2<br>0.520   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1330-060-14R1-P | 03046255 | 13,3<br>0.524   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1340-060-14R1-P | 03046256 | 13,4<br>0.528   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1349-060-14R1-P | 03046350 | 13,494<br>0.531 | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1350-060-14R1-P | 03046257 | 13,5<br>0.531   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1355-060-14R1-P | 03138158 | 13,55<br>0.533  | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1360-060-14R1-P | 03046258 | 13,6<br>0.535   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1370-060-14R1-P | 03046259 | 13,7<br>0.539   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1380-060-14R1-P | 03046260 | 13,8<br>0.543   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1389-060-14R1-P | 03120498 | 13,891<br>0.547 | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1390-060-14R1-P | 03046261 | 13,9<br>0.547   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1400-060-14R1-P | 03046262 | 14,0<br>0.551   | 60,0<br>2.362 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1410-063-16R1-P | 03046263 | 14,1<br>0.555   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1420-063-16R1-P | 03046264 | 14,2<br>0.559   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1425-063-16R1-P | 03138159 | 14,25<br>0.561  | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1429-063-16R1-P | 03046351 | 14,288<br>0.563 | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1430-063-16R1-P | 03046265 | 14,3<br>0.563   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1440-063-16R1-P | 03046266 | 14,4<br>0.567   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1450-063-16R1-P | 03046267 | 14,5<br>0.571   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1460-063-16R1-P | 03046268 | 14,6<br>0.575   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1470-063-16R1-P | 03046269 | 14,7<br>0.579   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1475-063-16R1-P | 03046270 | 14,75<br>0.581  | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1480-063-16R1-P | 03046271 | 14,8<br>0.583   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1490-063-16R1-P | 03046272 | 14,9<br>0.587   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1500-063-16R1-P | 03046273 | 15,0<br>0.591   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1510-063-16R1-P | 03046274 | 15,1<br>0.594   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1520-063-16R1-P | 03046275 | 15,2<br>0.598   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1525-063-16R1-P | 03138160 | 15,25<br>0.600  | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1530-063-16R1-P | 03046276 | 15,3<br>0.602   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |

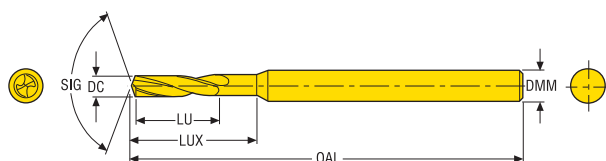
| Megnevezés             | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-1540-063-16R1-P | 03046277 | 15,4<br>0.606   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1550-063-16R1-P | 03046278 | 15,5<br>0.610   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1560-063-16R1-P | 03046280 | 15,6<br>0.614   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1570-063-16R1-P | 03046281 | 15,7<br>0.618   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1580-063-16R1-P | 03046282 | 15,8<br>0.622   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1588-063-16R1-P | 03046352 | 15,875<br>0.625 | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1590-063-16R1-P | 03046283 | 15,9<br>0.626   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1600-063-16R1-P | 03046284 | 16,0<br>0.630   | 63,0<br>2.480 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-1610-071-18R1-P | 03046285 | 16,1<br>0.634   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1620-071-18R1-P | 03046286 | 16,2<br>0.638   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1625-071-18R1-P | 03138161 | 16,25<br>0.640  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1630-071-18R1-P | 03046287 | 16,3<br>0.642   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1640-071-18R1-P | 03046288 | 16,4<br>0.646   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1650-071-18R1-P | 03046289 | 16,5<br>0.650   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1660-071-18R1-P | 03046290 | 16,6<br>0.654   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1667-071-18R1-P | 03120499 | 16,669<br>0.656 | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1670-071-18R1-P | 03046291 | 16,7<br>0.657   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1675-071-18R1-P | 03046292 | 16,75<br>0.659  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1680-071-18R1-P | 03046293 | 16,8<br>0.661   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1690-071-18R1-P | 03046294 | 16,9<br>0.665   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1700-071-18R1-P | 03046296 | 17,0<br>0.669   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1710-071-18R1-P | 03046297 | 17,1<br>0.673   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1720-071-18R1-P | 03046298 | 17,2<br>0.677   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1730-071-18R1-P | 03046299 | 17,3<br>0.681   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1740-071-18R1-P | 03046300 | 17,4<br>0.685   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1746-071-18R1-P | 03120500 | 17,463<br>0.688 | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1750-071-18R1-P | 03046301 | 17,5<br>0.689   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1760-071-18R1-P | 03046302 | 17,6<br>0.693   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1770-071-18R1-P | 03046303 | 17,7<br>0.697   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1780-071-18R1-P | 03046304 | 17,8<br>0.701   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |
| SD205A-1790-071-18R1-P | 03046305 | 17,9<br>0.705   | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740 | 48,0<br>1.890 | 93,0<br>3.661 | 18,0<br>0.709 |

| Megnevezés             | Cikkszám | DC             | LU            | OAL            | LFS            | LS            | LCF            | DMM           |
|------------------------|----------|----------------|---------------|----------------|----------------|---------------|----------------|---------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |
| SD205A-1800-071-18R1-P | 03046306 | 18,0<br>0.709  | 71,0<br>2.795 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 |
| SD205A-1810-077-20R1-P | 03046307 | 18,1<br>0.713  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1820-077-20R1-P | 03046308 | 18,2<br>0.717  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1830-077-20R1-P | 03046309 | 18,3<br>0.720  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1840-077-20R1-P | 03046310 | 18,4<br>0.724  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1850-077-20R1-P | 03046311 | 18,5<br>0.728  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1860-077-20R1-P | 03046312 | 18,6<br>0.732  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1870-077-20R1-P | 03046313 | 18,7<br>0.736  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1880-077-20R1-P | 03046314 | 18,8<br>0.740  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1890-077-20R1-P | 03046315 | 18,9<br>0.744  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1900-077-20R1-P | 03046316 | 19,0<br>0.748  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1905-077-20R1-P | 03046353 | 19,05<br>0.750 | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1910-077-20R1-P | 03046317 | 19,1<br>0.752  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1920-077-20R1-P | 03046318 | 19,2<br>0.756  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1930-077-20R1-P | 03046319 | 19,3<br>0.760  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1940-077-20R1-P | 03046320 | 19,4<br>0.764  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1950-077-20R1-P | 03046321 | 19,5<br>0.768  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1960-077-20R1-P | 03046322 | 19,6<br>0.772  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1970-077-20R1-P | 03046323 | 19,7<br>0.776  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1980-077-20R1-P | 03046324 | 19,8<br>0.780  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1990-077-20R1-P | 03046325 | 19,9<br>0.783  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-2000-077-20R1-P | 03046326 | 20,0<br>0.787  | 77,0<br>3.031 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |



## SD206

Fúrási mélység ~ 6 x D

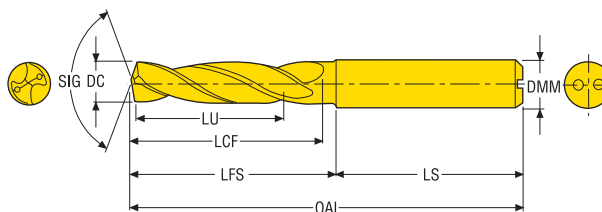


- Hengeres szár
- Külső hűtés
- Csúcs szög: 140°
- Bevonat: TiAIN
- Furat tűrés: IT9
- Forgácsolási adatokat lásd a 151. old.

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

## SD206A

Fúrási mélység ~ 6 x D

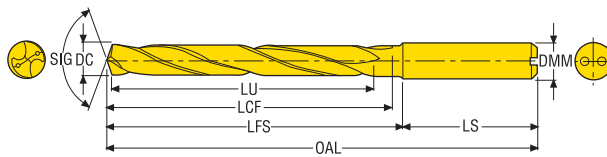


- Hengeres szár
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN
- Furat tűrés: IT9
- Forgácsolási adatokat lásd a 152 old.

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

## SD207A-P

Fúrási mélység ~ 7 x D – Metrikus



- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN
- Furat tűrés: IT9
- Forgácsolási adatokat lásd a 153 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

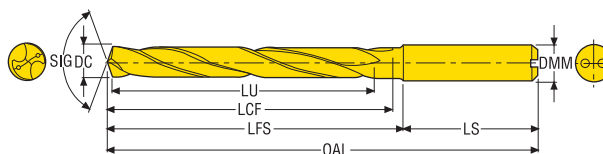
| Megnevezés             | Cikkszám | DC            | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|---------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD207A-0300-030-06R1-P | 03046358 | 3,0<br>0.118  | 30,0<br>1.181 | 74,0<br>2.913  | 38,0<br>1.496 | 36,0<br>1.417 | 36,0<br>1.417 | 6,0<br>0.236  |
| SD207A-0330-030-06R1-P | 03046359 | 3,3<br>0.130  | 30,0<br>1.181 | 74,0<br>2.913  | 38,0<br>1.496 | 36,0<br>1.417 | 36,0<br>1.417 | 6,0<br>0.236  |
| SD207A-0350-030-06R1-P | 03046360 | 3,5<br>0.138  | 30,0<br>1.181 | 74,0<br>2.913  | 38,0<br>1.496 | 36,0<br>1.417 | 36,0<br>1.417 | 6,0<br>0.236  |
| SD207A-0400-037-06R1-P | 03046361 | 4,0<br>0.157  | 37,0<br>1.457 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 43,0<br>1.693 | 6,0<br>0.236  |
| SD207A-0450-037-06R1-P | 03046412 | 4,5<br>0.177  | 37,0<br>1.457 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 43,0<br>1.693 | 6,0<br>0.236  |
| SD207A-0480-045-06R1-P | 03046413 | 4,8<br>0.189  | 45,0<br>1.772 | 94,0<br>3.701  | 58,0<br>2.283 | 36,0<br>1.417 | 56,0<br>2.205 | 6,0<br>0.236  |
| SD207A-0500-045-06R1-P | 03046414 | 5,0<br>0.197  | 45,0<br>1.772 | 94,0<br>3.701  | 58,0<br>2.283 | 36,0<br>1.417 | 56,0<br>2.205 | 6,0<br>0.236  |
| SD207A-0520-045-06R1-P | 03046362 | 5,2<br>0.205  | 45,0<br>1.772 | 94,0<br>3.701  | 58,0<br>2.283 | 36,0<br>1.417 | 56,0<br>2.205 | 6,0<br>0.236  |
| SD207A-0550-045-06R1-P | 03046363 | 5,5<br>0.217  | 45,0<br>1.772 | 94,0<br>3.701  | 58,0<br>2.283 | 36,0<br>1.417 | 56,0<br>2.205 | 6,0<br>0.236  |
| SD207A-0580-045-06R1-P | 03046407 | 5,8<br>0.228  | 45,0<br>1.772 | 94,0<br>3.701  | 58,0<br>2.283 | 36,0<br>1.417 | 56,0<br>2.205 | 6,0<br>0.236  |
| SD207A-0600-045-06R1-P | 03046364 | 6,0<br>0.236  | 45,0<br>1.772 | 94,0<br>3.701  | 58,0<br>2.283 | 36,0<br>1.417 | 56,0<br>2.205 | 6,0<br>0.236  |
| SD207A-0635-057-08R1-P | 03046365 | 6,35<br>0.250 | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 67,0<br>2.638 | 8,0<br>0.315  |
| SD207A-0650-057-08R1-P | 03046366 | 6,5<br>0.256  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 67,0<br>2.638 | 8,0<br>0.315  |
| SD207A-0680-057-08R1-P | 03046367 | 6,8<br>0.268  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 67,0<br>2.638 | 8,0<br>0.315  |
| SD207A-0690-057-08R1-P | 03046368 | 6,9<br>0.272  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 67,0<br>2.638 | 8,0<br>0.315  |
| SD207A-0700-057-08R1-P | 03046369 | 7,0<br>0.276  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 67,0<br>2.638 | 8,0<br>0.315  |
| SD207A-0750-057-08R1-P | 03046370 | 7,5<br>0.295  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 72,0<br>2.835 | 8,0<br>0.315  |
| SD207A-0780-057-08R1-P | 03046371 | 7,8<br>0.307  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 72,0<br>2.835 | 8,0<br>0.315  |
| SD207A-0800-057-08R1-P | 03046372 | 8,0<br>0.315  | 57,0<br>2.244 | 110,0<br>4.331 | 74,0<br>2.913 | 36,0<br>1.417 | 72,0<br>2.835 | 8,0<br>0.315  |
| SD207A-0850-062-10R1-P | 03046373 | 8,5<br>0.335  | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228 | 40,0<br>1.575 | 80,0<br>3.150 | 10,0<br>0.394 |
| SD207A-0860-062-10R1-P | 03046374 | 8,6<br>0.339  | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228 | 40,0<br>1.575 | 80,0<br>3.150 | 10,0<br>0.394 |

| Megnevezés             | Cikkszám | DC             | LU            | OAL            | LFS            | LS            | LCF            | DMM           |
|------------------------|----------|----------------|---------------|----------------|----------------|---------------|----------------|---------------|
|                        |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |
| SD207A-0870-062-10R1-P | 03046411 | 8,7<br>0.343   | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-0880-062-10R1-P | 03046408 | 8,8<br>0.346   | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-0900-062-10R1-P | 03046375 | 9,0<br>0.354   | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-0950-062-10R1-P | 03046376 | 9,5<br>0.374   | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-0953-062-10R1-P | 03046377 | 9,525<br>0.375 | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-0975-062-10R1-P | 03046402 | 9,75<br>0.384  | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-0980-062-10R1-P | 03046403 | 9,8<br>0.386   | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-1000-062-10R1-P | 03046378 | 10,0<br>0.394  | 62,0<br>2.441 | 122,0<br>4.803 | 82,0<br>3.228  | 40,0<br>1.575 | 80,0<br>3.150  | 10,0<br>0.394 |
| SD207A-1020-072-12R1-P | 03046379 | 10,2<br>0.402  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1040-072-12R1-P | 03046401 | 10,4<br>0.409  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1050-072-12R1-P | 03046380 | 10,5<br>0.413  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1080-072-12R1-P | 03046404 | 10,8<br>0.425  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1100-072-12R1-P | 03046381 | 11,0<br>0.433  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1150-072-12R1-P | 03046382 | 11,5<br>0.453  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1180-072-12R1-P | 03046405 | 11,8<br>0.465  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1200-072-12R1-P | 03046383 | 12,0<br>0.472  | 72,0<br>2.835 | 141,0<br>5.551 | 96,0<br>3.780  | 45,0<br>1.772 | 94,0<br>3.701  | 12,0<br>0.472 |
| SD207A-1225-083-14R1-P | 03046415 | 12,25<br>0.482 | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1250-083-14R1-P | 03046384 | 12,5<br>0.492  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1270-083-14R1-P | 03046385 | 12,7<br>0.500  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1280-083-14R1-P | 03046416 | 12,8<br>0.504  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1300-083-14R1-P | 03046386 | 13,0<br>0.512  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1350-083-14R1-P | 03046387 | 13,5<br>0.531  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1380-083-14R1-P | 03046409 | 13,8<br>0.543  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1400-083-14R1-P | 03046388 | 14,0<br>0.551  | 83,0<br>3.268 | 155,0<br>6.102 | 110,0<br>4.331 | 45,0<br>1.772 | 108,0<br>4.252 | 14,0<br>0.551 |
| SD207A-1425-092-16R1-P | 03046417 | 14,25<br>0.561 | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |
| SD207A-1450-092-16R1-P | 03046389 | 14,5<br>0.571  | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |
| SD207A-1480-092-16R1-P | 03046418 | 14,8<br>0.583  | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |
| SD207A-1500-092-16R1-P | 03046390 | 15,0<br>0.591  | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |
| SD207A-1550-092-16R1-P | 03046391 | 15,5<br>0.610  | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |
| SD207A-1580-092-16R1-P | 03046410 | 15,8<br>0.622  | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |
| SD207A-1600-092-16R1-P | 03046392 | 16,0<br>0.630  | 92,0<br>3.622 | 171,0<br>6.732 | 123,0<br>4.843 | 48,0<br>1.890 | 121,0<br>4.764 | 16,0<br>0.630 |

| Megnevezés             | Cikkszám | DC             | LU             | OAL            | LFS            | LS            | LCF            | DMM           |
|------------------------|----------|----------------|----------------|----------------|----------------|---------------|----------------|---------------|
|                        |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |
| SD207A-1650-103-18R1-P | 03046393 | 16,5<br>0.650  | 103,0<br>4.055 | 185,0<br>7.283 | 137,0<br>5.394 | 48,0<br>1.890 | 135,0<br>5.315 | 18,0<br>0.709 |
| SD207A-1680-103-18R1-P | 03046419 | 16,8<br>0.661  | 103,0<br>4.055 | 185,0<br>7.283 | 137,0<br>5.394 | 48,0<br>1.890 | 135,0<br>5.315 | 18,0<br>0.709 |
| SD207A-1700-103-18R1-P | 03046394 | 17,0<br>0.669  | 103,0<br>4.055 | 185,0<br>7.283 | 137,0<br>5.394 | 48,0<br>1.890 | 135,0<br>5.315 | 18,0<br>0.709 |
| SD207A-1750-103-18R1-P | 03046395 | 17,5<br>0.689  | 103,0<br>4.055 | 185,0<br>7.283 | 137,0<br>5.394 | 48,0<br>1.890 | 135,0<br>5.315 | 18,0<br>0.709 |
| SD207A-1780-103-18R1-P | 03046420 | 17,8<br>0.701  | 103,0<br>4.055 | 185,0<br>7.283 | 137,0<br>5.394 | 48,0<br>1.890 | 135,0<br>5.315 | 18,0<br>0.709 |
| SD207A-1800-103-18R1-P | 03046396 | 18,0<br>0.709  | 103,0<br>4.055 | 185,0<br>7.283 | 137,0<br>5.394 | 48,0<br>1.890 | 135,0<br>5.315 | 18,0<br>0.709 |
| SD207A-1850-112-20R1-P | 03046397 | 18,5<br>0.728  | 112,0<br>4.409 | 200,0<br>7.874 | 150,0<br>5.906 | 50,0<br>1.969 | 148,0<br>5.827 | 20,0<br>0.787 |
| SD207A-1880-112-20R1-P | 03046421 | 18,8<br>0.740  | 112,0<br>4.409 | 200,0<br>7.874 | 150,0<br>5.906 | 50,0<br>1.969 | 148,0<br>5.827 | 20,0<br>0.787 |
| SD207A-1900-112-20R1-P | 03046398 | 19,0<br>0.748  | 112,0<br>4.409 | 200,0<br>7.874 | 150,0<br>5.906 | 50,0<br>1.969 | 148,0<br>5.827 | 20,0<br>0.787 |
| SD207A-1905-112-20R1-P | 03046399 | 19,05<br>0.750 | 112,0<br>4.409 | 200,0<br>7.874 | 150,0<br>5.906 | 50,0<br>1.969 | 148,0<br>5.827 | 20,0<br>0.787 |
| SD207A-1980-112-20R1-P | 03046406 | 19,8<br>0.780  | 112,0<br>4.409 | 200,0<br>7.874 | 150,0<br>5.906 | 50,0<br>1.969 | 148,0<br>5.827 | 20,0<br>0.787 |
| SD207A-2000-112-20R1-P | 03046400 | 20,0<br>0.787  | 112,0<br>4.409 | 200,0<br>7.874 | 150,0<br>5.906 | 50,0<br>1.969 | 148,0<br>5.827 | 20,0<br>0.787 |

## SD216A

Fúrási mélység ~ 16 x D

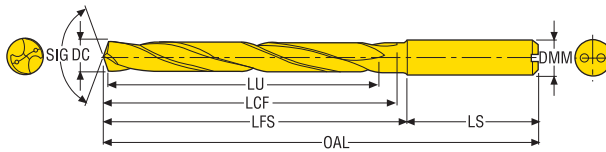


- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 136°
- Bevonat: TiAlN + TiN
- Furat tűrés: IT9
- Forgácsolási adatokat lásd a 154. old.
- Kőzet átmérőkhöz lásd a MyDesign szoftvert.

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

## SD230A

Fúrási mélység ~ 30 x D



- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 136°
- Bevonat: TiAlN + TiN
- Furat tűrés: IT9
- Forgácsolási adatokat lásd a 155 old.
- Közttes átmérőkhöz lásd a MyDesign szoftvert.

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



## Feedmax™ SD245A

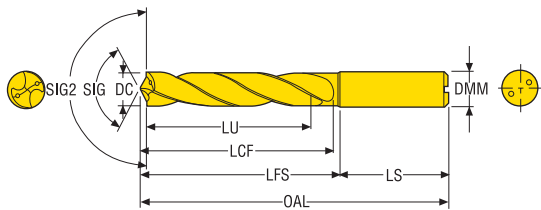
A Feedmax SD245A tömör keményfém fúrók a szabálytalan kimenettel és keresztező furatokkal megszakított furatkészítési alkalmazásokban magas szintű stabilitást és általánosan jobb megmunkálási teljesítményt nyújtanak. A kiváló furatgeometriát az alábbi jellemzők biztosítják a felhasználó számára:

- Négy élszalag
- Optimalizált központosító csúcs
- Rendkívül kopásálló TiAlN+TiN bevonat
- Továbbfejlesztett élkialakítás



## SD245A

Fúrási mélység ~ 5 x D



- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 140°/180°
- Bevonat: TiAlN + TiN
- Furat tűrés: IT8
- Forgácsolási adatokat lásd a 156 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés              | Cikkszám | DC               | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|------------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                         |          | mm<br>Inch       | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD245A-5.0-32-6R1       | 02691683 | 5,0<br>0.197     | 32,0<br>1.260 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD245A-6.0-32-6R1       | 02691684 | 6,0<br>0.236     | 32,0<br>1.260 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD245A-02500-138-0315R1 | 02691686 | 6,35<br>0.2500   | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-6.5-35-8R1       | 02691687 | 6,5<br>0.256     | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-02656-157-0315R1 | 02691688 | 6,747<br>0.2656  | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-6.8-40-8R1       | 02691689 | 6,8<br>0.268     | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-7.0-40-8R1       | 02691690 | 7,0<br>0.276     | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-02813-157-0315R1 | 02691691 | 7,144<br>0.2813  | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-7.5-40-8R1       | 02691692 | 7,5<br>0.295     | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-03125-165-0315R1 | 02691693 | 7,938<br>0.3125  | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-8.0-42-8R1       | 02691694 | 8,0<br>0.315     | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD245A-8.5-42-10R1      | 02691695 | 8,5<br>0.335     | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD245A-9.0-45-10R1      | 02546059 | 9,0<br>0.354     | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD245A-9.5-45-10R1      | 02691696 | 9,5<br>0.374     | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD245A-03750-189-0394R1 | 02691697 | 9,525<br>0.3750  | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD245A-10.0-48-10R1     | 02536888 | 10,0<br>0.394    | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD245A-10.2-48-12R1     | 02691699 | 10,2<br>0.402    | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD245A-04063-189-0472R1 | 02691700 | 10,319<br>0.4063 | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD245A-10.5-48-12R1     | 02691701 | 10,5<br>0.413    | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD245A-11.0-56-12R1     | 02561860 | 11,0<br>0.433    | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD245A-04375-221-0472R1 | 02691702 | 11,113<br>0.4375 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |

| Megnevezés              | Cikkszám | DC               | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|------------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                         |          | mm<br>Inch       | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD245A-11.5-56-12R1     | 02691704 | 11,5<br>0.453    | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD245A-12.0-56-12R1     | 02691705 | 12,0<br>0.472    | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD245A-12.5-56-14R1     | 02691706 | 12,5<br>0.492    | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD245A-0500-221-0551R1  | 02691707 | 12,7<br>0.500    | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD245A-13.0-56-14R1     | 02691708 | 13,0<br>0.512    | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD245A-05312-232-0551R1 | 02691709 | 13,494<br>0.5312 | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD245A-13.5-59-14R1     | 02691710 | 13,5<br>0.531    | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD245A-14.0-59-14R1     | 02691711 | 14,0<br>0.551    | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |



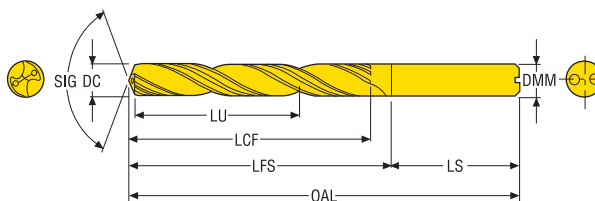
## Feedmax™ SD265A

A Seco Feedmax SD265A IT 7 nagy pontosságú fúrók kifogástalan pontosságot nyújtanak. Mindemellett egyetlen SD265A fúró több szerszámot is kivált és egyszerűbbé teszi a bonyolult fúrési feladatokat. Az alábbi jellemzők biztosítják az egyetlen menetben történő furatkészítés lehetőségét:

- Optimalizált fúrógeometria és központosító fúróhegy
- Összesen 6 élszalag
- Szűk gyártási tűrések ( $\pm 3\mu$ )
- TiAlN bevonat az alacsony súrlódás és a kiváló kopásállóság érdekében

## SD265A

Fúrási mélység ~ 5 x D



- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN + TiN
- Furat tűrés: IT7
- Forgácsolási adatokat lásd a 157 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.
- Szár szabvány ANSI / ASME B18.8.2-1995.

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

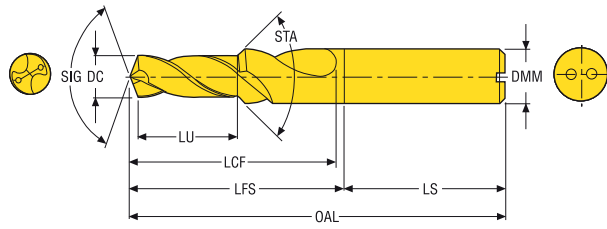


## Feedmax™ – Élettörő fúrók

A Seco Feedmax™ élettörő fúrók a hatékonyság maximalizálása érdekében egyetlen műveletbe kombinálják fúrást és az élettörést. A standard termékínálat M4-től M16 méretig lefedi az általános metrikus menetek előfúrásai alkalmazásait.

- A különleges kialakítás minimálisra csökkenti a furatonkénti költséget, és növeli a termelékenységet
- A speciális alacsony súrlódású bevonat nagy melegkeménységet és kiváló forgácskidobást biztosít
- A központosító geometria 45°-os (90° bezárt szögű) letörési szöge kiváló furatminőséget nyújt

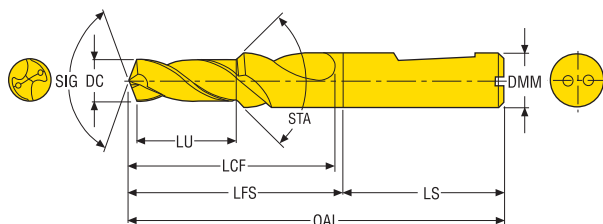
## Életörő fúró - M4-M16 menet



- Hengeres szár DIN 6537A
- Belső hűtés
- Bevonat: TiAlN + TiN
- Furat tűrés: IT8-9
- Included chamfer angle = 90°
- Forgácsolási adatokat lásd a 147, 148 old.

| Megnevezés                 | Cikkszám | Menetfúró típus                 | Menetfúró méret | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|----------------------------|----------|---------------------------------|-----------------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                            |          |                                 |                 | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-C45-3.3-11.4-6R1    | 02500320 | Normál osztás<br>Metrikus menet | M4              | 3,3<br>0.130   | 11,4<br>0.449 | 66,0<br>2.598  | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236  |
| SD203A-C45-3.4-11.4-6R1    | 02500323 | Normál osztás<br>Metrikus menet | M4              | 3,4<br>0.134   | 11,4<br>0.449 | 66,0<br>2.598  | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236  |
| SD203A-C45-4.2-13.6-6R1    | 02500324 | Normál osztás<br>Metrikus menet | M5              | 4,2<br>0.165   | 13,6<br>0.535 | 66,0<br>2.598  | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236  |
| SD203A-C45-4.3-13.6-6R1    | 02500325 | Normál osztás<br>Metrikus menet | M5              | 4,3<br>0.169   | 13,6<br>0.535 | 66,0<br>2.598  | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236  |
| SD203A-C45-5.0-16.5-8R1    | 02500326 | Normál osztás<br>Metrikus menet | M6              | 5,0<br>0.197   | 16,5<br>0.650 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 28,0<br>1.102 | 8,0<br>0.315  |
| SD203A-C45-5.1-16.5-8R1    | 02500327 | Normál osztás<br>Metrikus menet | M6              | 5,1<br>0.201   | 16,5<br>0.650 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 28,0<br>1.102 | 8,0<br>0.315  |
| SD203A-C45-6.8-21-10R1     | 02500328 | Normál osztás<br>Metrikus menet | M8              | 6,8<br>0.268   | 21,0<br>0.827 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 34,0<br>1.339 | 10,0<br>0.394 |
| SD203A-C45-6.9-21-10R1     | 02500330 | Normál osztás<br>Metrikus menet | M8              | 6,9<br>0.272   | 21,0<br>0.827 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 34,0<br>1.339 | 10,0<br>0.394 |
| SD203A-C45-7.0-21-10R1     | 02500331 | Finom menet<br>Metrikus menet   | M8x1.0          | 7,0<br>0.276   | 21,0<br>0.827 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 34,0<br>1.339 | 10,0<br>0.394 |
| SD203A-C45-8.5-25.5-12R1   | 02500333 | Normál osztás<br>Metrikus menet | M10             | 8,5<br>0.335   | 25,5<br>1.004 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 47,0<br>1.850 | 12,0<br>0.472 |
| SD203A-C45-8.7-25.5-12R1   | 02500334 | Normál osztás<br>Metrikus menet | M10             | 8,7<br>0.343   | 25,5<br>1.004 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 47,0<br>1.850 | 12,0<br>0.472 |
| SD203A-C45-9.0-25.5-12R1   | 02500340 | Finom menet<br>Metrikus menet   | M10x1.0         | 9,0<br>0.354   | 25,5<br>1.004 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 47,0<br>1.850 | 12,0<br>0.472 |
| SD203A-C45-10.2-30.0-14R1  | 02500342 | Normál osztás<br>Metrikus menet | M12             | 10,2<br>0.402  | 30,0<br>1.181 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 55,0<br>2.165 | 14,0<br>0.551 |
| SD203A-C45-10.4-30.0-14R1  | 02500343 | Normál osztás<br>Metrikus menet | M12             | 10,4<br>0.409  | 30,0<br>1.181 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 55,0<br>2.165 | 14,0<br>0.551 |
| SD203A-C45-10.5-30.0-14R1  | 02500344 | Finom menet<br>Metrikus menet   | M12x1.5         | 10,5<br>0.413  | 34,5<br>1.358 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 55,0<br>2.165 | 14,0<br>0.551 |
| SD203A-C45-12.0-34.5-16R1  | 02500346 | Normál osztás<br>Metrikus menet | M14             | 12,0<br>0.472  | 34,5<br>1.358 | 115,0<br>4.528 | 70,0<br>2.756 | 45,0<br>1.772 | 60,0<br>2.362 | 16,0<br>0.630 |
| SD203A-C45-12.25-34.5-16R1 | 02500348 | Normál osztás<br>Metrikus menet | M14             | 12,25<br>0.482 | 34,5<br>1.358 | 115,0<br>4.528 | 70,0<br>2.756 | 45,0<br>1.772 | 60,0<br>2.362 | 16,0<br>0.630 |
| SD203A-C45-12.5-34.5-16R1  | 02500349 | Finom menet<br>Metrikus menet   | M14x1.5         | 12,5<br>0.492  | 34,5<br>1.358 | 115,0<br>4.528 | 70,0<br>2.756 | 45,0<br>1.772 | 60,0<br>2.362 | 16,0<br>0.630 |
| SD203A-C45-14.0-38.5-18R1  | 02500350 | Normál osztás<br>Metrikus menet | M16             | 14,0<br>0.551  | 38,5<br>1.516 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 65,0<br>2.559 | 18,0<br>0.709 |
| SD203A-C45-14.25-38.5-18R1 | 02500354 | Normál osztás<br>Metrikus menet | M16             | 14,25<br>0.561 | 38,5<br>1.516 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 65,0<br>2.559 | 18,0<br>0.709 |
| SD203A-C45-14.5-38.5-18R1  | 02500356 | Finom menet<br>Metrikus menet   | M16x1.5         | 14,5<br>0.571  | 38,5<br>1.516 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 65,0<br>2.559 | 18,0<br>0.709 |

## Életőrő fúró - M4-M16 menet

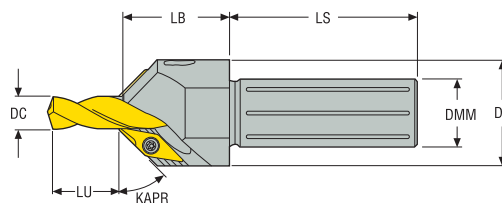


- Whistle Notch szár DIN 6537B
- Belső hűtés
- Bevonat: TiAlN + TiN
- Furat tűrés: IT8-9
- Included chamfer angle = 90°
- Forgácsolási adatokat lásd a 147, 148 old.

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

## Életörő modul az Universal és Feedmax fúrókhoz

Metrikus



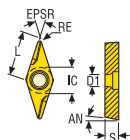
## Fúrási mélység LU

| Megnevezés     | Cikkszám | DC         | 3 x D<br>LU<br>(min-max) | 5 x D<br>LU<br>(min-max) | 7 x D<br>LU<br>(min-max) | Max. letörési mélység | 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  |

## Pótalkatrészek

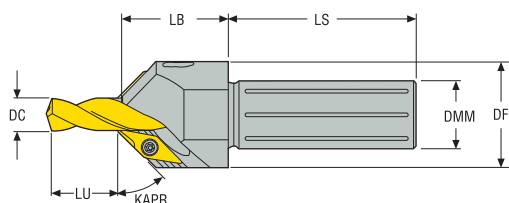
| Fúró átmérő<br>(mm) | Lapka kulcs | Lapka csavar | Rögzítő kulcs | Rögzítő csavar | Kazetta     |
|---------------------|-------------|--------------|---------------|----------------|-------------|
|                     |             |              |               |                |             |
|                     | Váltólapka  | Váltólapka   | Modul         | Modul          | Modul       |
| 4,00 - 16,00        | T07P-2      | C02205-T07P  | H1.5-2D       | SH3040         | SD200-3x7.3 |

| Tűrések:<br>mm                         | Méret                 | IC<br>mm | L<br>mm | S<br>mm | D1<br>mm | RE<br>mm |
|--|-----------------------|----------|---------|---------|----------|----------|
| IC = ±0,025<br>S = ±0,07<br>RE = ±0,10 | C45                   | 5,556    | 9,000   | 2,500   | 2,900    | 0,200    |
|  | Minőség: T400D        |          |         |         |          |          |
|  | Megnevezés: SD200-C45 |          |         |         |          |          |
|  | Cikkszám: 02510325    |          |         |         |          |          |





## Élettörő modul az Universal és Feedmax fúrókhoz



| Megnevezés          | Cikkszám | DC          | Fúrási mélység LU |             |             | Max. letörési mélység | DF          | LB          | LS          | DMM         | KAPR° |
|---------------------|----------|-------------|-------------------|-------------|-------------|-----------------------|-------------|-------------|-------------|-------------|-------|
|                     |          |             | 3 x D LU          | 5 x D LU    | 7 x D LU    |                       |             |             |             |             |       |
|                     |          |             | (min-max)         | (min-max)   | (min-max)   |                       |             |             |             |             |       |
|                     |          | <i>Inch</i> | <i>Inch</i>       | <i>Inch</i> | <i>Inch</i> | <i>Inch</i>           | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> |       |
| 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    |

### Pótalkatrészek

| Fúró átmérő (inch) | Lapka kulcs | Lapka csavar | Rögzítő kulcs | Kazetta     |
|--------------------|-------------|--------------|---------------|-------------|
|                    |             |              |               |             |
|                    | Váltólapka  | Váltólapka   | Modul         | Modul       |
| 0.1574 - 0.6299    | T07P-2      | C02205-T07P  | H1.5-2D       | SD200-3x7.3 |

| Tűrések: inch                                      | Méret                 | IC inch | L inch | S inch | D1 inch | RE inch |
|--|-----------------------|---------|--------|--------|---------|---------|
| <p>IC = ±0.001<br/>S = ±0.0027<br/>RE = ±0.004</p> | C45                   | 0.2187  | 0.3543 | 0.0984 | 0.1141  | 0.0078  |
|  | Minőség: T400D        |         |        |        |         |         |
|  | Megnevezés: SD200-C45 |         |        |        |         |         |
|  | Cikkszám: 02510325    |         |        |        |         |         |

## Élletőrő modul felszerelési útmutató

**1.**

**2.**

**3.**

**4.**

**Maximális életőrés**

max. 2,8 mm (0.110")

| Fúró átmérő DC | LU fúrási mélység (min-max) |       |                 |       |             |       |             |
|----------------|-----------------------------|-------|-----------------|-------|-------------|-------|-------------|
|                | SD1103 / SD203A             |       | SD1105 / SD205A |       | SD207A      |       |             |
| mm             |                             | mm    | inch            | mm    | inch        | mm    | inch        |
| 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 |

Csak hengeres szárral használható (R-1).

Bevezetés

Fúrás

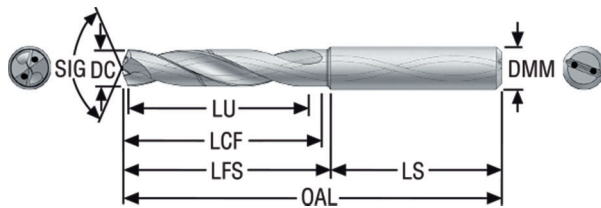
Dörzsárazás

Késztergálás

Melléklet

## SD203A, -MS

Fúrási mélység ~ 3 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN +NbN
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 158-159 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés              | Cikkszám | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|-------------------------|----------|---------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                         |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD203A-0200-007-04R1-MS | 10004064 | 2,0<br>0.079  | 7,0<br>0.276  | 41,0<br>1.614 | 14,0<br>0.551 | 27,0<br>1.063 | 11,0<br>0.433 | 4,0<br>0.157 |
| SD203A-0210-007-04R1-MS | 10004065 | 2,1<br>0.083  | 7,0<br>0.276  | 41,0<br>1.614 | 14,0<br>0.551 | 27,0<br>1.063 | 11,0<br>0.433 | 4,0<br>0.157 |
| SD203A-0220-007-04R1-MS | 10004066 | 2,2<br>0.087  | 7,0<br>0.276  | 41,0<br>1.614 | 14,0<br>0.551 | 27,0<br>1.063 | 11,0<br>0.433 | 4,0<br>0.157 |
| SD203A-0230-008-04R1-MS | 10004067 | 2,3<br>0.091  | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0240-008-04R1-MS | 10004068 | 2,4<br>0.094  | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0250-008-04R1-MS | 10004072 | 2,5<br>0.098  | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0260-008-04R1-MS | 10004073 | 2,6<br>0.102  | 8,0<br>0.315  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 12,5<br>0.492 | 4,0<br>0.157 |
| SD203A-0270-009-04R1-MS | 10004074 | 2,7<br>0.106  | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0278-009-04R1-MS | 10004075 | 2,78<br>0.109 | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0290-009-04R1-MS | 10004076 | 2,9<br>0.114  | 9,0<br>0.354  | 44,0<br>1.732 | 17,0<br>0.669 | 27,0<br>1.063 | 14,5<br>0.571 | 4,0<br>0.157 |
| SD203A-0300-014-06R1-MS | 10004077 | 3,0<br>0.118  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0310-014-06R1-MS | 10004078 | 3,1<br>0.122  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0320-014-06R1-MS | 10004079 | 3,2<br>0.126  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0330-014-06R1-MS | 10004080 | 3,3<br>0.130  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0340-014-06R1-MS | 10004081 | 3,4<br>0.134  | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0350-015-06R1-MS | 10004083 | 3,5<br>0.138  | 15,0<br>0.591 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0357-015-06R1-MS | 10004084 | 3,57<br>0.141 | 15,0<br>0.591 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0370-015-06R1-MS | 10004085 | 3,7<br>0.146  | 15,0<br>0.591 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-0380-017-06R1-MS | 10004086 | 3,8<br>0.150  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0390-017-06R1-MS | 10004087 | 3,9<br>0.154  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |

| Megnevezés              | Cikkszám | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|-------------------------|----------|---------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                         |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD203A-0397-017-06R1-MS | 10004088 | 3,97<br>0.156 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0400-017-06R1-MS | 10004089 | 4,0<br>0.157  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0410-017-06R1-MS | 10004090 | 4,1<br>0.161  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0420-017-06R1-MS | 10004091 | 4,2<br>0.165  | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0430-018-06R1-MS | 10004092 | 4,3<br>0.169  | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0450-018-06R1-MS | 10004093 | 4,5<br>0.177  | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-0460-018-06R1-MS | 10004094 | 4,6<br>0.181  | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD203A-0465-018-06R1-MS | 10004095 | 4,65<br>0.183 | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD203A-0470-018-06R1-MS | 10004096 | 4,7<br>0.185  | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD203A-0476-020-06R1-MS | 10004097 | 4,76<br>0.187 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0480-020-06R1-MS | 10004098 | 4,8<br>0.189  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0490-020-06R1-MS | 10004099 | 4,9<br>0.193  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0500-020-06R1-MS | 10004101 | 5,0<br>0.197  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0510-020-06R1-MS | 10004102 | 5,1<br>0.201  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0516-020-06R1-MS | 10004103 | 5,16<br>0.203 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0520-020-06R1-MS | 10004104 | 5,2<br>0.205  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0530-020-06R1-MS | 10004105 | 5,3<br>0.209  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0540-020-06R1-MS | 10004106 | 5,4<br>0.213  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0550-020-06R1-MS | 10004107 | 5,5<br>0.217  | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0556-020-06R1-MS | 10004108 | 5,56<br>0.219 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0560-021-06R1-MS | 10004109 | 5,6<br>0.220  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0570-021-06R1-MS | 10004110 | 5,7<br>0.224  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0580-021-06R1-MS | 10004111 | 5,8<br>0.228  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0590-021-06R1-MS | 10004112 | 5,9<br>0.232  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0595-021-06R1-MS | 10004113 | 5,95<br>0.234 | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0600-021-06R1-MS | 10004114 | 6,0<br>0.236  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-0610-021-08R1-MS | 10004115 | 6,1<br>0.240  | 21,0<br>0.827 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-0620-021-08R1-MS | 10004116 | 6,2<br>0.244  | 21,0<br>0.827 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-0630-021-08R1-MS | 10004117 | 6,3<br>0.248  | 21,0<br>0.827 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-0635-023-08R1-MS | 10004121 | 6,35<br>0.250 | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-0650-023-08R1-MS | 10004122 | 6,5<br>0.256  | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |

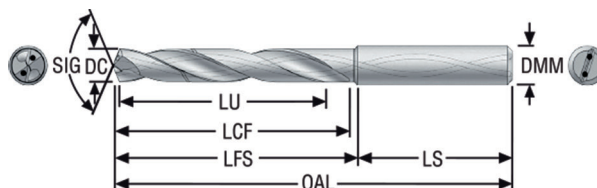
| Megnevezés              | Cikkszám | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
|                         |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-0660-023-08R1-MS | 10004123 | 6,6<br>0.260  | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0675-025-08R1-MS | 10004124 | 6,75<br>0.266 | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0680-025-08R1-MS | 10004125 | 6,8<br>0.268  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0690-025-08R1-MS | 10004127 | 6,9<br>0.272  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0700-025-08R1-MS | 10004128 | 7,0<br>0.276  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-0710-025-08R1-MS | 10004129 | 7,1<br>0.280  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0714-025-08R1-MS | 10004130 | 7,14<br>0.281 | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0720-025-08R1-MS | 10004132 | 7,2<br>0.283  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0730-025-08R1-MS | 10004133 | 7,3<br>0.287  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0740-025-08R1-MS | 10004134 | 7,4<br>0.291  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0750-025-08R1-MS | 10004135 | 7,5<br>0.295  | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0760-027-08R1-MS | 10004136 | 7,6<br>0.299  | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0780-027-08R1-MS | 10004137 | 7,8<br>0.307  | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0794-027-08R1-MS | 10004138 | 7,94<br>0.313 | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0800-027-08R1-MS | 10004139 | 8,0<br>0.315  | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-0810-027-10R1-MS | 10004140 | 8,1<br>0.319  | 27,0<br>1.063 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0820-027-10R1-MS | 10004141 | 8,2<br>0.323  | 27,0<br>1.063 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0830-027-10R1-MS | 10004143 | 8,3<br>0.327  | 27,0<br>1.063 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0840-027-10R1-MS | 10004144 | 8,4<br>0.331  | 27,0<br>1.063 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0850-027-10R1-MS | 10004146 | 8,5<br>0.335  | 27,0<br>1.063 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0860-029-10R1-MS | 10004147 | 8,6<br>0.339  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0870-029-10R1-MS | 10004148 | 8,7<br>0.343  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0873-029-10R1-MS | 10004149 | 8,73<br>0.344 | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0880-029-10R1-MS | 10004150 | 8,8<br>0.346  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0900-029-10R1-MS | 10004151 | 9,0<br>0.354  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0910-029-10R1-MS | 10004153 | 9,1<br>0.358  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0913-029-10R1-MS | 10004154 | 9,13<br>0.359 | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0920-029-10R1-MS | 10004156 | 9,2<br>0.362  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0930-029-10R1-MS | 10004157 | 9,3<br>0.366  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0950-029-10R1-MS | 10004158 | 9,5<br>0.374  | 29,0<br>1.142 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0953-031-10R1-MS | 10004160 | 9,53<br>0.375 | 31,0<br>1.220 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |

| Megnevezés              | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                         |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-0970-031-10R1-MS | 10004161 | 9,7<br>0.382   | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0980-031-10R1-MS | 10004162 | 9,8<br>0.386   | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0990-031-10R1-MS | 10004163 | 9,9<br>0.390   | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-0992-031-10R1-MS | 10004164 | 9,92<br>0.391  | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-1000-031-10R1-MS | 10004165 | 10,0<br>0.394  | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-1010-031-12R1-MS | 10004166 | 10,1<br>0.398  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1020-031-12R1-MS | 10004167 | 10,2<br>0.402  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1032-031-12R1-MS | 10004168 | 10,32<br>0.406 | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1040-031-12R1-MS | 10004169 | 10,4<br>0.409  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1050-031-12R1-MS | 10004170 | 10,5<br>0.413  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1072-033-12R1-MS | 10004171 | 10,72<br>0.422 | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1080-033-12R1-MS | 10004172 | 10,8<br>0.425  | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1100-033-12R1-MS | 10004173 | 11,0<br>0.433  | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1111-033-12R1-MS | 10004174 | 11,11<br>0.437 | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1120-033-12R1-MS | 10004175 | 11,2<br>0.441  | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1150-033-12R1-MS | 10004176 | 11,5<br>0.453  | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1180-033-12R1-MS | 10004177 | 11,8<br>0.465  | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1191-036-12R1-MS | 10004309 | 11,91<br>0.469 | 36,0<br>1.417 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1200-036-12R1-MS | 10004314 | 12,0<br>0.472  | 36,0<br>1.417 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-1210-036-14R1-MS | 10004315 | 12,1<br>0.476  | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1250-036-14R1-MS | 10004316 | 12,5<br>0.492  | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1270-036-14R1-MS | 10004317 | 12,7<br>0.500  | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1300-036-14R1-MS | 10004319 | 13,0<br>0.512  | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1310-036-14R1-MS | 10004320 | 13,1<br>0.516  | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1350-037-14R1-MS | 10004321 | 13,5<br>0.531  | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1400-037-14R1-MS | 10004325 | 14,0<br>0.551  | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-1420-037-16R1-MS | 10004332 | 14,2<br>0.559  | 37,0<br>1.457 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1425-038-16R1-MS | 10004333 | 14,25<br>0.561 | 38,0<br>1.496 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1470-038-16R1-MS | 10004334 | 14,7<br>0.579  | 38,0<br>1.496 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1500-040-16R1-MS | 10004335 | 15,0<br>0.591  | 40,0<br>1.575 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1525-040-16R1-MS | 10004336 | 15,25<br>0.600 | 40,0<br>1.575 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |

| Megnevezés              | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                         |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-1550-040-16R1-MS | 10004338 | 15,5<br>0.610  | 40,0<br>1.575 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1588-040-16R1-MS | 10004339 | 15,88<br>0.625 | 40,0<br>1.575 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1600-040-16R1-MS | 10004340 | 16,0<br>0.630  | 40,0<br>1.575 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |
| SD203A-1650-045-18R1-MS | 10004341 | 16,5<br>0.650  | 45,0<br>1.772 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1700-045-18R1-MS | 10004342 | 17,0<br>0.669  | 45,0<br>1.772 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1750-045-18R1-MS | 10004343 | 17,5<br>0.689  | 45,0<br>1.772 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1800-045-18R1-MS | 10004344 | 18,0<br>0.709  | 45,0<br>1.772 | 123,0<br>4.843 | 75,0<br>2.953 | 48,0<br>1.890 | 73,0<br>2.874 | 18,0<br>0.709 |
| SD203A-1850-050-20R1-MS | 10004345 | 18,5<br>0.728  | 50,0<br>1.969 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-1900-050-20R1-MS | 10004346 | 19,0<br>0.748  | 50,0<br>1.969 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-1905-050-20R1-MS | 10004347 | 19,05<br>0.750 | 50,0<br>1.969 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-1950-050-20R1-MS | 10004348 | 19,5<br>0.768  | 50,0<br>1.969 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |
| SD203A-2000-050-20R1-MS | 10004349 | 20,0<br>0.787  | 50,0<br>1.969 | 131,0<br>5.157 | 81,0<br>3.189 | 50,0<br>1.969 | 79,0<br>3.110 | 20,0<br>0.787 |

## SD205A, -MS

Fúrási mélység ~ 5 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN +NbN
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 160-161 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés              | Cikkszám | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|-------------------------|----------|---------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                         |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD205A-0200-012-04R1-MS | 10004179 | 2,0<br>0.079  | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0210-012-04R1-MS | 10004180 | 2,1<br>0.083  | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0220-012-04R1-MS | 10004181 | 2,2<br>0.087  | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0230-012-04R1-MS | 10004182 | 2,3<br>0.091  | 12,0<br>0.472 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 15,0<br>0.591 | 4,0<br>0.157 |
| SD205A-0240-013-04R1-MS | 10004183 | 2,4<br>0.094  | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0250-013-04R1-MS | 10004184 | 2,5<br>0.098  | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0260-013-04R1-MS | 10004185 | 2,6<br>0.102  | 13,0<br>0.512 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-0270-013-04R1-MS | 10004186 | 2,7<br>0.106  | 15,0<br>0.591 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 20,5<br>0.807 | 4,0<br>0.157 |
| SD205A-0280-013-04R1-MS | 10004187 | 2,8<br>0.110  | 15,0<br>0.591 | 50,0<br>1.969 | 23,0<br>0.906 | 27,0<br>1.063 | 20,5<br>0.807 | 4,0<br>0.157 |
| SD205A-0300-021-06R1-MS | 10004188 | 3,0<br>0.118  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0310-021-06R1-MS | 10004189 | 3,1<br>0.122  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0318-021-06R1-MS | 10004191 | 3,18<br>0.125 | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0330-021-06R1-MS | 10004192 | 3,3<br>0.130  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0340-021-06R1-MS | 10004193 | 3,4<br>0.134  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0350-021-06R1-MS | 10004194 | 3,5<br>0.138  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0360-027-06R1-MS | 10004195 | 3,6<br>0.142  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-0380-027-06R1-MS | 10004196 | 3,8<br>0.150  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0390-027-06R1-MS | 10004197 | 3,9<br>0.154  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0400-027-06R1-MS | 10004198 | 4,0<br>0.157  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0410-027-06R1-MS | 10004199 | 4,1<br>0.161  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |



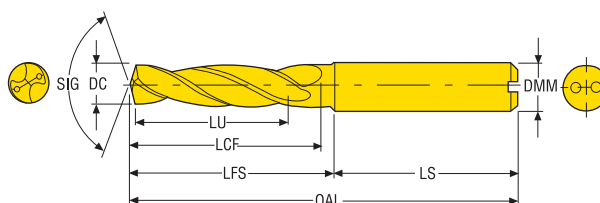
| Megnevezés              | Cikkszám | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|-------------------------|----------|---------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                         |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD205A-0420-027-06R1-MS | 10004200 | 4,2<br>0.165  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0430-027-06R1-MS | 10004201 | 4,3<br>0.169  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0450-027-06R1-MS | 10004202 | 4,5<br>0.177  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0460-027-06R1-MS | 10004203 | 4,6<br>0.181  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0465-027-06R1-MS | 10004205 | 4,65<br>0.183 | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0470-027-06R1-MS | 10004206 | 4,7<br>0.185  | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-0476-027-06R1-MS | 10004208 | 4,76<br>0.187 | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0490-032-06R1-MS | 10004209 | 4,9<br>0.193  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0500-032-06R1-MS | 10004211 | 5,0<br>0.197  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0510-032-06R1-MS | 10004212 | 5,1<br>0.201  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0516-032-06R1-MS | 10004213 | 5,16<br>0.203 | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0520-032-06R1-MS | 10004214 | 5,2<br>0.205  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0550-032-06R1-MS | 10004215 | 5,5<br>0.217  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0556-032-06R1-MS | 10004216 | 5,56<br>0.219 | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0560-032-06R1-MS | 10004218 | 5,6<br>0.220  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0580-032-06R1-MS | 10004219 | 5,8<br>0.228  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0590-032-06R1-MS | 10004220 | 5,9<br>0.232  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0595-032-06R1-MS | 10004221 | 5,95<br>0.234 | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0600-032-06R1-MS | 10004222 | 6,0<br>0.236  | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-0620-035-08R1-MS | 10004224 | 6,2<br>0.244  | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0630-035-08R1-MS | 10004225 | 6,3<br>0.248  | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0635-035-08R1-MS | 10004226 | 6,35<br>0.250 | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0640-035-08R1-MS | 10004227 | 6,4<br>0.252  | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0650-035-08R1-MS | 10004228 | 6,5<br>0.256  | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0660-035-08R1-MS | 10004229 | 6,6<br>0.260  | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0670-035-08R1-MS | 10004231 | 6,7<br>0.264  | 35,0<br>1.378 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0680-040-08R1-MS | 10004234 | 6,8<br>0.268  | 40,0<br>1.575 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0690-040-08R1-MS | 10004235 | 6,9<br>0.272  | 40,0<br>1.575 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0700-040-08R1-MS | 10004236 | 7,0<br>0.276  | 40,0<br>1.575 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0710-040-08R1-MS | 10004237 | 7,1<br>0.280  | 40,0<br>1.575 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205A-0714-040-08R1-MS | 10004238 | 7,14<br>0.281 | 40,0<br>1.575 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |

| Megnevezés              | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                         |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-0720-040-08R1-MS | 10004239 | 7,2<br>0.283   | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0750-040-08R1-MS | 10004240 | 7,5<br>0.295   | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0780-042-08R1-MS | 10004241 | 7,8<br>0.307   | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0794-042-08R1-MS | 10004243 | 7,94<br>0.313  | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0800-042-08R1-MS | 10004245 | 8,0<br>0.315   | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-0810-042-10R1-MS | 10004246 | 8,1<br>0.319   | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0820-042-10R1-MS | 10004247 | 8,2<br>0.323   | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0840-042-10R1-MS | 10004250 | 8,4<br>0.331   | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0850-042-10R1-MS | 10004251 | 8,5<br>0.335   | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0870-045-10R1-MS | 10004252 | 8,7<br>0.343   | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0880-045-10R1-MS | 10004255 | 8,8<br>0.346   | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0900-045-10R1-MS | 10004256 | 9,0<br>0.354   | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0910-045-10R1-MS | 10004257 | 9,1<br>0.358   | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0950-045-10R1-MS | 10004258 | 9,5<br>0.374   | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0953-048-10R1-MS | 10004259 | 9,53<br>0.375  | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0980-048-10R1-MS | 10004266 | 9,8<br>0.386   | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-0992-048-10R1-MS | 10004269 | 9,92<br>0.391  | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-1000-048-10R1-MS | 10004270 | 10,0<br>0.394  | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-1020-048-12R1-MS | 10004272 | 10,2<br>0.402  | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1030-048-12R1-MS | 10004273 | 10,3<br>0.406  | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1050-048-12R1-MS | 10004274 | 10,5<br>0.413  | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1070-056-12R1-MS | 10004275 | 10,7<br>0.421  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1080-056-12R1-MS | 10004276 | 10,8<br>0.425  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1100-056-12R1-MS | 10004277 | 11,0<br>0.433  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1111-056-12R1-MS | 10004278 | 11,11<br>0.437 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1130-056-12R1-MS | 10004279 | 11,3<br>0.445  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1150-056-12R1-MS | 10004280 | 11,5<br>0.453  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1180-056-12R1-MS | 10004281 | 11,8<br>0.465  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1200-056-12R1-MS | 10004282 | 12,0<br>0.472  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-1220-056-14R1-MS | 10004283 | 12,2<br>0.480  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-1250-056-14R1-MS | 10004284 | 12,5<br>0.492  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |

| Megnevezés              | Cikkszám | DC             | LU            | OAL            | LFS            | LS            | LCF            | DMM           |
|-------------------------|----------|----------------|---------------|----------------|----------------|---------------|----------------|---------------|
|                         |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    |
| SD205A-1270-056-14R1-MS | 10004285 | 12,7<br>0.500  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110  | 45,0<br>1.772 | 77,0<br>3.031  | 14,0<br>0.551 |
| SD205A-1300-056-14R1-MS | 10004286 | 13,0<br>0.512  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110  | 45,0<br>1.772 | 77,0<br>3.031  | 14,0<br>0.551 |
| SD205A-1310-056-14R1-MS | 10004287 | 13,1<br>0.516  | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110  | 45,0<br>1.772 | 77,0<br>3.031  | 14,0<br>0.551 |
| SD205A-1350-059-14R1-MS | 10004288 | 13,5<br>0.531  | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110  | 45,0<br>1.772 | 77,0<br>3.031  | 14,0<br>0.551 |
| SD205A-1400-059-14R1-MS | 10004290 | 14,0<br>0.551  | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110  | 45,0<br>1.772 | 77,0<br>3.031  | 14,0<br>0.551 |
| SD205A-1420-060-16R1-MS | 10004291 | 14,2<br>0.559  | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1425-060-16R1-MS | 10004292 | 14,25<br>0.561 | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1450-060-16R1-MS | 10004293 | 14,5<br>0.571  | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1500-060-16R1-MS | 10004295 | 15,0<br>0.591  | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1550-062-16R1-MS | 10004296 | 15,5<br>0.610  | 62,0<br>2.441 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1580-062-16R1-MS | 10004297 | 15,8<br>0.622  | 62,0<br>2.441 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1600-062-16R1-MS | 10004298 | 16,0<br>0.630  | 62,0<br>2.441 | 133,0<br>5.236 | 85,0<br>3.346  | 48,0<br>1.890 | 83,0<br>3.268  | 16,0<br>0.630 |
| SD205A-1650-071-18R1-MS | 10004299 | 16,5<br>0.650  | 64,0<br>2.520 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 |
| SD205A-1700-071-18R1-MS | 10004300 | 17,0<br>0.669  | 64,0<br>2.520 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 |
| SD205A-1750-071-18R1-MS | 10004301 | 17,5<br>0.689  | 66,0<br>2.598 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 |
| SD205A-1800-071-18R1-MS | 10004302 | 18,0<br>0.709  | 66,0<br>2.598 | 143,0<br>5.630 | 95,0<br>3.740  | 48,0<br>1.890 | 93,0<br>3.661  | 18,0<br>0.709 |
| SD205A-1850-077-20R1-MS | 10004303 | 18,5<br>0.728  | 71,0<br>2.795 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1900-077-20R1-MS | 10004304 | 19,0<br>0.748  | 71,0<br>2.795 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1930-077-20R1-MS | 10004305 | 19,3<br>0.760  | 71,0<br>2.795 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-1950-077-20R1-MS | 10004306 | 19,5<br>0.768  | 71,0<br>2.795 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |
| SD205A-2000-077-20R1-MS | 10004307 | 20,0<br>0.787  | 71,0<br>2.795 | 153,0<br>6.024 | 103,0<br>4.055 | 50,0<br>1.969 | 101,0<br>3.976 | 20,0<br>0.787 |

## SD203A, -M

Fúrási mélység ~ 3 x D – Metrikus



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAlN + TiN
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 147, 148 old.
- Kőzet átmérőkhöz lásd a MyDesign szoftvert.

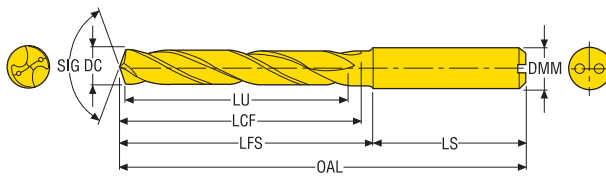
| Megnevezés                | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|---------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                           |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD203A-3.0-14-6R1-M       | 02569995 | 3,0<br>0.118   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.1-14-6R1-M       | 02570998 | 3,1<br>0.122   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.3-14-6R1-M       | 02555958 | 3,3<br>0.130   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.4-14-6R1-M       | 02570984 | 3,4<br>0.134   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.5-15-6R1-M       | 02533784 | 3,5<br>0.138   | 15,0<br>0.591 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.9-17-6R1-M       | 02570988 | 3,9<br>0.154   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-4.0-17-6R1-M       | 02539902 | 4,0<br>0.157   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-4.2-17-6R1-M       | 02555959 | 4,2<br>0.165   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-4.3-18-6R1-M       | 02533700 | 4,3<br>0.169   | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-4.5-18-6R1-M       | 02570993 | 4,5<br>0.177   | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-01875-079-0236R1-M | 02450103 | 4,763<br>0.188 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-4.8-20-6R1-M       | 02570982 | 4,8<br>0.189   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-4.9-20-6R1-M       | 02592709 | 4,9<br>0.193   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-5.0-20-6R1-M       | 02450075 | 5,0<br>0.197   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-5.5-21-6R1-M       | 02544249 | 5,5<br>0.217   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-02188-083-0236R1-M | 02450104 | 5,558<br>0.219 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-5.6-21-6R1-M       | 02544028 | 5,6<br>0.220   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-5.9-21-6R1-M       | 02515290 | 5,9<br>0.232   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-6.0-21-6R1-M       | 02450076 | 6,0<br>0.236   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-02500-091-0315R1-M | 02450105 | 6,35<br>0.250  | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |

| Megnevezés                | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|---------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                           |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-6.5-23-8R1-M       | 02450077 | 6,5<br>0.256    | 23,0<br>0.906 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-6.6-23-8R1-M       | 02450078 | 6,6<br>0.260    | 23,0<br>0.906 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-02656-098-0315R1-M | 02450106 | 6,746<br>0.266  | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-6.8-25-8R1-M       | 02450079 | 6,8<br>0.268    | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-6.9-25-8R1-M       | 02450080 | 6,9<br>0.272    | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-7.0-25-8R1-M       | 02450081 | 7,0<br>0.276    | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-02813-098-0315R1-M | 02450107 | 7,145<br>0.281  | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-7.2-25-8R1-M       | 02537185 | 7,2<br>0.283    | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-7.3-25-8R1-M       | 02530109 | 7,3<br>0.287    | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-7.5-25-8R1-M       | 02450082 | 7,5<br>0.295    | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-7.6-27-8R1-M       | 02545197 | 7,6<br>0.299    | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-7.8-27-8R1-M       | 02450083 | 7,8<br>0.307    | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-03125-106-0315R1-M | 02450108 | 7,938<br>0.313  | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-8.0-27-8R1-M       | 02450084 | 8,0<br>0.315    | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-8.5-27-10R1-M      | 02450085 | 8,5<br>0.335    | 27,0<br>1.063 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-03438-114-0394R1-M | 02450109 | 8,733<br>0.344  | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-8.8-29-10R1-M      | 02450086 | 8,8<br>0.346    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.0-29-10R1-M      | 02450087 | 9,0<br>0.354    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-03594-114-0394R1-M | 02450110 | 9,129<br>0.359  | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.2-29-10R1-M      | 02546516 | 9,2<br>0.362    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.3-29-10R1-M      | 02582375 | 9,3<br>0.366    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.5-29-10R1-M      | 02450088 | 9,5<br>0.374    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-03750-122-0394R1-M | 02450111 | 9,525<br>0.375  | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.8-31-10R1-M      | 02450089 | 9,8<br>0.386    | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.9-31-10R1-M      | 02515293 | 9,9<br>0.390    | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-10.0-31-10R1-M     | 02450090 | 10,0<br>0.394   | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-10.2-31-12R1-M     | 02450091 | 10,2<br>0.402   | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-04063-122-0472R1-M | 02450112 | 10,32<br>0.406  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-10.4-31-12R1-M     | 02535267 | 10,4<br>0.409   | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-10.5-31-12R1-M     | 02450092 | 10,5<br>0.413   | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-04219-130-0472R1-M | 02450113 | 10,716<br>0.422 | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |

| Megnevezés                | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|---------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                           |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-10.8-33-12R1-M     | 02450093 | 10,8<br>0.425   | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-11.0-33-12R1-M     | 02450094 | 11,0<br>0.433   | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-04375-130-0472R1-M | 02450114 | 11,113<br>0.438 | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-11.5-33-12R1-M     | 02450095 | 11,5<br>0.453   | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-11.8-33-12R1-M     | 02450096 | 11,8<br>0.465   | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-04688-142-0472R1-M | 02592711 | 11,908<br>0.469 | 36,0<br>1.417 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-12.0-36-12R1-M     | 02450097 | 12,0<br>0.472   | 36,0<br>1.417 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-12.25-36-14R1-M    | 02592712 | 12,25<br>0.482  | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-12.3-36-14R1-M     | 02450098 | 12,3<br>0.484   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-12.5-36-14R1-M     | 02450099 | 12,5<br>0.492   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-05000-142-0551R1-M | 02450115 | 12,7<br>0.500   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-12.9-36-14R1-M     | 02538263 | 12,9<br>0.508   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-13.0-36-14R1-M     | 02450100 | 13,0<br>0.512   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-13.5-37-14R1-M     | 02450101 | 13,5<br>0.531   | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-14.0-37-14R1-M     | 02450102 | 14,0<br>0.551   | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-14.25-38-16R1-M    | 02592715 | 14,25<br>0.561  | 38,0<br>1.496 | 115,0<br>4.528 | 67,0<br>2.638 | 48,0<br>1.890 | 65,0<br>2.559 | 16,0<br>0.630 |

## SD205A, -M

Fúrási mélység ~ 5 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat: TiAIN + TiN
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 149, 150 old.
- Közttes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés                | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|---------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                           |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD205A-2.5-13-4R1-M       | 02666989 | 2,5<br>0.098   | 13,0<br>0.512 | 46,0<br>1.811 | 19,0<br>0.748 | 27,0<br>1.063 | 17,5<br>0.689 | 4,0<br>0.157 |
| SD205A-3.0-21-6R1-M       | 02556426 | 3,0<br>0.118   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-3.1-21-6R1-M       | 02642448 | 3,1<br>0.122   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-3.18-21-6R1-M      | 02541863 | 3,18<br>0.125  | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-3.3-21-6R1-M       | 02555960 | 3,3<br>0.130   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-3.4-21-6R1-M       | 02554264 | 3,4<br>0.134   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-3.5-21-6R1-M       | 02533780 | 3,5<br>0.138   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 26,0<br>1.024 | 6,0<br>0.236 |
| SD205A-4.0-27-6R1-M       | 02508340 | 4,0<br>0.157   | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-4.2-27-6R1-M       | 02502549 | 4,2<br>0.165   | 27,0<br>1.063 | 74,0<br>2.913 | 40,0<br>1.575 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-4.3-27-6R1-M       | 02592718 | 4,3<br>0.169   | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-4.5-27-6R1-M       | 02563659 | 4,5<br>0.177   | 27,0<br>1.063 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-4.7-27-6R1-M       | 02604031 | 4,7<br>0.185   | 27,0<br>1.063 | 74,0<br>2.913 | 40,0<br>1.575 | 36,0<br>1.417 | 34,0<br>1.339 | 6,0<br>0.236 |
| SD205A-01875-126-0236R1-M | 02450062 | 4,763<br>0.188 | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-4.9-32-6R1-M       | 02592720 | 4,9<br>0.193   | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-5.0-32-6R1-M       | 02450034 | 5,0<br>0.197   | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-5.1-32-6R1-M       | 02600034 | 5,1<br>0.201   | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-5.2-32-6R1-M       | 02504408 | 5,2<br>0.205   | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-5.5-32-6R1-M       | 02537341 | 5,5<br>0.217   | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-02188-126-0236R1-M | 02450063 | 5,558<br>0.219 | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205A-5.6-32-6R1-M       | 02612445 | 5,6<br>0.220   | 32,0<br>1.260 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |

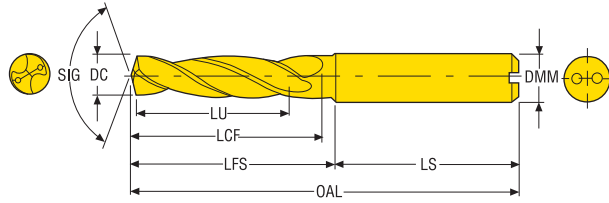
| Megnevezés                | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|---------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                           |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-5.9-32-6R1-M       | 02539334 | 5,9<br>0.232    | 32,0<br>1.260 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-6.0-32-6R1-M       | 02450035 | 6,0<br>0.236    | 32,0<br>1.260 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-6.2-35-8R1-M       | 02547543 | 6,2<br>0.244    | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-02500-138-0315R1-M | 02450064 | 6,35<br>0.250   | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-6.4-35-8R1-M       | 02666488 | 6,4<br>0.252    | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-6.5-35-8R1-M       | 02450036 | 6,5<br>0.256    | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-6.6-35-8R1-M       | 02450037 | 6,6<br>0.260    | 35,0<br>1.378 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-6.8-40-8R1-M       | 02450038 | 6,8<br>0.268    | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-6.9-40-8R1-M       | 02450039 | 6,9<br>0.272    | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-02813-157-0315R1-M | 02450066 | 7,145<br>0.281  | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-7.2-40-8R1-M       | 02519059 | 7,2<br>0.283    | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-7.5-40-8R1-M       | 02450041 | 7,5<br>0.295    | 40,0<br>1.575 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-7.8-42-8R1-M       | 02450042 | 7,8<br>0.307    | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-03125-165-0315R1-M | 02450067 | 7,938<br>0.313  | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-8.0-42-8R1-M       | 02450043 | 8,0<br>0.315    | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-8.1-42-10R1-M      | 02672327 | 8,1<br>0.319    | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-8.4-42-10R1-M      | 02570977 | 8,4<br>0.331    | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-8.5-42-10R1-M      | 02450044 | 8,5<br>0.335    | 42,0<br>1.654 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-8.8-45-10R1-M      | 02450045 | 8,8<br>0.346    | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-9.0-45-10R1-M      | 02450046 | 9,0<br>0.354    | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-9.2-45-10R1-M      | 02516406 | 9,2<br>0.362    | 45,0<br>1.772 | 103,0<br>4.055 | 42,0<br>1.654 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-9.5-45-10R1-M      | 02450047 | 9,5<br>0.374    | 45,0<br>1.772 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-03750-189-0394R1-M | 02450070 | 9,525<br>0.375  | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-9.8-48-10R1-M      | 02450048 | 9,8<br>0.386    | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-10.0-48-10R1-M     | 02450049 | 10,0<br>0.394   | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |
| SD205A-10.2-48-12R1-M     | 02450050 | 10,2<br>0.402   | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-10.5-48-12R1-M     | 02450051 | 10,5<br>0.413   | 48,0<br>1.890 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-10.8-56-12R1-M     | 02450052 | 10,8<br>0.425   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-10.9-56-12R1-M     | 02592725 | 10,9<br>0.429   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-11.0-56-12R1-M     | 02450053 | 11,0<br>0.433   | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-04375-221-0472R1-M | 02450073 | 11,113<br>0.438 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |



| Megnevezés                | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|---------------------------|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                           |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-11.5-56-12R1-M     | 02450054 | 11,5<br>0.453  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-11.8-56-12R1-M     | 02450055 | 11,8<br>0.465  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-12.0-56-12R1-M     | 02450056 | 12,0<br>0.472  | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |
| SD205A-12.5-56-14R1-M     | 02450058 | 12,5<br>0.492  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-05000-221-0551R1-M | 02450074 | 12,7<br>0.500  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-12.9-56-14R1-M     | 02592729 | 12,9<br>0.508  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-13.0-56-14R1-M     | 02450059 | 13,0<br>0.512  | 56,0<br>2.205 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-13.5-59-14R1-M     | 02450060 | 13,5<br>0.531  | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-14.0-59-14R1-M     | 02450061 | 14,0<br>0.551  | 59,0<br>2.323 | 124,0<br>4.882 | 79,0<br>3.110 | 45,0<br>1.772 | 77,0<br>3.031 | 14,0<br>0.551 |
| SD205A-14.25-60-16R1-M    | 02592732 | 14,25<br>0.561 | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-14.5-60-16R1-M     | 03117534 | 14,5<br>0.571  | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-15.0-60-16R1-M     | 02570652 | 15,0<br>0.591  | 60,0<br>2.362 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-15.5-62-16R1-M     | 02543076 | 15,5<br>0.610  | 62,0<br>2.441 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |
| SD205A-16.0-62-16R1-M     | 02555961 | 16,0<br>0.630  | 62,0<br>2.441 | 133,0<br>5.236 | 85,0<br>3.346 | 48,0<br>1.890 | 83,0<br>3.268 | 16,0<br>0.630 |

## SD203A, -T

Fúrási mélység ~ 3 x D



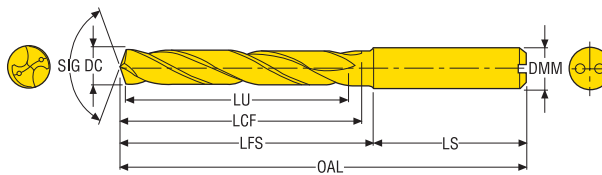
- Hengeres szár DIN 6537A
- Túrás DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat nélküli
- Furat túrés: IT8-9
- Forgácsolási adatok - [www.secotools.com](http://www.secotools.com)
- Kőzet átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés                | Cikkszám | DC             | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|---------------------------|----------|----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                           |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-01875-079-0236R1-T | 02569147 | 4,763<br>0.188 | 20,0<br>0.787 | 66,0<br>2.598  | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-5.0-20-6R1-T       | 02523021 | 5,0<br>0.197   | 20,0<br>0.787 | 66,0<br>2.598  | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-02188-083-0236R1-T | 02569156 | 5,558<br>0.219 | 20,0<br>0.787 | 66,0<br>2.598  | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-6.0-21-6R1-T       | 02542682 | 6,0<br>0.236   | 21,0<br>0.827 | 66,0<br>2.598  | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-02500-091-0315R1-T | 02569149 | 6,35<br>0.250  | 23,0<br>0.906 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-6.5-23-8R1-T       | 02545316 | 6,5<br>0.256   | 23,0<br>0.906 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-6.9-25-8R1-T       | 02537280 | 6,9<br>0.272   | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-7.0-25-8R1-T       | 02525985 | 7,0<br>0.276   | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-02813-098-0315R1-T | 02569151 | 7,145<br>0.281 | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-7.5-25-8R1-T       | 02527667 | 7,5<br>0.295   | 25,0<br>0.984 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-03125-106-0315R1-T | 02569152 | 7,938<br>0.313 | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-8.0-27-8R1-T       | 02513679 | 8,0<br>0.315   | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-8.5-27-10R1-T      | 02548250 | 8,5<br>0.335   | 27,0<br>1.063 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-8.8-29-10R1-T      | 02569153 | 8,8<br>0.346   | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.0-29-10R1-T      | 02524440 | 9,0<br>0.354   | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.5-29-10R1-T      | 02545386 | 9,5<br>0.374   | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-10.0-31-10R1-T     | 02525984 | 10,0<br>0.394  | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-10.5-31-12R1-T     | 02545387 | 10,5<br>0.413  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-11.0-33-12R1-T     | 02569155 | 11,0<br>0.433  | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |

| Megnevezés            | Cikkszám | DC                | LU                | OAL               | LFS               | LS                | LCF               | DMM               |
|-----------------------|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
|                       |          | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> |
| SD203A-11.5-33-12R1-T | 02567385 | 11,5<br>0.453     | 33,0<br>1.299     | 102,0<br>4.016    | 57,0<br>2.244     | 45,0<br>1.772     | 55,0<br>2.165     | 12,0<br>0.472     |
| SD203A-12.0-36-12R1-T | 02562784 | 12,0<br>0.472     | 36,0<br>1.417     | 102,0<br>4.016    | 57,0<br>2.244     | 45,0<br>1.772     | 55,0<br>2.165     | 12,0<br>0.472     |

## SD205A, -T

Fúrási mélység ~ 5 x D

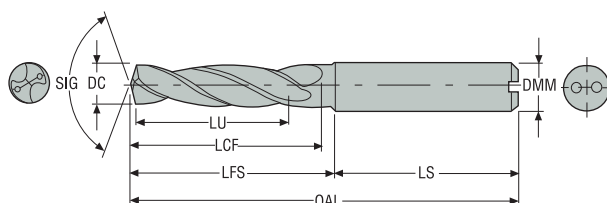


- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- Bevonat nélküli
- Furat tűrés: IT8-9
- Forgácsolási adatok - [www.secotools.com](http://www.secotools.com)
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés            | Cikkszám | DC            | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|-----------------------|----------|---------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                       |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-8.0-42-8R1-T   | 02569164 | 8,0<br>0.315  | 42,0<br>1.654 | 91,0<br>3.583  | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315  |
| SD205A-12.0-56-12R1-T | 02527621 | 12,0<br>0.472 | 56,0<br>2.205 | 118,0<br>4.646 | 73,0<br>2.874 | 45,0<br>1.772 | 71,0<br>2.795 | 12,0<br>0.472 |

## SD203A, -N

Fúrási mélység ~ 3 x D



- Hengeres szár DIN 6537A
- Tűrés DC m7
- Belső hűtés
- Csúcs szög: 140°
- DLC bevonatos
- Furat tűrés: IT8-9
- Forgácsolási adatokat lásd a 147, 148 old.
- Kötés átmérők a Custom Design szoftverben.

| Megnevezés                | Cikkszám | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|---------------------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                           |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD203A-2.5-8-4R1-N        | 02691548 | 2,5<br>0.098   | 8,0<br>0.315  | 44,0<br>1.732 | 16,0<br>0.630 | 28,0<br>1.102 | 13,0<br>0.512 | 4,0<br>0.157 |
| SD203A-3.0-14-6R1-N       | 02691549 | 3,0<br>0.118   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.3-14-6R1-N       | 02691551 | 3,3<br>0.130   | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-3.5-15-6R1-N       | 02691552 | 3,5<br>0.138   | 15,0<br>0.591 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236 |
| SD203A-4.0-17-6R1-N       | 02691553 | 4,0<br>0.157   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-4.1-17-6R1-N       | 02691554 | 4,1<br>0.161   | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-4.5-18-6R1-N       | 02691555 | 4,5<br>0.177   | 18,0<br>0.709 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236 |
| SD203A-5.0-20-6R1-N       | 02691556 | 5,0<br>0.197   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-5.2-20-6R1-N       | 02691557 | 5,2<br>0.205   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-5.5-20-6R1-N       | 02691558 | 5,5<br>0.217   | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-6.0-21-6R1-N       | 02691559 | 6,0<br>0.236   | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236 |
| SD203A-02500-091-0315R1-N | 02691560 | 6,35<br>0.250  | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-6.5-23-8R1-N       | 02691562 | 6,5<br>0.256   | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-02656-098-0315R1-N | 02691564 | 6,746<br>0.266 | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-6.8-25-8R1-N       | 02691565 | 6,8<br>0.268   | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-7.0-25-8R1-N       | 02643590 | 7,0<br>0.276   | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-7.1-25-8R1-N       | 02691567 | 7,1<br>0.280   | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315 |
| SD203A-02813-098-0315R1-N | 02691568 | 7,145<br>0.281 | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315 |
| SD203A-7.5-25-8R1-N       | 02691569 | 7,5<br>0.295   | 25,0<br>0.984 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315 |
| SD203A-03125-106-0315R1-N | 02691570 | 7,938<br>0.313 | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315 |

| Megnevezés                | Cikkszám | DC              | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|---------------------------|----------|-----------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                           |          | mm<br>Inch      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD203A-8.0-27-8R1-N       | 02691571 | 8,0<br>0.315    | 27,0<br>1.063 | 79,0<br>3.110  | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-8.5-27-10R1-N      | 02643592 | 8,5<br>0.335    | 27,0<br>1.063 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.0-29-10R1-N      | 02691574 | 9,0<br>0.354    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-9.5-29-10R1-N      | 02691575 | 9,5<br>0.374    | 29,0<br>1.142 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-03750-122-0394R1-N | 02691576 | 9,525<br>0.375  | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-10.0-31-10R1-N     | 02691577 | 10,0<br>0.394   | 31,0<br>1.220 | 89,0<br>3.504  | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |
| SD203A-10.2-31-12R1-N     | 02691578 | 10,2<br>0.402   | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-04063-122-0472R1-N | 02691579 | 10,32<br>0.406  | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-10.5-31-12R1-N     | 02691580 | 10,5<br>0.413   | 31,0<br>1.220 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-11.0-33-12R1-N     | 02691582 | 11,0<br>0.433   | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-04375-130-0472R1-N | 02691585 | 11,113<br>0.438 | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-11.5-33-12R1-N     | 02691588 | 11,5<br>0.453   | 33,0<br>1.299 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-12.0-36-12R1-N     | 02691589 | 12,0<br>0.472   | 36,0<br>1.417 | 102,0<br>4.016 | 57,0<br>2.244 | 45,0<br>1.772 | 55,0<br>2.165 | 12,0<br>0.472 |
| SD203A-12.5-36-14R1-N     | 02691591 | 12,5<br>0.492   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-05000-142-0551R1-N | 02691592 | 12,7<br>0.500   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-13.0-36-14R1-N     | 02691594 | 13,0<br>0.512   | 36,0<br>1.417 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-05312-146-0551R1-N | 02691596 | 13,492<br>0.531 | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-13.5-37-14R1-N     | 02691597 | 13,5<br>0.531   | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |
| SD203A-14.0-37-14R1-N     | 02691598 | 14,0<br>0.551   | 37,0<br>1.457 | 107,0<br>4.213 | 62,0<br>2.441 | 45,0<br>1.772 | 60,0<br>2.362 | 14,0<br>0.551 |



## Kompozitok fúrása

A Seco két különböző megoldást is kínál a kompozitok fúrásához: gyémánt bevonatú fúrókat és polikristályos gyémánt (PCD) fúrókat. Ezeknek a szerszámoknak a geometriája kifejezetten normál kompozitokhoz és rétegelt anyagokhoz lett optimalizálva.

- A C2 és az CX2 lapos geometriájú fúróhegye olyan rétegelt kompozitokat is megmunkál, ami alumíniumot vagy titánt is tartalmaz
- A CX1 és a CX2 egyaránt polikristályos gyémánt (PCD) fúró, melyek kompozitok megmunkálásakor jobb termelékenységet és szerszámélettartamot nyújtanak, mint a hagyományos fúrók
- A C1 és a C2 egyaránt gyémánt bevonatos keményfém fúró, melyek Dura gyémánt bevonata nagyon jó szívósságot és kopásállóságot biztosít

## Kompozit megmunkálás

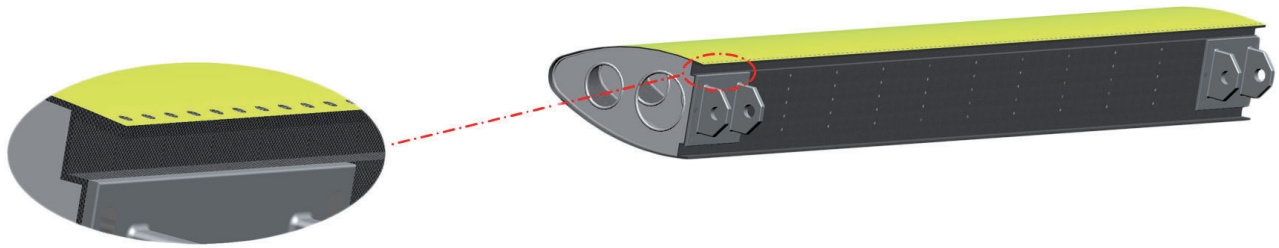
Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

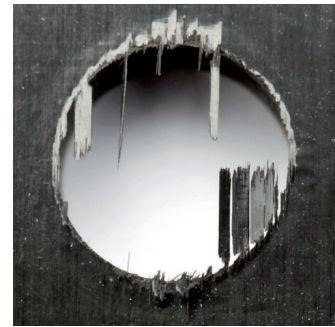


### Mikor a furat minősége van a fókuszban

A be-/kilépés során fellépő leválásnál és kirepedezésnél a cél egyszerű; kompozit alkalmazásokra optimalizál szerszámok, valamint szendvics anyagokra optimalizál szerszámok tervezése. Mindkét esetben kiváló teljesítményt kell nyújtani a be- és a kilépésnél egyaránt. (Szendvics anyagokban ez általában magában foglalja az Al vagy Ti anyagokból történő kilépést is.)

- Nincs felszakadás (belépésnél)
- Nincs leválás (kilépésnél)

A Dura diamond bevonat végig biztosítja a jó mérettűrést a szerszám hosszú élettartama alatt.



### Alkalmazási példa

Lemez CFRP/GFRP  
(kilépés kompozit anyagban)



CX1 geometria



Szendvics anyag  
(kilépés Al/Ti-ből)



CX2 geometria



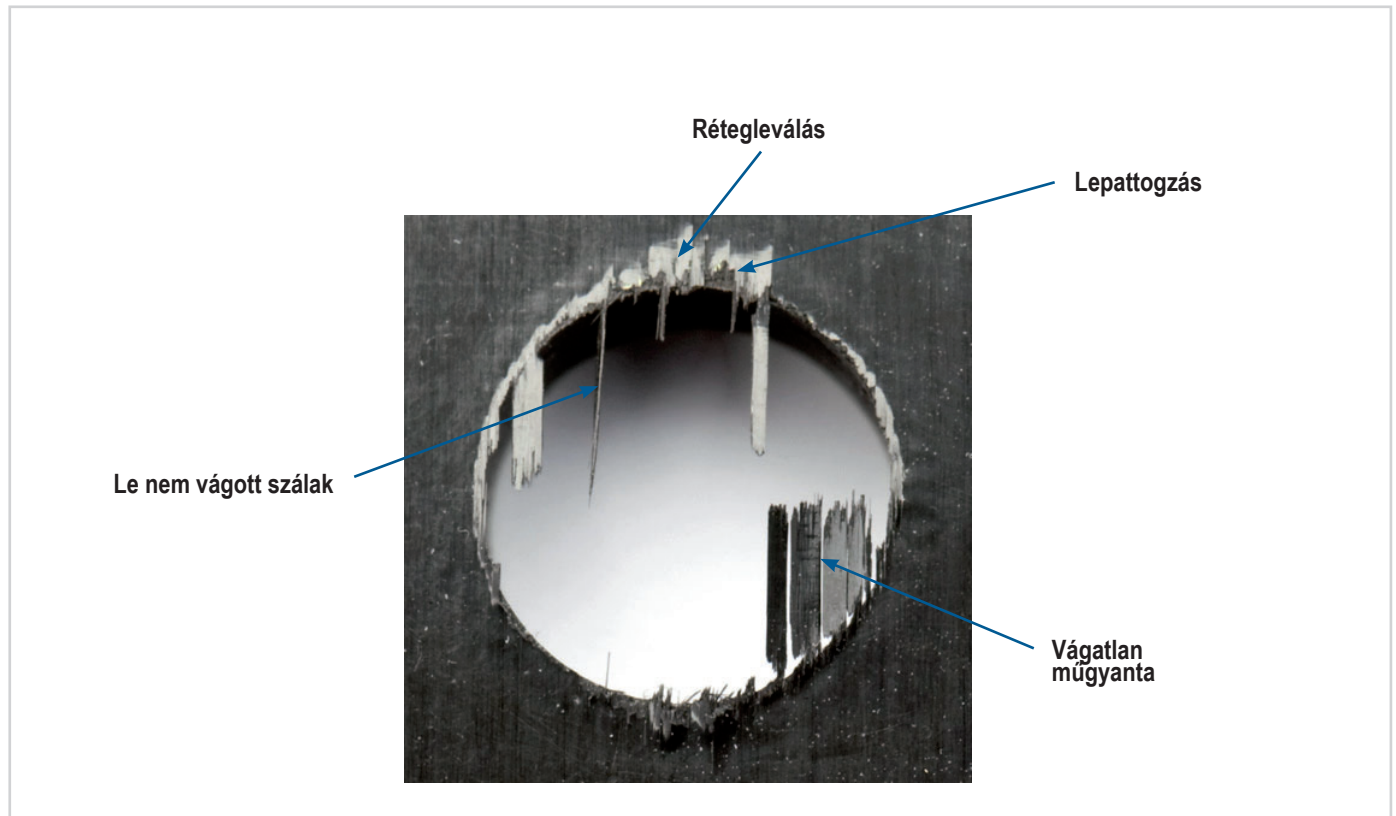
CX31 geometriájú PCD  
Univerzális geometria  
sík CFRP/GFRP és  
szendvics anyagokhoz



CFRP = Carbon Fiber Reinforced Plastic – szénzál-erősítésű műanyag  
GFRP = Glass Fiber Reinforced Plastic – üvegszál-erősítésű műanyag



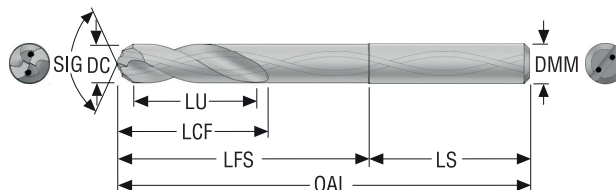
## Problémamegoldás – Furat kilépés



| Probléma:        | Rétegleválás<br>(felválás / lenyomódás)   | Lepattogzás  | Le nem vágott szálak  | Vágtatlan műgyanta  |
|------------------|---|--|---|---|
| <b>Megoldás:</b> | <b>Felválás</b> <ul style="list-style-type: none"> <li>▪ Használjon negatívabb geometriájú szerszámot</li> <li>▪ Csökkentse a fordulatonkénti előtolást</li> </ul> <b>Lenyomódás</b> <ul style="list-style-type: none"> <li>▪ Csökkentse a fordulatonkénti előtolást</li> </ul> | <ul style="list-style-type: none"> <li>▪ Használjon pozitívabb geometriájú szerszámot</li> <li>▪ Csökkentse a fordulatonkénti előtolást</li> </ul> | <ul style="list-style-type: none"> <li>▪ Használjon élesebb geometriájú szerszámot</li> <li>▪ Csökkentse a fordulatonkénti előtolást</li> </ul> | <ul style="list-style-type: none"> <li>▪ Használjon élesebb geometriát</li> <li>▪ Csökkentse a fordulatonkénti előtolást</li> <li>▪ Csökkentse a forgácsolási sebességet</li> </ul> |
| Probléma:        | Megolvadt gyanta<br>(túl nagy hő)   | Rövid szerszámélettartam   |   |   |
| <b>Megoldás:</b> | <ul style="list-style-type: none"> <li>▪ Csökkentse a forgácsolási sebességet</li> </ul>  | <ul style="list-style-type: none"> <li>▪ Csökkentse a forgácsolási sebességet</li> </ul>   |   |   |

## SD205A-C1

Fúrási mélység ~ 5 x D

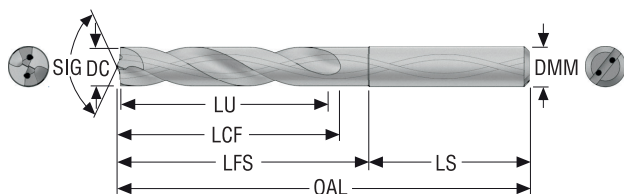


- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 60°/130°
- Dura gyémánt bevonat
- Forgácsolási adatokat lásd a 149, 150 old.

| Megnevezés             | Cikkszám | Várható_furat_tűrés |               | DC            | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|---------------------|---------------|---------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm                  | Inch          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |
| SD205A-6.0-31-6R1-C1   | 02740089 | 5,975/6,025         | 0.2352/0.2372 | 6,0<br>0.236  | 31,0<br>1.220 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-9.55-46-10R1-C1 | 02740092 | 9,525/9,576         | 0.3750/0.3770 | 9,55<br>0.376 | 46,0<br>1.811 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |

## SD205A-C2

Fúrési mélység ~ 5 x D

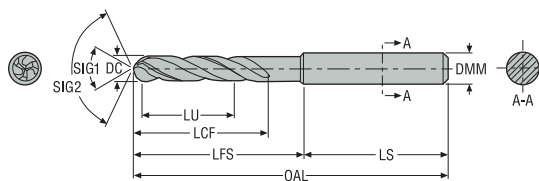


- Hengeres szár DIN 6537A
- Belső hűtés
- Csúcs szög: 140°/180°
- Dura gyémánt bevonat
- Forgácsolási adatokat lásd a 149, 150 old.

| Megnevezés             | Cikkszám | Várható_furat_tűrés |               | DC            | LU            | OAL            | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|---------------------|---------------|---------------|---------------|----------------|---------------|---------------|---------------|---------------|
|                        |          | mm                  | Inch          |               |               |                |               |               |               |               |
| SD205A-6.0-32-6R1-C2   | 02740099 | 5,975/6,025         | 0.2352/0.2372 | 6,0<br>0.236  | 32,0<br>1.260 | 82,0<br>3.228  | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236  |
| SD205A-9.55-48-10R1-C2 | 02740103 | 9,525/9,576         | 0.3750/0.3770 | 9,55<br>0.376 | 48,0<br>1.890 | 103,0<br>4.055 | 63,0<br>2.480 | 40,0<br>1.575 | 61,0<br>2.402 | 10,0<br>0.394 |

## SD203-CX1

Fúrási mélység ~ 3 x D

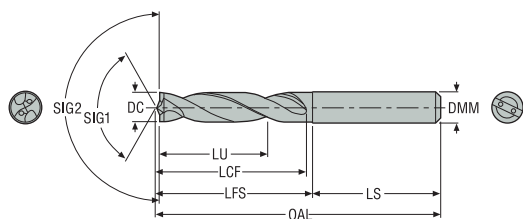


- Hengeres szár DIN 6537A
- PCD vágóélek.
- Csúcs szög: 60°/130°
- Forgácsolási adatokat lásd a 147, 148 old.

| Megnevezés             | Cikkszám | Várható_furat_tűrés |               | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM           |
|------------------------|----------|---------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
|                        |          | mm                  | Inch          |               |               |               |               |               |               |               |
| SD203-3.26-14-6R1-CX1  | 02827923 | 3,235/3,285         | 0.1273/0.1293 | 3,26<br>0.128 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 21,0<br>0.827 | 6,0<br>0.236  |
| SD203-4.17-17-6R1-CX1  | 02827924 | 4,142/4,192         | 0.1630/0.1650 | 4,17<br>0.164 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 25,0<br>0.984 | 6,0<br>0.236  |
| SD203-4.83-20-6R1-CX1  | 02827925 | 4,805/4,855         | 0.1891/0.1911 | 4,83<br>0.190 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203-6.06-21-6R1-CX1  | 02827926 | 6,035/6,085         | 0.2375/0.2395 | 6,06<br>0.239 | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203-6.36-23-8R1-CX1  | 02827927 | 6,33/6,38           | 0.2492/0.2511 | 6,36<br>0.250 | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203-7.94-27-8R1-CX1  | 02827928 | 7,913/7,963         | 0.3115/0.3135 | 7,94<br>0.313 | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203-9.53-31-10R1-CX1 | 02827929 | 9,504/9,554         | 0.3741/0.3761 | 9,53<br>0.375 | 31,0<br>1.220 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |

## SD203A-CX2

Fúrési mélység ~ 3 x D

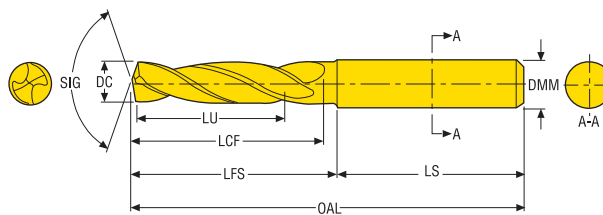


- Hengeres szár DIN 6537A
- PCD vágóélek.
- Csúcs szög: 120°/180°
- Forgácsolási adatokat lásd a 149, 150 old.

| Megnevezés              | Cikkszám | Várható_furat_tűrés |               | DC            | LU            | OAL           | LFS           | LS            | LCF           | DMM           |
|-------------------------|----------|---------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|
|                         |          | mm                  | Inch          |               |               |               |               |               |               |               |
| SD203A-3.26-14-6R1-CX2  | 02827930 | 3,235/3,285         | 0.1273/0.1293 | 3,26<br>0.128 | 14,0<br>0.551 | 62,0<br>2.441 | 26,0<br>1.024 | 36,0<br>1.417 | 20,0<br>0.787 | 6,0<br>0.236  |
| SD203A-4.17-17-6R1-CX2  | 02827931 | 4,142/4,192         | 0.1630/0.1650 | 4,17<br>0.164 | 17,0<br>0.669 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 24,0<br>0.945 | 6,0<br>0.236  |
| SD203A-4.83-20-6R1-CX2  | 02827932 | 4,805/4,855         | 0.1891/0.1911 | 4,83<br>0.190 | 20,0<br>0.787 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-6.06-21-6R1-CX2  | 02827933 | 6,035/6,085         | 0.2375/0.2395 | 6,06<br>0.239 | 21,0<br>0.827 | 66,0<br>2.598 | 30,0<br>1.181 | 36,0<br>1.417 | 28,0<br>1.102 | 6,0<br>0.236  |
| SD203A-6.36-23-8R1-CX2  | 02827934 | 6,33/6,38           | 0.2492/0.2511 | 6,36<br>0.250 | 23,0<br>0.906 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 34,0<br>1.339 | 8,0<br>0.315  |
| SD203A-7.94-27-8R1-CX2  | 02827935 | 7,913/7,963         | 0.3115/0.3135 | 7,94<br>0.313 | 27,0<br>1.063 | 79,0<br>3.110 | 43,0<br>1.693 | 36,0<br>1.417 | 41,0<br>1.614 | 8,0<br>0.315  |
| SD203A-9.53-31-10R1-CX2 | 02827936 | 9,504/9,554         | 0.3741/0.3761 | 9,53<br>0.375 | 31,0<br>1.220 | 89,0<br>3.504 | 49,0<br>1.929 | 40,0<br>1.575 | 47,0<br>1.850 | 10,0<br>0.394 |

## SD205-CX31

Fúrási mélység ~ 5 x D



- Hengeres szár DIN 6537A
- PCD vágóélek.
- Csúcs szög: 120°
- Forgácsolási adatokat lásd a 149 old.

| Megnevezés              | Cikkszám | Várható_furat_tűrés |               | DC             | LU            | OAL           | LFS           | LS            | LCF           | DMM          |
|-------------------------|----------|---------------------|---------------|----------------|---------------|---------------|---------------|---------------|---------------|--------------|
|                         |          | mm                  | Inch          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD205-4.10-26-6R1-CX31  | 02780522 | 4,075/4,125         | 0.1604/0.1624 | 4,1<br>0.161   | 26,0<br>1.024 | 74,0<br>2.913 | 38,0<br>1.496 | 36,0<br>1.417 | 37,0<br>1.457 | 6,0<br>0.236 |
| SD205-4.78-31-6R1-CX31  | 02780523 | 4,755/4,805         | 0.1872/0.1891 | 4,78<br>0.188  | 31,0<br>1.220 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205-6.00-31-6R1-CX31  | 02780524 | 5,975/6,025         | 0.2352/0.2372 | 6,0<br>0.236   | 31,0<br>1.220 | 82,0<br>3.228 | 46,0<br>1.811 | 36,0<br>1.417 | 44,0<br>1.732 | 6,0<br>0.236 |
| SD205-6.38-34-8R1-CX31  | 02780525 | 6,350/6,401         | 0.2500/0.2520 | 6,38<br>0.251  | 34,0<br>1.339 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |
| SD205-7.963-40-8R1-CX31 | 02780527 | 7,938/7,988         | 0.3125/0.3144 | 7,963<br>0.314 | 40,0<br>1.575 | 91,0<br>3.583 | 55,0<br>2.165 | 36,0<br>1.417 | 53,0<br>2.087 | 8,0<br>0.315 |



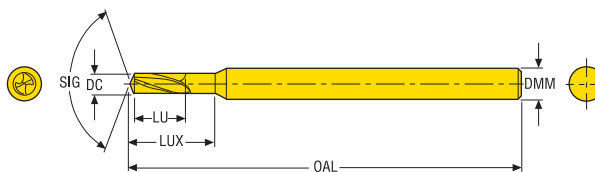
## Mikro-fúrás

A Seco mikro-fúrési alkalmazásokat célzó, dedikált termékeket tartalmazó portfóliója a kis méretű, tömör keményfém mikrofúrók SD22 és SD26 termékcsaládját tartalmazza.

- A hagyományos HSS fúrókhoz képest drámaian nagyobb teljesítményt nyújtanak
- Alkalmas autóiipari és orvosi iparágakban való alkalmazásokhoz, valamint a gépiparban apró alkatrészek gyártásához

## SD22

Fúrési mélység ~ 2 X D (előfúró)



- Hengeres szár
- Külső hűtés
- Csúcs szög: 130°
- Bevonat nélküli
- Forgácsolási adatokat lásd a 169-173 old.

| Megnevezés         | Cikkszám | DC            |               | LU            |               | LUX          |            | DMM |
|--------------------|----------|---------------|---------------|---------------|---------------|--------------|------------|-----|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch |     |
| SD22-0.10-0.20-3R1 | 02731574 | 0,1<br>0.004  | 0,2<br>0.008  | 38,0<br>1.496 | 0,55<br>0.022 | 3,0<br>0.118 |            |     |
| SD22-0.11-0.22-3R1 | 02730362 | 0,11<br>0.004 | 0,22<br>0.009 | 38,0<br>1.496 | 0,55<br>0.022 | 3,0<br>0.118 |            |     |
| SD22-0.12-0.24-3R1 | 02730460 | 0,12<br>0.005 | 0,24<br>0.009 | 38,0<br>1.496 | 0,55<br>0.022 | 3,0<br>0.118 |            |     |
| SD22-0.13-0.26-3R1 | 02730461 | 0,13<br>0.005 | 0,26<br>0.010 | 38,0<br>1.496 | 0,6<br>0.024  | 3,0<br>0.118 |            |     |
| SD22-0.14-0.28-3R1 | 02730462 | 0,14<br>0.006 | 0,28<br>0.011 | 38,0<br>1.496 | 0,6<br>0.024  | 3,0<br>0.118 |            |     |
| SD22-0.15-0.30-3R1 | 02731575 | 0,15<br>0.006 | 0,3<br>0.012  | 38,0<br>1.496 | 0,6<br>0.024  | 3,0<br>0.118 |            |     |
| SD22-0.16-0.32-3R1 | 02730464 | 0,16<br>0.006 | 0,32<br>0.013 | 38,0<br>1.496 | 0,6<br>0.024  | 3,0<br>0.118 |            |     |
| SD22-0.17-0.34-3R1 | 02730465 | 0,17<br>0.007 | 0,34<br>0.013 | 38,0<br>1.496 | 0,7<br>0.028  | 3,0<br>0.118 |            |     |
| SD22-0.18-0.36-3R1 | 02730466 | 0,18<br>0.007 | 0,36<br>0.014 | 38,0<br>1.496 | 0,7<br>0.028  | 3,0<br>0.118 |            |     |
| SD22-0.19-0.38-3R1 | 02730467 | 0,19<br>0.007 | 0,38<br>0.015 | 38,0<br>1.496 | 0,7<br>0.028  | 3,0<br>0.118 |            |     |
| SD22-0.20-0.40-3R1 | 02731576 | 0,2<br>0.008  | 0,4<br>0.016  | 38,0<br>1.496 | 0,75<br>0.030 | 3,0<br>0.118 |            |     |
| SD22-0.21-0.42-3R1 | 02730468 | 0,21<br>0.008 | 0,42<br>0.017 | 38,0<br>1.496 | 0,75<br>0.030 | 3,0<br>0.118 |            |     |
| SD22-0.22-0.44-3R1 | 02730469 | 0,22<br>0.009 | 0,44<br>0.017 | 38,0<br>1.496 | 0,8<br>0.031  | 3,0<br>0.118 |            |     |
| SD22-0.23-0.46-3R1 | 02730470 | 0,23<br>0.009 | 0,46<br>0.018 | 38,0<br>1.496 | 0,8<br>0.031  | 3,0<br>0.118 |            |     |
| SD22-0.24-0.48-3R1 | 02730471 | 0,24<br>0.009 | 0,48<br>0.019 | 38,0<br>1.496 | 0,8<br>0.031  | 3,0<br>0.118 |            |     |
| SD22-0.25-0.50-3R1 | 02731577 | 0,25<br>0.010 | 0,5<br>0.020  | 38,0<br>1.496 | 0,9<br>0.035  | 3,0<br>0.118 |            |     |
| SD22-0.26-0.52-3R1 | 02730472 | 0,26<br>0.010 | 0,52<br>0.020 | 38,0<br>1.496 | 0,9<br>0.035  | 3,0<br>0.118 |            |     |
| SD22-0.27-0.54-3R1 | 02730473 | 0,27<br>0.011 | 0,54<br>0.021 | 38,0<br>1.496 | 0,9<br>0.035  | 3,0<br>0.118 |            |     |
| SD22-0.28-0.56-3R1 | 02730474 | 0,28<br>0.011 | 0,56<br>0.022 | 38,0<br>1.496 | 1,0<br>0.039  | 3,0<br>0.118 |            |     |
| SD22-0.29-0.58-3R1 | 02730475 | 0,29<br>0.011 | 0,58<br>0.023 | 38,0<br>1.496 | 1,0<br>0.039  | 3,0<br>0.118 |            |     |
| SD22-0.30-0.60-3R1 | 02731579 | 0,3<br>0.012  | 0,6<br>0.024  | 38,0<br>1.496 | 1,2<br>0.047  | 3,0<br>0.118 |            |     |



| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX           | DMM          |
|--------------------|----------|---------------|---------------|---------------|---------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD22-0.31-0.62-3R1 | 02730476 | 0,31<br>0.012 | 0,62<br>0.024 | 38,0<br>1.496 | 1,2<br>0.047  | 3,0<br>0.118 |
| SD22-0.32-0.64-3R1 | 02730477 | 0,32<br>0.013 | 0,64<br>0.025 | 38,0<br>1.496 | 1,2<br>0.047  | 3,0<br>0.118 |
| SD22-0.33-0.66-3R1 | 02730478 | 0,33<br>0.013 | 0,66<br>0.026 | 38,0<br>1.496 | 1,2<br>0.047  | 3,0<br>0.118 |
| SD22-0.34-0.68-3R1 | 02730479 | 0,34<br>0.013 | 0,68<br>0.027 | 38,0<br>1.496 | 1,35<br>0.053 | 3,0<br>0.118 |
| SD22-0.35-0.70-3R1 | 02731580 | 0,35<br>0.014 | 0,7<br>0.028  | 38,0<br>1.496 | 1,35<br>0.053 | 3,0<br>0.118 |
| SD22-0.36-0.72-3R1 | 02730480 | 0,36<br>0.014 | 0,72<br>0.028 | 38,0<br>1.496 | 1,35<br>0.053 | 3,0<br>0.118 |
| SD22-0.37-0.74-3R1 | 02730481 | 0,37<br>0.015 | 0,74<br>0.029 | 38,0<br>1.496 | 1,35<br>0.053 | 3,0<br>0.118 |
| SD22-0.38-0.76-3R1 | 02730482 | 0,38<br>0.015 | 0,76<br>0.030 | 38,0<br>1.496 | 1,5<br>0.059  | 3,0<br>0.118 |
| SD22-0.39-0.78-3R1 | 02730483 | 0,39<br>0.015 | 0,78<br>0.031 | 38,0<br>1.496 | 1,5<br>0.059  | 3,0<br>0.118 |
| SD22-0.40-0.80-3R1 | 02731581 | 0,4<br>0.016  | 0,8<br>0.031  | 38,0<br>1.496 | 1,6<br>0.063  | 3,0<br>0.118 |
| SD22-0.41-0.82-3R1 | 02730484 | 0,41<br>0.016 | 0,82<br>0.032 | 38,0<br>1.496 | 1,6<br>0.063  | 3,0<br>0.118 |
| SD22-0.42-0.84-3R1 | 02730485 | 0,42<br>0.017 | 0,84<br>0.033 | 38,0<br>1.496 | 1,6<br>0.063  | 3,0<br>0.118 |
| SD22-0.43-0.86-3R1 | 02730486 | 0,43<br>0.017 | 0,86<br>0.034 | 38,0<br>1.496 | 1,6<br>0.063  | 3,0<br>0.118 |
| SD22-0.44-0.88-3R1 | 02730487 | 0,44<br>0.017 | 0,88<br>0.035 | 38,0<br>1.496 | 1,6<br>0.063  | 3,0<br>0.118 |
| SD22-0.45-0.90-3R1 | 02731582 | 0,45<br>0.018 | 0,9<br>0.035  | 38,0<br>1.496 | 1,6<br>0.063  | 3,0<br>0.118 |
| SD22-0.46-0.92-3R1 | 02730488 | 0,46<br>0.018 | 0,92<br>0.036 | 38,0<br>1.496 | 1,7<br>0.067  | 3,0<br>0.118 |
| SD22-0.47-0.94-3R1 | 02730489 | 0,47<br>0.019 | 0,94<br>0.037 | 38,0<br>1.496 | 1,7<br>0.067  | 3,0<br>0.118 |
| SD22-0.48-0.96-3R1 | 02730490 | 0,48<br>0.019 | 0,96<br>0.038 | 38,0<br>1.496 | 1,7<br>0.067  | 3,0<br>0.118 |
| SD22-0.49-0.98-3R1 | 02730491 | 0,49<br>0.019 | 0,98<br>0.039 | 38,0<br>1.496 | 1,7<br>0.067  | 3,0<br>0.118 |
| SD22-0.50-1.00-3R1 | 02731584 | 0,5<br>0.020  | 1,0<br>0.039  | 38,0<br>1.496 | 1,7<br>0.067  | 3,0<br>0.118 |
| SD22-0.51-1.02-3R1 | 02730492 | 0,51<br>0.020 | 1,02<br>0.040 | 38,0<br>1.496 | 1,8<br>0.071  | 3,0<br>0.118 |
| SD22-0.52-1.04-3R1 | 02730493 | 0,52<br>0.020 | 1,04<br>0.041 | 38,0<br>1.496 | 1,8<br>0.071  | 3,0<br>0.118 |
| SD22-0.53-1.06-3R1 | 02730494 | 0,53<br>0.021 | 1,06<br>0.042 | 38,0<br>1.496 | 1,8<br>0.071  | 3,0<br>0.118 |
| SD22-0.54-1.08-3R1 | 02730495 | 0,54<br>0.021 | 1,08<br>0.043 | 38,0<br>1.496 | 1,8<br>0.071  | 3,0<br>0.118 |
| SD22-0.55-1.10-3R1 | 02731585 | 0,55<br>0.022 | 1,1<br>0.043  | 38,0<br>1.496 | 1,8<br>0.071  | 3,0<br>0.118 |
| SD22-0.56-1.12-3R1 | 02730496 | 0,56<br>0.022 | 1,12<br>0.044 | 38,0<br>1.496 | 1,9<br>0.075  | 3,0<br>0.118 |
| SD22-0.57-1.14-3R1 | 02730497 | 0,57<br>0.022 | 1,14<br>0.045 | 38,0<br>1.496 | 1,9<br>0.075  | 3,0<br>0.118 |
| SD22-0.58-1.16-3R1 | 02730498 | 0,58<br>0.023 | 1,16<br>0.046 | 38,0<br>1.496 | 1,9<br>0.075  | 3,0<br>0.118 |
| SD22-0.59-1.18-3R1 | 02730499 | 0,59<br>0.023 | 1,18<br>0.046 | 38,0<br>1.496 | 1,9<br>0.075  | 3,0<br>0.118 |
| SD22-0.60-1.20-3R1 | 02731586 | 0,6<br>0.024  | 1,2<br>0.047  | 38,0<br>1.496 | 1,9<br>0.075  | 3,0<br>0.118 |
| SD22-0.61-1.22-3R1 | 02730500 | 0,61<br>0.024 | 1,22<br>0.048 | 38,0<br>1.496 | 2,0<br>0.079  | 3,0<br>0.118 |

| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|---------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD22-0.62-1.24-3R1 | 02730501 | 0,62<br>0.024 | 1,24<br>0.049 | 38,0<br>1.496 | 2,0<br>0.079 | 3,0<br>0.118 |
| SD22-0.63-1.26-3R1 | 02730502 | 0,63<br>0.025 | 1,26<br>0.050 | 38,0<br>1.496 | 2,0<br>0.079 | 3,0<br>0.118 |
| SD22-0.64-1.28-3R1 | 02730503 | 0,64<br>0.025 | 1,28<br>0.050 | 38,0<br>1.496 | 2,0<br>0.079 | 3,0<br>0.118 |
| SD22-0.65-1.30-3R1 | 02731587 | 0,65<br>0.026 | 1,3<br>0.051  | 38,0<br>1.496 | 2,0<br>0.079 | 3,0<br>0.118 |
| SD22-0.66-1.32-3R1 | 02730504 | 0,66<br>0.026 | 1,32<br>0.052 | 38,0<br>1.496 | 2,1<br>0.083 | 3,0<br>0.118 |
| SD22-0.67-1.34-3R1 | 02730505 | 0,67<br>0.026 | 1,34<br>0.053 | 38,0<br>1.496 | 2,1<br>0.083 | 3,0<br>0.118 |
| SD22-0.68-1.36-3R1 | 02730506 | 0,68<br>0.027 | 1,36<br>0.054 | 38,0<br>1.496 | 2,1<br>0.083 | 3,0<br>0.118 |
| SD22-0.69-1.38-3R1 | 02730507 | 0,69<br>0.027 | 1,38<br>0.054 | 38,0<br>1.496 | 2,1<br>0.083 | 3,0<br>0.118 |
| SD22-0.70-1.40-3R1 | 02731589 | 0,7<br>0.028  | 1,4<br>0.055  | 38,0<br>1.496 | 2,1<br>0.083 | 3,0<br>0.118 |
| SD22-0.71-1.42-3R1 | 02730508 | 0,71<br>0.028 | 1,42<br>0.056 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD22-0.72-1.44-3R1 | 02730509 | 0,72<br>0.028 | 1,44<br>0.057 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD22-0.73-1.46-3R1 | 02730510 | 0,73<br>0.029 | 1,46<br>0.057 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD22-0.74-1.48-3R1 | 02730511 | 0,74<br>0.029 | 1,48<br>0.058 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD22-0.75-1.50-3R1 | 02731590 | 0,75<br>0.030 | 1,5<br>0.059  | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD22-0.76-1.52-3R1 | 02730512 | 0,76<br>0.030 | 1,52<br>0.060 | 38,0<br>1.496 | 2,3<br>0.091 | 3,0<br>0.118 |
| SD22-0.77-1.54-3R1 | 02730513 | 0,77<br>0.030 | 1,54<br>0.061 | 38,0<br>1.496 | 2,3<br>0.091 | 3,0<br>0.118 |
| SD22-0.78-1.56-3R1 | 02730514 | 0,78<br>0.031 | 1,56<br>0.061 | 38,0<br>1.496 | 2,3<br>0.091 | 3,0<br>0.118 |
| SD22-0.79-1.58-3R1 | 02730515 | 0,79<br>0.031 | 1,58<br>0.062 | 38,0<br>1.496 | 2,3<br>0.091 | 3,0<br>0.118 |
| SD22-0.80-1.60-3R1 | 02731592 | 0,8<br>0.031  | 1,6<br>0.063  | 38,0<br>1.496 | 2,3<br>0.091 | 3,0<br>0.118 |
| SD22-0.81-1.62-3R1 | 02730516 | 0,81<br>0.032 | 1,62<br>0.064 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD22-0.82-1.64-3R1 | 02730517 | 0,82<br>0.032 | 1,64<br>0.065 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD22-0.83-1.66-3R1 | 02730518 | 0,83<br>0.033 | 1,66<br>0.065 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD22-0.84-1.68-3R1 | 02730519 | 0,84<br>0.033 | 1,68<br>0.066 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD22-0.85-1.70-3R1 | 02731593 | 0,85<br>0.033 | 1,7<br>0.067  | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD22-0.86-1.72-3R1 | 02730520 | 0,86<br>0.034 | 1,72<br>0.068 | 38,0<br>1.496 | 2,5<br>0.098 | 3,0<br>0.118 |
| SD22-0.87-1.74-3R1 | 02730521 | 0,87<br>0.034 | 1,74<br>0.069 | 38,0<br>1.496 | 2,5<br>0.098 | 3,0<br>0.118 |
| SD22-0.88-1.76-3R1 | 02730522 | 0,88<br>0.035 | 1,76<br>0.069 | 38,0<br>1.496 | 2,5<br>0.098 | 3,0<br>0.118 |
| SD22-0.89-1.78-3R1 | 02730523 | 0,89<br>0.035 | 1,78<br>0.070 | 38,0<br>1.496 | 2,5<br>0.098 | 3,0<br>0.118 |
| SD22-0.90-1.80-3R1 | 02731594 | 0,9<br>0.035  | 1,8<br>0.071  | 38,0<br>1.496 | 2,5<br>0.098 | 3,0<br>0.118 |
| SD22-0.91-1.82-3R1 | 02730524 | 0,91<br>0.036 | 1,82<br>0.072 | 38,0<br>1.496 | 2,6<br>0.102 | 3,0<br>0.118 |
| SD22-0.92-1.84-3R1 | 02730525 | 0,92<br>0.036 | 1,84<br>0.072 | 38,0<br>1.496 | 2,6<br>0.102 | 3,0<br>0.118 |

| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|---------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD22-0.93-1.86-3R1 | 02730526 | 0,93<br>0.037 | 1,86<br>0.073 | 38,0<br>1.496 | 2,6<br>0.102 | 3,0<br>0.118 |
| SD22-0.94-1.88-3R1 | 02730527 | 0,94<br>0.037 | 1,88<br>0.074 | 38,0<br>1.496 | 2,6<br>0.102 | 3,0<br>0.118 |
| SD22-0.95-1.90-3R1 | 02731595 | 0,95<br>0.037 | 1,9<br>0.075  | 38,0<br>1.496 | 2,6<br>0.102 | 3,0<br>0.118 |
| SD22-0.96-1.92-3R1 | 02730528 | 0,96<br>0.038 | 1,92<br>0.076 | 38,0<br>1.496 | 2,7<br>0.106 | 3,0<br>0.118 |
| SD22-0.97-1.94-3R1 | 02730529 | 0,97<br>0.038 | 1,94<br>0.076 | 38,0<br>1.496 | 2,7<br>0.106 | 3,0<br>0.118 |
| SD22-0.98-1.96-3R1 | 02730530 | 0,98<br>0.039 | 1,96<br>0.077 | 38,0<br>1.496 | 2,7<br>0.106 | 3,0<br>0.118 |
| SD22-0.99-1.98-3R1 | 02730531 | 0,99<br>0.039 | 1,98<br>0.078 | 38,0<br>1.496 | 2,7<br>0.106 | 3,0<br>0.118 |
| SD22-1.00-2.00-3R1 | 02731596 | 1,0<br>0.039  | 2,0<br>0.079  | 38,0<br>1.496 | 2,7<br>0.106 | 3,0<br>0.118 |
| SD22-1.01-2.02-3R1 | 02730532 | 1,01<br>0.040 | 2,02<br>0.080 | 38,0<br>1.496 | 3,5<br>0.138 | 3,0<br>0.118 |
| SD22-1.02-2.04-3R1 | 02730533 | 1,02<br>0.040 | 2,04<br>0.080 | 38,0<br>1.496 | 3,5<br>0.138 | 3,0<br>0.118 |
| SD22-1.03-2.06-3R1 | 02730534 | 1,03<br>0.041 | 2,06<br>0.081 | 38,0<br>1.496 | 3,5<br>0.138 | 3,0<br>0.118 |
| SD22-1.04-2.08-3R1 | 02730535 | 1,04<br>0.041 | 2,08<br>0.082 | 38,0<br>1.496 | 3,5<br>0.138 | 3,0<br>0.118 |
| SD22-1.05-2.10-3R1 | 02730536 | 1,05<br>0.041 | 2,1<br>0.083  | 38,0<br>1.496 | 3,5<br>0.138 | 3,0<br>0.118 |
| SD22-1.06-2.12-3R1 | 02730537 | 1,06<br>0.042 | 2,12<br>0.083 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD22-1.07-2.14-3R1 | 02730538 | 1,07<br>0.042 | 2,14<br>0.084 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD22-1.08-2.16-3R1 | 02730539 | 1,08<br>0.043 | 2,16<br>0.085 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD22-1.09-2.18-3R1 | 02730540 | 1,09<br>0.043 | 2,18<br>0.086 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD22-1.10-2.20-3R1 | 02731598 | 1,1<br>0.043  | 2,2<br>0.087  | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD22-1.11-2.22-3R1 | 02730541 | 1,11<br>0.044 | 2,22<br>0.087 | 38,0<br>1.496 | 3,7<br>0.146 | 3,0<br>0.118 |
| SD22-1.12-2.24-3R1 | 02730542 | 1,12<br>0.044 | 2,24<br>0.088 | 38,0<br>1.496 | 3,7<br>0.146 | 3,0<br>0.118 |
| SD22-1.13-2.26-3R1 | 02730543 | 1,13<br>0.044 | 2,26<br>0.089 | 38,0<br>1.496 | 3,7<br>0.146 | 3,0<br>0.118 |
| SD22-1.14-2.28-3R1 | 02730544 | 1,14<br>0.045 | 2,28<br>0.090 | 38,0<br>1.496 | 3,7<br>0.146 | 3,0<br>0.118 |
| SD22-1.15-2.30-3R1 | 02730545 | 1,15<br>0.045 | 2,3<br>0.091  | 38,0<br>1.496 | 3,7<br>0.146 | 3,0<br>0.118 |
| SD22-1.16-2.32-3R1 | 02730546 | 1,16<br>0.046 | 2,32<br>0.091 | 38,0<br>1.496 | 3,8<br>0.150 | 3,0<br>0.118 |
| SD22-1.17-2.34-3R1 | 02730547 | 1,17<br>0.046 | 2,34<br>0.092 | 38,0<br>1.496 | 3,8<br>0.150 | 3,0<br>0.118 |
| SD22-1.18-2.36-3R1 | 02730548 | 1,18<br>0.046 | 2,36<br>0.093 | 38,0<br>1.496 | 3,8<br>0.150 | 3,0<br>0.118 |
| SD22-1.19-2.38-3R1 | 02730549 | 1,19<br>0.047 | 2,38<br>0.094 | 38,0<br>1.496 | 3,8<br>0.150 | 3,0<br>0.118 |
| SD22-1.20-2.40-3R1 | 02731599 | 1,2<br>0.047  | 2,4<br>0.094  | 38,0<br>1.496 | 3,8<br>0.150 | 3,0<br>0.118 |
| SD22-1.21-2.42-3R1 | 02730550 | 1,21<br>0.048 | 2,42<br>0.095 | 38,0<br>1.496 | 4,2<br>0.165 | 3,0<br>0.118 |
| SD22-1.22-2.44-3R1 | 02730551 | 1,22<br>0.048 | 2,44<br>0.096 | 38,0<br>1.496 | 4,2<br>0.165 | 3,0<br>0.118 |
| SD22-1.23-2.46-3R1 | 02730552 | 1,23<br>0.048 | 2,46<br>0.097 | 38,0<br>1.496 | 4,2<br>0.165 | 3,0<br>0.118 |

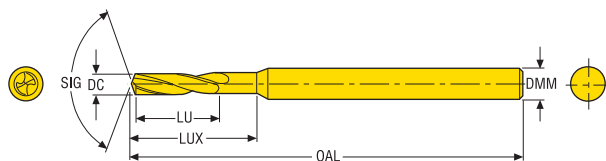
| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|---------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD22-1.24-2.48-3R1 | 02730553 | 1,24<br>0.049 | 2,48<br>0.098 | 38,0<br>1.496 | 4,2<br>0.165 | 3,0<br>0.118 |
| SD22-1.25-2.50-3R1 | 02730554 | 1,25<br>0.049 | 2,5<br>0.098  | 38,0<br>1.496 | 4,2<br>0.165 | 3,0<br>0.118 |
| SD22-1.26-2.52-3R1 | 02730555 | 1,26<br>0.050 | 2,52<br>0.099 | 38,0<br>1.496 | 4,3<br>0.169 | 3,0<br>0.118 |
| SD22-1.27-2.54-3R1 | 02730556 | 1,27<br>0.050 | 2,54<br>0.100 | 38,0<br>1.496 | 4,3<br>0.169 | 3,0<br>0.118 |
| SD22-1.28-2.56-3R1 | 02730557 | 1,28<br>0.050 | 2,56<br>0.101 | 38,0<br>1.496 | 4,3<br>0.169 | 3,0<br>0.118 |
| SD22-1.29-2.58-3R1 | 02730558 | 1,29<br>0.051 | 2,58<br>0.102 | 38,0<br>1.496 | 4,3<br>0.169 | 3,0<br>0.118 |
| SD22-1.30-2.60-3R1 | 02731600 | 1,3<br>0.051  | 2,6<br>0.102  | 38,0<br>1.496 | 4,3<br>0.169 | 3,0<br>0.118 |
| SD22-1.31-2.62-3R1 | 02730559 | 1,31<br>0.052 | 2,62<br>0.103 | 38,0<br>1.496 | 4,4<br>0.173 | 3,0<br>0.118 |
| SD22-1.32-2.64-3R1 | 02730560 | 1,32<br>0.052 | 2,64<br>0.104 | 38,0<br>1.496 | 4,4<br>0.173 | 3,0<br>0.118 |
| SD22-1.33-2.66-3R1 | 02730561 | 1,33<br>0.052 | 2,66<br>0.105 | 38,0<br>1.496 | 4,4<br>0.173 | 3,0<br>0.118 |
| SD22-1.34-2.68-3R1 | 02730562 | 1,34<br>0.053 | 2,68<br>0.106 | 38,0<br>1.496 | 4,4<br>0.173 | 3,0<br>0.118 |
| SD22-1.35-2.70-3R1 | 02730563 | 1,35<br>0.053 | 2,7<br>0.106  | 38,0<br>1.496 | 4,4<br>0.173 | 3,0<br>0.118 |
| SD22-1.36-2.72-3R1 | 02730564 | 1,36<br>0.054 | 2,72<br>0.107 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD22-1.37-2.74-3R1 | 02730565 | 1,37<br>0.054 | 2,74<br>0.108 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD22-1.38-2.76-3R1 | 02730566 | 1,38<br>0.054 | 2,76<br>0.109 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD22-1.39-2.78-3R1 | 02730567 | 1,39<br>0.055 | 2,78<br>0.109 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD22-1.40-2.80-3R1 | 02731602 | 1,4<br>0.055  | 2,8<br>0.110  | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD22-1.41-2.82-3R1 | 02730568 | 1,41<br>0.056 | 2,82<br>0.111 | 38,0<br>1.496 | 4,6<br>0.181 | 3,0<br>0.118 |
| SD22-1.42-2.84-3R1 | 02730569 | 1,42<br>0.056 | 2,84<br>0.112 | 38,0<br>1.496 | 4,6<br>0.181 | 3,0<br>0.118 |
| SD22-1.43-2.86-3R1 | 02730570 | 1,43<br>0.056 | 2,86<br>0.113 | 38,0<br>1.496 | 4,6<br>0.181 | 3,0<br>0.118 |
| SD22-1.44-2.88-3R1 | 02730571 | 1,44<br>0.057 | 2,88<br>0.113 | 38,0<br>1.496 | 4,6<br>0.181 | 3,0<br>0.118 |
| SD22-1.45-2.90-3R1 | 02730572 | 1,45<br>0.057 | 2,9<br>0.114  | 38,0<br>1.496 | 4,6<br>0.181 | 3,0<br>0.118 |
| SD22-1.46-2.92-3R1 | 02730573 | 1,46<br>0.057 | 2,92<br>0.115 | 38,0<br>1.496 | 4,7<br>0.185 | 3,0<br>0.118 |
| SD22-1.47-2.94-3R1 | 02730574 | 1,47<br>0.058 | 2,94<br>0.116 | 38,0<br>1.496 | 4,7<br>0.185 | 3,0<br>0.118 |
| SD22-1.48-2.96-3R1 | 02730575 | 1,48<br>0.058 | 2,96<br>0.117 | 38,0<br>1.496 | 4,7<br>0.185 | 3,0<br>0.118 |
| SD22-1.49-2.98-3R1 | 02730576 | 1,49<br>0.059 | 2,98<br>0.117 | 38,0<br>1.496 | 4,7<br>0.185 | 3,0<br>0.118 |
| SD22-1.50-3.00-3R1 | 02731603 | 1,5<br>0.059  | 3,0<br>0.118  | 38,0<br>1.496 | 4,7<br>0.185 | 3,0<br>0.118 |
| SD22-1.51-3.02-3R1 | 02730577 | 1,51<br>0.059 | 3,02<br>0.119 | 38,0<br>1.496 | 5,1<br>0.201 | 3,0<br>0.118 |
| SD22-1.52-3.04-3R1 | 02730578 | 1,52<br>0.060 | 3,04<br>0.120 | 38,0<br>1.496 | 5,1<br>0.201 | 3,0<br>0.118 |
| SD22-1.53-3.06-3R1 | 02730579 | 1,53<br>0.060 | 3,06<br>0.120 | 38,0<br>1.496 | 5,1<br>0.201 | 3,0<br>0.118 |
| SD22-1.54-3.08-3R1 | 02730580 | 1,54<br>0.061 | 3,08<br>0.121 | 38,0<br>1.496 | 5,1<br>0.201 | 3,0<br>0.118 |

| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|---------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD22-1.55-3.10-3R1 | 02730581 | 1,55<br>0.061 | 3,1<br>0.122  | 38,0<br>1.496 | 5,1<br>0.201 | 3,0<br>0.118 |
| SD22-1.56-3.12-3R1 | 02730582 | 1,56<br>0.061 | 3,12<br>0.123 | 38,0<br>1.496 | 5,2<br>0.205 | 3,0<br>0.118 |
| SD22-1.57-3.14-3R1 | 02730583 | 1,57<br>0.062 | 3,14<br>0.124 | 38,0<br>1.496 | 5,2<br>0.205 | 3,0<br>0.118 |
| SD22-1.58-3.16-3R1 | 02730584 | 1,58<br>0.062 | 3,16<br>0.124 | 38,0<br>1.496 | 5,2<br>0.205 | 3,0<br>0.118 |
| SD22-1.59-3.18-3R1 | 02730585 | 1,59<br>0.063 | 3,18<br>0.125 | 38,0<br>1.496 | 5,2<br>0.205 | 3,0<br>0.118 |
| SD22-1.60-3.20-3R1 | 02731605 | 1,6<br>0.063  | 3,2<br>0.126  | 38,0<br>1.496 | 5,2<br>0.205 | 3,0<br>0.118 |
| SD22-1.61-3.22-3R1 | 02730586 | 1,61<br>0.063 | 3,22<br>0.127 | 38,0<br>1.496 | 5,3<br>0.209 | 3,0<br>0.118 |
| SD22-1.62-3.24-3R1 | 02730587 | 1,62<br>0.064 | 3,24<br>0.128 | 38,0<br>1.496 | 5,3<br>0.209 | 3,0<br>0.118 |
| SD22-1.63-3.26-3R1 | 02730588 | 1,63<br>0.064 | 3,26<br>0.128 | 38,0<br>1.496 | 5,3<br>0.209 | 3,0<br>0.118 |
| SD22-1.64-3.28-3R1 | 02730589 | 1,64<br>0.065 | 3,28<br>0.129 | 38,0<br>1.496 | 5,3<br>0.209 | 3,0<br>0.118 |
| SD22-1.65-3.30-3R1 | 02730590 | 1,65<br>0.065 | 3,3<br>0.130  | 38,0<br>1.496 | 5,3<br>0.209 | 3,0<br>0.118 |
| SD22-1.66-3.32-3R1 | 02730592 | 1,66<br>0.065 | 3,32<br>0.131 | 38,0<br>1.496 | 5,4<br>0.213 | 3,0<br>0.118 |
| SD22-1.67-3.34-3R1 | 02730593 | 1,67<br>0.066 | 3,34<br>0.131 | 38,0<br>1.496 | 5,4<br>0.213 | 3,0<br>0.118 |
| SD22-1.68-3.36-3R1 | 02730594 | 1,68<br>0.066 | 3,36<br>0.132 | 38,0<br>1.496 | 5,4<br>0.213 | 3,0<br>0.118 |
| SD22-1.69-3.38-3R1 | 02730595 | 1,69<br>0.067 | 3,38<br>0.133 | 38,0<br>1.496 | 5,4<br>0.213 | 3,0<br>0.118 |
| SD22-1.70-3.40-3R1 | 02731606 | 1,7<br>0.067  | 3,4<br>0.134  | 38,0<br>1.496 | 5,4<br>0.213 | 3,0<br>0.118 |
| SD22-1.71-3.42-3R1 | 02730596 | 1,71<br>0.067 | 3,42<br>0.135 | 38,0<br>1.496 | 5,5<br>0.217 | 3,0<br>0.118 |
| SD22-1.72-3.44-3R1 | 02730597 | 1,72<br>0.068 | 3,44<br>0.135 | 38,0<br>1.496 | 5,5<br>0.217 | 3,0<br>0.118 |
| SD22-1.73-3.46-3R1 | 02730598 | 1,73<br>0.068 | 3,46<br>0.136 | 38,0<br>1.496 | 5,5<br>0.217 | 3,0<br>0.118 |
| SD22-1.74-3.48-3R1 | 02730599 | 1,74<br>0.069 | 3,48<br>0.137 | 38,0<br>1.496 | 5,5<br>0.217 | 3,0<br>0.118 |
| SD22-1.75-3.50-3R1 | 02730601 | 1,75<br>0.069 | 3,5<br>0.138  | 38,0<br>1.496 | 5,5<br>0.217 | 3,0<br>0.118 |
| SD22-1.76-3.52-3R1 | 02730602 | 1,76<br>0.069 | 3,52<br>0.139 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD22-1.77-3.54-3R1 | 02730603 | 1,77<br>0.070 | 3,54<br>0.139 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD22-1.78-3.56-3R1 | 02730604 | 1,78<br>0.070 | 3,56<br>0.140 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD22-1.79-3.58-3R1 | 02730605 | 1,79<br>0.070 | 3,58<br>0.141 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD22-1.80-3.60-3R1 | 02731607 | 1,8<br>0.071  | 3,6<br>0.142  | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD22-1.81-3.62-3R1 | 02730606 | 1,81<br>0.071 | 3,62<br>0.143 | 38,0<br>1.496 | 5,7<br>0.224 | 3,0<br>0.118 |
| SD22-1.82-3.64-3R1 | 02730607 | 1,82<br>0.072 | 3,64<br>0.143 | 38,0<br>1.496 | 5,7<br>0.224 | 3,0<br>0.118 |
| SD22-1.83-3.66-3R1 | 02730608 | 1,83<br>0.072 | 3,66<br>0.144 | 38,0<br>1.496 | 5,7<br>0.224 | 3,0<br>0.118 |
| SD22-1.84-3.68-3R1 | 02730609 | 1,84<br>0.072 | 3,68<br>0.145 | 38,0<br>1.496 | 5,7<br>0.224 | 3,0<br>0.118 |
| SD22-1.85-3.70-3R1 | 02730610 | 1,85<br>0.073 | 3,7<br>0.146  | 38,0<br>1.496 | 5,7<br>0.224 | 3,0<br>0.118 |

| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|---------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD22-1.86-3.72-3R1 | 02730611 | 1,86<br>0.073 | 3,72<br>0.146 | 38,0<br>1.496 | 5,8<br>0.228 | 3,0<br>0.118 |
| SD22-1.87-3.74-3R1 | 02730612 | 1,87<br>0.074 | 3,74<br>0.147 | 38,0<br>1.496 | 5,8<br>0.228 | 3,0<br>0.118 |
| SD22-1.88-3.76-3R1 | 02730613 | 1,88<br>0.074 | 3,76<br>0.148 | 38,0<br>1.496 | 5,8<br>0.228 | 3,0<br>0.118 |
| SD22-1.89-3.78-3R1 | 02730614 | 1,89<br>0.074 | 3,78<br>0.149 | 38,0<br>1.496 | 5,8<br>0.228 | 3,0<br>0.118 |
| SD22-1.90-3.80-3R1 | 02731609 | 1,9<br>0.075  | 3,8<br>0.150  | 38,0<br>1.496 | 5,8<br>0.228 | 3,0<br>0.118 |
| SD22-1.91-3.82-3R1 | 02730615 | 1,91<br>0.075 | 3,82<br>0.150 | 38,0<br>1.496 | 5,9<br>0.232 | 3,0<br>0.118 |
| SD22-1.92-3.84-3R1 | 02730616 | 1,92<br>0.076 | 3,84<br>0.151 | 38,0<br>1.496 | 5,9<br>0.232 | 3,0<br>0.118 |
| SD22-1.93-3.86-3R1 | 02730617 | 1,93<br>0.076 | 3,86<br>0.152 | 38,0<br>1.496 | 5,9<br>0.232 | 3,0<br>0.118 |
| SD22-1.94-3.88-3R1 | 02730618 | 1,94<br>0.076 | 3,88<br>0.153 | 38,0<br>1.496 | 5,9<br>0.232 | 3,0<br>0.118 |
| SD22-1.95-3.90-3R1 | 02730619 | 1,95<br>0.077 | 3,9<br>0.154  | 38,0<br>1.496 | 5,9<br>0.232 | 3,0<br>0.118 |
| SD22-1.96-3.92-3R1 | 02730620 | 1,96<br>0.077 | 3,92<br>0.154 | 38,0<br>1.496 | 6,0<br>0.236 | 3,0<br>0.118 |
| SD22-1.97-3.94-3R1 | 02730621 | 1,97<br>0.078 | 3,94<br>0.155 | 38,0<br>1.496 | 6,0<br>0.236 | 3,0<br>0.118 |
| SD22-1.98-3.96-3R1 | 02730622 | 1,98<br>0.078 | 3,96<br>0.156 | 38,0<br>1.496 | 6,0<br>0.236 | 3,0<br>0.118 |
| SD22-1.99-3.98-3R1 | 02730623 | 1,99<br>0.078 | 3,98<br>0.157 | 38,0<br>1.496 | 6,0<br>0.236 | 3,0<br>0.118 |
| SD22-2.00-4.00-3R1 | 02731610 | 2,0<br>0.079  | 4,0<br>0.157  | 38,0<br>1.496 | 6,0<br>0.236 | 3,0<br>0.118 |

## SD26

Fúrési mélység ~ 6 x D



- Hengeres szár
- Külső hűtés
- Csúcs szög: 130°
- Bevonat nélküli
- Forgácsolási adatokat lásd a 169-173 old.

| Megnevezés         | Cikkszám | DC            | LU            | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|---------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD26-0.10-0.40-3R1 | 02731612 | 0,1<br>0.004  | 0,4<br>0.016  | 38,0<br>1.496 | 0,7<br>0.028 | 3,0<br>0.118 |
| SD26-0.11-0.40-3R1 | 02730624 | 0,11<br>0.004 | 0,4<br>0.016  | 38,0<br>1.496 | 0,7<br>0.028 | 3,0<br>0.118 |
| SD26-0.12-0.40-3R1 | 02730625 | 0,12<br>0.005 | 0,4<br>0.016  | 38,0<br>1.496 | 0,7<br>0.028 | 3,0<br>0.118 |
| SD26-0.13-0.65-3R1 | 02730626 | 0,13<br>0.005 | 0,65<br>0.026 | 38,0<br>1.496 | 1,0<br>0.039 | 3,0<br>0.118 |
| SD26-0.14-0.65-3R1 | 02730627 | 0,14<br>0.006 | 0,65<br>0.026 | 38,0<br>1.496 | 1,0<br>0.039 | 3,0<br>0.118 |
| SD26-0.15-0.65-3R1 | 02731613 | 0,15<br>0.006 | 0,9<br>0.035  | 38,0<br>1.496 | 1,4<br>0.055 | 3,0<br>0.118 |
| SD26-0.16-0.90-3R1 | 02730628 | 0,16<br>0.006 | 0,9<br>0.035  | 38,0<br>1.496 | 1,4<br>0.055 | 3,0<br>0.118 |
| SD26-0.17-0.90-3R1 | 02730629 | 0,17<br>0.007 | 0,9<br>0.035  | 38,0<br>1.496 | 1,4<br>0.055 | 3,0<br>0.118 |
| SD26-0.18-0.90-3R1 | 02730630 | 0,18<br>0.007 | 0,9<br>0.035  | 38,0<br>1.496 | 1,4<br>0.055 | 3,0<br>0.118 |
| SD26-0.19-0.90-3R1 | 02730631 | 0,19<br>0.007 | 0,9<br>0.035  | 38,0<br>1.496 | 1,4<br>0.055 | 3,0<br>0.118 |
| SD26-0.20-1.25-3R1 | 02731615 | 0,2<br>0.008  | 1,25<br>0.049 | 38,0<br>1.496 | 1,8<br>0.071 | 3,0<br>0.118 |
| SD26-0.21-1.25-3R1 | 02730632 | 0,21<br>0.008 | 1,25<br>0.049 | 38,0<br>1.496 | 1,8<br>0.071 | 3,0<br>0.118 |
| SD26-0.22-1.25-3R1 | 02730633 | 0,22<br>0.009 | 1,25<br>0.049 | 38,0<br>1.496 | 1,8<br>0.071 | 3,0<br>0.118 |
| SD26-0.23-1.25-3R1 | 02730634 | 0,23<br>0.009 | 1,25<br>0.049 | 38,0<br>1.496 | 1,8<br>0.071 | 3,0<br>0.118 |
| SD26-0.24-1.25-3R1 | 02730635 | 0,24<br>0.009 | 1,25<br>0.049 | 38,0<br>1.496 | 1,8<br>0.071 | 3,0<br>0.118 |
| SD26-0.25-1.55-3R1 | 02731617 | 0,25<br>0.010 | 1,55<br>0.061 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD26-0.26-1.55-3R1 | 02730636 | 0,26<br>0.010 | 1,55<br>0.061 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD26-0.27-1.55-3R1 | 02730637 | 0,27<br>0.011 | 1,55<br>0.061 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD26-0.28-1.55-3R1 | 02730638 | 0,28<br>0.011 | 1,55<br>0.061 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD26-0.29-1.55-3R1 | 02730639 | 0,29<br>0.011 | 1,55<br>0.061 | 38,0<br>1.496 | 2,2<br>0.087 | 3,0<br>0.118 |
| SD26-0.30-1.80-3R1 | 02731618 | 0,3<br>0.012  | 1,8<br>0.071  | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |

| Megnevezés         | Cikkszám | DC            | LU           | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|--------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch   | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD26-0.31-1.80-3R1 | 02730640 | 0,31<br>0.012 | 1,8<br>0.071 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD26-0.32-1.80-3R1 | 02730641 | 0,32<br>0.013 | 1,8<br>0.071 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD26-0.33-1.80-3R1 | 02730642 | 0,33<br>0.013 | 1,8<br>0.071 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD26-0.34-1.80-3R1 | 02730643 | 0,34<br>0.013 | 1,8<br>0.071 | 38,0<br>1.496 | 2,4<br>0.094 | 3,0<br>0.118 |
| SD26-0.35-2.20-3R1 | 02731619 | 0,35<br>0.014 | 2,2<br>0.087 | 38,0<br>1.496 | 2,8<br>0.110 | 3,0<br>0.118 |
| SD26-0.36-2.20-3R1 | 02730644 | 0,36<br>0.014 | 2,2<br>0.087 | 38,0<br>1.496 | 2,8<br>0.110 | 3,0<br>0.118 |
| SD26-0.37-2.20-3R1 | 02730645 | 0,37<br>0.015 | 2,2<br>0.087 | 38,0<br>1.496 | 2,8<br>0.110 | 3,0<br>0.118 |
| SD26-0.38-2.20-3R1 | 02730646 | 0,38<br>0.015 | 2,2<br>0.087 | 38,0<br>1.496 | 2,8<br>0.110 | 3,0<br>0.118 |
| SD26-0.39-2.70-3R1 | 02730647 | 0,39<br>0.015 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.40-2.70-3R1 | 02731620 | 0,4<br>0.016  | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.41-2.70-3R1 | 02730648 | 0,41<br>0.016 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.42-2.70-3R1 | 02730649 | 0,42<br>0.017 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.43-2.70-3R1 | 02730650 | 0,43<br>0.017 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.44-2.70-3R1 | 02730651 | 0,44<br>0.017 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.45-2.70-3R1 | 02731621 | 0,45<br>0.018 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.46-2.70-3R1 | 02730652 | 0,46<br>0.018 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.47-2.70-3R1 | 02730653 | 0,47<br>0.019 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.48-2.70-3R1 | 02730654 | 0,48<br>0.019 | 2,7<br>0.106 | 38,0<br>1.496 | 3,6<br>0.142 | 3,0<br>0.118 |
| SD26-0.49-3.20-3R1 | 02730655 | 0,49<br>0.019 | 3,2<br>0.126 | 38,0<br>1.496 | 4,0<br>0.157 | 3,0<br>0.118 |
| SD26-0.50-3.20-3R1 | 02731622 | 0,5<br>0.020  | 3,2<br>0.126 | 38,0<br>1.496 | 4,0<br>0.157 | 3,0<br>0.118 |
| SD26-0.51-3.20-3R1 | 02730656 | 0,51<br>0.020 | 3,2<br>0.126 | 38,0<br>1.496 | 4,0<br>0.157 | 3,0<br>0.118 |
| SD26-0.52-3.20-3R1 | 02730657 | 0,52<br>0.020 | 3,2<br>0.126 | 38,0<br>1.496 | 4,0<br>0.157 | 3,0<br>0.118 |
| SD26-0.53-3.20-3R1 | 02730658 | 0,53<br>0.021 | 3,2<br>0.126 | 38,0<br>1.496 | 4,0<br>0.157 | 3,0<br>0.118 |
| SD26-0.54-3.60-3R1 | 02730659 | 0,54<br>0.021 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.55-3.60-3R1 | 02731623 | 0,55<br>0.022 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.56-3.60-3R1 | 02730660 | 0,56<br>0.022 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.57-3.60-3R1 | 02730661 | 0,57<br>0.022 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.58-3.60-3R1 | 02730662 | 0,58<br>0.023 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.59-3.60-3R1 | 02730663 | 0,59<br>0.023 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.60-3.60-3R1 | 02731624 | 0,6<br>0.024  | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |
| SD26-0.61-3.90-3R1 | 02730664 | 0,61<br>0.024 | 3,6<br>0.142 | 38,0<br>1.496 | 4,5<br>0.177 | 3,0<br>0.118 |



| Megnevezés         | Cikkszám | DC            | LU           | OAL           | LUX          | DMM          |
|--------------------|----------|---------------|--------------|---------------|--------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch   | mm<br>Inch    | mm<br>Inch   | mm<br>Inch   |
| SD26-0.62-3.90-3R1 | 02730665 | 0,62<br>0.024 | 3,9<br>0.154 | 38,0<br>1.496 | 5,0<br>0.197 | 3,0<br>0.118 |
| SD26-0.63-3.90-3R1 | 02730666 | 0,63<br>0.025 | 3,9<br>0.154 | 38,0<br>1.496 | 5,0<br>0.197 | 3,0<br>0.118 |
| SD26-0.64-3.90-3R1 | 02730667 | 0,64<br>0.025 | 3,9<br>0.154 | 38,0<br>1.496 | 5,0<br>0.197 | 3,0<br>0.118 |
| SD26-0.65-3.90-3R1 | 02731625 | 0,65<br>0.026 | 3,9<br>0.154 | 38,0<br>1.496 | 5,0<br>0.197 | 3,0<br>0.118 |
| SD26-0.66-3.90-3R1 | 02730668 | 0,66<br>0.026 | 3,9<br>0.154 | 38,0<br>1.496 | 5,0<br>0.197 | 3,0<br>0.118 |
| SD26-0.67-3.90-3R1 | 02730669 | 0,67<br>0.026 | 3,9<br>0.154 | 38,0<br>1.496 | 5,0<br>0.197 | 3,0<br>0.118 |
| SD26-0.68-4.50-3R1 | 02730670 | 0,68<br>0.027 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.69-4.50-3R1 | 02730671 | 0,69<br>0.027 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.70-4.50-3R1 | 02731626 | 0,7<br>0.028  | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.71-4.50-3R1 | 02730672 | 0,71<br>0.028 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.72-4.50-3R1 | 02730673 | 0,72<br>0.028 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.73-4.50-3R1 | 02730674 | 0,73<br>0.029 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.74-4.50-3R1 | 02730675 | 0,74<br>0.029 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.75-4.50-3R1 | 02731627 | 0,75<br>0.030 | 4,5<br>0.177 | 38,0<br>1.496 | 5,6<br>0.220 | 3,0<br>0.118 |
| SD26-0.76-5.00-3R1 | 02730676 | 0,76<br>0.030 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.77-5.00-3R1 | 02730677 | 0,77<br>0.030 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.78-5.00-3R1 | 02730678 | 0,78<br>0.031 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.79-5.00-3R1 | 02730679 | 0,79<br>0.031 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.80-5.00-3R1 | 02731628 | 0,8<br>0.031  | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.81-5.00-3R1 | 02730680 | 0,81<br>0.032 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.82-5.00-3R1 | 02730681 | 0,82<br>0.032 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.83-5.00-3R1 | 02730682 | 0,83<br>0.033 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.84-5.00-3R1 | 02730683 | 0,84<br>0.033 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.85-5.00-3R1 | 02731629 | 0,85<br>0.033 | 5,0<br>0.197 | 38,0<br>1.496 | 6,3<br>0.248 | 3,0<br>0.118 |
| SD26-0.86-5.70-3R1 | 02730684 | 0,86<br>0.034 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |
| SD26-0.87-5.70-3R1 | 02730685 | 0,87<br>0.034 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |
| SD26-0.88-5.70-3R1 | 02730686 | 0,88<br>0.035 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |
| SD26-0.89-5.70-3R1 | 02730687 | 0,89<br>0.035 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |
| SD26-0.90-5.70-3R1 | 02731630 | 0,9<br>0.035  | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |
| SD26-0.91-5.70-3R1 | 02730688 | 0,91<br>0.036 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |
| SD26-0.92-5.70-3R1 | 02730689 | 0,92<br>0.036 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280 | 3,0<br>0.118 |

| Megnevezés         | Cikkszám | DC            | LU           | OAL           | LUX           | DMM          |
|--------------------|----------|---------------|--------------|---------------|---------------|--------------|
|                    |          | mm<br>Inch    | mm<br>Inch   | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD26-0.93-5.70-3R1 | 02730690 | 0,93<br>0.037 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280  | 3,0<br>0.118 |
| SD26-0.94-5.70-3R1 | 02730691 | 0,94<br>0.037 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280  | 3,0<br>0.118 |
| SD26-0.95-5.70-3R1 | 02731631 | 0,95<br>0.037 | 5,7<br>0.224 | 38,0<br>1.496 | 7,1<br>0.280  | 3,0<br>0.118 |
| SD26-0.96-6.50-3R1 | 02730692 | 0,96<br>0.038 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-0.97-6.50-3R1 | 02730693 | 0,97<br>0.038 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-0.98-6.50-3R1 | 02730694 | 0,98<br>0.039 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-0.99-6.50-3R1 | 02730695 | 0,99<br>0.039 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.00-6.50-3R1 | 02731632 | 1,0<br>0.039  | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.01-6.50-3R1 | 02730696 | 1,01<br>0.040 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.02-6.50-3R1 | 02730697 | 1,02<br>0.040 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.03-6.50-3R1 | 02730698 | 1,03<br>0.041 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.04-6.50-3R1 | 02730699 | 1,04<br>0.041 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.05-6.50-3R1 | 02730700 | 1,05<br>0.041 | 6,5<br>0.256 | 38,0<br>1.496 | 8,0<br>0.315  | 3,0<br>0.118 |
| SD26-1.06-7.30-3R1 | 02730701 | 1,06<br>0.042 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.07-7.30-3R1 | 02730702 | 1,07<br>0.042 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.08-7.30-3R1 | 02730703 | 1,08<br>0.043 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.09-7.30-3R1 | 02730704 | 1,09<br>0.043 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.10-7.30-3R1 | 02731633 | 1,1<br>0.043  | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.11-7.30-3R1 | 02730705 | 1,11<br>0.044 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.12-7.30-3R1 | 02730706 | 1,12<br>0.044 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.13-7.30-3R1 | 02730707 | 1,13<br>0.044 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.14-7.30-3R1 | 02730708 | 1,14<br>0.045 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.15-7.30-3R1 | 02730709 | 1,15<br>0.045 | 7,3<br>0.287 | 38,0<br>1.496 | 9,0<br>0.354  | 3,0<br>0.118 |
| SD26-1.16-8.20-3R1 | 02730710 | 1,16<br>0.046 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.17-8.20-3R1 | 02730711 | 1,17<br>0.046 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.18-8.20-3R1 | 02730712 | 1,18<br>0.046 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.19-8.20-3R1 | 02730713 | 1,19<br>0.047 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.20-8.20-3R1 | 02731634 | 1,2<br>0.047  | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.21-8.20-3R1 | 02730714 | 1,21<br>0.048 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.22-8.20-3R1 | 02730715 | 1,22<br>0.048 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.23-8.20-3R1 | 02730716 | 1,23<br>0.048 | 8,2<br>0.323 | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |

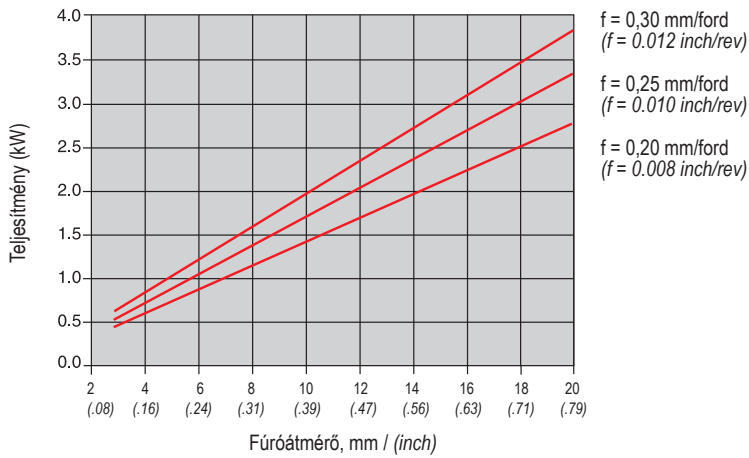
| Megnevezés          | Cikkszám | DC            | LU            | OAL           | LUX           | DMM          |
|---------------------|----------|---------------|---------------|---------------|---------------|--------------|
|                     |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD26-1.24-8.20-3R1  | 02730717 | 1,24<br>0.049 | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.25-8.20-3R1  | 02730718 | 1,25<br>0.049 | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.26-8.20-3R1  | 02730719 | 1,26<br>0.050 | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.27-8.20-3R1  | 02730720 | 1,27<br>0.050 | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.28-8.20-3R1  | 02730721 | 1,28<br>0.050 | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.29-8.20-3R1  | 02730722 | 1,29<br>0.051 | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.30-8.20-3R1  | 02731635 | 1,3<br>0.051  | 8,2<br>0.323  | 38,0<br>1.496 | 10,0<br>0.394 | 3,0<br>0.118 |
| SD26-1.31-9.20-3R1  | 02730723 | 1,31<br>0.052 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.32-9.20-3R1  | 02730724 | 1,32<br>0.052 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.33-9.20-3R1  | 02730725 | 1,33<br>0.052 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.34-9.20-3R1  | 02730726 | 1,34<br>0.053 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.35-9.20-3R1  | 02730727 | 1,35<br>0.053 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.36-9.20-3R1  | 02730728 | 1,36<br>0.054 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.37-9.20-3R1  | 02730729 | 1,37<br>0.054 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.38-9.20-3R1  | 02730730 | 1,38<br>0.054 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.39-9.20-3R1  | 02730731 | 1,39<br>0.055 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.40-9.20-3R1  | 02731637 | 1,4<br>0.055  | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.41-9.20-3R1  | 02730732 | 1,41<br>0.056 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.42-9.20-3R1  | 02730733 | 1,42<br>0.056 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.43-9.20-3R1  | 02730734 | 1,43<br>0.056 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.44-9.20-3R1  | 02730735 | 1,44<br>0.057 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.45-9.20-3R1  | 02730736 | 1,45<br>0.057 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.46-9.20-3R1  | 02730737 | 1,46<br>0.057 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.47-9.20-3R1  | 02730738 | 1,47<br>0.058 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.48-9.20-3R1  | 02730739 | 1,48<br>0.058 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.49-9.20-3R1  | 02730740 | 1,49<br>0.059 | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.50-9.20-3R1  | 02731638 | 1,5<br>0.059  | 9,2<br>0.362  | 38,0<br>1.496 | 11,2<br>0.441 | 3,0<br>0.118 |
| SD26-1.51-11.20-3R1 | 02730741 | 1,51<br>0.059 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.52-11.20-3R1 | 02730742 | 1,52<br>0.060 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.53-11.20-3R1 | 02730743 | 1,53<br>0.060 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.54-11.20-3R1 | 02730744 | 1,54<br>0.061 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |

| Megnevezés          | Cikkszám | DC            | LU            | OAL           | LUX           | DMM          |
|---------------------|----------|---------------|---------------|---------------|---------------|--------------|
|                     |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD26-1.55-11.20-3R1 | 02730745 | 1,55<br>0.061 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.56-11.20-3R1 | 02730746 | 1,56<br>0.061 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.57-11.20-3R1 | 02730747 | 1,57<br>0.062 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.58-11.20-3R1 | 02730748 | 1,58<br>0.062 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.59-11.20-3R1 | 02730749 | 1,59<br>0.063 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.60-11.20-3R1 | 02731639 | 1,6<br>0.063  | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.61-11.20-3R1 | 02730750 | 1,61<br>0.063 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.62-11.20-3R1 | 02730751 | 1,62<br>0.064 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.63-11.20-3R1 | 02730752 | 1,63<br>0.064 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.64-11.20-3R1 | 02730753 | 1,64<br>0.065 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.65-11.20-3R1 | 02730754 | 1,65<br>0.065 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.66-11.20-3R1 | 02730755 | 1,66<br>0.065 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.67-11.20-3R1 | 02730756 | 1,67<br>0.066 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.68-11.20-3R1 | 02730757 | 1,68<br>0.066 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.69-11.20-3R1 | 02730758 | 1,69<br>0.067 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.70-11.20-3R1 | 02731640 | 1,7<br>0.067  | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.71-11.20-3R1 | 02730759 | 1,71<br>0.067 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.72-11.20-3R1 | 02730760 | 1,72<br>0.068 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.73-11.20-3R1 | 02730761 | 1,73<br>0.068 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.74-11.20-3R1 | 02730762 | 1,74<br>0.069 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.75-11.20-3R1 | 02730763 | 1,75<br>0.069 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.76-11.20-3R1 | 02730764 | 1,76<br>0.069 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.77-11.20-3R1 | 02730765 | 1,77<br>0.070 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.78-11.20-3R1 | 02730766 | 1,78<br>0.070 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.79-11.20-3R1 | 02730767 | 1,79<br>0.070 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.80-11.20-3R1 | 02731641 | 1,8<br>0.071  | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.81-11.20-3R1 | 02730768 | 1,81<br>0.071 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.82-11.20-3R1 | 02730769 | 1,82<br>0.072 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.83-11.20-3R1 | 02730770 | 1,83<br>0.072 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.84-11.20-3R1 | 02730771 | 1,84<br>0.072 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.85-11.20-3R1 | 02730772 | 1,85<br>0.073 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |

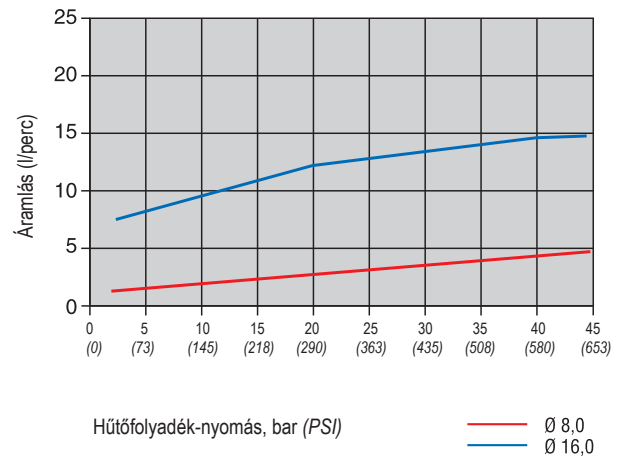
| Megnevezés          | Cikkszám | DC            | LU            | OAL           | LUX           | DMM          |
|---------------------|----------|---------------|---------------|---------------|---------------|--------------|
|                     |          | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch   |
| SD26-1.86-11.20-3R1 | 02730773 | 1,86<br>0.073 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.87-11.20-3R1 | 02730774 | 1,87<br>0.074 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.88-11.20-3R1 | 02730775 | 1,88<br>0.074 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.89-11.20-3R1 | 02730776 | 1,89<br>0.074 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.90-11.20-3R1 | 02731642 | 1,9<br>0.075  | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.91-11.20-3R1 | 02730777 | 1,91<br>0.075 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.92-11.20-3R1 | 02730778 | 1,92<br>0.076 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.93-11.20-3R1 | 02730779 | 1,93<br>0.076 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.94-11.20-3R1 | 02730780 | 1,94<br>0.076 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.95-11.20-3R1 | 02730781 | 1,95<br>0.077 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.96-11.20-3R1 | 02730782 | 1,96<br>0.077 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.97-11.20-3R1 | 02730783 | 1,97<br>0.078 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.98-11.20-3R1 | 02730784 | 1,98<br>0.078 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-1.99-11.20-3R1 | 02730785 | 1,99<br>0.078 | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |
| SD26-2.00-11.20-3R1 | 02731643 | 2,0<br>0.079  | 11,2<br>0.441 | 38,0<br>1.496 | 13,4<br>0.528 | 3,0<br>0.118 |

## Forgácsolási paraméterek

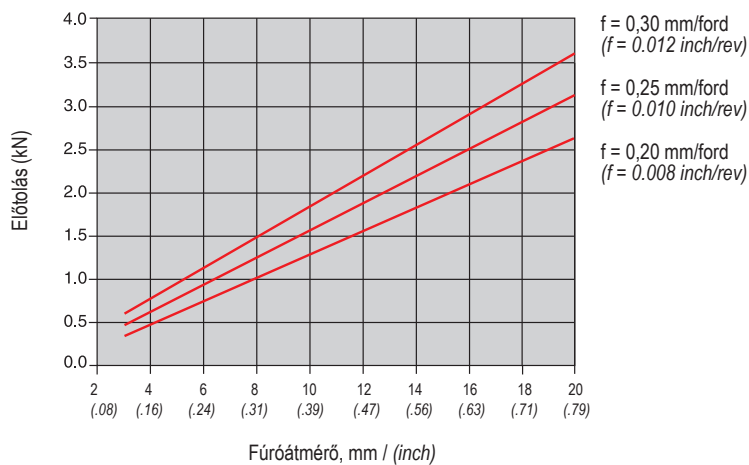
### Teljesítményfelvétel



### Hűtőfolyadék-áramlás a nyomás függvényében



### Előtolási erő



#### Módszer:

Allítsa az előtolást feljebb vagy lejjebb, hogy a lehető legjobb forgácsképződést érje el.

A megnövelt fordulatonkénti előtolás rövidebb forgácsot eredményez.

A fenti előtolási erő- és teljesítményfelvételi értékek csupán irányadók, és függenek a forgácsolási paramétereiktől, a munkadarab anyagától és szerszámkopástól.

### Forgácsolási paraméterek

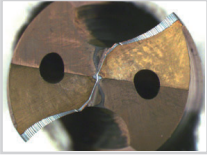
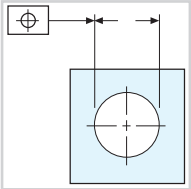
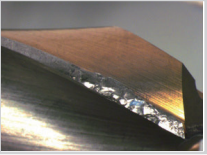
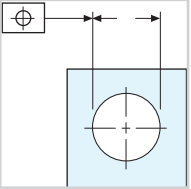

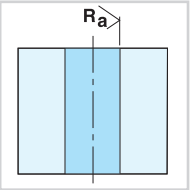
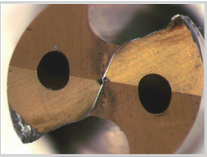
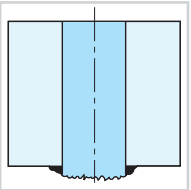
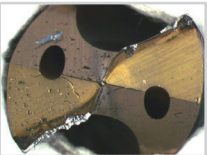
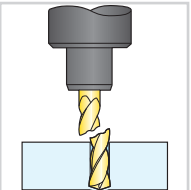
SD1103, SD1103A, SD1105A, SD203A, SD205A, SD206, SD206A, SD207A, SD216A, SD230A  
IT8-9/R<sub>a</sub> 1-3\*

| Fúró Ø DC (mm) | IT9 tűrés (µm) | IT10 tűrés (µm) | Fúró Ø DC (inch) | IT9 tűrés (inch) | IT10 tűrés (inch) |
|----------------|----------------|-----------------|------------------|------------------|-------------------|
| < 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            |

\* A felületi minőségben alacsony széntartalmú acélok és korrózióálló anyagok megmunkálásánál minőségromlás léphet fel.

## Problémamegoldás – Elsődleges ellenőrzések

- Befogási stabilitás
- Gép főorsó állapota
- Befogó állapota
- Szerszám befogás:
  - Útés 0,04 TIR-en belül
  - Ha előfúrást használ, 0,04 TIR-en belül
- Forgácsolási paraméterek
- Hűtő-kenő folyadék:
  - Nyomás
  - Áramlás
  - Koncentráció

|   |  |
|---|--|
| <p><b>Gyors hátkopás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a vágósebességet.</li> <li>• Növelje a hűtőfolyadék koncentrációját.</li> </ul>   | <p><b>Nem megfelelő a furatátmérő túrése</b></p> <ul style="list-style-type: none"> <li>• Növelje a fordulatonkénti előtolást</li> <li>• Alkalmazzon dörzsárazást, lásd: 328 old.</li> <li>• Alkalmazzon kiesztörgálást, lásd: 492-493 old.</li> </ul>    |
| <p><b>Kopás/Periférikus élkopás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a vágósebességet.</li> <li>• Növelje a hűtőfolyadék koncentrációját.</li> </ul>    | <p><b>Nem megfelelő furatpozicionálás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást belépésnél</li> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Alkalmazzon kiesztörgálást, lásd: 492-493 old.</li> <li>• Durva, kemény és ferde felületek átfúrásakor - belépéskor és kilépéskor csökkentse az előtolást 30–50%-kal</li> <li>• Végezzen központfúrást 140°-os csúcshézaggal</li> </ul>  |
| <p><b>Központi élettöredezés</b></p> <ul style="list-style-type: none"> <li>• Csökkentse belépéskor a fordulatonkénti előtolást</li> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Alkalmazzon kiesztörgálást, lásd: 492-493 old.</li> </ul>                     | <p><b>Nem megfelelő felületi minőség</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Növelje a forgácsolási sebességet</li> <li>• Alkalmazzon dörzsárazást, lásd: 328 old.</li> </ul>    |
| <p><b>Élettöredezés / Külső sarok, vágóél</b></p> <ul style="list-style-type: none"> <li>• Csökkentse az előtolást be/kilépésnél</li> <li>• Csökkentse a vágósebességet</li> <li>• Növelje a hűtőfolyadék koncentrációját</li> <li>• Éleztesse újra a fúrót</li> </ul>     | <p><b>Erősen sorjás kimeneti nyílás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást a kimenetnél</li> <li>• Csökkentse az élkialakítás szélességét (BN)</li> </ul>    |
| <p><b>Felrakódott él</b></p> <ul style="list-style-type: none"> <li>• Ha az él külső részén történik, növelje a vágósebességet</li> <li>• Ha az él középhez közelebb történik, növelje a fordulatonkénti előtolást</li> <li>• Ha kopott a fúró, éleztesse újra</li> </ul>  | <p><b>Szerszám-törés belépésnél/a furat alján</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást be/kilépésnél</li> <li>• Módosítsa a forgácsolási adatokat a jobb forgácsolástávoltás érdekében</li> </ul>    |

## Az utasítások ugyanazok, mint az SD1103, SD1103A, SD1105A, SD1108A és SD1112A esetében

### Utasítások:

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa: 12A2, szemcse méret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

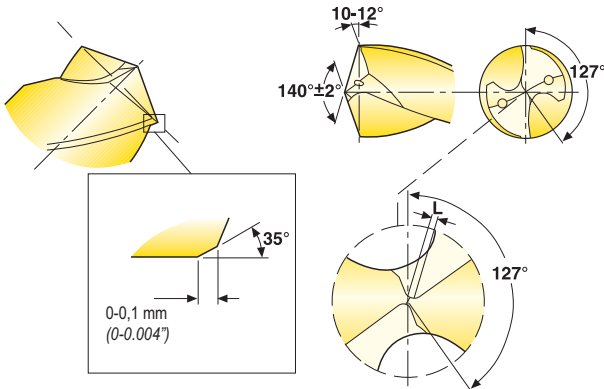
Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy élettörés (4. kép).

### Fontos:

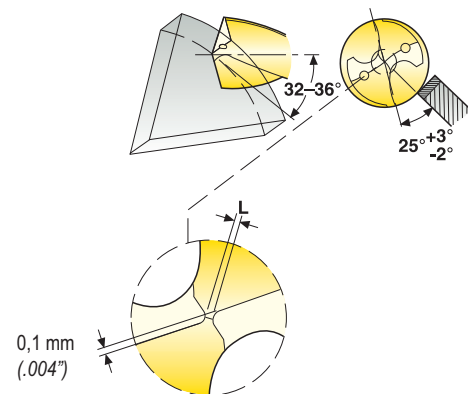
- A vágóéleknek szimmetrikusnak kell lenniük és az élkialakításnak is egyeznie kell.
- Az élkialakítást alkalmazni kell a teljes élhosszon.

#### 1. Négy él pont



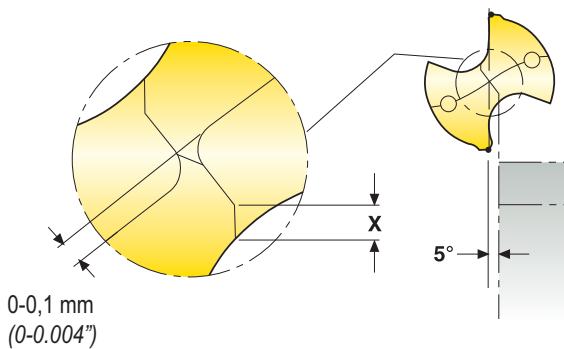
Az axiális ütés legyen 0,02 mm-en (0.008") belül

#### 2. Keresztél élezés



| Fúró Ø DC mm | L mm    | Fúró Ø DC inch | L inch      |
|--------------|---------|----------------|-------------|
| 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 |

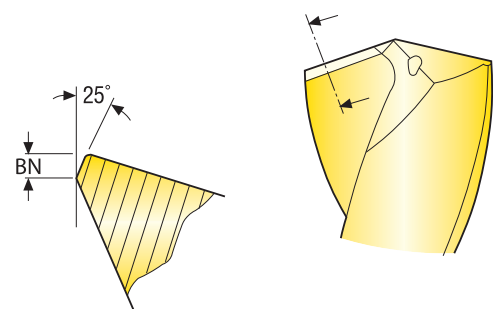
#### 3. Az X sík élezése



$$X = 0,08 \times (0,003) \times \text{fúróátmérő DC}$$

A max. megengedett hátkopás mértéke 0,1–0,3 mm (0.004–0.012") lehet.

#### 4. Élkialakítás



| Munkadarab anyag  | BN             |                |                     |                     |
|-------------------|----------------|----------------|---------------------|---------------------|
|                   | Fúró Ø ≤ 10 mm | Fúró Ø > 10 mm | Fúró Ø ≤ 0.394 inch | Fúró Ø > 0.394 inch |
| Acél              | 0,05           | 0,10           | 0.002               | 0.004               |
| Korrózióálló acél | 0,05           | 0,05           | 0.002               | 0.002               |
| Öntvény           | 0,05           | 0,10           | 0.002               | 0.004               |



## A P geometriájú SD203A, SD205A és SD207A lapkák élezési utasítása

**Utasítások:**

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa: 12A2, szemcse méret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

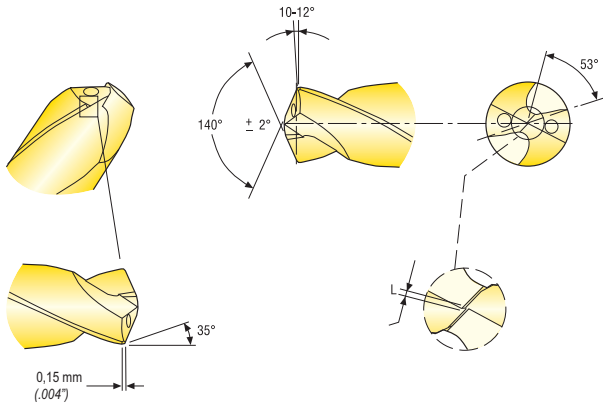
Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy életörés (4. kép).

**Fontos:**

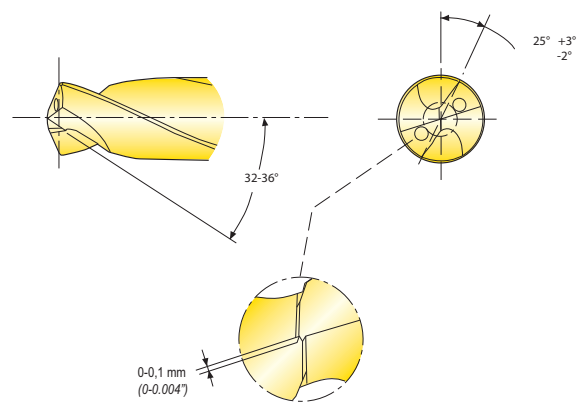
- A vágóéleknek szimmetrikusnak kell lenniük és az élkialakításnak is egyeznie kell.
- Az élkialakítást alkalmazni kell a teljes élhosszon.

**1. Kúposág**



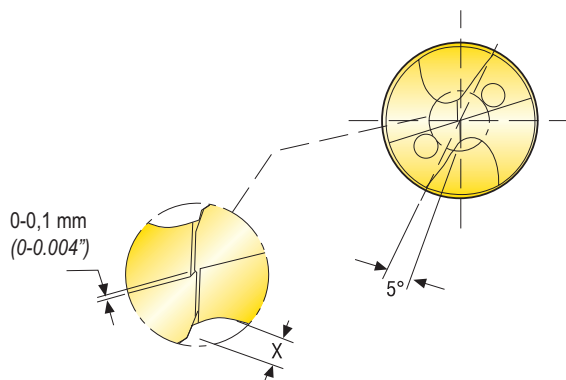
Az axiális ütés legyen 0,02 mm-en (0,008") belül

**2. Keresztél élezés**



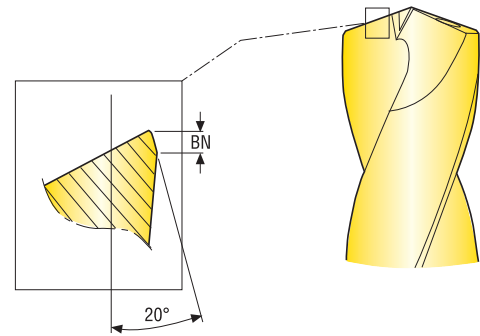
| Fúró Ø DC mm | L mm    | Fúró Ø DC inch | L inch      |
|--------------|---------|----------------|-------------|
| 2-10         | 0,1-0,3 | 0.079-0.394    | 0.004-0.012 |
| 10-20        | 0,2-0,4 | 0.394-0.787    | 0.008-0.016 |

**3. Az X sík élezése**



$X = 0,08 \times (0,003) \times \text{fúróátmérő DC}$

**4. Él kialakítás**



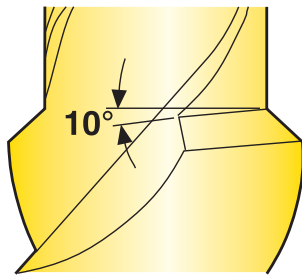
| Munkadarab anyag  | BN             |                |                     |                     |
|-------------------|----------------|----------------|---------------------|---------------------|
|                   | Fúró Ø ≤ 10 mm | Fúró Ø > 10 mm | Fúró Ø ≤ 0.394 inch | Fúró Ø > 0.394 inch |
| Acél              | 0,05           | 0,10           | 0.002               | 0.004               |
| Korrózióálló acél | 0,05           | 0,05           | 0.002               | 0.002               |
| Ötvény            | 0,05           | 0,10           | 0.002               | 0.004               |

A max. megengedett hátkopás mértéke 0,1–0,3 mm (0.004–0.012") lehet.

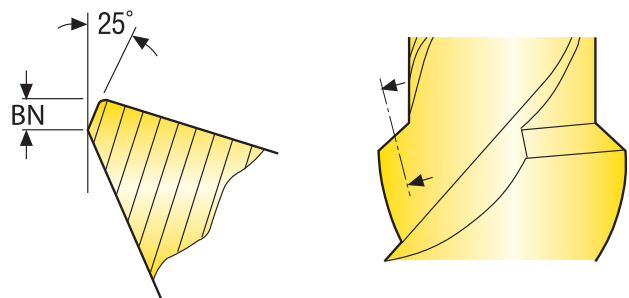
## Élletőrő fúrók újraélezési útmutatója

Az újraélezési utasítások ugyanazok, mint az SD203, SD203A, SD205A és SD207A-nál, kivéve az életőrést.

### 1. Élletőrő lejtés



### 2. Élletőrő élkiképzése



| Munkadarab anyag  | BN                            |                            |                                    |                                 |
|-------------------|-------------------------------|----------------------------|------------------------------------|---------------------------------|
|                   | Fúró $\varnothing \leq 10$ mm | Fúró $\varnothing > 10$ mm | Fúró $\varnothing \leq 0.394$ inch | Fúró $\varnothing > 0.394$ inch |
| Acél              | 0,05                          | 0,10                       | 0.002                              | 0.004                           |
| Korrózióálló acél | 0,05                          | 0,05                       | 0.002                              | 0.002                           |
| Ötvény            | 0,05                          | 0,10                       | 0.002                              | 0.004                           |

## Az újraélezési utasítások ugyanazok, mint az SD212A, SD216A, SD220A, SD225A és SD230A geometriáknál

**Utasítások:**

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa 11V9, szemcseméret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy élettörés (4. kép).

**Fontos:**

- A vágóéleknek szimmetrikusnak kell lenniük és az élkialakításnak is egyeznie kell.
- Az élkialakítást alkalmazni kell a teljes élhosszon.

### 1. Kúposág

Az axiális ütés legyen 0,02 mm-en (0.008") belül

### 2. Keresztél élezés

| Fúró Ø DC mm | L mm | Fúró Ø DC inch | L inch |
|--------------|------|----------------|--------|
| 2-10         | 0,2  | 0.079-0.394    | 0.008  |
| 10-20        | 0,4  | 0.394-0.787    | 0.016  |

### 3. Az X sík élezése

$X = 0,08 \times (0,003) \times \text{fúróátmérő DC}$

### 4. Él kialakítás

| Munkadarab anyag  | BN             |                |                     |                     |
|-------------------|----------------|----------------|---------------------|---------------------|
|                   | Fúró Ø ≤ 10 mm | Fúró Ø > 10 mm | Fúró Ø ≤ 0.394 inch | Fúró Ø > 0.394 inch |
| Acél              | 0,05           | 0,10           | 0.002               | 0.004               |
| Korrózióálló acél | 0,05           | 0,05           | 0.002               | 0.002               |
| Ötvény            | 0,05           | 0,10           | 0.002               | 0.004               |

A max. megengedett hátkopás mértéke 0,1–0,3 mm (0.004–0.012") lehet.

## Újraélezési utasítások az SD265A típushoz

**Utasítások:**

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa: 12A2, szemcse méret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

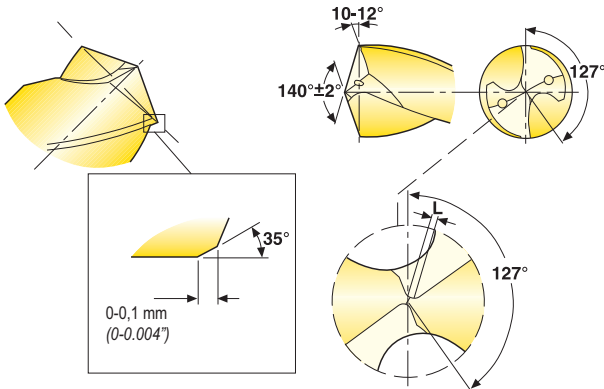
Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy élettörés (4. kép).

**Fontos:**

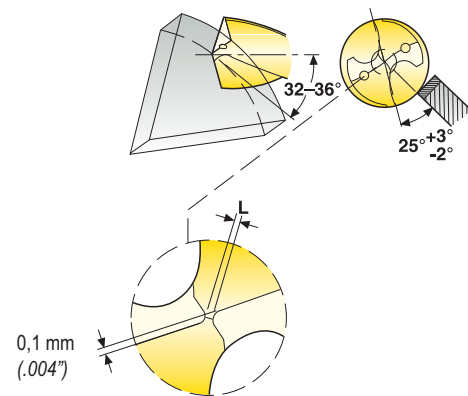
- A vágóéleknek szimmetrikusnak kell lenniük és az élalakításnak is egyeznie kell.
- Az élalakítást alkalmazni kell a teljes élhosszon.

### 1. Kúposág



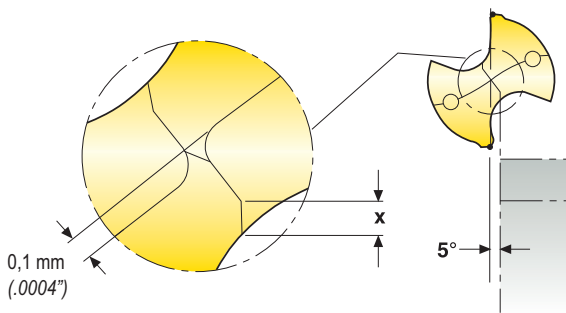
Az axiális ütés legyen 0,02 mm-en (0.008") belül

### 2. Keresztél élezés



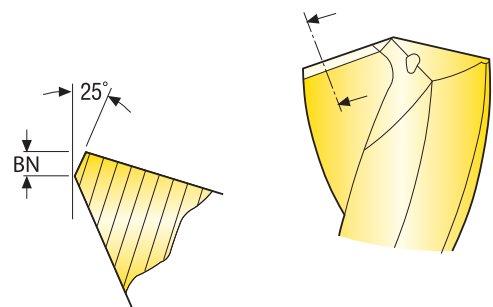
| Fúró Ø DC mm | L mm | Fúró Ø DC inch | L inch |
|--------------|------|----------------|--------|
| 2-10         | 0,2  | 0.079-0.394    | 0.008  |
| 10-20        | 0,4  | 0.394-0.787    | 0.016  |

### 3. Az X sík élezése



$X = 0,08 \times (0,003) \times \text{fúróátmérő DC}$

### 4. Élalakítás



| Munkadarab anyag  | BN             |                |                     |                     |
|-------------------|----------------|----------------|---------------------|---------------------|
|                   | Fúró Ø ≤ 10 mm | Fúró Ø > 10 mm | Fúró Ø ≤ 0.394 inch | Fúró Ø > 0.394 inch |
| Acél              | 0,05           | 0,10           | 0.002               | 0.004               |
| Korrózióálló acél | 0,05           | 0,05           | 0.002               | 0.002               |
| Öntvény           | 0,05           | 0,10           | 0.002               | 0.004               |

A max. megengedett hátkopás mértéke 0,1–0,3 mm (0.004–0.012") lehet.

## Újraélezési utasítások az -MS geometriához

### Utasítások:

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa: 12A2, szemcse méret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy életörés (4. kép).

### Fontos:

- A vágóéleknek szimmetrikusnak kell lenniük és az élkialakításnak is egyeznie kell.
- Az élkialakítást alkalmazni kell a teljes élhosszon.

#### 1. Négy él

Az axiális ütés legyen 0,02 mm-en (0.008\") belül

#### 2. R rádiusz köszörülése

#### 3. Keresztél élezés

#### 4. Él kialakítás

| Fúró Ø DC mm | BN mm | Fúró Ø DC inch | BN inch |
|--------------|-------|----------------|---------|
| 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 |

A max. megengedett hátkopás mértéke 0,1–0,3 mm (0.004–0.012\") lehet.

## Az újraélezési utasítások az -M és -T geometriához

### Utasítások:

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa: 12A2, szemcse méret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

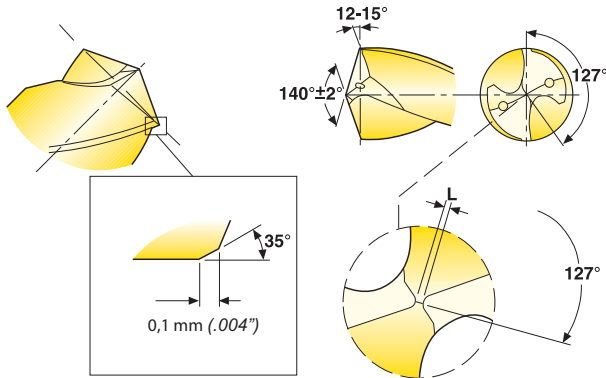
Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy élettörés (4. kép).

### Fontos:

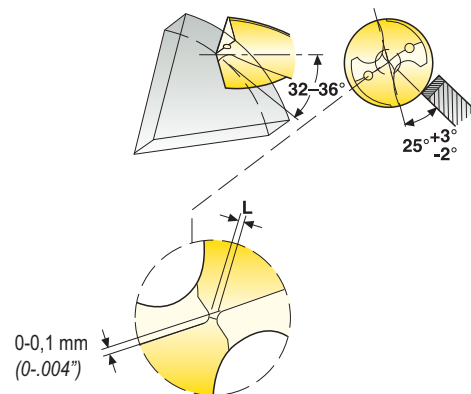
- A vágóéleknek szimmetrikusnak kell lenniük és az élalakításnak is egyeznie kell.
- Az élalakítást alkalmazni kell a teljes élhosszon.

#### 1. Kúposág



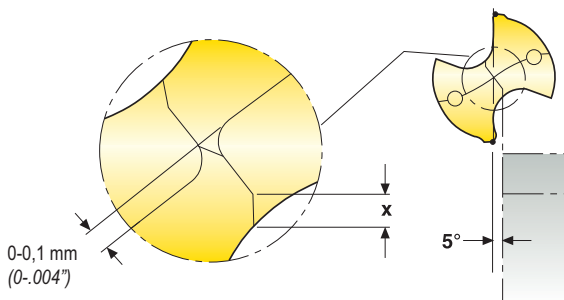
Az axiális ütés legyen 0,01 mm-en (0.0004") belül

#### 2. Keresztél élezés



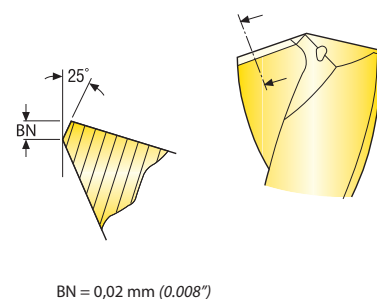
| Fúró Ø DC mm | L mm      | Fúró Ø DC inch | L inch      |
|--------------|-----------|----------------|-------------|
| 3-6          | 0,1-0,2   | 0.118-0.236    | 0.004-0.008 |
| 6-10         | 0,13-0,27 | 0.236-0.394    | 0.005-0.011 |
| 10-20        | 0,2-0,4   | 0.394-0.787    | 0.008-0.016 |

#### 3. Az X sík élezése



A max. megengedett hátkopás mértéke 0,1-0,3 mm (0.004-0.012") lehet.

#### 4. Élalakítás



## Újraélezési utasítások az -N geometriához

Általános:

$X = 0,08 \times \text{fúróátmérő DC}$

Utasítások:

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: Korong típusa 12A2, szemcseméret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy élettörés (4. kép).

Fontos:

- A vágóéleknek szimmetrikusnak kell lenniük és az élkialakításnak is egyeznie kell.
- Az élkialakítást alkalmazni kell a teljes élhosszon.

### 1. Kúposág

Az axiális ütés legyen 0,01 mm-en (0.0004") belül

### 2. Keresztél élezés

| Fúró Ø DC mm | L mm      | Fúró Ø DC inch | L inch      |
|--------------|-----------|----------------|-------------|
| 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. Az X sík élezése

### 4. Él kialakítás

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

A max. megengedett hátkopás mértéke 0,1–0,3 mm (0.004–0.012") lehet.

## SD1103 – Ø 3-20 mm / 0.118-0.787 inch

| SMG | f                |                  |                  |                  |                   |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|------------------|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>Ø 0.787 |                |
| P1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,25              | 0,28              | 0,30              | 0,32              | 0,34              | 0,36              | 105            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 345            |
| P2  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,32              | 0,34              | 0,36              | 0,36              | 105            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.013             | 0.013             | 0.014             | 0.014             | 345            |
| P3  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 90             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 295            |
| P4  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 80             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 260            |
| P5  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 75             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 245            |
| P6  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 85             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 280            |
| P7  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 80             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 260            |
| P8  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 75             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 245            |
| P11 | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 75             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 245            |
| P12 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 46             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 150            |
| M1  | 0,080            | 0,095            | 0,13             | 0,17             | 0,20              | 0,22              | 0,24              | 0,26              | 0,28              | 0,30              | 55             |
|     | 0.0032           | 0.0038           | 0.0050           | 0.0065           | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.011             | 0.012             | 180            |
| M2  | 0,070            | 0,085            | 0,12             | 0,15             | 0,18              | 0,20              | 0,22              | 0,24              | 0,25              | 0,26              | 45             |
|     | 0.0028           | 0.0034           | 0.0048           | 0.0060           | 0.0070            | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.010             | 150            |
| K1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,30              | 0,34              | 0,34              | 0,36              | 70             |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 230            |
| K2  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 60             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 195            |
| K3  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 50             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 165            |
| K4  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 49             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 160            |
| K5  | 0,10             | 0,11             | 0,15             | 0,18             | 0,20              | 0,24              | 0,25              | 0,28              | 0,28              | 0,30              | 29             |
|     | 0.0040           | 0.0044           | 0.0060           | 0.0070           | 0.0080            | 0.0095            | 0.010             | 0.011             | 0.011             | 0.012             | 95             |
| H3  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 24             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 80             |
| H5  | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 45             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 150            |
| H7  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 24             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 80             |
| H8  | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 45             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 150            |
| H11 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 60             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 195            |
| H12 | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 27             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 90             |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



SD1103A – Ø 3-20 mm / 0.118-0.787 inch

| SMG | f                |                  |                  |                  |                   |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|------------------|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>Ø 0.787 |                |
| P1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,25              | 0,28              | 0,30              | 0,32              | 0,34              | 0,36              | 150            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 490            |
| P2  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,32              | 0,34              | 0,36              | 0,36              | 145            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.013             | 0.013             | 0.014             | 0.014             | 475            |
| P3  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 125            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 410            |
| P4  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 110            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 360            |
| P5  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 105            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 345            |
| P6  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 120            |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 395            |
| P7  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 110            |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 360            |
| P8  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 105            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 345            |
| P11 | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 75             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 245            |
| P12 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 50             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 165            |
| M1  | 0,080            | 0,095            | 0,13             | 0,17             | 0,20              | 0,22              | 0,24              | 0,26              | 0,28              | 0,30              | 80             |
|     | 0.0032           | 0.0038           | 0.0050           | 0.0065           | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.011             | 0.012             | 260            |
| M2  | 0,070            | 0,085            | 0,12             | 0,15             | 0,18              | 0,20              | 0,22              | 0,24              | 0,25              | 0,26              | 65             |
|     | 0.0028           | 0.0034           | 0.0048           | 0.0060           | 0.0070            | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.010             | 215            |
| M3  | 0,055            | 0,070            | 0,095            | 0,12             | 0,14              | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 48             |
|     | 0.0022           | 0.0028           | 0.0038           | 0.0048           | 0.0055            | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 155            |
| M4  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 36             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 120            |
| M5  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 30             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 100            |
| K1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,30              | 0,34              | 0,34              | 0,36              | 95             |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 310            |
| K2  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 80             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 260            |
| K3  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 70             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 230            |
| K4  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 65             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 215            |
| K5  | 0,10             | 0,11             | 0,15             | 0,18             | 0,20              | 0,24              | 0,25              | 0,28              | 0,28              | 0,30              | 39             |
|     | 0.0040           | 0.0044           | 0.0060           | 0.0070           | 0.0080            | 0.0095            | 0.010             | 0.011             | 0.011             | 0.012             | 130            |
| N1  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 260            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 850            |
| N2  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 170            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 560            |
| N3  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 110            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 360            |
| N11 | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 210            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 690            |
| H3  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 34             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 110            |
| H5  | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 65             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 215            |
| H7  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 34             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 110            |
| H8  | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 65             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 215            |
| H11 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 80             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 260            |
| H12 | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 38             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 125            |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD1105A – Ø 3-20 mm / 0.118-0.787 inch

| SMG | f                |                  |                  |                  |                   |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|------------------|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>Ø 0.787 |                |
| P1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,25              | 0,28              | 0,30              | 0,32              | 0,34              | 0,36              | 135            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 445            |
| P2  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,32              | 0,34              | 0,36              | 0,36              | 135            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.013             | 0.013             | 0.014             | 0.014             | 445            |
| P3  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 115            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 375            |
| P4  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 100            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 330            |
| P5  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 95             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 310            |
| P6  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 110            |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 360            |
| P7  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 100            |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 330            |
| P8  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 95             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 310            |
| P11 | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 65             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 215            |
| P12 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 48             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 155            |
| M1  | 0,080            | 0,095            | 0,13             | 0,17             | 0,20              | 0,22              | 0,24              | 0,26              | 0,28              | 0,30              | 70             |
|     | 0.0032           | 0.0038           | 0.0050           | 0.0065           | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.011             | 0.012             | 230            |
| M2  | 0,070            | 0,085            | 0,12             | 0,15             | 0,18              | 0,20              | 0,22              | 0,24              | 0,25              | 0,26              | 60             |
|     | 0.0028           | 0.0034           | 0.0048           | 0.0060           | 0.0070            | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.010             | 195            |
| M3  | 0,055            | 0,070            | 0,095            | 0,12             | 0,14              | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 44             |
|     | 0.0022           | 0.0028           | 0.0038           | 0.0048           | 0.0055            | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 145            |
| M4  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 33             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 110            |
| M5  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 27             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 90             |
| K1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,30              | 0,34              | 0,34              | 0,36              | 85             |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 280            |
| K2  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 75             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 245            |
| K3  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 65             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 215            |
| K4  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 60             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 195            |
| K5  | 0,10             | 0,11             | 0,15             | 0,18             | 0,20              | 0,24              | 0,25              | 0,28              | 0,28              | 0,30              | 36             |
|     | 0.0040           | 0.0044           | 0.0060           | 0.0070           | 0.0080            | 0.0095            | 0.010             | 0.011             | 0.011             | 0.012             | 120            |
| N1  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 240            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 790            |
| N2  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 155            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 510            |
| N3  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 100            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 330            |
| N11 | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 190            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 620            |
| H3  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 31             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 100            |
| H5  | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 60             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 195            |
| H7  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 31             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 100            |
| H8  | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 60             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 195            |
| H11 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 75             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 245            |
| H12 | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 35             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 115            |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

SD1108A – Ø 3-20 mm / 0.118-0.787 inch

| SMG | f                |                  |                  |                  |                   |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|------------------|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>Ø 0.787 |                |
| P1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,25              | 0,28              | 0,30              | 0,32              | 0,34              | 0,36              | 120            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 395            |
| P2  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,32              | 0,34              | 0,36              | 0,36              | 115            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.013             | 0.013             | 0.014             | 0.014             | 375            |
| P3  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 100            |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 330            |
| P4  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 85             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 280            |
| P5  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 85             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 280            |
| P6  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 95             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 310            |
| P7  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 90             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 295            |
| P8  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 85             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 280            |
| P11 | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 60             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 195            |
| P12 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 42             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 140            |
| M1  | 0,080            | 0,095            | 0,13             | 0,17             | 0,20              | 0,22              | 0,24              | 0,26              | 0,28              | 0,30              | 60             |
|     | 0.0032           | 0.0038           | 0.0050           | 0.0065           | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.011             | 0.012             | 195            |
| M2  | 0,070            | 0,085            | 0,12             | 0,15             | 0,18              | 0,20              | 0,22              | 0,24              | 0,25              | 0,26              | 50             |
|     | 0.0028           | 0.0034           | 0.0048           | 0.0060           | 0.0070            | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.010             | 165            |
| M3  | 0,055            | 0,070            | 0,095            | 0,12             | 0,14              | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 38             |
|     | 0.0022           | 0.0028           | 0.0038           | 0.0048           | 0.0055            | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 125            |
| M4  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 29             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 95             |
| M5  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 24             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 80             |
| K1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,30              | 0,34              | 0,34              | 0,36              | 75             |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 245            |
| K2  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 65             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 215            |
| K3  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 55             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 180            |
| K4  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 50             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 165            |
| K5  | 0,10             | 0,11             | 0,15             | 0,18             | 0,20              | 0,24              | 0,25              | 0,28              | 0,28              | 0,30              | 31             |
|     | 0.0040           | 0.0044           | 0.0060           | 0.0070           | 0.0080            | 0.0095            | 0.010             | 0.011             | 0.011             | 0.012             | 100            |
| N1  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 205            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 670            |
| N2  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 135            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 445            |
| N3  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 90             |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 295            |
| N11 | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 165            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 540            |
| H3  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 27             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 90             |
| H5  | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 50             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 165            |
| H7  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 27             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 90             |
| H8  | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 50             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 165            |
| H11 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 65             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 215            |
| H12 | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 30             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 100            |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

When drilling in stainless steel with 8xD and 12xD a pre-drilling operation might be needed

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD112 – Ø 3-20 mm / 0.118-0.787 inch

| SMG | f                |                  |                  |                  |                   |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|------------------|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>Ø 0.787 |                |
| P1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,25              | 0,28              | 0,30              | 0,32              | 0,34              | 0,36              | 100            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 330            |
| P2  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,32              | 0,34              | 0,36              | 0,36              | 100            |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.013             | 0.013             | 0.014             | 0.014             | 330            |
| P3  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 85             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 280            |
| P4  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 75             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 245            |
| P5  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 70             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 230            |
| P6  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 80             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 260            |
| P7  | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 75             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 245            |
| P8  | 0,11             | 0,13             | 0,17             | 0,20             | 0,24              | 0,28              | 0,30              | 0,32              | 0,34              | 0,34              | 70             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.011             | 0.012             | 0.013             | 0.013             | 0.013             | 230            |
| P11 | 0,11             | 0,12             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 50             |
|     | 0.0044           | 0.0048           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 165            |
| P12 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 36             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 120            |
| M1  | 0,080            | 0,095            | 0,13             | 0,17             | 0,20              | 0,22              | 0,24              | 0,26              | 0,28              | 0,30              | 55             |
|     | 0.0032           | 0.0038           | 0.0050           | 0.0065           | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.011             | 0.012             | 180            |
| M2  | 0,070            | 0,085            | 0,12             | 0,15             | 0,18              | 0,20              | 0,22              | 0,24              | 0,25              | 0,26              | 43             |
|     | 0.0028           | 0.0034           | 0.0048           | 0.0060           | 0.0070            | 0.0080            | 0.0085            | 0.0095            | 0.010             | 0.010             | 140            |
| M3  | 0,055            | 0,070            | 0,095            | 0,12             | 0,14              | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 33             |
|     | 0.0022           | 0.0028           | 0.0038           | 0.0048           | 0.0055            | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 110            |
| M4  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 25             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 80             |
| M5  | 0,050            | 0,060            | 0,085            | 0,11             | 0,12              | 0,14              | 0,15              | 0,17              | 0,18              | 0,19              | 21             |
|     | 0.0020           | 0.0024           | 0.0034           | 0.0044           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0070            | 0.0075            | 70             |
| K1  | 0,12             | 0,14             | 0,18             | 0,22             | 0,26              | 0,28              | 0,30              | 0,34              | 0,34              | 0,36              | 65             |
|     | 0.0048           | 0.0055           | 0.0070           | 0.0085           | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 0.014             | 215            |
| K2  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 55             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 180            |
| K3  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 47             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 155            |
| K4  | 0,11             | 0,13             | 0,16             | 0,20             | 0,24              | 0,26              | 0,28              | 0,30              | 0,32              | 0,34              | 45             |
|     | 0.0044           | 0.0050           | 0.0065           | 0.0080           | 0.0095            | 0.010             | 0.011             | 0.012             | 0.013             | 0.013             | 150            |
| K5  | 0,10             | 0,11             | 0,15             | 0,18             | 0,20              | 0,24              | 0,25              | 0,28              | 0,28              | 0,30              | 27             |
|     | 0.0040           | 0.0044           | 0.0060           | 0.0070           | 0.0080            | 0.0095            | 0.010             | 0.011             | 0.011             | 0.012             | 90             |
| N1  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 180            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 590            |
| N2  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 115            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 375            |
| N3  | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 75             |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 245            |
| N11 | 0,15             | 0,17             | 0,22             | 0,25             | 0,28              | 0,32              | 0,34              | 0,36              | 0,38              | 0,40              | 145            |
|     | 0.0060           | 0.0065           | 0.0085           | 0.010            | 0.011             | 0.013             | 0.013             | 0.014             | 0.015             | 0.016             | 475            |
| H3  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 23             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 75             |
| H5  | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 43             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 140            |
| H7  | 0,048            | 0,055            | 0,075            | 0,090            | 0,10              | 0,12              | 0,13              | 0,14              | 0,14              | 0,15              | 23             |
|     | 0.0019           | 0.0022           | 0.0030           | 0.0036           | 0.0040            | 0.0048            | 0.0050            | 0.0055            | 0.0055            | 0.0060            | 75             |
| H8  | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 43             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 140            |
| H11 | 0,075            | 0,085            | 0,11             | 0,14             | 0,16              | 0,18              | 0,19              | 0,20              | 0,22              | 0,22              | 55             |
|     | 0.0030           | 0.0034           | 0.0044           | 0.0055           | 0.0065            | 0.0070            | 0.0075            | 0.0080            | 0.0085            | 0.0085            | 180            |
| H12 | 0,055            | 0,065            | 0,085            | 0,10             | 0,12              | 0,14              | 0,15              | 0,16              | 0,17              | 0,17              | 26             |
|     | 0.0022           | 0.0026           | 0.0034           | 0.0040           | 0.0048            | 0.0055            | 0.0060            | 0.0065            | 0.0065            | 0.0065            | 85             |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

When drilling in stainless steel with 8xD and 12xD a pre-drilling operation might be needed

SD203A – Ø 2-8 mm / 0.079-0.315 inch

| SMG |    | f                |                  |                  |                  |                  |                  | v <sub>c</sub> |
|-----|----|------------------|------------------|------------------|------------------|------------------|------------------|----------------|
|     |    | Ø2,00<br>Ø 0.079 | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>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           | 160            |
| 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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD203A – Ø 10-20 mm / 0.394-0.787 inch

| SMG |    | f                 |                   |                   |                   |                   |                   | V <sub>c</sub> |
|-----|----|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |    | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

SD205A – Ø 2-8 mm / 0.079-0.315 inch

| SMG |    | f                |                  |                  |                  |                  |                  | v <sub>c</sub> |
|-----|----|------------------|------------------|------------------|------------------|------------------|------------------|----------------|
|     |    | Ø2,00<br>Ø 0.079 | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>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           | 160            |
| 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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

SD205A – Ø 10-20 mm / 0.394-0.787 inch

| SMG |    | f                 |                   |                   |                   |                   |                   | V <sub>c</sub> |
|-----|----|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |    | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



## SD206 – Ø 0,7-2 mm / 0.0276-0.0787 inch

| SMG |   | f                 |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|----------------|
|     |   | Ø0,70<br>Ø 0.0276 | Ø1,00<br>Ø 0.0394 | Ø2,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD206A – Ø 1-2 mm / 0.0394-0.0787 inch

| SMG |   | f                 |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|----------------|
|     |   | Ø1,00<br>Ø 0.0394 | Ø1,50<br>Ø 0.0591 | Ø2,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



## SD216A – Ø 3-14 mm / 0.118-0.551 inch

| SMG |   | f                |                  |                  |                  |                   |                   |                   |     | v <sub>c</sub> |
|-----|---|------------------|------------------|------------------|------------------|-------------------|-------------------|-------------------|-----|----------------|
|     |   | Ø3,00<br>Ø 0.118 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

SD230A – Ø 3-12 mm / 0.118-0.472 inch

| SMG |   | f                |                  |                  |                  |                   |                   | v <sub>c</sub> |
|-----|---|------------------|------------------|------------------|------------------|-------------------|-------------------|----------------|
|     |   | Ø3,00<br>Ø 0.118 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD245A – Ø 4-16 mm / 0.157-0.630 inch

| SMG |   | f                |                  |                  |                   |                   |                   |                   | v <sub>c</sub> |
|-----|---|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

SD265A – Ø 4-16 mm / 0.157-0.630 inch

| SMG |   | f                |                  |                  |                   |                   |                   |                   | V <sub>c</sub> |
|-----|---|------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø4,00<br>Ø 0.157 | Ø6,00<br>Ø 0.236 | Ø8,00<br>Ø 0.315 | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD203A -MS Ø 2-8 mm / 0.079-0.315 inch

| SMG |    | f                |                  |                  |                  |                  |                  | V <sub>c</sub> |
|-----|----|------------------|------------------|------------------|------------------|------------------|------------------|----------------|
|     |    | Ø2,00<br>Ø 0.079 | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



## SD203A-MS Ø 10-20 mm / 0.394-0.787 inch

| SMG |    | f                 |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|----|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |    | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD205A -MS Ø 2-8 mm / 0.079-0.315 inch

| SMG |    | f                |                  |                  |                  |                  |                  | V <sub>c</sub> |
|-----|----|------------------|------------------|------------------|------------------|------------------|------------------|----------------|
|     |    | Ø2,00<br>Ø 0.079 | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD205A-MS Ø 10-20 mm / 0.394-0.787 inch

| SMG |    | f                 |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|----|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |    | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD203A – Ø 2-8 mm / 0.079-0.315 inch

| SMG |   | f                |                  |                  |                  |                  |                  | V <sub>c</sub> |
|-----|---|------------------|------------------|------------------|------------------|------------------|------------------|----------------|
|     |   | Ø2,00<br>Ø 0.079 | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

When drilling in stainless steel with 8xD and 12xD a pre-drilling operation might be needed

SD203A – Ø 10-20 mm / 0.394-0.787 inch

| SMG |   | f                 |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

When drilling in stainless steel with 8xD and 12xD a pre-drilling operation might be needed

## SD205A – Ø 2-8 mm / 0.079-0.315 inch

| SMG |   | f                |                  |                  |                  |                  |                  | V <sub>c</sub> |
|-----|---|------------------|------------------|------------------|------------------|------------------|------------------|----------------|
|     |   | Ø2,00<br>Ø 0.079 | Ø3,00<br>Ø 0.118 | Ø4,00<br>Ø 0.157 | Ø5,00<br>Ø 0.197 | Ø6,00<br>Ø 0.236 | Ø8,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

When drilling in stainless steel with 8xD and 12xD a pre-drilling operation might be needed

SD205A – Ø 10-20 mm / 0.394-0.787 inch

| SMG |   | f                 |                   |                   |                   |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø10,00<br>Ø 0.394 | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

When drilling in stainless steel with 8xD and 12xD a pre-drilling operation might be needed

## SD205A-C1 – Ø 3-13 mm / 0.118-0.512 inch

| SMG |    | f                |                  |                  |                  |                   |                   | V <sub>c</sub> |
|-----|----|------------------|------------------|------------------|------------------|-------------------|-------------------|----------------|
|     |    | Ø3,00<br>Ø 0.118 | Ø5,00<br>Ø 0.197 | Ø7,00<br>Ø 0.276 | Ø9,00<br>Ø 0.354 | Ø11,00<br>Ø 0.433 | Ø13,00<br>Ø 0.512 |                |
| TS2 | C1 | 0,060            | 0,060            | 0,065            | 0,070            | 0,075             | 0,080             | 65             |
|     | C1 | 0,0024           | 0,0024           | 0,0026           | 0,0028           | 0,0030            | 0,0032            | 215            |
| TS3 | C1 | 0,060            | 0,060            | 0,065            | 0,070            | 0,075             | 0,080             | 50             |
|     | C1 | 0,0024           | 0,0024           | 0,0026           | 0,0028           | 0,0030            | 0,0032            | 165            |
| TP2 | C1 | 0,060            | 0,060            | 0,065            | 0,070            | 0,075             | 0,080             | 65             |
|     | C1 | 0,0024           | 0,0024           | 0,0026           | 0,0028           | 0,0030            | 0,0032            | 215            |
| TP3 | C1 | 0,060            | 0,060            | 0,065            | 0,070            | 0,075             | 0,080             | 50             |
|     | C1 | 0,0024           | 0,0024           | 0,0026           | 0,0028           | 0,0030            | 0,0032            | 165            |

## SD205A-C2 – Ø 3-13 mm / 0.118-0.512 inch

| SMG |    | f                |                  |                  |                  |                   |                   | V <sub>c</sub> |
|-----|----|------------------|------------------|------------------|------------------|-------------------|-------------------|----------------|
|     |    | Ø3,00<br>Ø 0.118 | Ø5,00<br>Ø 0.197 | Ø7,00<br>Ø 0.276 | Ø9,00<br>Ø 0.354 | Ø11,00<br>Ø 0.433 | Ø13,00<br>Ø 0.512 |                |
| N1  | C2 | 0,095            | 0,10             | 0,11             | 0,12             | 0,13              | 0,14              | 80             |
|     | C2 | 0,0038           | 0,0040           | 0,0044           | 0,0048           | 0,0050            | 0,0055            | 260            |
| N2  | C2 | 0,095            | 0,10             | 0,11             | 0,12             | 0,13              | 0,14              | 50             |
|     | C2 | 0,0038           | 0,0040           | 0,0044           | 0,0048           | 0,0050            | 0,0055            | 165            |
| N3  | C2 | 0,095            | 0,10             | 0,11             | 0,12             | 0,13              | 0,14              | 33             |
|     | C2 | 0,0038           | 0,0040           | 0,0044           | 0,0048           | 0,0050            | 0,0055            | 110            |
| S11 | C2 | 0,055            | 0,065            | 0,080            | 0,090            | 0,10              | 0,11              | 50             |
|     | C2 | 0,0022           | 0,0026           | 0,0032           | 0,0036           | 0,0040            | 0,0044            | 165            |
| S12 | C2 | 0,055            | 0,065            | 0,080            | 0,090            | 0,10              | 0,11              | 40             |
|     | C2 | 0,0022           | 0,0026           | 0,0032           | 0,0036           | 0,0040            | 0,0044            | 130            |
| S13 | C2 | 0,048            | 0,060            | 0,070            | 0,080            | 0,090             | 0,10              | 31             |
|     | C2 | 0,0019           | 0,0024           | 0,0028           | 0,0032           | 0,0036            | 0,0040            | 100            |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Cutting data depends on exiting material. N1-N3 and S11-S13 used for stack drilling application

N1-N3 = Alu

S11-S13 = Ti

TS/TP = Composite



**SD203-CX1 – Ø 3-9 mm / 0.118-0.354 inch**

| SMG |     | f                |                  |                  |                  | v <sub>c</sub> |
|-----|-----|------------------|------------------|------------------|------------------|----------------|
|     |     | Ø3,00<br>Ø 0.118 | Ø5,00<br>Ø 0.197 | Ø7,00<br>Ø 0.276 | Ø9,00<br>Ø 0.354 |                |
| TS2 | CX1 | 0,075            | 0,085            | 0,090            | 0,10             | 150            |
|     | CX1 | 0.0030           | 0.0034           | 0.0036           | 0.0040           | 490            |
| TS3 | CX1 | 0,075            | 0,085            | 0,090            | 0,10             | 120            |
|     | CX1 | 0.0030           | 0.0034           | 0.0036           | 0.0040           | 395            |
| TP2 | CX1 | 0,075            | 0,085            | 0,090            | 0,10             | 150            |
|     | CX1 | 0.0030           | 0.0034           | 0.0036           | 0.0040           | 490            |
| TP3 | CX1 | 0,075            | 0,085            | 0,090            | 0,10             | 120            |
|     | CX1 | 0.0030           | 0.0034           | 0.0036           | 0.0040           | 395            |

**SD203A-CX2 – Ø 3-9 mm / 0.118-0.354 inch**

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

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Cutting data depends on exiting material. N1-N3 and S11-S13 used for stack drilling application

N1-N3 = Alu

S11-S13 = Ti

TS/TP = Composite

## SD205-CX31 – Ø 4-8 mm / 0.157-0.315 inch

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

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Cutting data depends on exiting material. N1-N3 and S11-S13 used for stack drilling application

N1-N3 = Alu

S11-S13 = Ti

TS/TP = Composite

## SD22 &amp; SD26 – Ø 0,1-0,3 mm / 0.0039-0.0118 inch

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

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

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## SD22 &amp; SD26 – Ø 0,4-0,5 mm / 0.0157-0.0197 inch

| SMG | f                  |                    | v <sub>c</sub> |
|-----|--------------------|--------------------|----------------|
|     | Ø 0,40<br>Ø 0.0157 | Ø 0,50<br>Ø 0.0197 |                |
| P1  | 0,0030             | 0,0036             | 14             |
|     | 0,00012            | 0,00014            | 46             |
| P2  | 0,0030             | 0,0036             | 14             |
|     | 0,00012            | 0,00014            | 46             |
| P3  | 0,0028             | 0,0034             | 12             |
|     | 0,00011            | 0,00013            | 39             |
| P4  | 0,0028             | 0,0034             | 10             |
|     | 0,00011            | 0,00013            | 33             |
| P5  | 0,0028             | 0,0034             | 10             |
|     | 0,00011            | 0,00013            | 33             |
| P6  | 0,0028             | 0,0032             | 11             |
|     | 0,00011            | 0,00013            | 36             |
| P7  | 0,0028             | 0,0032             | 11             |
|     | 0,00011            | 0,00013            | 36             |
| P8  | 0,0028             | 0,0034             | 10             |
|     | 0,00011            | 0,00013            | 33             |
| P11 | 0,0028             | 0,0032             | 10             |
|     | 0,00011            | 0,00013            | 33             |
| P12 | 0,0019             | 0,0022             | 6              |
|     | 0,000075           | 0,000085           | 20             |
| M1  | 0,0030             | 0,0036             | 5              |
|     | 0,00012            | 0,00014            | 16             |
| M2  | 0,0028             | 0,0034             | 4              |
|     | 0,00011            | 0,00013            | 13             |
| K1  | 0,0030             | 0,0036             | 10             |
|     | 0,00012            | 0,00014            | 33             |
| K2  | 0,0028             | 0,0034             | 9              |
|     | 0,00011            | 0,00013            | 30             |
| K3  | 0,0028             | 0,0034             | 7              |
|     | 0,00011            | 0,00013            | 23             |
| K4  | 0,0028             | 0,0034             | 7              |
|     | 0,00011            | 0,00013            | 23             |
| K5  | 0,0025             | 0,0030             | 4              |
|     | 0,00010            | 0,00012            | 13             |
| N2  | 0,0038             | 0,0046             | 30             |
|     | 0,00015            | 0,00018            | 100            |
| N3  | 0,0038             | 0,0046             | 20             |
|     | 0,00015            | 0,00018            | 65             |
| S11 | 0,0022             | 0,0026             | 8              |
|     | 0,000085           | 0,00010            | 26             |
| S12 | 0,0022             | 0,0026             | 6              |
|     | 0,000085           | 0,00010            | 20             |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

SD22 & SD26 – Ø 0,6-0,8 mm / 0.0236-0.0315 inch

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

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

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## SD22 &amp; SD26 – Ø 0,9-1,1 mm / 0.0354-0.0433 inch

| SMG | f                 |                   |                   | v <sub>c</sub> |
|-----|-------------------|-------------------|-------------------|----------------|
|     | Ø0,90<br>Ø 0.0354 | Ø1,00<br>Ø 0.0394 | Ø1,10<br>Ø 0.0433 |                |
| P1  | 0,0060            | 0,0065            | 0,0075            | 50             |
|     | 0.00024           | 0.00026           | 0.00030           | 165            |
| P2  | 0,0060            | 0,0070            | 0,0075            | 48             |
|     | 0.00024           | 0.00028           | 0.00030           | 155            |
| P3  | 0,0060            | 0,0065            | 0,0070            | 42             |
|     | 0.00024           | 0.00026           | 0.00028           | 140            |
| P4  | 0,0055            | 0,0065            | 0,0070            | 37             |
|     | 0.00022           | 0.00026           | 0.00028           | 120            |
| P5  | 0,0055            | 0,0060            | 0,0070            | 35             |
|     | 0.00022           | 0.00024           | 0.00028           | 115            |
| P6  | 0,0055            | 0,0060            | 0,0065            | 39             |
|     | 0.00022           | 0.00024           | 0.00026           | 130            |
| P7  | 0,0055            | 0,0060            | 0,0065            | 37             |
|     | 0.00022           | 0.00024           | 0.00026           | 120            |
| P8  | 0,0060            | 0,0065            | 0,0070            | 35             |
|     | 0.00024           | 0.00026           | 0.00028           | 115            |
| P11 | 0,0055            | 0,0060            | 0,0065            | 36             |
|     | 0.00022           | 0.00024           | 0.00026           | 120            |
| P12 | 0,0038            | 0,0042            | 0,0046            | 21             |
|     | 0.00015           | 0.00017           | 0.00018           | 70             |
| M1  | 0,0060            | 0,0070            | 0,0075            | 12             |
|     | 0.00024           | 0.00028           | 0.00030           | 39             |
| M2  | 0,0055            | 0,0060            | 0,0070            | 10             |
|     | 0.00022           | 0.00024           | 0.00028           | 33             |
| K1  | 0,0060            | 0,0070            | 0,0075            | 20             |
|     | 0.00024           | 0.00028           | 0.00030           | 65             |
| K2  | 0,0055            | 0,0060            | 0,0070            | 17             |
|     | 0.00022           | 0.00024           | 0.00028           | 55             |
| K3  | 0,0055            | 0,0060            | 0,0070            | 15             |
|     | 0.00022           | 0.00024           | 0.00028           | 49             |
| K4  | 0,0055            | 0,0060            | 0,0070            | 14             |
|     | 0.00022           | 0.00024           | 0.00028           | 46             |
| K5  | 0,0050            | 0,0055            | 0,0060            | 8              |
|     | 0.00020           | 0.00022           | 0.00024           | 26             |
| N2  | 0,0080            | 0,0085            | 0,0095            | 80             |
|     | 0.00032           | 0.00034           | 0.00038           | 260            |
| N3  | 0,0080            | 0,0085            | 0,0095            | 55             |
|     | 0.00032           | 0.00034           | 0.00038           | 180            |
| S11 | 0,0046            | 0,0050            | 0,0055            | 19             |
|     | 0.00018           | 0.00020           | 0.00022           | 60             |
| S12 | 0,0046            | 0,0050            | 0,0055            | 15             |
|     | 0.00018           | 0.00020           | 0.00022           | 49             |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD22 &amp; SD26 – Ø 1,2-2,0 mm / 0.0472-0.0787 inch

| SMG | f                 |                   |                   |                   |                   | v <sub>c</sub> |
|-----|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     | Ø1,20<br>Ø 0.0472 | Ø1,40<br>Ø 0.0551 | Ø1,60<br>Ø 0.0630 | Ø1,80<br>Ø 0.0709 | Ø2,00<br>Ø 0.0787 |                |
| P1  | 0,0080            | 0,0090            | 0,010             | 0,012             | 0,013             | 70             |
|     | 0.00032           | 0.00036           | 0.00040           | 0.00048           | 0.00050           | 230            |
| P2  | 0,0080            | 0,0095            | 0,011             | 0,012             | 0,013             | 70             |
|     | 0.00032           | 0.00038           | 0.00044           | 0.00048           | 0.00050           | 230            |
| P3  | 0,0075            | 0,0090            | 0,010             | 0,011             | 0,012             | 60             |
|     | 0.00030           | 0.00036           | 0.00040           | 0.00044           | 0.00048           | 195            |
| P4  | 0,0075            | 0,0085            | 0,010             | 0,011             | 0,012             | 50             |
|     | 0.00030           | 0.00034           | 0.00040           | 0.00044           | 0.00048           | 165            |
| P5  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 50             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 165            |
| P6  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 55             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 180            |
| P7  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 55             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 180            |
| P8  | 0,0075            | 0,0090            | 0,010             | 0,011             | 0,012             | 50             |
|     | 0.00030           | 0.00036           | 0.00040           | 0.00044           | 0.00048           | 165            |
| P11 | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 50             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 165            |
| P12 | 0,0050            | 0,0060            | 0,0065            | 0,0075            | 0,0080            | 30             |
|     | 0.00020           | 0.00024           | 0.00026           | 0.00030           | 0.00032           | 100            |
| M1  | 0,0080            | 0,0095            | 0,011             | 0,012             | 0,013             | 15             |
|     | 0.00032           | 0.00038           | 0.00044           | 0.00048           | 0.00050           | 49             |
| M2  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 12             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 39             |
| K1  | 0,0080            | 0,0095            | 0,011             | 0,012             | 0,013             | 35             |
|     | 0.00032           | 0.00038           | 0.00044           | 0.00048           | 0.00050           | 115            |
| K2  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 30             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 100            |
| K3  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 26             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 85             |
| K4  | 0,0075            | 0,0085            | 0,0095            | 0,011             | 0,012             | 25             |
|     | 0.00030           | 0.00034           | 0.00038           | 0.00044           | 0.00048           | 80             |
| K5  | 0,0065            | 0,0075            | 0,0085            | 0,010             | 0,011             | 15             |
|     | 0.00026           | 0.00030           | 0.00034           | 0.00040           | 0.00044           | 49             |
| N2  | 0,010             | 0,012             | 0,014             | 0,015             | 0,017             | 100            |
|     | 0.00040           | 0.00048           | 0.00055           | 0.00060           | 0.00065           | 330            |
| N3  | 0,010             | 0,012             | 0,014             | 0,015             | 0,017             | 65             |
|     | 0.00040           | 0.00048           | 0.00055           | 0.00060           | 0.00065           | 215            |
| S11 | 0,0060            | 0,0070            | 0,0075            | 0,0085            | 0,0095            | 26             |
|     | 0.00024           | 0.00028           | 0.00030           | 0.00034           | 0.00038           | 85             |
| S12 | 0,0060            | 0,0070            | 0,0075            | 0,0085            | 0,0095            | 20             |
|     | 0.00024           | 0.00028           | 0.00030           | 0.00034           | 0.00038           | 65             |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



## Seco Crownloc®

A Seco Crownloc® a cserélhető hegyű fúrók családja, melyekkel kiváló minőségű furatok készíthetők alacsonyabb költséggel. A nagy pontosságú fúrókkal összevethető Crownloc cserélhető hegyekkel küszöböli ki az újraélezés szükségességét és költségeit.

- A koronán áthaladó dupla folyadékfurat jóvoltából nagy mennyiségű hűtő-kenő folyadék juttatható a vágóélekhez.
- A Crownloc® optimalizált csúcsgeometriák nagy választékában kapható a különféle alkalmazásokhoz és munkadarab anyagokhoz.



## Választék áttekintés

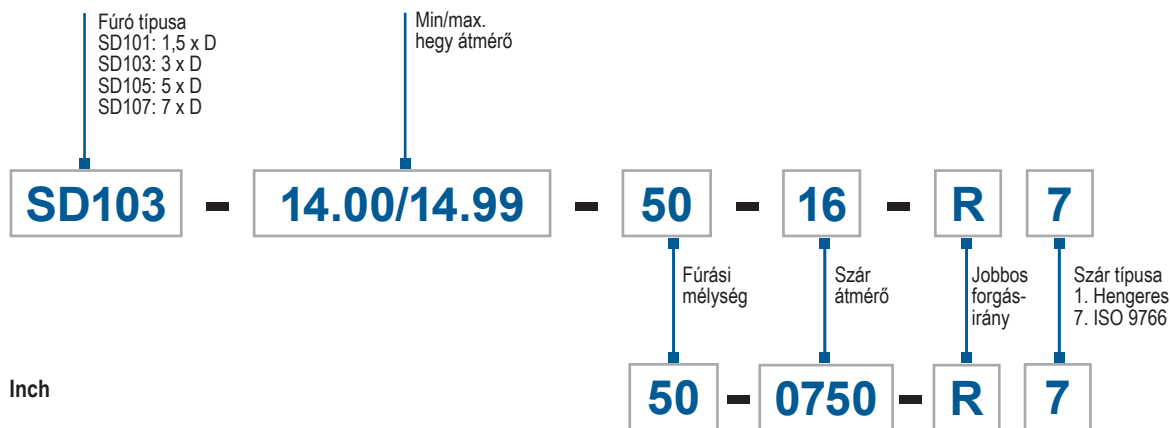
| Crownloc®  | ∅ Választék                      | Fúrási mélység | Fúró ∅ túrése | Furat túrés (1) | Felületi minőség (2)         |
|--|----------------------------------|----------------|---------------|-----------------|------------------------------|
| <b>SD101</b><br><br>Oldal 178-179 old.        | 12,00-25,99 mm<br>(0.472-1.023") | ~ 1,5 x D      | k7            | IT 10           | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD103</b><br><br>Oldal 180-181 old.        | 9,52-25,99 mm<br>(0.375-1.023")  | ~ 3 x D        | k7            | IT 10           | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD105</b><br><br>Oldal 182-183 old.      | 10,00-25,99 mm<br>(0.394-1.023") | ~ 5 x D        | k7            | IT 10           | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD107</b><br><br>Oldal 184-185 old.      | 12,00-25,99 mm<br>(0.472-1.023") | ~ 7 x D        | k7            | IT 10           | Ra 1-4 μm<br>(Ra 39-157 μin) |
| <b>Élletörő modul</b><br><br>Oldal 193 old. | 12,00-19,99 mm<br>(0.472-0.787") | -              | -             | -               | -                            |

- 1) Eltérések a munkadarab anyagtól és az alkalmazott forgácsolási paraméterektől függően adódhatnak.  
 2) A fúrási mélység, forgácsolási adatok, hűtőfolyadék nyomás és anyagminőség befolyásolhatja a felületi minőséget.

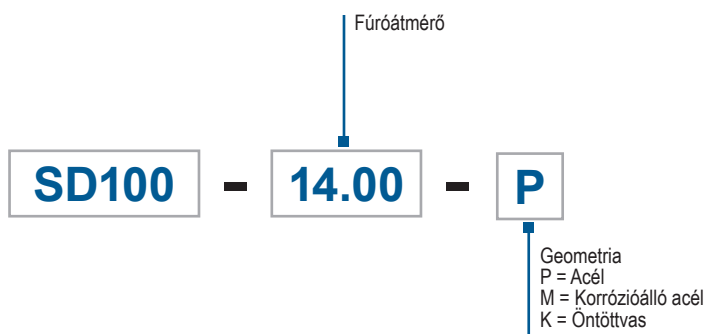
## Jelmagyarázat

### Jelmagyarázat, fúrótestek

#### Metrikus

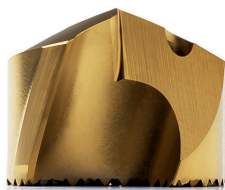


### Jelmagyarázat, koronák

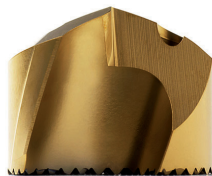


#### Geometriák

**P-geometria**  
– Univerzális geometria, elsődleges választás acél fúrásához



**M-geometria**  
– Rozsdamentes acélhoz és hőálló ötvözetekhez



**K-geometria**  
– Elsődleges választás öntöttvas fúrásához



## Befogási útmutató

1. Körültekintően tisztítsa meg a fűrőtest érintkező felületét a forgáctól, törmeléktől.
2. Győződjön meg róla, hogy a behúzószár ki van teljesen engedve.
3. Helyezzen egy új hegyet a behúzószárra, és hajtsa rá, amíg el nem éri a menet alját.

Forgassa kissé vissza a hegyet addig, amíg a forgácskihordó homyak illeszkednek. Szorítsa le a hegyet a testhez, amíg meghúzza a rögzítő csavart. Ellenőrizze, hogy a felületek megfelelően illeszkednek. Határozottan húzza meg a rögzítőcsavart nyomatékhatalóval kulccsal.

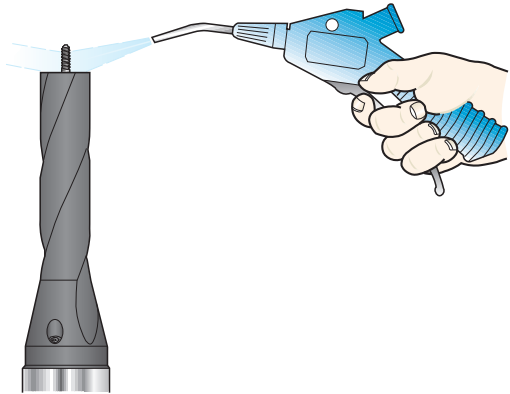
### Stabilitás

Az alkalmazás stabilitása fontos a legjobb szerszámelettartam és furat pontosságának eléréséhez. Ellenőrizze a gép főorsóját, a készüléket és a munkadarab megfogását a maximális stabilitás és merevség eléréséhez. Az instabil feltételek szerszámtöréshez vezethetnek.

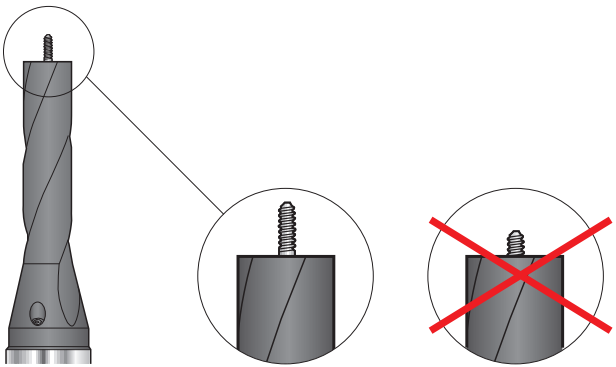
### Forgás

A Totally Indicated Run-out (TIR-teljes megengedett tűrés) nem haladhatja meg forgó alkalmazásnál a 0,06 mm-t (0.002"). Befogott állapotban a főorsóban mérje az ütést!

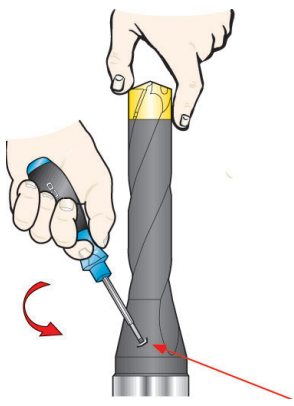
**1.**



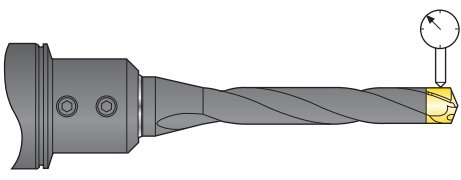
**2.**




**3.**



**Állóhelyzet**  
A fűrő és a munkadarab forgástengely eltérése álló alkalmazásnál nem haladhatja meg sugárirányban a 0,03 mm-t (0.001").



**Ajánlott szerszámbefogók**  
A legjobb eredmények elérése érdekében használja a DIN 1835 B/DIN 6535 HB (Weldon) befogót. További információkért tekintse meg a Felszerszámozás katalógust.

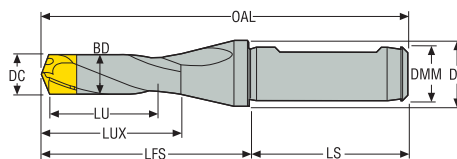


**Weldon**

| Fűrő Ø DC mm | M <sub>c</sub> Nm | Fűrő Ø DC inch | M <sub>c</sub> 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                 |

## SD101

Fúrási mélység ~ 1,5 x D – Metrikus szár



- SD101 -R7 szár
- Belső hűtés
- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Forgácsolási adatokat lásd a 196 old.

| Megnevezés                | Cikkszám | 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 |

### Pótalkatrészek

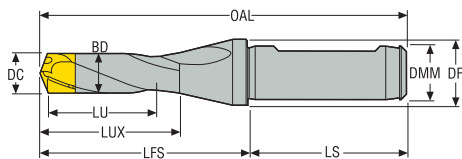
| Fúró átmérő (mm) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|------------------|---------------|----------------|-----------------|
| 12,00-13,99      | H1.5-2D       | MP6SS3X12      | SD101-SP-5.0    |
| 14,00-16,99      | H2.0-2D       | MP6SS4X12      | SD101-SP-6.0    |
| 17,00-19,99      | H2.5-2D       | MP6SS5X16      | SD101-SP-7.0    |
| 20,00-25,99      | H2.5-2D       | MP6SS5X16      | SD101-SP-8.0    |

### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
| H00-1.5          | H00-1509       |
| H00-2.0          | H00-2020       |
| H00-2.5          | H00-2530       |
| H00-2.5          | H00-2535       |

## SD101 -R7 Szár

Fúrési mélység ~ 1,5 x D – Inch szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 196 old.

| Megnevezés                  | Cikkszám | Max. fúrási mélység | Fúró átm. DC | LU    | BD    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|-----------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|-------|
|                             |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

### Pótalkatrészek

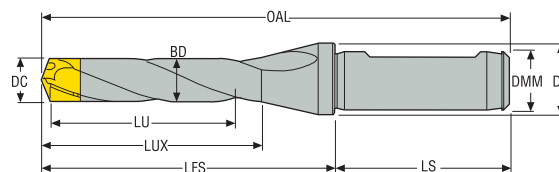
| Fúró átmérő (inch) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|--------------------|---------------|----------------|-----------------|
| 0.472-0.551        | H1.5-2D       | MP6SS3X12      | SD101-SP-5.0    |
| 0.551-0.669        | H2.0-2D       | MP6SS4X12      | SD101-SP-6.0    |
| 0.669-0.787        | H2.5-2D       | MP6SS5X16      | SD101-SP-7.0    |
| 0.787-1.023        | H2.5-2D       | MP6SS5X16      | SD101-SP-8.0    |

### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
| H00-1.5          | H00-1509       |
| H00-2.0          | H00-2020       |
| H00-2.5          | H00-2530       |
| H00-2.5          | H00-2535       |

## SD103

Fúrási mélység ~ 3 x D – Metrikus szár



- SD103 -R7 szár
- Belső hűtés
- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Forgácsolási adatokat lásd a 197 old.

| Megnevezés                | Cikkszám | 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 |

### Pótalkatrészek

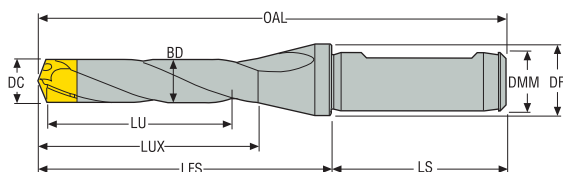
| Fúró átmérő (mm) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|------------------|---------------|----------------|-----------------|
| 10,00-11,99      | H1.5-2D       | MP6SS3X12      | SD103-SP-4.0    |
| 12,00-13,99      | H1.5-2D       | MP6SS3X12      | SD103-SP-5.0    |
| 14,00-16,99      | 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    |

### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
| 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 Szár

Fúrási mélység ~ 3 x D – Inch shank



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 197 old.

| Megnevezés                  | Cikkszám | Max. fúrási mélység | Fúró átm. DC | LU    | BD    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|-----------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|-------|
|                             |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

### Pótalkatrészek

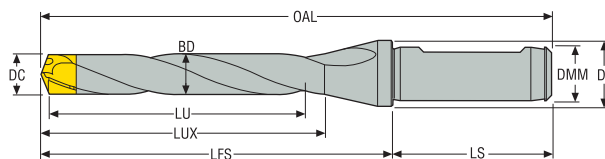
| Fúró átmérő (inch) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|--------------------|---------------|----------------|-----------------|
| 0.374-0.393        | H1.5-2D       | MP6SS3X12      | -               |
| 0.394-0.472        | H1.5-2D       | MP6SS3X12      | SD103-SP-4.0    |
| 0.472-0.551        | 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    |

### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
| 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

Fúrási mélység ~ 5 x D – Metrikus szár



- SD105 -R7 szár
- Belső hűtés
- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Forgácsolási adatokat lásd a 198 old.

| Megnevezés                 | Cikkszám | 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 |

### Pótalkatrészek

| Fúró átmérő (mm) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|------------------|---------------|----------------|-----------------|
| 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    |

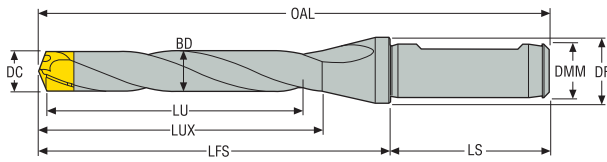
### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
| 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 Szár

Fúrési mélység ~ 5 x D – Inch szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 198 old.

| Megnevezés                   | Cikkszám | Max. fúrési mélység | Fúró átm. DC | LU    | BD    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|------------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|-------|
|                              |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

### Pótalkatrészek

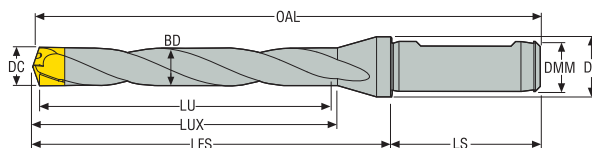
| Fúró átmérő (inch) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|--------------------|---------------|----------------|-----------------|
|                    |               |                |                 |
| 0.394-0.472        | H1.5-2D       | MP6SS3X12      | SD105-SP-4.0    |
| 0.472-0.551        | 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    |

### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
|                  |                |
| 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

Fúrési mélység ~ 7 x D – Metrikus szár



- SD107 -R7 szár
- Belső hűtés
- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Forgácsolási adatokat lásd a 199 old.

| Megnevezés                 | Cikkszám | 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 |

### Pótalkatrészek

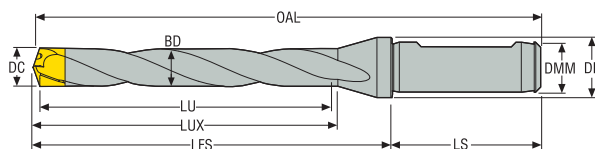
| Fúró átmérő (mm) | Rögzítő kulcs | Rögzítő csavar | Alkatrész szett |
|------------------|---------------|----------------|-----------------|
| 12,00-13,99      | H1.5-2D       | MP6SS3X12      | SD107-SP-5.0    |
| 14,00-16,99      | H2.0-2D       | MP6SS4X12      | SD107-SP-6.0    |
| 17,00-19,99      | H2.5-2D       | MP6SS5X16      | SD107-SP-7.0    |
| 20,00-25,99      | H2.5-2D       | MP6SS5X16      | SD107-SP-8.0    |

### Kiegészítők

| Cserélhető penge | Nyomaték kulcs |
|------------------|----------------|
| H00-1.5          | H00-1509       |
| H00-2.0          | H00-2020       |
| H00-2.5          | H00-2530       |
| H00-2.5          | H00-2535       |

## SD107 -R7 Szár

Fúrési mélység ~ 7 x D – Inch szár










- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 199 old.

| Megnevezés                   | Cikkszám | Max. fúrési mélység | Fúró átm. DC | LU    | BD    | DF    | OAL    | LS    | LFS   | LUX   | DMM   |
|------------------------------|----------|---------------------|--------------|-------|-------|-------|--------|-------|-------|-------|-------|
|                              |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch   | Inch  | Inch  | Inch  | Inch  |
| 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 |

### Pótalkatrészek

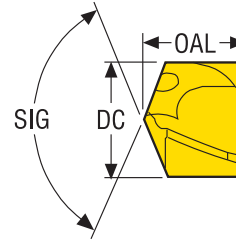
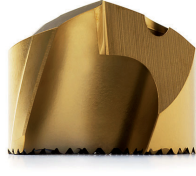
| Fúró átmérő (inch) | Rögzítő kulcs   | Rögzítő csavar  | Alkatrész szett  |
|--------------------|---|---|--|
| 0.472-0.551        |  H1.5-2D |  MP6SS3X12 |  SD107-SP-5.0 |
| 0.551-0.669        |  H2.0-2D |  MP6SS4X12 |  SD107-SP-6.0 |
| 0.669-0.787        |  H2.5-2D |  MP6SS5X16 |  SD107-SP-7.0 |
| 0.787-1.023        |  H2.5-2D |  MP6SS5X16 |  SD107-SP-8.0 |

### Kiegészítők

| Fúró átmérő (inch) | Cserélhető penge  | Nyomaték kulcs   |
|--------------------|---|--|
| 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 |

## Koronák - Geometria -P, -M és -K

Csúcs szög: 140°



| Megnevezés     | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntötvashoz | DC     |       | OAL  |       |
|----------------|----------|---------------------|---|-------------------------|--------|-------|------|-------|
|                |          |                     |   |                         | mm     | inch  | mm   | inch  |
| 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 |

| Megnevezés    | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntöttvashoz | DC    |       | OAL  |       |
|---------------|----------|---------------------|---|--------------------------|-------|-------|------|-------|
|               |          |                     |   |                          | mm    | inch  | mm   | inch  |
| 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 |

| Megnevezés    | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntöttvashoz | DC    |       | OAL  |       |
|---------------|----------|---------------------|---|--------------------------|-------|-------|------|-------|
|               |          |                     |   |                          | mm    | inch  | mm   | inch  |
| 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 |

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

| Megnevezés    | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntöttvashoz | DC    |       | OAL  |       |
|---------------|----------|---------------------|---|--------------------------|-------|-------|------|-------|
|               |          |                     |   |                          | mm    | inch  | mm   | inch  |
| 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 |

| Megnevezés     | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntöttvashoz | DC     |       | OAL  |       |
|----------------|----------|---------------------|---|--------------------------|--------|-------|------|-------|
|                |          |                     |   |                          | mm     | inch  | mm   | inch  |
| 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 |

Bevezetés

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Melléklet

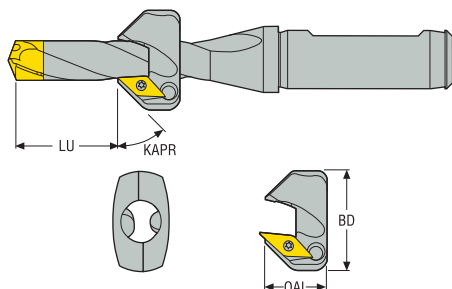


| Megnevezés     | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntöttvashoz | DC     |       | OAL  |       |
|----------------|----------|---------------------|---|--------------------------|--------|-------|------|-------|
|                |          |                     |   |                          | mm     | inch  | mm   | inch  |
| 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 |

| Megnevezés     | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | K-geometria öntöttvashoz | DC    |       | OAL  |       |
|----------------|----------|---------------------|---|--------------------------|-------|-------|------|-------|
|                |          |                     |   |                          | mm    | inch  | mm   | inch  |
| 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 |

■ Raktári szabványos termék.

Életörő modul



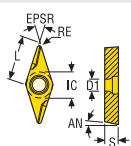
| Fúrás mélység LU      |          |                   |                 |               |                 |               |                 |               |                 |                |                       |               |               |    |
|-----------------------|----------|-------------------|-----------------|---------------|-----------------|-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

Pótalkatrészek

| Fúró átmérő (mm)  | Lapka csavar |             | Lapka kulcs |        | Rögzítő kulcs |  |
|-------------------|--------------|-------------|-------------|--------|---------------|--|
|                   | Váltólapka   | Modul       | Váltólapka  | Modul  |               |  |
| 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 |               |  |

Váltólapka

| Tűrések: mm/inch.   | Méret                     | IC mm/inch.   | L mm/inch.  | S mm/inch.  | D1 mm/inch. | RE mm/inch. |
|---|---------------------------|---------------|-------------|-------------|-------------|-------------|
| IC = ±0,025/0.0009842"<br>S = ±0,07/0.0027559"<br>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" |
|   | Minőség:T400D             |               |             |             |             |             |
|   | Megnevezés: VCGX090202-D1 |               |             |             |             |             |
|   | Cikkszám: 00014948        |               |             |             |             |             |



Bevezetés

Fúrás

Dörzsálás

Késztergálás

Melléklet

## Életőrő modul – Befogási útmutató/modul felhelyezése

Bevezetés

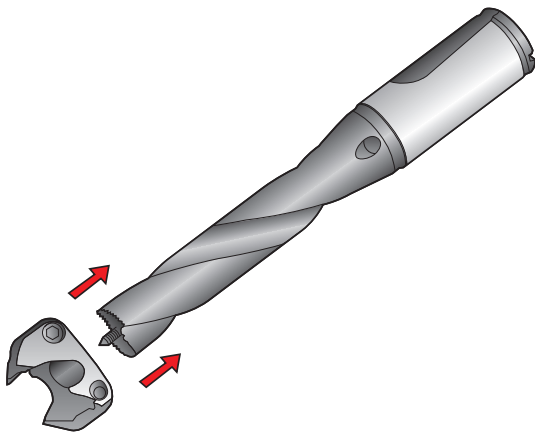
Fúrás

Dörzsarázás

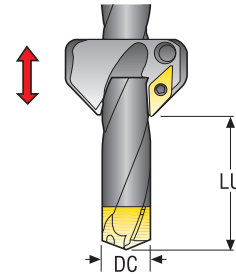
Késztergálás

Melléklet

**1.** Helyezze a modult a fúróra életőrő lapka és hegy nélkül.

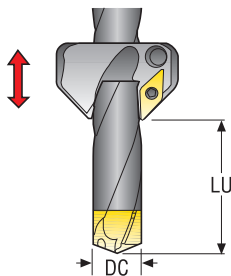


**2.1** Helyezze a modult a szárhoz a lehető legközelebb.



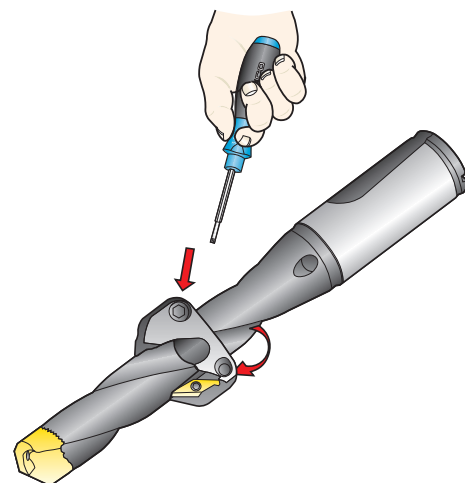
| DC   |      | LU fúrási mélység (min-max) |            |       |            |
|------|------|-----------------------------|------------|-------|------------|
| mm   | inch | SD101                       |            | SD103 |            |
| mm   | inch | mm                          | inch       | mm    | inch       |
| 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** Helyezze a modult a szárhoz a lehető legközelebb.



| DC   |      | LU fúrási mélység (min-max) |             |        |             |
|------|------|-----------------------------|-------------|--------|-------------|
| mm   | inch | SD105                       |             | SD107  |             |
| mm   | inch | mm                          | inch        | mm     | inch        |
| 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.** Húzza meg mindkét csavart az alábbi táblázat szerint.



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

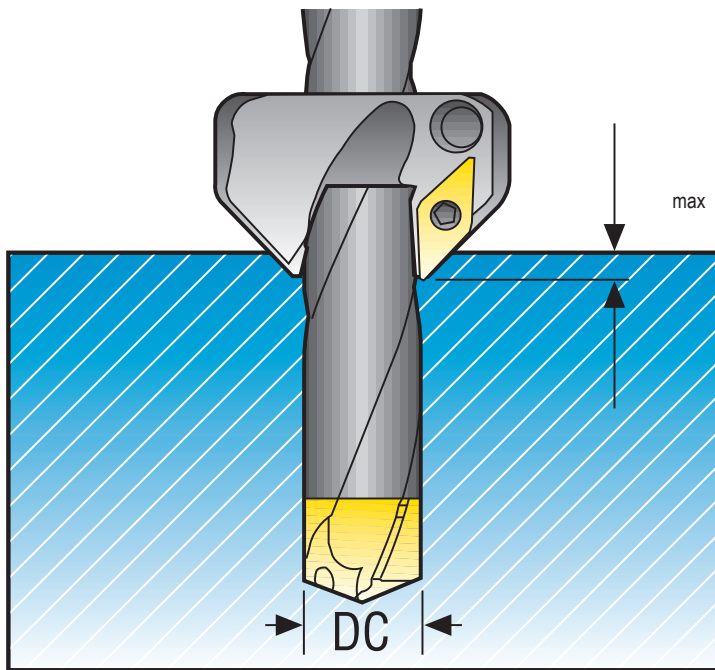
## Életörő modul

Az életörési művelethez ajánlott forgácsolási sebesség és előtolási értékek ugyanazok, mint a Crownloc® esetében, lásd: 196-199.

### Problémamegoldás

|                           |  |
|---------------------------|--|
| Vibráció az életöréssorán | <ul style="list-style-type: none"> <li>• Csökkentse a vágósebességet.</li> <li>• Amennyiben lehetséges, helyezze közelebb a modult a befogáshoz.</li> <li>• Amennyiben lehetséges, használjon rövidebb fúrót.</li> </ul> |
|---------------------------|--|

### Maximális életörés



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







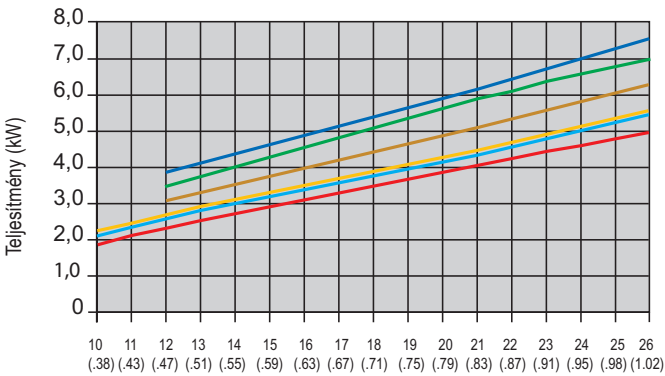




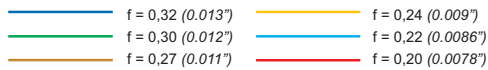
## Forgácsolási paraméterek

A feltüntetett értékek változhatnak pl. a forgácsolási paraméterek, anyagminőség, a gép hatásfoka és a szerszámkopás függvényében. Az alábbi grafikonok P5-P6 Seco anyagcsoportra (SMG) és 90 m/perc forgácsolási sebességre vannak meghatározva (295 SFM).

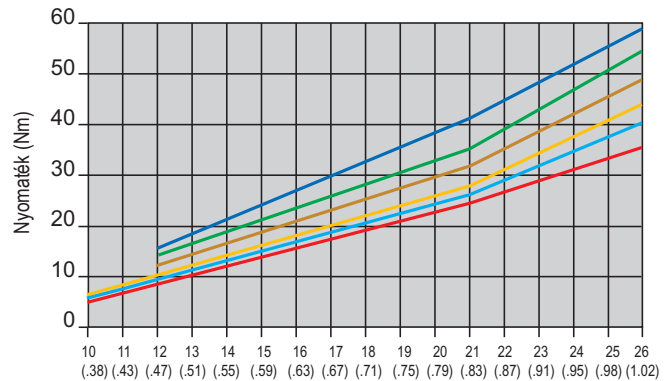
Teljesítményfelvétel



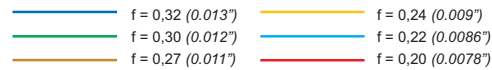
Fúróátmérő, mm / (inch)



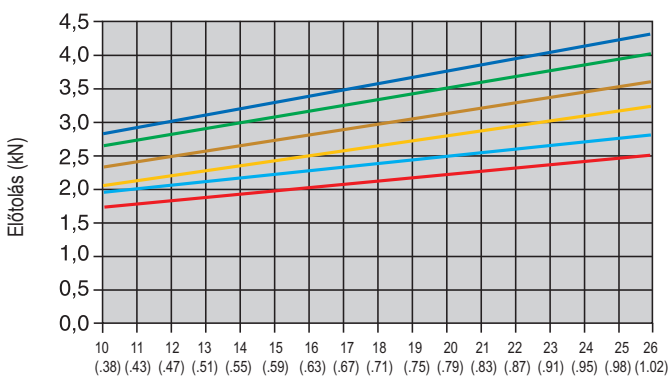
Fúrasi nyomatok



Fúróátmérő, mm / (inch)



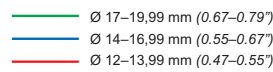
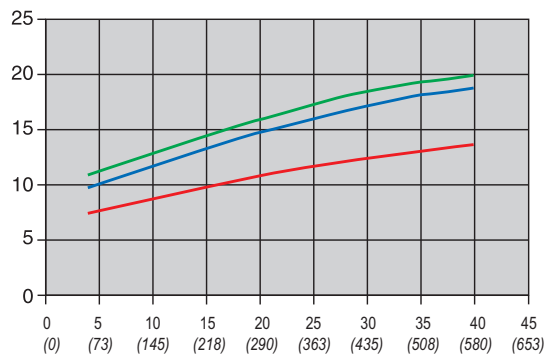
Előtolási erő



Fúróátmérő, mm / (inch)



Hűtőfolyadék-áramlás a nyomás függvényében



Javasolt hűtőfolyadék-áramlás D x 1 l/perc  
Minimális hűtőfolyadék-áramlás D/2 l/perc  
D = Fúróátmérő

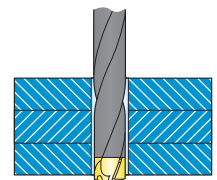
Minimálisan javasolt hűtőfolyadék-nyomás 10 bar (145 PSI) < 3 x D-nél  
Minimálisan javasolt hűtőfolyadék-nyomás 20 bar (290 PSI) > 3 x D-nél  
Minimálisan javasolt hűtőfolyadék-nyomás 40 bar (580 PSI) > 5 x D-nél

### Hűtő-kenő folyadék keverék

Ajánlott emulziókeverék 6–8%.  
Rozsdamentes acél, szuperötvözetek és nagy szilárdságú acél fúrása esetén a javasolt keverék 10%.

### Forgácsolási javaslatok

A rétegelt anyagok megmunkálása mindaddig lehetséges, amíg azok biztonságosan egymáshoz vannak rögzítve, tehát nincs légrés a darabok között. A légrések befolyásolhatják a forgács eltávolítását, és ezért sérülést okozhatnak a fúrót testen.



### Furat tűrés/Felületi minőség

#### SD101, SD103, SD105 és SD107

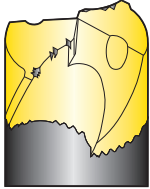
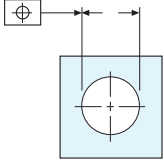
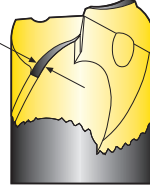
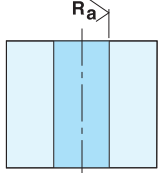

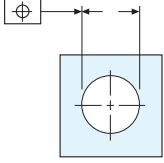
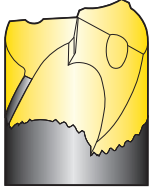
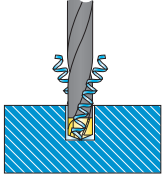
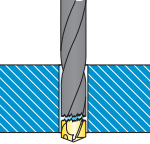
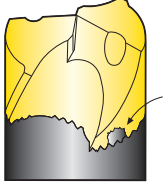
IT9-10 / R<sub>a</sub> 1-4\*, Ra 39-157 μm\*

| Fúró Ø DC (mm) | IT9 tűrés (μm) | IT10 tűrés (μm) | Fúró Ø DC (inch) | IT9 tűrés (inch) | IT10 tűrés (inch) |
|----------------|----------------|-----------------|------------------|------------------|-------------------|
| 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       |

\* Alacsony széntartalmú acélok és rozsdamentes acélok fúrásánál felületi minőség- és furattűrés-romlás léphet fel. A legjobb furatminőség elérése érdekében használja a lehető legrövidebb fúrot.

## Problémamegoldás – Elsődleges ellenőrzések:

- Befogási stabilitás
- Gép főorsó állapota
- Befogó állapota
- Szerszámbefogás:
  - Útés 0,06 TIR-en belül
- Forgácskihordás:
  - Forgácsolási paraméterek
- Hűtő-kenő folyadék:
  - Nyomás
  - Áramlás
  - Koncentráció

|  |   |
|--|---|
| <p><b>A vágóélek letöredezése</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• A fúró vibrációja esetén csökkentse a vágósebességet és növelje az előtolási sebességet</li> <li>• Durva, kemény vagy ferde felületek fúrásakor csökkentse az előtolási sebességet 30%-50%-kal be- és kilépéskor</li> </ul>    | <p><b>Nem megfelelő a furatátmérő túrése</b></p> <ul style="list-style-type: none"> <li>• Növelje a fordulatonkénti előtolást</li> <li>• Használjon Seco Feedmax tömör keményfém fúrót, lásd: 15-18 old.</li> <li>• Alkalmazzon dörszarázást, lásd: 328 old.</li> <li>• Alkalmazzon kiesztérgálást, lásd: 492-493 old.</li> </ul>    |
| <p><b>Túl gyors hátlapkopás</b></p> <ul style="list-style-type: none"> <li>• Ellenőrizze, hogy a megfelelő geometriát használja-e</li> <li>• Csökkentse a vágósebességet</li> </ul>    | <p><b>Nem megfelelő felületi minőség</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Növelje a forgácsolási sebességet</li> <li>• Ellenőrizze a megfelelő geometria használatát</li> <li>• Használjon Seco Feedmax tömör keményfém fúrót, lásd: 15-18 old.</li> <li>• Alkalmazzon dörszarázást, lásd: 328 old.</li> </ul>    |
| <p><b>Horony kopás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Csökkentse a vágósebességet</li> <li>• Növelje a hűtőfolyadék koncentrációját</li> </ul>    | <p><b>Nem megfelelő furatpozicionálás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Durva, kemény vagy ferde felületek átfúrásakor - belépéskor és kilépéskor csökkentse az előtolást 30–50%-kal</li> <li>• Fúrjon elő 140°-os csúcshézaggal</li> <li>• Használjon Seco Feedmax tömör keményfém fúrót, lásd a Feedmax oldalakat: 15-18 old.</li> <li>• Alkalmazzon kiesztérgálást, lásd: 492-493 old.</li> </ul>  |
| <p><b>Oldalélek kopása</b></p> <ul style="list-style-type: none"> <li>• Ellenőrizze, hogy a megfelelő geometriát használja-e</li> <li>• Csökkentse a forgácsolási sebességet</li> <li>• Növelje a hűtőfolyadék koncentrációját</li> <li>• Durva vagy kemény és ferde felületek fúrásakor csökkentse az előtolási sebességet 30–50%-kal be- és kilépéskor</li> </ul>   | <p><b>Forgácsberagadás a hosszú forgács miatt</b></p> <ul style="list-style-type: none"> <li>• Növelje az előtolást</li> <li>• Hosszú forgácsú anyagoknál az - SMG P1–P4, SMG M1–M2:                     <ul style="list-style-type: none"> <li>- Növelje a forgácsolási sebességet és csökkentse a fordulatonkénti előtolást</li> <li>- Használja az L geometriát (egyedi tervezés)</li> </ul> </li> </ul>    |
| <p><b>Törés kilépésnél</b></p> <ul style="list-style-type: none"> <li>• Amennyiben a hegy csatlakozási felülete sérül az anyagból történő kilépéskor. A hiba oka:                     <ul style="list-style-type: none"> <li>- A csatlakozási felületek nem lettek megfelelően megtisztítva, és kosz vagy forgács maradt a hegy és a fúrótest között</li> <li>- A korona nem lett megfelelően rögzítve. Használjon nyomatékkulcsot</li> <li>- A korona nem lett megfelelően hosszra rácsavarva a behúzószárra</li> </ul> </li> </ul>  | <p><b>A találkozó felületek sérülése</b></p> <ul style="list-style-type: none"> <li>• A kisebb élettoredezések nem veszélyesek a rögzítő rendszerre. Ennek nincs hatása a fúrási eredményre</li> <li>• Amennyiben jelentős sérülés keletkezik nagy előtolás vagy ferde furat készítésénél, csökkentse az előtolási sebességet</li> </ul>   |



## Crownloc® Plus

A Seco Crownloc® Plus a cserélhető koronájú Seco fúrók új generációja. Az új, Crownloc Plus rögzítőfelület javítja a forgács eltávolítást, és számos anyagnál a kopásállóságot.

- Erős kialakítású fúrótest, nagy szilárdságú rögzítőfelület mély és széles hornyokkal és polírozott testtel.
- Az elsődleges választás általános alkalmazásokhoz, a P geometria erős és sokoldalú megoldást jelent.
- Az M geometria kiváló teljesítményt biztosít hőálló ötvözeteknél, titánnál, titánötvözeteknél és rozsdamentes acélnál

## Választék áttekintés

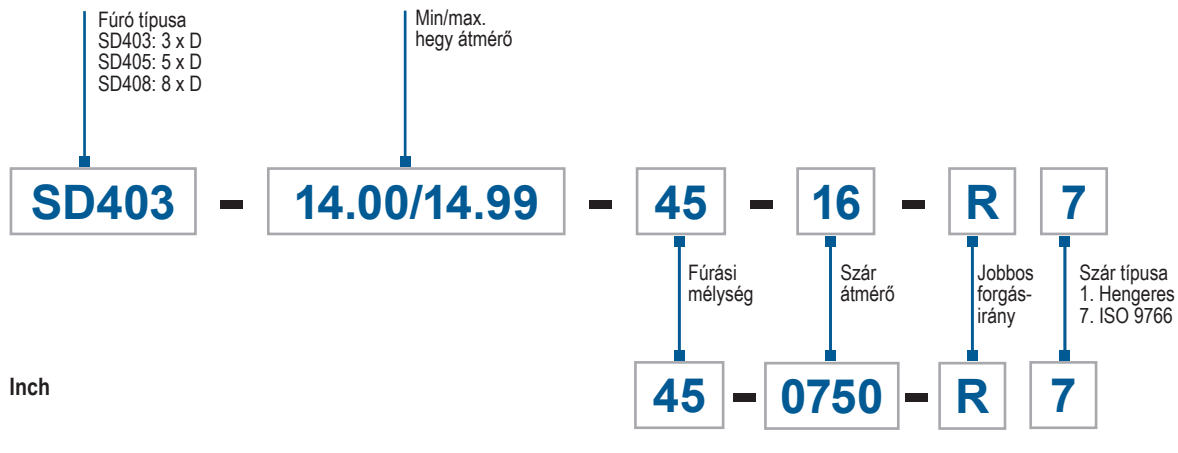
| Crownloc® Plus  | ∅ Választék                      | Fúrasi mélység | Fúró ∅ túrése | Furat túrés (1) | Felületi minőség (2)         |
|---|----------------------------------|----------------|---------------|-----------------|------------------------------|
| <b>SD403</b><br><br>Oldal 206-209 old.   | 12,00-19,99 mm<br>(0.472-0.787") | ~ 3 x D        | k7            | IT 9-10         | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD405</b><br><br>Oldal 210-213 old.   | 12,00-19,99 mm<br>(0.472-0.787") | ~ 5 x D        | k7            | IT 10           | Ra 1-3 μm<br>(Ra 39-118 μin) |
| <b>SD408</b><br><br>Oldal 214-217 old. | 12,00-19,99 mm<br>(0.472-0.787") | ~ 8 x D        | k7            | IT 10           | Ra 1-3 μm<br>(Ra 39-118 μin) |

- 1) Eltérések a munkadarab anyagtól és az alkalmazott forgácsolási paramétereiktől függően adódhatnak.  
 2) A fúrasi mélység, forgácsolási adatok, hűtőfolyadék nyomás és anyagminőség befolyásolhatja a felületi minőséget.

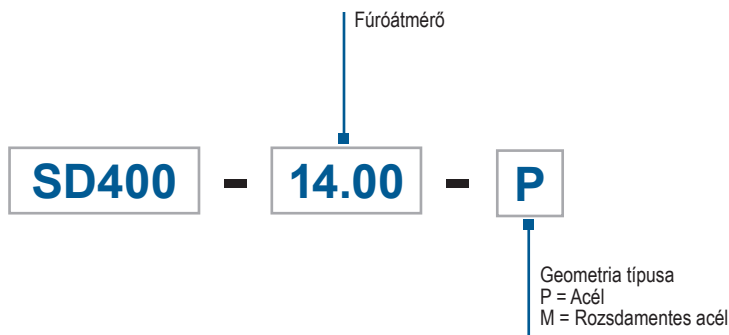
## Jelmagyarázat

### Crownloc® Plus fúrótestek

#### Metrikus



### Jelmagyarázat, koronák



### Geometriák

#### P-geometria

– Univerzális geometria, elsődleges választás acél fúrásához



#### M-geometria

– Rozsdamentes acélhoz és hőálló ötvözetekhez



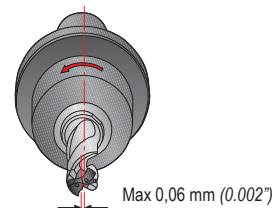
## Befogási útmutató

### 1. Stabilitás

Az alkalmazás stabilitása fontos a legjobb szerszámelettartam és furat pontosságának eléréséhez. Ellenőrizze a gép főorsóját, a készüléket és a munkadarab megfogását a maximális stabilitás és merevség eléréséhez. Az instabil feltételek szerszámtöréshez vezethetnek.

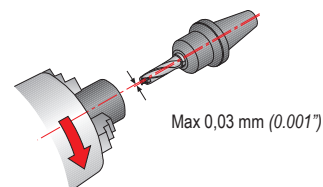
### 2. Forgó alkalmazás

A Totally Indicated Run-out (TIR-teljes megengedett tűrés) nem haladhatja meg forgó alkalmazásnál a 0,06 mm-t (0.002"). Mérje az ütést a fúró főorsóban történő 360°-os körbeforgatása közben.



### 3. Álló alkalmazás

A fúró és a munkadarab forgástengely eltérése álló alkalmazásnál nem haladhatja meg sugárirányban a 0,03 mm-t (0.001").



### 4. Javasolt befogók

A Seco Tools szerszám befogók széles választékát kínálja (patronos befogók, zsugorbefogók, Weldon hidraulikus tokmányok...), melyek különféle típusú főorsókhoz kaphatók. A legjobb eredmények elérése érdekében használja a BT JIS B 6339-ADB, ERHP 5672 típusú, nagy pontosságú precíziós befogót. További információkért tekintse meg a Felszerszámozás katalógust.



Nagy pontosságú patronos befogó  
(Csak hengeres, -R1 szárhoz)



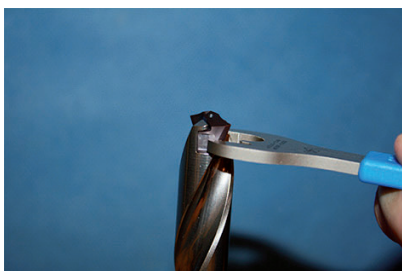
Hidraulikus befogó  
(mindig R1-es hengeres szárat használjon)



Weldon

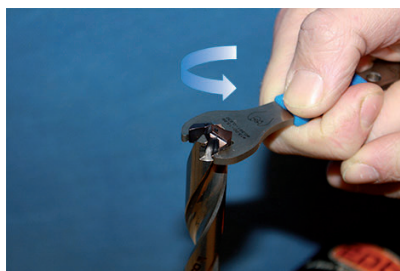
### 1.

Hogy levegye a koronát, keresse meg a két lapolást a koronán a kulccsal.



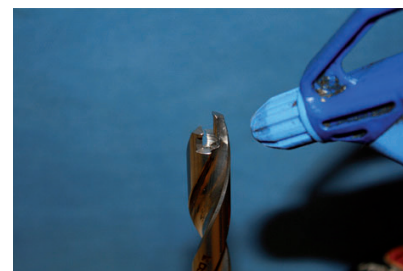
### 2.

Fordítsa el a kulcsot óramutató járásával ellentétesen, egy negyed fordulattal.



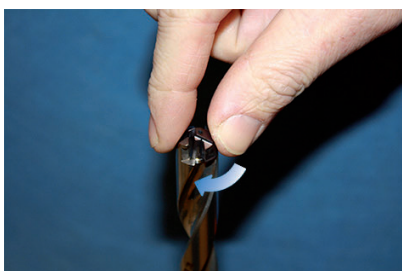
### 3.

Tisztítsa meg a csatlakozó felületet, mielőtt beszereli a koronát.



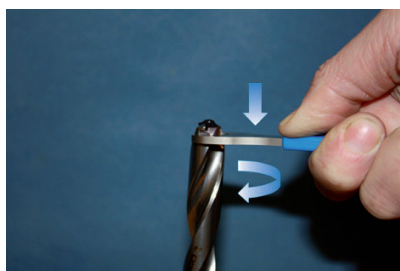
### 4.

Helyezze fel a koronát kézzel mielőtt használná a kulcsot.



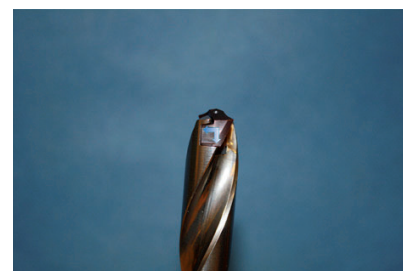
### 5.

A kulcs segítségével egyidejűleg nyomja lefelé a koronát, amikor az óramutató járásával megegyező irányban egy negyed fordulattal rögzíti azt a fúrótesten, és tartsa a fúrótesttől merőlegesen.



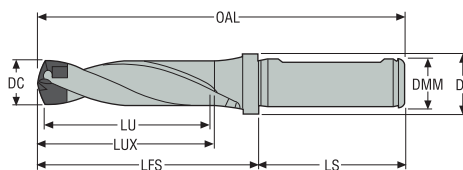
### 6.

Amikor a korona rá van szerelve a fúrótestre, teljes felfekvésnek kell lennie a csatlakozási felületeken, lásd az ábrát.



## SD403 – R7

Fúrési mélység ~ 3 x D – Metrikus szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 222 old.

| Megnevezés                | Cikkszám | 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 |

### Kiegészítők

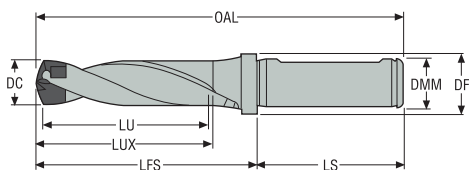
| Fúró átmérő (mm) | Kulcs     |
|------------------|-----------|
| 12,00-12,99      | SD400-K05 |
| 13,00-14,99      | SD400-K06 |
| 15,00-16,99      | SD400-K07 |
| 17,00-18,99      | SD400-K08 |
| 19,00-19,99      | SD400-K09 |





## SD403 – R7

Fúrási mélység ~ 3 x D – Inch szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 222 old.

| Megnevezés                  | Cikkszám | Max. fúrási mély-<br>ség | Fúró átm. DC | LU    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|-----------------------------|----------|--------------------------|--------------|-------|-------|-------|-------|-------|-------|-------|
|                             |          | Inch                     |              |       |       |       |       |       |       |       |
| 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 |

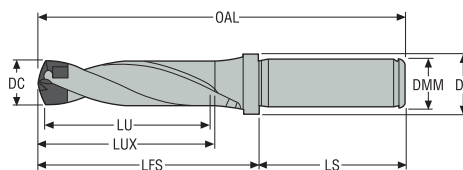
### Pótalkatrészek

| Fúró átmérő<br>(inch) | Kulcs     |
|-----------------------|-----------|
| 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

Fúrési mélység ~ 3 x D – Metrikus szár



- Hengeres szár (R1) rögzítésű befogók: 5834 és 5672
- Belső hűtés
- Forgácsolási adatokat lásd a 222 old. old.

| Megnevezés                | Cikkszám | 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 |

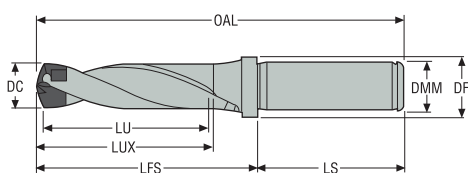
### Kiegészítők

| Fúró átmérő (mm) | Kulcs     |
|------------------|-----------|
| 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

Fúrási mélység ~ 3 x D – Inch szár



- Hengeres szár (R1) rögzítésű befogók: 5834 és 5672
- Belső hűtés
- Forgácsolási adatokat lásd a 222 old.

| Megnevezés                  | Cikkszám | Max. fúrási mélység | Fúró átm. DC | LU    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|-----------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|
|                             |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

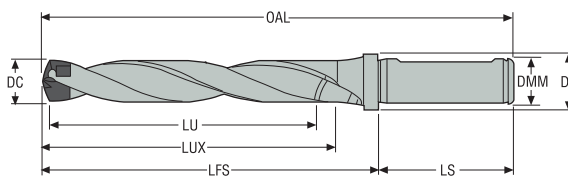
## Pótalkatrészek

| Fúró átmérő (inch) | Kulcs     |
|--------------------|-----------|
| 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

Fúrési mélység ~ 5 x D – Metrikus szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 223 old.

| Megnevezés                 | Cikkszám | 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 |

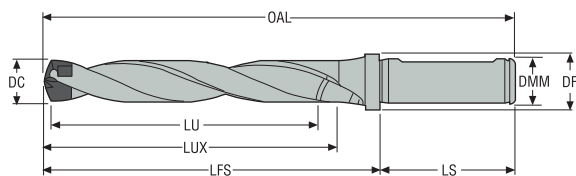
### Kiegészítők

| Fúró átmérő (mm) | Kulcs     |
|------------------|-----------|
| 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

Fúrási mélység ~ 5 x D – Inch szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 223 old.

| Megnevezés                   | Cikkszám | Max. fúrási mélység | Fúró átm. DC | LU    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|------------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|
|                              |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

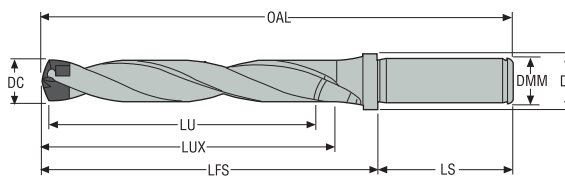
### Pótalkatrészek

| Fúró átmérő (inch) | Kulcs     |
|--------------------|-----------|
| 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

Fúrési mélység ~ 5 x D – Metrikus szár



- Hengeres szár (R1) rögzítésű befogók: 5834 és 5672
- Belső hűtés
- Forgácsolási adatokat lásd a 223 old.

| Megnevezés                 | Cikkszám | 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 |

### Kiegészítők

| Fúró átmérő (mm) | Kulcs     |
|------------------|-----------|
| 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 |



Bevezetés

Fúrás

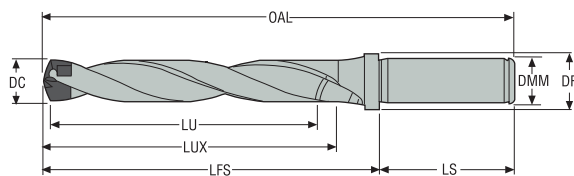
Dörzsárazás

Késztergálás

Melléklet

## SD405 – R1

Fúrási mélység ~ 5 x D – Inch szár



- Hengeres szár (R1) rögzítésű befogók: 5834 és 5672
- Belső hűtés
- Forgácsolási adatokat lásd a 223 old.

| Megnevezés                   | Cikkszám | Max. fúrási mélység | Fúró átm. DC | LU    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|------------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|
|                              |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

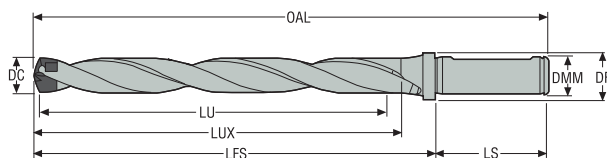
### Pótalkatrészek

| Fúró átmérő (inch) | Kulcs     |
|--------------------|-----------|
| 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

Fúrési mélység ~ 8 x D – Metrikus szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 224 old.

| Megnevezés                 | Cikkszám | 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 |

### Kiegészítők

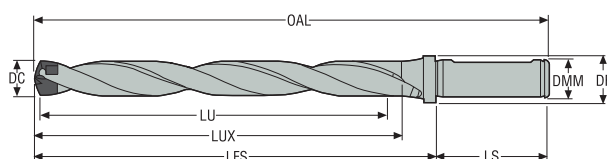
| Fúró átmérő (mm) | Kulcs     |
|------------------|-----------|
| 12,00-12,99      | SD400-K05 |
| 13,00-14,99      | SD400-K06 |
| 15,00-16,99      | SD400-K07 |
| 17,00-18,99      | SD400-K08 |
| 19,00-19,99      | SD400-K09 |





## SD408 – R7

Fúrési mélység ~ 8 x D – Inch szár



- ISO9766-nak megfelelő befogók: Weldon 1835B, ISO 5414, DIN 60880
- Belső hűtés
- Forgácsolási adatokat lásd a 224. old.

| Megnevezés                   | Cikkszám | Max. fúrési mélység | Fúró átm. DC | LU    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|------------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|
|                              |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

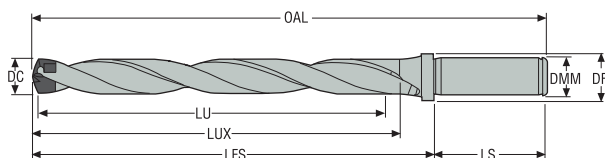
## Pótalkatrészek

| Fúró átmérő (inch) | Kulcs     |
|--------------------|-----------|
| 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

Fúrési mélység ~ 8 x D – Metrikus szár



- Hengeres szár (R1) rögzítésű befogók: 5834 és 5672
- Belső hűtés
- Forgácsolási adatokat lásd a 224 old.

| Megnevezés                 | Cikkszám | 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 |

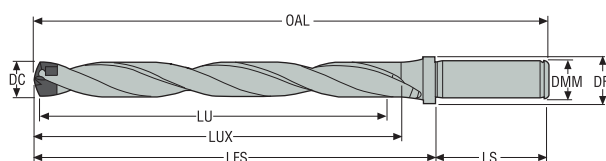
### Kiegészítők

| Fúró átmérő (mm) | Kulcs     |
|------------------|-----------|
| 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

Fúrési mélység ~ 8 x D – Inch szár



- Hengeres szár (R1) rögzítésű befogók: 5834 és 5672
- Belső hűtés
- Forgácsolási adatokat lásd a 224 old.

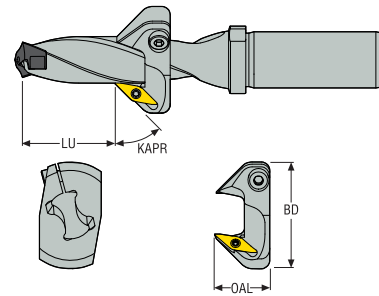
| Megnevezés                   | Cikkszám | Max. fúrési mélység | Fúró átm. DC | LU    | DF    | OAL   | LS    | LFS   | LUX   | DMM   |
|------------------------------|----------|---------------------|--------------|-------|-------|-------|-------|-------|-------|-------|
|                              |          | Inch                | Inch         | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |
| 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 |

### Pótalkatrészek

| Fúró átmérő (inch) | Kulcs     |
|--------------------|-----------|
| 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 |



## Életőrő modul



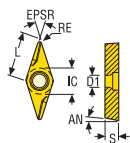
| Megnevezés            | Cikkszám | Fúróhoz           | Fúrési mélység LU |               |                 |               |                 |                |                       |               |               |       |
|-----------------------|----------|-------------------|-------------------|---------------|-----------------|---------------|------------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

### Pótalkatrészek

| Fúró átmérő (mm) | Lapka kulcs | Lapka csavar | Rögzítő kulcs | Rögzítő kulcs | Rögzítő csavar 1 | Rögzítő csavar 2 |
|------------------|-------------|--------------|---------------|---------------|------------------|------------------|
| SD400-C45...     | T07P-2      | C02505-T07P  | 2SMS795       | 3SMS795       | MC6S4X8          | P6SS4X8          |

### Váltólapka

| Tűrések:<br>mm/inch  | Méret                     | IC<br>mm/inch | L<br>mm/inch | S<br>mm/inch | D1<br>mm/inch | RE<br>mm/inch |
|--|---------------------------|---------------|--------------|--------------|---------------|---------------|
| IC = ±0,025/0.000984"<br>S = ±0,07/0.0027559"<br>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"   |
|  | Minőség: T400D            |               |              |              |               |               |
|  | Megnevezés: VCGX090202-D1 |               |              |              |               |               |
|  | Cikkszám: 00014948        |               |              |              |               |               |



## Koronák - Geometria -P és -M

Csúcs szög: 140°



| Megnevezés     | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | DC     |       |
|----------------|----------|---------------------|---|--------|-------|
|                |          |                     |   | mm     | inch  |
| 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 |

|                | Megnevezés     | Cikkszám      | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | DC     |       |
|----------------|----------------|---------------|---------------------|---|--------|-------|
|                |                |               |                     |   | mm     | inch  |
| Bevezetés      | 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 |
| Fúrás          | 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 |
|                | Dörzsárazás    | SD400-15.70-M | 02826237            | -   | ■      | 15,7  |
| 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 |
| Kicsztergálás  | 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 |
| Melléklet      | 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  |       |

| Megnevezés     | Cikkszám | P-geometria acélhoz | M-geometria korrózióálló acélhoz és hőálló ötvözetekhez | DC     |       |
|----------------|----------|---------------------|---|--------|-------|
|                |          |                     |   | mm     | inch  |
| 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 |

■ Raktári szabványos termék.

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD403 – Ø 12-20 mm / 0.472-0.787 inch

| SMG |   | f                 |                   |                   |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



## SD405 – Ø 12-20 mm / 0.472-0.787 inch

| SMG |   | f                 |                   |                   |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD408 – Ø 12-20 mm / 0.472-0.787 inch

| SMG |   | f                 |                   |                   |                   |                   | v <sub>c</sub> |
|-----|---|-------------------|-------------------|-------------------|-------------------|-------------------|----------------|
|     |   | Ø12,00<br>Ø 0.472 | Ø14,00<br>Ø 0.551 | Ø16,00<br>Ø 0.630 | Ø18,00<br>Ø 0.709 | Ø20,00<br>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            |

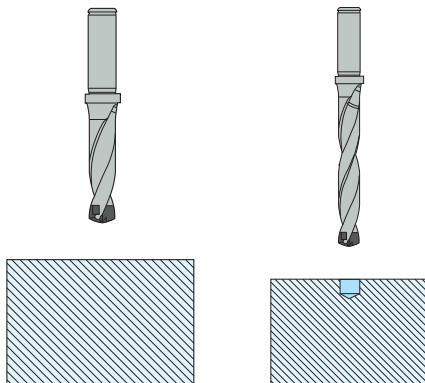
SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## Alkalmazási információk

## Alkalmazási információk

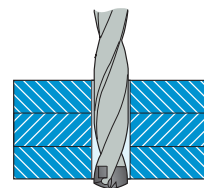
## Mégmunkált felület

SD403 és SD405 használata esetén nincs szükség előfúrásra vagy belépési előtolásra. SD408 fúrótest használatakor mindig javasolt az előfúrás. (SD405 fúrónál rozsdamentes acélban előfúrásra lehet szükség.)



## Rétegelt anyagok

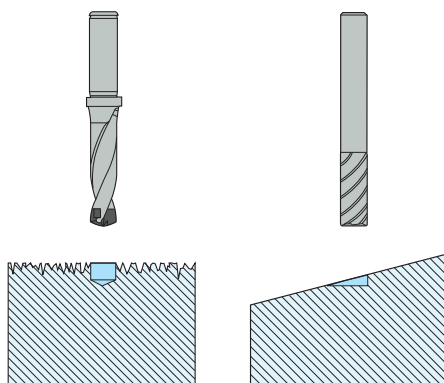
A rétegelt anyagok megmunkálása mindaddig lehetséges, amíg azok biztonságosan egymáshoz vannak rögzítve, tehát nincs légrés a darabok között. A légrések befolyásolhatják a forgács eltávolítását, és ezért sérülést okozhatnak a fúrótesten.



## Szabálytalan/szög alatti furat belépés

Szabálytalan vagy ferde felületnél előmegmunkálás szükséges.  $> 3 \times D$  fúráskor szabványos szerszámmal, pl. SD403 használatával történő előfúrás javasolt

## Előmegmunkálási alternatívák



Szabálytalan felületre történő furatbelépés

Sík felület megmunkálása egy keményfém maróval a Seco választékból.

Furat belépés ferde felületre

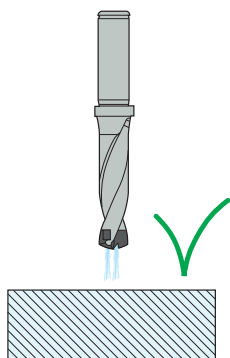
## Hűtési javaslatok

## Hűtőfolyadék-nyomás

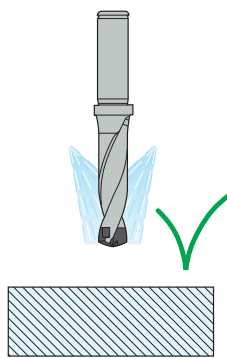
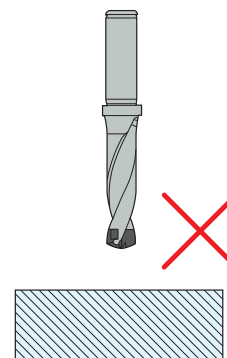
Minimálisan javasolt hűtőfolyadék-nyomás 10 bar (145 PSI)  $\leq 3 \times D$ -nél  
Minimálisan javasolt hűtőfolyadék-nyomás 30 bar (435 PSI)  $> 3 \times D$ -nél

## Hűtő-kenő folyadék keverék

Ajánlott emulziókeverék 6–8%. Rozsdamentes acél, szuperötvözetek és nagy szilárdságú acél fúrása esetén a javasolt keverék 10%



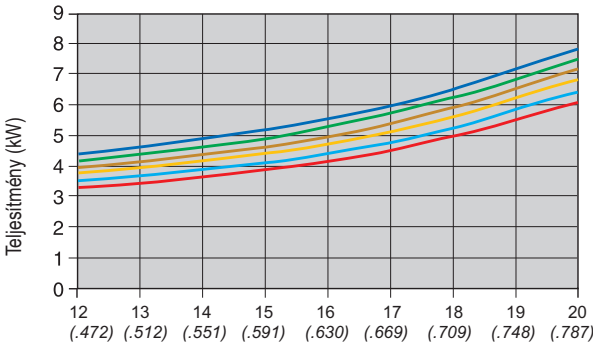
Elsődleges választás

 $< 3 \times D$ 

## Forgácsolási paraméterek

A feltüntetett értékek változhatnak pl. a forgácsolási paraméterek, anyagminőség, a gép hatásfoka és a szerszámkopás függvényében. Az alábbi grafikonok P5-P6 Seco anyagcsoportra (SMG) és 90 m/perc forgácsolási sebességre vannak meghatározva (295 SFM).

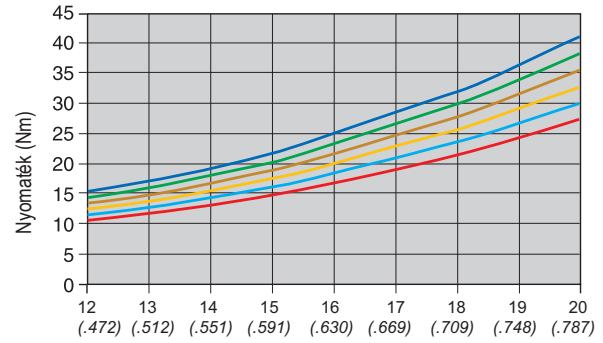
Teljesítményfelvétel



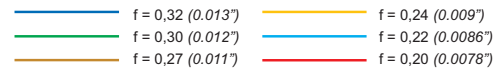
Fúróátmérő, mm / (inch)



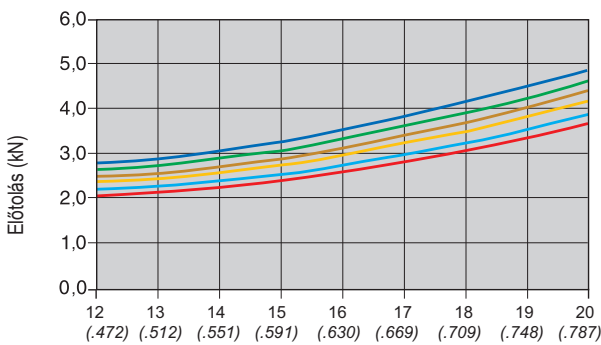
Fúrási nyomaték



Fúróátmérő, mm / (inch)



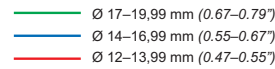
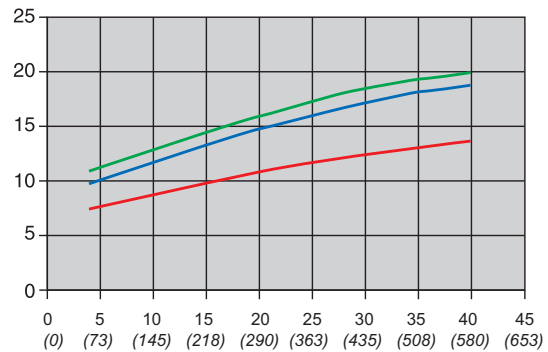
Előtolási erő



Fúróátmérő, mm / (inch)



Hűtőfolyadék-áramlás a nyomás függvényében



Javasolt hűtőfolyadék-áramlás  $D \times 1$  l/perc  
Minimális hűtőfolyadék-áramlás  $D/2$  l/perc  
D = Fúróátmérő

Minimálisan javasolt hűtőfolyadék-nyomás 10 bar (145 PSI)  $\leq 3 \times D$ -nél  
Minimálisan javasolt hűtőfolyadék-nyomás 20 bar (290 PSI)  $\leq 5 \times D$ -nél  
Minimálisan javasolt hűtőfolyadék-nyomás 40 bar (580 PSI)  $> 5 \times D$ -nél

### Hűtő-kenő folyadék keverék

Ajánlott emulziókeverék 6–8%.  
Rozsdamentes acél, szuperötvözetek és nagy szilárdságú acél fúrása esetén a javasolt keverék 10%.

### Furat tűrés/Felületi minőség

| SD403, SD405 és SD408<br>IT9-10 / $R_a$ 1-4*, $Ra$ 39-157 $\mu$ m* |                      |                       |                  |                  |                   |
|--|----------------------|-----------------------|------------------|------------------|-------------------|
| Fúró Ø DC (mm)   | IT9 tűrés ( $\mu$ m) | IT10 tűrés ( $\mu$ m) | Fúró Ø DC (inch) | IT9 tűrés (inch) | IT10 tűrés (inch) |
| 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       |

\* Alacsony széntartalmú acélok és rozsdamentes acélok fúrásánál felületi minőség- és furattűrés-romlás léphet fel. A legjobb furatminőség elérése érdekében használja a lehető legrövidebb fúrót.

## Problémamegoldás – Elsődleges ellenőrzések:

- Befogási stabilitás
- Gép főorsó állapota
- Befogó állapota
- Szerszámbefogás:
  - Útés 0,06 TIR-en belül
- Forgácskihordás:
  - Forgácsolási paraméterek
- Hűtő-kenő folyadék:
  - Nyomás
  - Áramlás
  - Koncentráció

|   |   |
|---|---|
| <p><b>A vágóélek letöredezése</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• A fúró vibrációja esetén csökkentse a vágósebességet és növelje az előtolási sebességet</li> <li>• Durva, kemény vagy ferde felületek fúrásakor csökkentse az előtolási sebességet 30%-50%-kal be- és kilépéskor</li> </ul>        | <p><b>Nem megfelelő a furatátmérő tűrése</b></p> <ul style="list-style-type: none"> <li>• Növelje a fordulatonkénti előtolást</li> <li>• Használjon Seco Feedmax tömör keményfém fúrót, lásd: 15-18 old.</li> <li>• Alkalmazzon dörzsárazást, lásd: 328 old.</li> <li>• Alkalmazzon kiesztörgálást, lásd: 492-493 old.</li> </ul>   |
| <p><b>Túl gyors hátlapkopás</b></p> <ul style="list-style-type: none"> <li>• Ellenőrizze, hogy a megfelelő geometriát használja-e</li> <li>• Csökkentse a vágósebességet</li> </ul>   | <p><b>Nem megfelelő felületi minőség</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Növelje a forgácsolási sebességet</li> <li>• Ellenőrizze a megfelelő geometria használatát</li> <li>• Használjon Seco Feedmax tömör keményfém fúrót, lásd: 15-18 old.</li> <li>• Alkalmazzon dörzsárazást, lásd: 328 old.</li> </ul>  |
| <p><b>Horony kopás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Csökkentse a vágósebességet</li> <li>• Növelje a hűtőfolyadék koncentrációját</li> </ul>  | <p><b>Nem megfelelő furatpozicionálás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse a fordulatonkénti előtolást</li> <li>• Durva, kemény vagy ferde felületek átfúrásakor - belépéskor és kilépéskor csökkentse az előtolást 30–50%-kal</li> <li>• Fúrjon elő 140°-os csúcshézaggal</li> <li>• Használjon Seco Feedmax tömör keményfém fúrót, lásd a Feedmax oldalakat: 15-18 old.</li> <li>• Alkalmazzon kiesztörgálást, lásd: 492-493 old.</li> </ul> |
| <p><b>Oldalélek kopása</b></p> <ul style="list-style-type: none"> <li>• Ellenőrizze, hogy a megfelelő geometriát használja-e</li> <li>• Csökkentse a forgácsolási sebességet</li> <li>• Növelje a hűtőfolyadék koncentrációját</li> <li>• Durva vagy kemény és ferde felületek fúrásakor csökkentse az előtolási sebességet 30–50%-kal be- és kilépéskor</li> </ul> | <p><b>Forgácsberagadás a hosszú forgács miatt</b></p> <ul style="list-style-type: none"> <li>• Növelje az előtolást</li> <li>• Hosszú forgácsú anyagoknál az - SMG P1–P4, SMG M1–M2:                     <ul style="list-style-type: none"> <li>- Növelje a forgácsolási sebességet és csökkentse a fordulatonkénti előtolást</li> <li>- Használja az L geometriát</li> </ul> </li> </ul>   |



## Perfomax®



A Perfomax® egy régóta bevált váltólapkás fúrócsalád, amely gazdaságos megoldást kínál a furatok termelékeny elkészítéséhez.

- A megbízható négyszögletes lapkák mindegyike négy vágóéllel rendelkezik.
- A legmodernebb lapkaminőségek és -geometriák különböző munkadarab anyagokhoz
- A fúrótest egyedi kialakítású forgácskorony kialakítással és minden méretnél hűtőfolyadék-furattal rendelkezik a forgácskidobás optimalizálása érdekében.

## Választék áttekintés

| Perfomax®  | ∅ Választék                | Fúrési mélység | Fúró ∅ tűrése              | Furat tűrés                   |
|--|----------------------------|----------------|----------------------------|-------------------------------|
| <b>SD522</b><br><br>Oldal 242, 243, 244-242, 243, 244 old.      | 15-59 mm<br>(0.594-2.375") | ~ 2 x D        | +/- 0,1 mm<br>(+/- 0.004") | +0/+ 0,2 mm<br>(+ 0/+ 0.008") |
| <b>SD523</b><br><br>Oldal 245, 246, 247, 248-261, 262, 263 old. | 15-59 mm<br>(0.594-2.375") | ~ 3 x D        | +/- 0,1 mm<br>(+/- 0.004") | +0/+ 0,3 mm<br>(+ 0/+ 0.012") |
| <b>SD524</b><br><br>Oldal 264, 265, 266-276, 277 old.          | 17-59 mm<br>(0.594-2.375") | ~ 4 x D        | +/- 0,1 mm<br>(+/- 0.004") | + 0,4 mm<br>(+ 0/+ 0.016")    |
| <b>SD525</b><br><br>Oldal 278, 279-280 old.                   | 19-45 mm<br>(0,750-2.000") | ~ 5 x D        | +/- 0,1 mm<br>(+/- 0.004") | +0/+ 0,5 mm<br>(+ 0/+ 0.020") |
| <b>SD542</b><br><br>Oldal 281-282 old.                        | 60-85 mm<br>(2.250-3.500") | ~ 2,5 x D      | +/- 0,1 mm<br>(+/- 0.004") | +0/+ 0,2 mm<br>(+ 0/+ 0.008") |

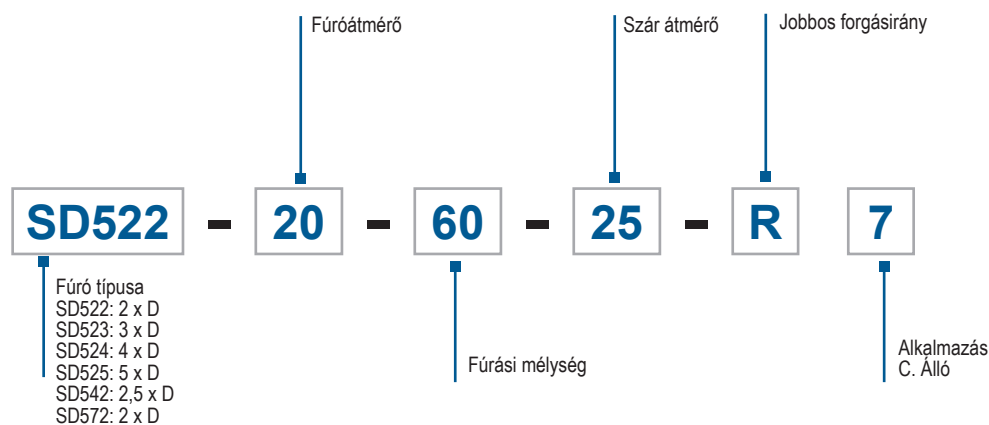
## Választék áttekintés

| Perfomax®   | ∅ Választék                         | Fúrési mélység    | Fúró ∅ tűrése                      | Furat tűrés                           |
|---|-------------------------------------|-------------------|------------------------------------|---------------------------------------|
| <p><b>SD572</b></p>  <p>Oldal 283, 284-283, 284 old.</p> | <p>15-47 mm<br/>(0.591"-1.850")</p> | <p>~ 2 x D</p>    | <p>+/- 0,1 mm<br/>(+/- 0.004")</p> | <p>+0/+ 0,2 mm<br/>(+ 0/+ 0.008")</p> |
| <p><b>SD602</b></p>  <p>Oldal 287-291 old.</p>           | <p>60-160 mm<br/>(2.5"-4.000")</p>  | <p>~ 1-10 x D</p> | <p>+/- 0,2 mm<br/>(+/- 0.008")</p> | <p>-</p>                              |

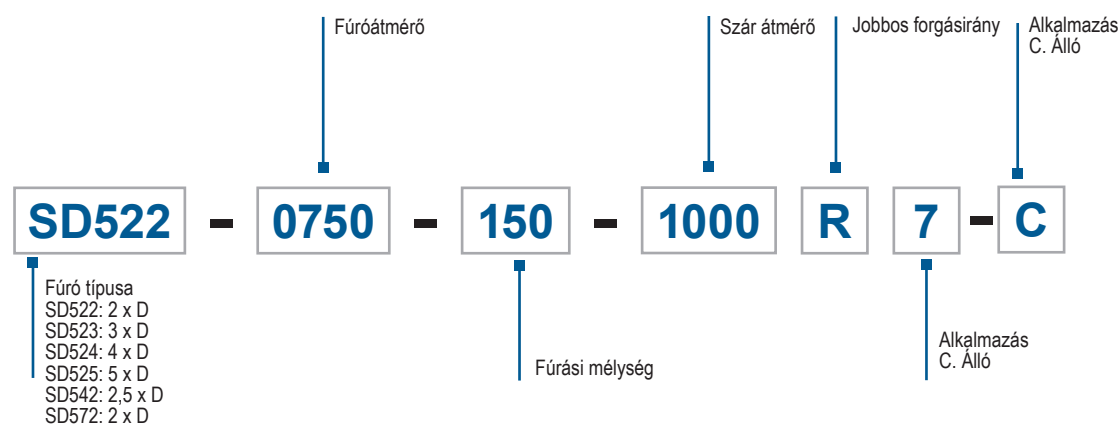


## Jelmagyarázat - Váltólapkás fúró

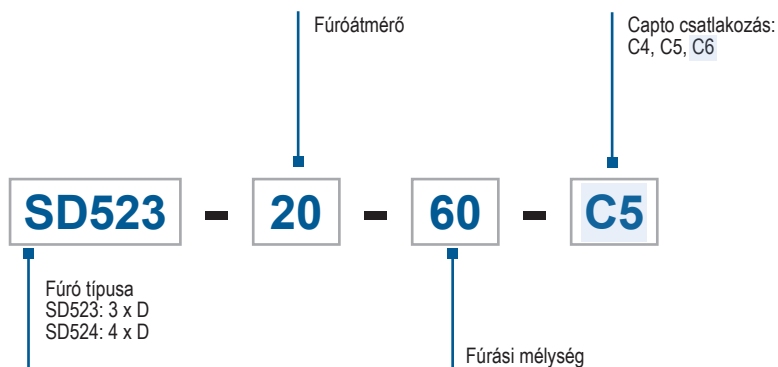
### Metrikus



### Inch



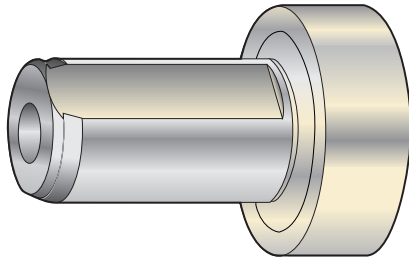
### Capto™



## Szárak

### Szárak

-R7



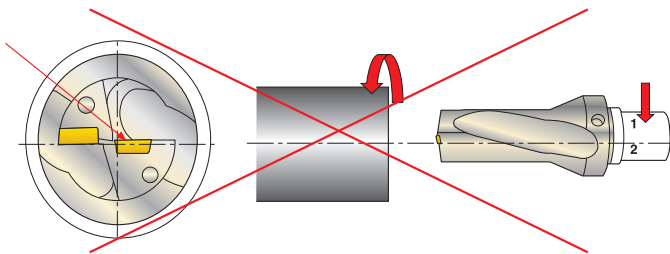
#### ISO 9766

Általános választás, a piacon található legtöbb befogóba illeszkedik:

- Weldon 1835B
- ISO 5414
- DIN 69880

Hűtőfolyadék beömlő nyílás a szerszám végén.

R7 és R7-C

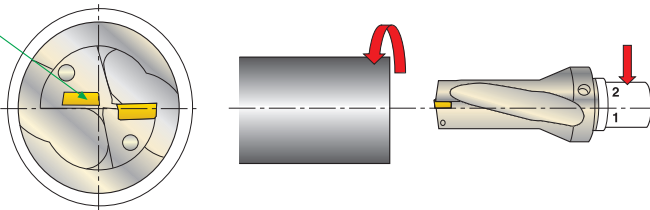


#### Kettő vagy négy lapolással ellátott szár

A lapka vágóélét központosítsa a munkadarab középvonala fölé.

#### Nem forgó műveletekhez:

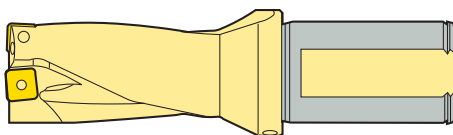
- A szárat egy további lapolással láttuk el a szerszám flexibilitásának növelése érdekében, esztergagépeken való alkalmazhatósághoz.
- Ilyen alkalmazásoknál a munkadarab és a szerszám középvonalának találkoznia kell.
- Amennyiben ez nem így van, a központi lapka a munkadarab középvonala fölé kerülhet, a fúró aluteljesítését okozva.



#### Négy lapolással ellátott szár

A lapka vágóélét központosítsa a munkadarab középvonala fölé.

A fúró hossz tengelye körül való 180 fokos elforgatás egy gyors és egyszerű megoldást nyújt, a második szárlapolásnak köszönhetően.

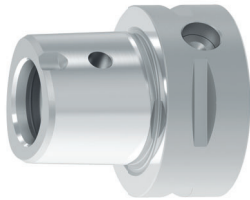


#### Figyelem!

- Amennyiben a fúrót -7-es szárral forgó alkalmazásban használja állítható befogóval, a lapolás ugyan azon az oldalon lesz, ahol a központi lapka használatos.
- Egyébként a fúróátmérő rosszul lesz pozicionálva.

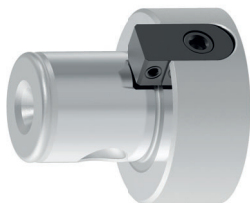
## Szárak

## Seco-Capto

**Seco-Capto C4, C5, C6**

- Flexibilis - Ugyanaz a befogó használható különböző gépeken.
- Moduláris - Hosszabbító adapterekkel kiegészíthető szerszámok.
- Nagy nyomaték átvitel - A nyomaték terhelés szimmetrikusan oszlik el.
- Nagyfokú merevség - A szűk persely garantálja a csatlakozás játék mentességét.
- Pontos - A sokszög illeszkedés erős, önközpontosító csatlakozást biztosít 2 mikronon belül.

## Graflex

**- G**

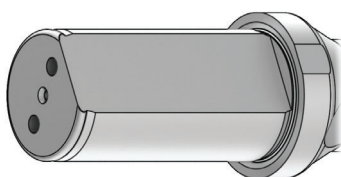
- Közvetlenül befogható a Graflex befogókba és két, 120°-ra elhelyezett gömbfejű hernyócsavarral rögzíthető.
- Merevséget és jó ütést nyújtó moduláris szerkezetek
- Hengeres illeszkedés – nagy pontosság.
- A modulok gyorsan és egyszerűen össze-/szétzerelhetők, ami nagy rugalmasságot biztosít.
- Hűtőfolyadék beömlő nyílás a szerszám végén.

## ABS 50 (kompatibilis)

**- 2**

- ABS 50-kompatibilis szár.
- ABS 50-es befogókba közvetlenül befogható egyetlen rögzítőcsavarral.
- Hűtőfolyadék beömlő nyílás a szerszám végén.

## VDI 30 és VDI 40 (kompatibilis)

**- 8**

- VDI kompatibilis szár.
- Közvetlenül befogható a következő típusú befogókba:
  - VDI 3425 bl.2
  - DIN 69880

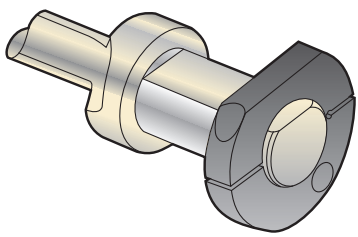
**Figyelem!**

A hűtőfolyadék gyűrű külön rendelendő.

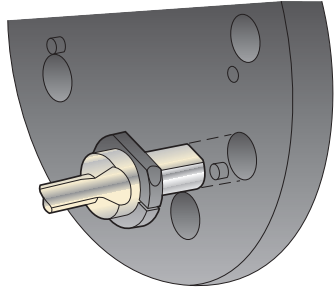
## Szárak – Hűtőgyűrű

| VDI 30         |             |             |                     | VDI 40         |             |             |       |                |                     |
|----------------|-------------|-------------|---------------------|----------------|-------------|-------------|-------|----------------|---------------------|
| Fúrasi mélység | Fúró átmérő |             | Alkatrész hűtőgyűrű | Fúrasi mélység | Fúró átmérő |             | Dugó  | Rögzítő csavar | Alkatrész hűtőgyűrű |
|                | mm          | inch        |                     |                | mm          | inch        |       |                |                     |
| 2 x D          | 15-31       | 0.591-1.220 | SDA5-30R8           | 2 x D          | 15-31       | 0.591-1.220 |       |                | SDA5-40R8           |
| 3 x D          | 15-31       | 0.591-1.220 | SDA5-30R8           | 3 x D          | 15-31       | 0.591-1.220 |       |                | SDA5-40R8           |
| 4 x D          | 17-31       | 0.669-1.220 | SDA5-30R8           | 4 x D          | 17-31       | 0.669-1.220 |       |                | SDA5-40R8           |
| 5 x D          | 19-31       | 0.748-1.220 | SDA5-30R8           | 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           |

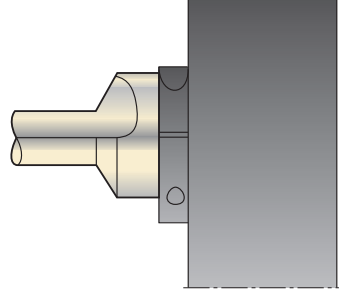
**1.** Rögzítse a gyűrűt a fúróra, de ne húzza meg a csavart.



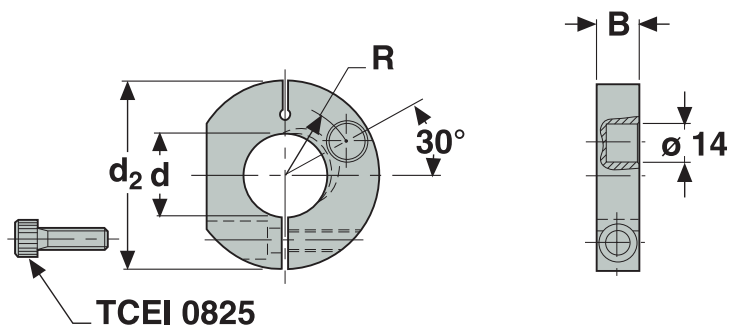
**2.** Rögzítse a fúrót a patronos befogóban.



**3.** Húzza meg a rögzítőcsavart a hűtőgyűrűben.

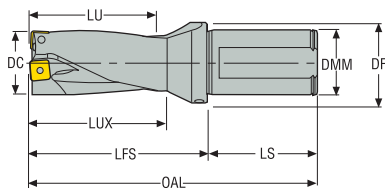


### Hűtőgyűrű



# SD522

Fúrési mélység ~ 2 x D



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 304, 305 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés         | Cikkszám | DC            | LU            | OAL            | LUX           | LFS           | LS            | DMM           | DF            | Lapka          |                 | Radiális állítás |                |
|--------------------|----------|---------------|---------------|----------------|---------------|---------------|---------------|---------------|---------------|----------------|-----------------|------------------|----------------|
|                    |          |               |               |                |               |               |               |               |               | Központi lapka | Periféria lapka | mm -<br>Inch -   | mm +<br>Inch + |
| SD522-15-30-20R7   | 03080744 | 15,0<br>0.591 | 30,0<br>1.181 | 110,0<br>4.331 | 35,0<br>1.378 | 60,0<br>2.362 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012  |
| SD522-15-30-25R7   | 03080745 | 15,0<br>0.591 | 30,0<br>1.181 | 116,0<br>4.567 | 35,0<br>1.378 | 60,0<br>2.362 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012  |
| SD522-15.5-31-20R7 | 03080740 | 15,5<br>0.610 | 31,0<br>1.220 | 111,0<br>4.370 | 36,0<br>1.417 | 61,0<br>2.402 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,17<br>0.007    | 0,36<br>0.014  |
| SD522-15.5-31-25R7 | 03080741 | 15,5<br>0.610 | 31,0<br>1.220 | 117,0<br>4.606 | 36,0<br>1.417 | 61,0<br>2.402 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,17<br>0.007    | 0,36<br>0.014  |
| SD522-16-32-20R7   | 03080749 | 16,0<br>0.630 | 32,0<br>1.260 | 112,0<br>4.409 | 37,0<br>1.457 | 62,0<br>2.441 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,12<br>0.005    | 0,41<br>0.016  |
| SD522-16-32-25R7   | 03080750 | 16,0<br>0.630 | 32,0<br>1.260 | 118,0<br>4.646 | 37,0<br>1.457 | 62,0<br>2.441 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,12<br>0.005    | 0,41<br>0.016  |
| SD522-16.5-33-20R7 | 03080746 | 16,5<br>0.650 | 33,0<br>1.299 | 113,0<br>4.449 | 38,0<br>1.496 | 63,0<br>2.480 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,07<br>0.003    | 0,46<br>0.018  |
| SD522-16.5-33-25R7 | 03080747 | 16,5<br>0.650 | 33,0<br>1.299 | 119,0<br>4.685 | 38,0<br>1.496 | 63,0<br>2.480 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,07<br>0.003    | 0,46<br>0.018  |
| SD522-17-34-20R7   | 03080754 | 17,0<br>0.669 | 34,0<br>1.339 | 114,0<br>4.488 | 39,0<br>1.535 | 64,0<br>2.520 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,02<br>0.001    | 0,5<br>0.020   |
| SD522-17-34-25R7   | 03080755 | 17,0<br>0.669 | 34,0<br>1.339 | 120,0<br>4.724 | 39,0<br>1.535 | 64,0<br>2.520 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,02<br>0.001    | 0,5<br>0.020   |
| SD522-17.5-35-20R7 | 03080752 | 17,5<br>0.689 | 35,0<br>1.378 | 115,0<br>4.528 | 40,0<br>1.575 | 65,0<br>2.559 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,43<br>0.017    | 0,1<br>0.004   |
| SD522-17.5-35-25R7 | 03080753 | 17,5<br>0.689 | 35,0<br>1.378 | 121,0<br>4.764 | 40,0<br>1.575 | 65,0<br>2.559 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,43<br>0.017    | 0,1<br>0.004   |
| SD522-18-36-20R7   | 03080760 | 18,0<br>0.709 | 36,0<br>1.417 | 116,0<br>4.567 | 41,0<br>1.614 | 66,0<br>2.598 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,32<br>0.013    | 0,21<br>0.008  |
| SD522-18-36-25R7   | 03080761 | 18,0<br>0.709 | 36,0<br>1.417 | 122,0<br>4.803 | 41,0<br>1.614 | 66,0<br>2.598 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,32<br>0.013    | 0,21<br>0.008  |
| SD522-18.5-37-20R7 | 03080758 | 18,5<br>0.728 | 37,0<br>1.457 | 117,0<br>4.606 | 42,0<br>1.654 | 67,0<br>2.638 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012  |
| SD522-18.5-37-25R7 | 03080759 | 18,5<br>0.728 | 37,0<br>1.457 | 123,0<br>4.843 | 42,0<br>1.654 | 67,0<br>2.638 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012  |
| SD522-19-38-20R7   | 03080765 | 19,0<br>0.748 | 38,0<br>1.496 | 118,0<br>4.646 | 43,0<br>1.693 | 68,0<br>2.677 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,11<br>0.004    | 0,42<br>0.017  |
| SD522-19-38-25R7   | 03080766 | 19,0<br>0.748 | 38,0<br>1.496 | 124,0<br>4.882 | 43,0<br>1.693 | 68,0<br>2.677 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,11<br>0.004    | 0,42<br>0.017  |
| SD522-19.5-39-20R7 | 03080764 | 19,5<br>0.768 | 39,0<br>1.535 | 119,0<br>4.685 | 44,0<br>1.732 | 69,0<br>2.717 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX060204      | 0,11<br>0.004    | 0,42<br>0.017  |
| SD522-20-40-25R7   | 03080771 | 20,0<br>0.787 | 40,0<br>1.575 | 126,0<br>4.961 | 45,0<br>1.772 | 70,0<br>2.756 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX060204      | 0,07<br>0.003    | 0,46<br>0.018  |
| SD522-21-42-25R7   | 03080775 | 21,0<br>0.827 | 42,0<br>1.654 | 128,0<br>5.039 | 47,0<br>1.850 | 72,0<br>2.835 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX060204      | 0,01<br>0        | 0,5<br>0.020   |

Bevezetés

Fúrás

Dörzsarázás

Készletgálás

Melléklet



| Megnevezés        | Cikkszám | DC            | LU             | OAL            | LUX            | LFS            | LS            | DMM           | DF             | Lapka      |                | Radiális állítás |                |
|-------------------|----------|---------------|----------------|----------------|----------------|----------------|---------------|---------------|----------------|------------|----------------|------------------|----------------|
|                   |          | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch | Központi lapka | Periféria lapka  | mm -<br>Inch - |
| SD522-43-86-40R7  | 03080830 | 43,0<br>1.693 | 86,0<br>3.386  | 184,0<br>7.244 | 91,0<br>3.583  | 116,0<br>4.567 | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX120408     | 0,05<br>0.002    | 0,5<br>0.020   |
| SD522-44-88-40R7  | 03080832 | 44,0<br>1.732 | 88,0<br>3.465  | 186,0<br>7.323 | 93,0<br>3.661  | 118,0<br>4.646 | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX120408     | 0,5<br>0.020     | 0,41<br>0.016  |
| SD522-45-90-40R7  | 03080834 | 45,0<br>1.772 | 90,0<br>3.543  | 188,0<br>7.402 | 95,0<br>3.740  | 120,0<br>4.724 | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX150512     | 0,5<br>0.020     | 0,41<br>0.016  |
| SD522-46-92-40R7  | 03080835 | 46,0<br>1.811 | 92,0<br>3.622  | 190,0<br>7.480 | 97,0<br>3.819  | 122,0<br>4.803 | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX150512     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD522-47-94-40R7  | 03080836 | 47,0<br>1.850 | 94,0<br>3.701  | 192,0<br>7.559 | 99,0<br>3.898  | 124,0<br>4.882 | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX150512     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD522-48-96-40R7  | 03080837 | 48,0<br>1.890 | 96,0<br>3.780  | 194,0<br>7.638 | 101,0<br>3.976 | 126,0<br>4.961 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     | 0,45<br>0.018    | 0,5<br>0.020   |
| SD522-49-98-40R7  | 03080838 | 49,0<br>1.929 | 98,0<br>3.858  | 196,0<br>7.717 | 103,0<br>4.055 | 128,0<br>5.039 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     | 0,2<br>0.008     | 0,5<br>0.020   |
| SD522-50-100-40R7 | 03080839 | 50,0<br>1.969 | 100,0<br>3.937 | 198,0<br>7.795 | 105,0<br>4.134 | 130,0<br>5.118 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     | 0,2<br>0.008     | 0,5<br>0.020   |
| SD522-51-102-40R7 | 03080840 | 51,0<br>2.008 | 102,0<br>4.016 | 200,0<br>7.874 | 107,0<br>4.213 | 132,0<br>5.197 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     | 0,2<br>0.008     | 0,5<br>0.020   |
| SD522-52-104-40R7 | 03080841 | 52,0<br>2.047 | 104,0<br>4.094 | 202,0<br>7.953 | 109,0<br>4.291 | 134,0<br>5.276 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     | 0,5<br>0.020     | 0,42<br>0.017  |
| SD522-53-106-40R7 | 03080842 | 53,0<br>2.087 | 106,0<br>4.173 | 204,0<br>8.031 | 111,0<br>4.370 | 136,0<br>5.354 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     | 0,5<br>0.020     | 0,42<br>0.017  |
| SD522-54-108-40R7 | 03080843 | 54,0<br>2.126 | 108,0<br>4.252 | 206,0<br>8.110 | 113,0<br>4.449 | 138,0<br>5.433 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD522-55-110-40R7 | 03080844 | 55,0<br>2.165 | 110,0<br>4.331 | 208,0<br>8.189 | 115,0<br>4.528 | 140,0<br>5.512 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD522-56-112-40R7 | 03080845 | 56,0<br>2.205 | 112,0<br>4.409 | 210,0<br>8.268 | 117,0<br>4.606 | 142,0<br>5.591 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD522-57-114-40R7 | 03080846 | 57,0<br>2.244 | 114,0<br>4.488 | 212,0<br>8.346 | 119,0<br>4.685 | 144,0<br>5.669 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     | 0,39<br>0.015    | 0,5<br>0.020   |
| SD522-58-116-40R7 | 03080847 | 58,0<br>2.283 | 116,0<br>4.567 | 214,0<br>8.425 | 121,0<br>4.764 | 146,0<br>5.748 | 68,0<br>2.677 | 40,0<br>1.575 | 63,0<br>2.480  | SPGX1904   | SCGX150512     | 0,09<br>0.004    | 0,5<br>0.020   |
| SD522-59-118-40R7 | 03080848 | 59,0<br>2.323 | 118,0<br>4.646 | 216,0<br>8.504 | 123,0<br>4.843 | 148,0<br>5.827 | 68,0<br>2.677 | 40,0<br>1.575 | 63,0<br>2.480  | SPGX1904   | SCGX150512     | 0,09<br>0.004    | 0,5<br>0.020   |

## Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar  | Lapka kulcs   |
|---------------------|---|---|
|                     |  |  |
|                     | Központi lapka  | Perif. lapka  |
| 15,00-17,45         | C02245-T07P   | C02245-T07P<br>T07P-2   |
| 17,46-19,49         | C02205-T07P   | C02245-T07P<br>T07P-2   |
| 19,50-21,24         | C02205-T07P   | C02205-T07P<br>T07P-2   |
| 21,25-22,49         | C02506-T08P   | C02506-T08P<br>T08P-2   |
| 22,50-25,49         | C02507-T08P   | C03007-T08P<br>T08P-2   |
| 25,50-28,49         | C03007-T09P   | C03007-T09P<br>T09P-2   |
| 28,50-31,49         | C03007-T09P   | C03009-T09P<br>T09P-2   |
| 31,50-40,49         | C03508-T15P   | C03508-T15P<br>T15P-2D  |
| 40,50-43,24         | C03508-T15P   | C05012-T15P<br>T15P-2D  |
| 43,25-59,00         | C04011-T15P   | C05012-T15P<br>T15P-2D  |

Kiegészítők

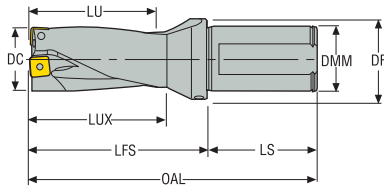
| Fúró átmérő (mm) | Nyomaték kulcs* | Cserélhető betét | Nyomaték érték |
|------------------|-----------------|------------------|----------------|
| 15,00-17,45      | T00-07P09       | T00-07P          | 0,9 Nm         |
| 17,46-19,49      | T00-07P09       | T00-07P          | 0,9 Nm         |
| 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         |

\*Betéttel együtt.



## SD522



Fúrési mélység ~ 2 x D – Inch






- ISO 9766 szár R7
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 304, 305 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés            | Cikkszám | DC    | LU    | OAL   | LUX   | LFS   | LS    | DMM   | DF    | Lapka          |                 | Radiális állítás |        |
|-----------------------|----------|-------|-------|-------|-------|-------|-------|-------|-------|----------------|-----------------|------------------|--------|
|                       |          |       |       |       |       |       |       |       |       | Központi lapka | Periféria lapka | Inch -           | Inch + |
| 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  |

Pótalkatrészek

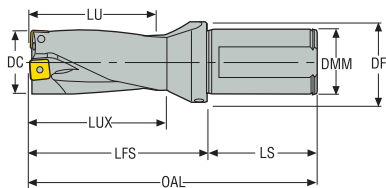
| Fúró átmérő (inch) | Lapka csavar  |              | Lapka kulcs   |
|--------------------|---|--------------|---|
|                    |  |              |  |
|                    | Központi lapka  | Perif. lapka |   |
| 0.594-0.687        | C02245-T07P   | C02245-T07P  | T07P-2  |
| 0.709-0.766        | 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   |

Kiegészítők

| Fúró átmérő (inch) | Nyomaték kulcs*  | Cserélhető betét   | Nyomaték érték   |
|--------------------|--|--|--|
|                    |  |  |  |
| 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

Fúrési mélység ~ 2 x D – Inch



- ISO 9766 szár R7-C
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 304-305 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.
- For stationary applications

| Megnevezés              | Cikkszám | DC    | LU    | OAL   | LUX   | LFS   | LS    | DMM   | DF    | Lapka          |                 | Radiális állítás |        |
|-------------------------|----------|-------|-------|-------|-------|-------|-------|-------|-------|----------------|-----------------|------------------|--------|
|                         |          |       |       |       |       |       |       |       |       | Központi lapka | Periféria lapka | Inch -           | Inch + |
| 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  |

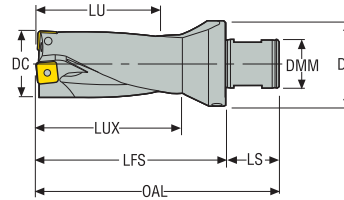
## Pótalkatrészek

## Kiegészítők

| Fúró átmérő (inch) | Hűtő adapter | Lapka csavar központi | Lapka csavar periféria | Kulcs   | Dugó | Nyomaték kulcs |
|--------------------|--------------|-----------------------|------------------------|---------|------|----------------|
| 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

Fúrási mélység ~ 2 x D



- ABS 50 kompatibilis szár, R2
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 304, 305 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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

Bevezetés

Fúrás

Dörzsarázás

Késztergálás



Melléklet

| Megnevezés          | Cikkszám | DC             | LU            | OAL            | LUX           | LFS            | LS         | DMM           | DF            | Lapka      |                | Radiális állítás |                |
|---------------------|----------|----------------|---------------|----------------|---------------|----------------|------------|---------------|---------------|------------|----------------|------------------|----------------|
|                     |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch | mm<br>Inch    | mm<br>Inch    | mm<br>Inch | Központi lapka | Periféria lapka  | mm -<br>Inch - |
| SD522-28.59-58-50R2 | 03080794 | 28,59<br>1.126 | 58,0<br>2.283 | 119,0<br>4.685 | 63,0<br>2.480 | 88,0<br>3.465  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,21<br>0.008    | 0,5<br>0.020   |
| SD522-29-58-50R2    | 03080797 | 29,0<br>1.142  | 58,0<br>2.283 | 119,0<br>4.685 | 63,0<br>2.480 | 88,0<br>3.465  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,18<br>0.007    | 0,5<br>0.020   |
| SD522-30-60-50R2    | 03080799 | 30,0<br>1.181  | 60,0<br>2.362 | 121,0<br>4.764 | 65,0<br>2.559 | 90,0<br>3.543  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,12<br>0.005    | 0,5<br>0.020   |
| SD522-31-62-50R2    | 03081063 | 31,0<br>1.220  | 62,0<br>2.441 | 123,0<br>4.843 | 67,0<br>2.638 | 92,0<br>3.622  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,12<br>0.005    | 0,5<br>0.020   |
| SD522-31.75-64-50R2 | 03080800 | 31,75<br>1.250 | 64,0<br>2.520 | 125,0<br>4.921 | 69,0<br>2.717 | 94,0<br>3.701  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,5<br>0.020     | 0,28<br>0.011  |
| SD522-32-64-50R2    | 03080804 | 32,0<br>1.260  | 64,0<br>2.520 | 125,0<br>4.921 | 69,0<br>2.717 | 94,0<br>3.701  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,5<br>0.020     | 0,31<br>0.012  |
| SD522-33-66-50R2    | 03080807 | 33,0<br>1.299  | 66,0<br>2.598 | 127,0<br>5.000 | 71,0<br>2.795 | 96,0<br>3.780  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,5<br>0.020     | 0,46<br>0.018  |
| SD522-34-68-50R2    | 03081064 | 34,0<br>1.339  | 68,0<br>2.677 | 129,0<br>5.079 | 73,0<br>2.874 | 98,0<br>3.858  | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,22<br>0.009    | 0,5<br>0.020   |
| SD522-35-70-50R2    | 03080812 | 35,0<br>1.378  | 70,0<br>2.756 | 131,0<br>5.157 | 75,0<br>2.953 | 100,0<br>3.937 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX11T308     | 0,22<br>0.009    | 0,5<br>0.020   |
| SD522-36-72-50R2    | 03080815 | 36,0<br>1.417  | 72,0<br>2.835 | 133,0<br>5.236 | 77,0<br>3.031 | 102,0<br>4.016 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX11T308     | 0,09<br>0.004    | 0,5<br>0.020   |
| SD522-37-74-50R2    | 03081065 | 37,0<br>1.457  | 74,0<br>2.913 | 135,0<br>5.315 | 79,0<br>3.110 | 104,0<br>4.094 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX11T308     | 0,09<br>0.004    | 0,5<br>0.020   |
| SD522-38-76-50R2    | 03080820 | 38,0<br>1.496  | 76,0<br>2.992 | 137,0<br>5.394 | 81,0<br>3.189 | 106,0<br>4.173 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD522-39-78-50R2    | 03081066 | 39,0<br>1.535  | 78,0<br>3.071 | 139,0<br>5.472 | 83,0<br>3.268 | 108,0<br>4.252 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     | 0,39<br>0.015    | 0,5<br>0.020   |
| SD522-40-80-50R2    | 03080825 | 40,0<br>1.575  | 80,0<br>3.150 | 141,0<br>5.551 | 85,0<br>3.346 | 110,0<br>4.331 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     | 0,19<br>0.007    | 0,5<br>0.020   |
| SD522-41-82-50R2    | 03080827 | 41,0<br>1.614  | 82,0<br>3.228 | 143,0<br>5.630 | 87,0<br>3.425 | 112,0<br>4.409 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     | 0,19<br>0.007    | 0,5<br>0.020   |
| SD522-42-84-50R2    | 03080829 | 42,0<br>1.654  | 84,0<br>3.307 | 145,0<br>5.709 | 89,0<br>3.504 | 114,0<br>4.488 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     | 0,19<br>0.007    | 0,5<br>0.020   |
| SD522-43-86-50R2    | 03081067 | 43,0<br>1.693  | 86,0<br>3.386 | 147,0<br>5.787 | 91,0<br>3.583 | 116,0<br>4.567 | 31,0       | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     | 0,05<br>0.002    | 0,5<br>0.020   |
| SD522-44.45-89-50R2 | 03080831 | 44,45<br>1.750 | 89,0<br>3.504 | 150,0<br>5.906 | 94,0<br>3.701 | 119,0<br>4.685 | 31,0       | 50,0<br>1.969 | 50,0<br>1.969 | SPGX1504   | SCGX120408     | 0,5<br>0.020     | 0,41<br>0.016  |

## Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar  |              | Lapka kulcs   |
|---------------------|---|--------------|---|
|                     |  |              |  |
|                     | Központi lapka  | Perif. lapka |   |
| 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   |

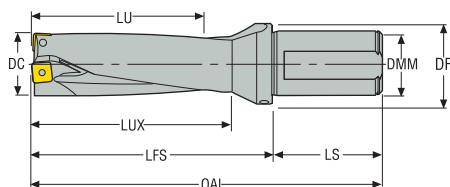
Kiegészítők

| Fúró átmérő (mm) | Nyomaték kulcs*   | Cserélhető betét  | Nyomaték érték |
|------------------|---|---|----------------|
| 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         |

\*Betéttel együtt.

SD523

Fúrási mélység ~ 3 x D



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés         | Cikkszám | DC            | LU            | OAL            | LUX           | LFS           | LS            | DMM           | DF            | Lapka          |                 | Radiális állítás |               |
|--------------------|----------|---------------|---------------|----------------|---------------|---------------|---------------|---------------|---------------|----------------|-----------------|------------------|---------------|
|                    |          |               |               |                |               |               |               |               |               | Központi lapka | Periféria lapka | mm - Inch -      | mm + Inch +   |
| SD523-15-45-20R7   | 03080548 | 15,0<br>0.591 | 45,0<br>1.772 | 125,0<br>4.921 | 50,0<br>1.969 | 75,0<br>2.953 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012 |
| SD523-15-45-25R7   | 03080549 | 15,0<br>0.591 | 45,0<br>1.772 | 131,0<br>5.157 | 50,0<br>1.969 | 75,0<br>2.953 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012 |
| SD523-15.5-47-20R7 | 03080544 | 15,5<br>0.610 | 47,0<br>1.850 | 127,0<br>5.000 | 52,0<br>2.047 | 77,0<br>3.031 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,17<br>0.007    | 0,36<br>0.014 |
| SD523-15.5-47-25R7 | 03080545 | 15,5<br>0.610 | 47,0<br>1.850 | 133,0<br>5.236 | 52,0<br>2.047 | 77,0<br>3.031 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,17<br>0.007    | 0,36<br>0.014 |
| SD523-16-48-20R7   | 03080557 | 16,0<br>0.630 | 48,0<br>1.890 | 128,0<br>5.039 | 53,0<br>2.087 | 78,0<br>3.071 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,12<br>0.005    | 0,41<br>0.016 |
| SD523-16-48-25R7   | 03080558 | 16,0<br>0.630 | 48,0<br>1.890 | 134,0<br>5.276 | 53,0<br>2.087 | 78,0<br>3.071 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,12<br>0.005    | 0,41<br>0.016 |
| SD523-16.5-50-20R7 | 03080552 | 16,5<br>0.650 | 50,0<br>1.969 | 130,0<br>5.118 | 55,0<br>2.165 | 80,0<br>3.150 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,07<br>0.003    | 0,46<br>0.018 |
| SD523-16.5-50-25R7 | 03080554 | 16,5<br>0.650 | 50,0<br>1.969 | 136,0<br>5.354 | 55,0<br>2.165 | 80,0<br>3.150 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,07<br>0.003    | 0,46<br>0.018 |
| SD523-17-51-20R7   | 03080568 | 17,0<br>0.669 | 51,0<br>2.008 | 131,0<br>5.157 | 56,0<br>2.205 | 81,0<br>3.189 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0502       | SCGX050204      | 0,02<br>0.001    | 0,5<br>0.020  |
| SD523-17-51-25R7   | 03080569 | 17,0<br>0.669 | 51,0<br>2.008 | 137,0<br>5.394 | 56,0<br>2.205 | 81,0<br>3.189 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0502       | SCGX050204      | 0,02<br>0.001    | 0,5<br>0.020  |
| SD523-17.5-53-20R7 | 03080562 | 17,5<br>0.689 | 53,0<br>2.087 | 133,0<br>5.236 | 58,0<br>2.283 | 83,0<br>3.268 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,43<br>0.017    | 0,1<br>0.004  |
| SD523-17.5-53-25R7 | 03080563 | 17,5<br>0.689 | 53,0<br>2.087 | 139,0<br>5.472 | 58,0<br>2.283 | 83,0<br>3.268 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,43<br>0.017    | 0,1<br>0.004  |
| SD523-18-54-20R7   | 03080574 | 18,0<br>0.709 | 54,0<br>2.126 | 134,0<br>5.276 | 59,0<br>2.323 | 84,0<br>3.307 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,32<br>0.013    | 0,21<br>0.008 |
| SD523-18-54-25R7   | 03080575 | 18,0<br>0.709 | 54,0<br>2.126 | 140,0<br>5.512 | 59,0<br>2.323 | 84,0<br>3.307 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,32<br>0.013    | 0,21<br>0.008 |
| SD523-18.5-56-20R7 | 03080570 | 18,5<br>0.728 | 56,0<br>2.205 | 136,0<br>5.354 | 61,0<br>2.402 | 86,0<br>3.386 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012 |
| SD523-18.5-56-25R7 | 03080571 | 18,5<br>0.728 | 56,0<br>2.205 | 142,0<br>5.591 | 61,0<br>2.402 | 86,0<br>3.386 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,22<br>0.009    | 0,31<br>0.012 |
| SD523-19-57-20R7   | 03080583 | 19,0<br>0.748 | 57,0<br>2.244 | 137,0<br>5.394 | 62,0<br>2.441 | 87,0<br>3.425 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX050204      | 0,11<br>0.004    | 0,42<br>0.017 |
| SD523-19-57-25R7   | 03080584 | 19,0<br>0.748 | 57,0<br>2.244 | 143,0<br>5.630 | 62,0<br>2.441 | 87,0<br>3.425 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX050204      | 0,11<br>0.004    | 0,42<br>0.017 |
| SD523-19.5-59-20R7 | 03080579 | 19,5<br>0.768 | 59,0<br>2.323 | 139,0<br>5.472 | 64,0<br>2.520 | 89,0<br>3.504 | 50,0<br>1.969 | 20,0<br>0.787 | 30,0<br>1.181 | SPGX0602       | SCGX060204      | 0,11<br>0.004    | 0,42<br>0.017 |
| SD523-19.5-59-25R7 | 03080580 | 19,5<br>0.768 | 59,0<br>2.323 | 145,0<br>5.709 | 64,0<br>2.520 | 89,0<br>3.504 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX060204      | 0,11<br>0.004    | 0,42<br>0.017 |
| SD523-20-60-25R7   | 03080590 | 20,0<br>0.787 | 60,0<br>2.362 | 146,0<br>5.748 | 65,0<br>2.559 | 90,0<br>3.543 | 56,0<br>2.205 | 25,0<br>0.984 | 35,0<br>1.378 | SPGX0602       | SCGX060204      | 0,07<br>0.003    | 0,46<br>0.018 |







| Megnevezés        | Cikkszám | DC            | LU             | OAL             | LUX            | LFS            | LS            | DMM           | DF            | Lapka      |                | Radiális állítás |                |
|-------------------|----------|---------------|----------------|-----------------|----------------|----------------|---------------|---------------|---------------|------------|----------------|------------------|----------------|
|                   |          | mm<br>Inch    | mm<br>Inch     | mm<br>Inch      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch | Központi lapka | Periféria lapka  | mm -<br>Inch - |
| SD523-58-174-40R7 | 03080686 | 58,0<br>2.283 | 174,0<br>6.850 | 272,0<br>10.709 | 179,0<br>7.047 | 204,0<br>8.031 | 68,0<br>2.677 | 40,0<br>1.575 | 63,0<br>2.480 | SPGX1904   | SCGX150512     | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-59-177-40R7 | 03080687 | 59,0<br>2.323 | 177,0<br>6.969 | 275,0<br>10.827 | 182,0<br>7.165 | 207,0<br>8.150 | 68,0<br>2.677 | 40,0<br>1.575 | 63,0<br>2.480 | SPGX1904   | SCGX150512     | 0,09<br>0.004    | 0,5<br>0.020   |

### Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar   |              | Lapka kulcs |
|------------------|----------------|--------------|-------------|
|                  | Központi lapka | Perif. lapka |             |
| 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     |

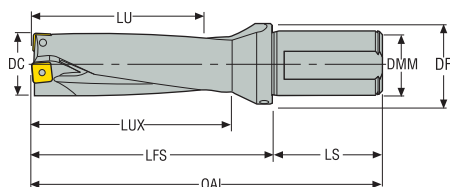
### Kiegészítők

| Fúró átmérő (mm) | Nyomaték kulcs* | Cserélhető betét | Nyomaték érték |
|------------------|-----------------|------------------|----------------|
| 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         |

\*Betéttel együtt.

## SD523

Fúrási mélység ~ 3 x D – Inch



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

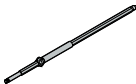

| Megnevezés            | Cikkszám | DC    | LU    | OAL   | LUX   | LFS   | LS    | DMM   | DF    | Lapka    |                | Radiális állítás |        |
|-----------------------|----------|-------|-------|-------|-------|-------|-------|-------|-------|----------|----------------|------------------|--------|
|                       |          | Inch  | Inch  | inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch     | Központi lapka | Periféria lapka  | Inch - |
| 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  |

| Megnevezés            | Cikkszám | DC    | LU    | OAL    | LUX   | LFS   | LS    | DMM   | DF    | Lapka          |                 | Radiális állítás |        |
|-----------------------|----------|-------|-------|--------|-------|-------|-------|-------|-------|----------------|-----------------|------------------|--------|
|                       |          | Inch  | Inch  | inch   | Inch  | Inch  | Inch  | Inch  | Inch  | Központi lapka | Periféria lapka | Inch -           | Inch + |
| 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  |

### Pótalkatrészek

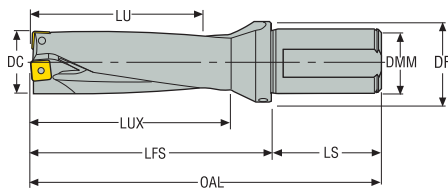
| Fúró átmérő (inch) | Lapka csavar központi   | Lapka csavar periféria  | Kulcs  |
|--------------------|---|---|--|
| 0.562-0.687        |  C02245-T07P |  C02245-T07P |  T07P-2 |
| 0.709-0.766        | C02205-T07P   | C02245-T07P   | T07P-2   |
| 0.787-0.827        | C02205-T07P   | C02205-T07P   | 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  |

### Kiegészítők

| Fúró átmérő (inch) | Cserélhető penge  | Nyomaték kulcs  |
|--------------------|---|---|
| 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

Fúrési mélység ~ 3 x D – Inch





- ISO 9766 szár R7-C
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.
- For stationary applications

| Megnevezés              | Cikkszám | DC    | LU    | OAL   | LUX   | LFS   | LS    | DMM   | DF    | Lapka          |                 | Radiális állítás |        |
|-------------------------|----------|-------|-------|-------|-------|-------|-------|-------|-------|----------------|-----------------|------------------|--------|
|                         |          |       |       |       |       |       |       |       |       | Központi lapka | Periféria lapka | Inch -           | Inch + |
| 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  |


Bevezetés

| Megnevezés              | Cikkszám | DC    | LU    | OAL    | LUX   | LFS   | LS    | DMM   | DF    | Lapka          |                 | Radiális állítás |        |
|-------------------------|----------|-------|-------|--------|-------|-------|-------|-------|-------|----------------|-----------------|------------------|--------|
|                         |          | Inch  | Inch  | Inch   | Inch  | Inch  | Inch  | Inch  | Inch  | Központi lapka | Periféria lapka | Inch -           | Inch + |
| 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  |

### Pótalkatrészek

| Fúró átmérő (inch) | Hűtő adapter   | Lapka csavar központi   | Lapka csavar periféria  | Kulcs  | Dugó   |
|--------------------|--|---|---|--|--|
| 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   |

### Kiegészítők

| Fúró átmérő (inch) | Nyomaték kulcs  |
|--------------------|---|
| 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   |

Fúrás

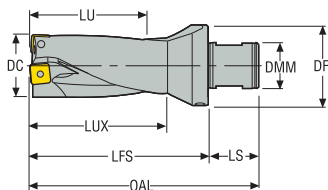
Dörzsárazás

Késztergálás

Melléklet

# SD523

Fúrési mélység ~ 3 x D



- ABS 50 kompatibilis szár, -2
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet



| Megnevezés           | Cikkszám | DC             | LU             | OAL            | LUX            | LFS            | LS            | DMM           | DF            | Lapka      |                | Radiális állítás |                |
|----------------------|----------|----------------|----------------|----------------|----------------|----------------|---------------|---------------|---------------|------------|----------------|------------------|----------------|
|                      |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch | Központi lapka | Periféria lapka  | mm -<br>Inch - |
| SD523-28.59-86-50R2  | 03080625 | 28,59<br>1.126 | 86,0<br>3.386  | 147,0<br>5.787 | 91,0<br>3.583  | 116,0<br>4.567 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,21<br>0.008    | 0,5<br>0.020   |
| SD523-29-87-50R2     | 03080630 | 29,0<br>1.142  | 87,0<br>3.425  | 148,0<br>5.827 | 92,0<br>3.622  | 117,0<br>4.606 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,18<br>0.007    | 0,5<br>0.020   |
| SD523-30-90-50R2     | 03080633 | 30,0<br>1.181  | 90,0<br>3.543  | 151,0<br>5.945 | 95,0<br>3.740  | 120,0<br>4.724 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,12<br>0.005    | 0,5<br>0.020   |
| SD523-31-93-50R2     | 03080637 | 31,0<br>1.220  | 93,0<br>3.661  | 154,0<br>6.063 | 98,0<br>3.858  | 123,0<br>4.843 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903   | SCGX09T308     | 0,12<br>0.005    | 0,5<br>0.020   |
| SD523-31.75-96-50R2  | 03080635 | 31,75<br>1.250 | 96,0<br>3.780  | 157,0<br>6.181 | 101,0<br>3.976 | 126,0<br>4.961 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,5<br>0.020     | 0,28<br>0.011  |
| SD523-32-96-50R2     | 03080640 | 32,0<br>1.260  | 96,0<br>3.780  | 157,0<br>6.181 | 101,0<br>3.976 | 126,0<br>4.961 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,5<br>0.020     | 0,31<br>0.012  |
| SD523-33-99-50R2     | 03080643 | 33,0<br>1.299  | 99,0<br>3.898  | 160,0<br>6.299 | 104,0<br>4.094 | 129,0<br>5.079 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,5<br>0.020     | 0,46<br>0.018  |
| SD523-34-102-50R2    | 03080646 | 34,0<br>1.339  | 102,0<br>4.016 | 163,0<br>6.417 | 107,0<br>4.213 | 132,0<br>5.197 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX09T308     | 0,22<br>0.009    | 0,5<br>0.020   |
| SD523-35-105-50R2    | 03080650 | 35,0<br>1.378  | 105,0<br>4.134 | 166,0<br>6.535 | 110,0<br>4.331 | 135,0<br>5.315 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX11T308     | 0,22<br>0.009    | 0,5<br>0.020   |
| SD523-36-108-50R2    | 03080870 | 36,0<br>1.417  | 108,0<br>4.252 | 169,0<br>6.654 | 113,0<br>4.449 | 138,0<br>5.433 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX11T308     | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-37-111-50R2    | 03080871 | 37,0<br>1.457  | 111,0<br>4.370 | 172,0<br>6.772 | 116,0<br>4.567 | 141,0<br>5.551 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3   | SCGX11T308     | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-38-114-50R2    | 03080657 | 38,0<br>1.496  | 114,0<br>4.488 | 175,0<br>6.890 | 119,0<br>4.685 | 144,0<br>5.669 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     | 0,5<br>0.020     | 0,5<br>0.020   |
| SD523-39-117-50R2    | 03080660 | 39,0<br>1.535  | 117,0<br>4.606 | 178,0<br>7.008 | 122,0<br>4.803 | 147,0<br>5.787 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     | 0,39<br>0.015    | 0,5<br>0.020   |
| SD523-40-120-50R2    | 03080872 | 40,0<br>1.575  | 120,0<br>4.724 | 181,0<br>7.126 | 125,0<br>4.921 | 150,0<br>5.906 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     | 0,19<br>0.007    | 0,5<br>0.020   |
| SD523-41-123-50R2    | 03080873 | 41,0<br>1.614  | 123,0<br>4.843 | 184,0<br>7.244 | 128,0<br>5.039 | 153,0<br>6.024 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     | 0,19<br>0.007    | 0,5<br>0.020   |
| SD523-42-126-50R2    | 03080874 | 42,0<br>1.654  | 126,0<br>4.961 | 187,0<br>7.362 | 131,0<br>5.157 | 156,0<br>6.142 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     | 0,19<br>0.007    | 0,5<br>0.020   |
| SD523-43-129-50R2    | 03080875 | 43,0<br>1.693  | 129,0<br>5.079 | 190,0<br>7.480 | 134,0<br>5.276 | 159,0<br>6.260 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     | 0,05<br>0.002    | 0,5<br>0.020   |
| SD523-44-132-50R2    | 03080671 | 44,0<br>1.732  | 132,0<br>5.197 | 193,0<br>7.598 | 137,0<br>5.394 | 162,0<br>6.378 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX1504   | SCGX120408     | 0,5<br>0.020     | 0,41<br>0.016  |
| SD523-44.45-134-50R2 | 03080668 | 44,45<br>1.750 | 134,0<br>5.276 | 195,0<br>7.677 | 139,0<br>5.472 | 164,0<br>6.457 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX1504   | SCGX120408     | 0,5<br>0.020     | 0,41<br>0.016  |

### Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar   | Lapka kulcs         |
|------------------|----------------|---------------------|
|                  |                |                     |
|                  | Központi lapka | Perif. lapka        |
| 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 |



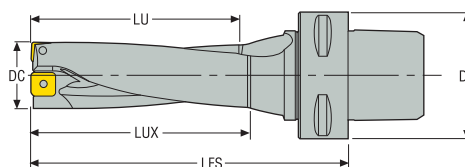
## Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs*   | Cserélhető<br>betét   | Nyomaték érték |
|---------------------|---|---|----------------|
|                     |  |  |                |
| 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         |

\*Betéttel együtt.

## SD523

Fúrési mélység ~ 3 x D



- Seco-Capto™ C4 szár
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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

| Megnevezés        | Cikkszám | DC             | LU            | LUX           | LFS            | DF            | Lapka          |                 | Radiális állítás |                |
|-------------------|----------|----------------|---------------|---------------|----------------|---------------|----------------|-----------------|------------------|----------------|
|                   |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | Központi lapka | Periféria lapka | mm -<br>Inch -   | mm +<br>Inch + |
| SD523-28.59-86-C4 | 03081010 | 28,59<br>1.126 | 86,0<br>3.386 | 91,0<br>3.583 | 131,0<br>5.157 | 40,0<br>1.575 | SPGX0903       | SCGX09T308      | 0,21<br>0.008    | 0,5<br>0.020   |
| SD523-29-87-C4    | 03080939 | 29,0<br>1.142  | 87,0<br>3.425 | 92,0<br>3.622 | 132,0<br>5.197 | 40,0<br>1.575 | SPGX0903       | SCGX09T308      | 0,18<br>0.007    | 0,5<br>0.020   |
| SD523-30-90-C4    | 03080940 | 30,0<br>1.181  | 90,0<br>3.543 | 95,0<br>3.740 | 135,0<br>5.315 | 40,0<br>1.575 | SPGX0903       | SCGX09T308      | 0,12<br>0.005    | 0,5<br>0.020   |

### Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar   |              | Lapka kulcs |
|---------------------|----------------|--------------|-------------|
|                     | Központi lapka | Perif. lapka |             |
| 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     |

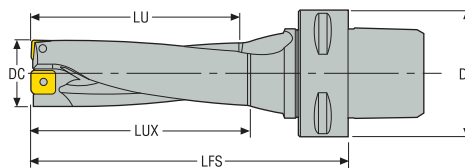
### Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs* | Cserélhető betét | Nyomaték érték |
|---------------------|-----------------|------------------|----------------|
| 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         |

\*Betéttel együtt.

## SD523

Fúrési mélység ~ 3 x D



- Seco-Capto™ C5 szár
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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



| Megnevezés        | Cikkszám | DC             | LU             | LUX            | LFS            | DF            | Lapka          |                 | Radiális állítás |                |
|-------------------|----------|----------------|----------------|----------------|----------------|---------------|----------------|-----------------|------------------|----------------|
|                   |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | Központi lapka | Periféria lapka | mm -<br>Inch -   | mm +<br>Inch + |
| SD523-28.59-86-C5 | 03081004 | 28,59<br>1.126 | 86,0<br>3.386  | 91,0<br>3.583  | 131,0<br>5.157 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      | 0,21<br>0.008    | 0,5<br>0.020   |
| SD523-29-87-C5    | 03080959 | 29,0<br>1.142  | 87,0<br>3.425  | 92,0<br>3.622  | 132,0<br>5.197 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      | 0,18<br>0.007    | 0,5<br>0.020   |
| SD523-30-90-C5    | 03080960 | 30,0<br>1.181  | 90,0<br>3.543  | 95,0<br>3.740  | 135,0<br>5.315 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      | 0,12<br>0.005    | 0,5<br>0.020   |
| SD523-31-93-C5    | 03080961 | 31,0<br>1.220  | 93,0<br>3.661  | 98,0<br>3.858  | 138,0<br>5.433 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      | 0,12<br>0.005    | 0,5<br>0.020   |
| SD523-31.75-96-C5 | 03081005 | 31,75<br>1.250 | 96,0<br>3.780  | 101,0<br>3.976 | 142,0<br>5.591 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      | 0,5<br>0.020     | 0,28<br>0.011  |
| SD523-32-96-C5    | 03080962 | 32,0<br>1.260  | 96,0<br>3.780  | 101,0<br>3.976 | 142,0<br>5.591 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      | 0,5<br>0.020     | 0,31<br>0.012  |
| SD523-33-99-C5    | 03080963 | 33,0<br>1.299  | 99,0<br>3.898  | 104,0<br>4.094 | 145,0<br>5.709 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      | 0,5<br>0.020     | 0,46<br>0.018  |
| SD523-34-102-C5   | 03080964 | 34,0<br>1.339  | 102,0<br>4.016 | 107,0<br>4.213 | 148,0<br>5.827 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      | 0,22<br>0.009    | 0,5<br>0.020   |
| SD523-35-105-C5   | 03080965 | 35,0<br>1.378  | 105,0<br>4.134 | 110,0<br>4.331 | 151,0<br>5.945 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      | 0,22<br>0.009    | 0,5<br>0.020   |
| SD523-36-108-C5   | 03080966 | 36,0<br>1.417  | 108,0<br>4.252 | 113,0<br>4.449 | 154,0<br>6.063 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-37-111-C5   | 03080967 | 37,0<br>1.457  | 111,0<br>4.370 | 116,0<br>4.567 | 157,0<br>6.181 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-38-114-C5   | 03080968 | 38,0<br>1.496  | 114,0<br>4.488 | 119,0<br>4.685 | 160,0<br>6.299 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      | 0,5<br>0.020     | 0,5<br>0.020   |
| SD523-39-117-C5   | 03080969 | 39,0<br>1.535  | 117,0<br>4.606 | 122,0<br>4.803 | 163,0<br>6.417 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      | 0,39<br>0.015    | 0,5<br>0.020   |
| SD523-40-120-C5   | 03080970 | 40,0<br>1.575  | 120,0<br>4.724 | 125,0<br>4.921 | 166,0<br>6.535 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      | 0,19<br>0.007    | 0,5<br>0.020   |

Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar   |              | Lapka kulcs |
|------------------|----------------|--------------|-------------|
|                  | Központi lapka | Perif. lapka |             |
| 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     |



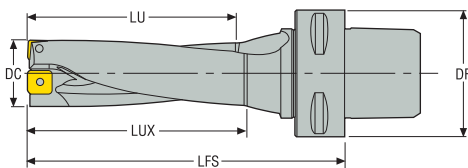
Kiegészítők

| Fúró átmérő (mm) | Nyomaték kulcs*   | Cserélhető betét  | Nyomaték érték |
|------------------|---|---|----------------|
| 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         |

\*Betéttel együtt.

## SD523

Fúrási mélység ~ 3 x D



- Seco-Capto™ C6 szár
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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



| Megnevezés        | Cikkszám | DC             | LU             | LUX            | LFS            | DF            | Lapka          |                 | Radiális állítás |                |
|-------------------|----------|----------------|----------------|----------------|----------------|---------------|----------------|-----------------|------------------|----------------|
|                   |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | Központi lapka | Periféria lapka | mm -<br>Inch -   | mm +<br>Inch + |
| SD523-28.59-86-C6 | 03081014 | 28,59<br>1.126 | 86,0<br>3.386  | 91,0<br>3.583  | 133,0<br>5.236 | 63,0<br>2.480 | SPGX0903       | SCGX09T308      | 0,21<br>0.008    | 0,5<br>0.020   |
| SD523-29-87-C6    | 03080989 | 29,0<br>1.142  | 87,0<br>3.425  | 92,0<br>3.622  | 134,0<br>5.276 | 63,0<br>2.480 | SPGX0903       | SCGX09T308      | 0,18<br>0.007    | 0,5<br>0.020   |
| SD523-30-90-C6    | 03080990 | 30,0<br>1.181  | 90,0<br>3.543  | 95,0<br>3.740  | 137,0<br>5.394 | 63,0<br>2.480 | SPGX0903       | SCGX09T308      | 0,12<br>0.005    | 0,5<br>0.020   |
| SD523-31-93-C6    | 03080991 | 31,0<br>1.220  | 93,0<br>3.661  | 98,0<br>3.858  | 140,0<br>5.512 | 63,0<br>2.480 | SPGX0903       | SCGX09T308      | 0,12<br>0.005    | 0,5<br>0.020   |
| SD523-31.75-96-C6 | 03081015 | 31,75<br>1.250 | 96,0<br>3.780  | 101,0<br>3.976 | 144,0<br>5.669 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      | 0,5<br>0.020     | 0,28<br>0.011  |
| SD523-32-96-C6    | 03080992 | 32,0<br>1.260  | 96,0<br>3.780  | 101,0<br>3.976 | 144,0<br>5.669 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      | 0,5<br>0.020     | 0,31<br>0.012  |
| SD523-33-99-C6    | 03080993 | 33,0<br>1.299  | 99,0<br>3.898  | 104,0<br>4.094 | 147,0<br>5.787 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      | 0,5<br>0.020     | 0,46<br>0.018  |
| SD523-34-102-C6   | 03080994 | 34,0<br>1.339  | 102,0<br>4.016 | 107,0<br>4.213 | 150,0<br>5.906 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      | 0,22<br>0.009    | 0,5<br>0.020   |
| SD523-35-105-C6   | 03080995 | 35,0<br>1.378  | 105,0<br>4.134 | 110,0<br>4.331 | 153,0<br>6.024 | 63,0<br>2.480 | SPGX11T3       | SCGX11T308      | 0,22<br>0.009    | 0,5<br>0.020   |
| SD523-36-108-C6   | 03080996 | 36,0<br>1.417  | 108,0<br>4.252 | 113,0<br>4.449 | 156,0<br>6.142 | 63,0<br>2.480 | SPGX11T3       | SCGX11T308      | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-37-111-C6   | 03080997 | 37,0<br>1.457  | 111,0<br>4.370 | 116,0<br>4.567 | 159,0<br>6.260 | 63,0<br>2.480 | SPGX11T3       | SCGX11T308      | 0,09<br>0.004    | 0,5<br>0.020   |
| SD523-38-114-C6   | 03080998 | 38,0<br>1.496  | 114,0<br>4.488 | 119,0<br>4.685 | 162,0<br>6.378 | 63,0<br>2.480 | SPGX12T3       | SCGX11T308      | 0,5<br>0.020     | 0,5<br>0.020   |
| SD523-39-117-C6   | 03080999 | 39,0<br>1.535  | 117,0<br>4.606 | 122,0<br>4.803 | 165,0<br>6.496 | 63,0<br>2.480 | SPGX12T3       | SCGX11T308      | 0,39<br>0.015    | 0,5<br>0.020   |
| SD523-40-120-C6   | 03081000 | 40,0<br>1.575  | 120,0<br>4.724 | 125,0<br>4.921 | 168,0<br>6.614 | 63,0<br>2.480 | SPGX12T3       | SCGX11T308      | 0,19<br>0.007    | 0,5<br>0.020   |

### Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar  |   | Lapka kulcs   |
|------------------|---|---|---|
|                  |  |  |  |
|                  | Központi lapka  | Perif. lapka  |   |
| 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   |



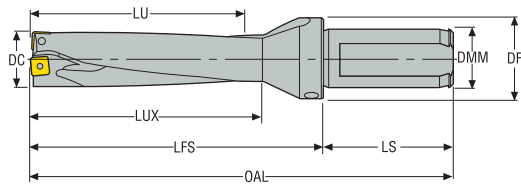
## Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs*   | Cserélhető<br>betét   | Nyomaték érték |
|---------------------|---|---|----------------|
|                     |  |  |                |
| 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         |

\*Betéttel együtt.

## SD524

Fúrési mélység ~ 4 x D



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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

Bevezetés

Fúrás

Dörzsarázás

Késztergálás



Melléklet

| Megnevezés        | Cikkszám | DC            | LU             | OAL             | LUX            | LFS             | LS            | DMM           | DF             | Lapka      |                |
|-------------------|----------|---------------|----------------|-----------------|----------------|-----------------|---------------|---------------|----------------|------------|----------------|
|                   |          | mm<br>Inch    | mm<br>Inch     | mm<br>Inch      | mm<br>Inch     | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch | Központi lapka |
| SD524-36-144-40R7 | 03080365 | 36,0<br>1.417 | 144,0<br>5.669 | 242,0<br>9.528  | 149,0<br>5.866 | 174,0<br>6.850  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX11T3   | SCGX11T308     |
| SD524-37-148-40R7 | 03080366 | 37,0<br>1.457 | 148,0<br>5.827 | 246,0<br>9.685  | 153,0<br>6.024 | 178,0<br>7.008  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX11T3   | SCGX11T308     |
| SD524-38-152-40R7 | 03080367 | 38,0<br>1.496 | 152,0<br>5.984 | 250,0<br>9.843  | 157,0<br>6.181 | 182,0<br>7.165  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX11T308     |
| SD524-39-156-40R7 | 03080368 | 39,0<br>1.535 | 156,0<br>6.142 | 254,0<br>10.000 | 161,0<br>6.339 | 186,0<br>7.323  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX11T308     |
| SD524-40-160-40R7 | 03080369 | 40,0<br>1.575 | 160,0<br>6.299 | 258,0<br>10.157 | 165,0<br>6.496 | 190,0<br>7.480  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX11T308     |
| SD524-41-164-40R7 | 03080370 | 41,0<br>1.614 | 164,0<br>6.457 | 262,0<br>10.315 | 169,0<br>6.654 | 194,0<br>7.638  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX120408     |
| SD524-42-168-40R7 | 03080371 | 42,0<br>1.654 | 168,0<br>6.614 | 266,0<br>10.472 | 173,0<br>6.811 | 198,0<br>7.795  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX120408     |
| SD524-43-172-40R7 | 03080372 | 43,0<br>1.693 | 172,0<br>6.772 | 270,0<br>10.630 | 177,0<br>6.969 | 202,0<br>7.953  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX12T3   | SCGX120408     |
| SD524-44-176-40R7 | 03080373 | 44,0<br>1.732 | 176,0<br>6.929 | 274,0<br>10.787 | 181,0<br>7.126 | 206,0<br>8.110  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX120408     |
| SD524-45-180-40R7 | 03080374 | 45,0<br>1.772 | 180,0<br>7.087 | 278,0<br>10.945 | 185,0<br>7.283 | 210,0<br>8.268  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX150512     |
| SD524-46-184-40R7 | 03080375 | 46,0<br>1.811 | 184,0<br>7.244 | 282,0<br>11.102 | 189,0<br>7.441 | 214,0<br>8.425  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX150512     |
| SD524-47-188-40R7 | 03080376 | 47,0<br>1.850 | 188,0<br>7.402 | 286,0<br>11.260 | 193,0<br>7.598 | 218,0<br>8.583  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969  | SPGX1504   | SCGX150512     |
| SD524-48-192-40R7 | 03080377 | 48,0<br>1.890 | 192,0<br>7.559 | 290,0<br>11.417 | 197,0<br>7.756 | 222,0<br>8.740  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     |
| SD524-49-196-40R7 | 03080378 | 49,0<br>1.929 | 196,0<br>7.717 | 294,0<br>11.575 | 201,0<br>7.913 | 226,0<br>8.898  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     |
| SD524-50-200-40R7 | 03080379 | 50,0<br>1.969 | 200,0<br>7.874 | 298,0<br>11.732 | 205,0<br>8.071 | 230,0<br>9.055  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     |
| SD524-51-204-40R7 | 03080380 | 51,0<br>2.008 | 204,0<br>8.031 | 302,0<br>11.890 | 209,0<br>8.228 | 234,0<br>9.213  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1504   | SCGX150512     |
| SD524-52-208-40R7 | 03080381 | 52,0<br>2.047 | 208,0<br>8.189 | 306,0<br>12.047 | 213,0<br>8.386 | 238,0<br>9.370  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     |
| SD524-53-212-40R7 | 03080382 | 53,0<br>2.087 | 212,0<br>8.346 | 310,0<br>12.205 | 217,0<br>8.543 | 242,0<br>9.528  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     |
| SD524-54-216-40R7 | 03080383 | 54,0<br>2.126 | 216,0<br>8.504 | 314,0<br>12.362 | 221,0<br>8.701 | 246,0<br>9.685  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     |
| SD524-55-220-40R7 | 03080384 | 55,0<br>2.165 | 220,0<br>8.661 | 318,0<br>12.520 | 225,0<br>8.858 | 250,0<br>9.843  | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     |
| SD524-56-224-40R7 | 03080385 | 56,0<br>2.205 | 224,0<br>8.819 | 322,0<br>12.677 | 229,0<br>9.016 | 254,0<br>10.000 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     |
| SD524-57-228-40R7 | 03080386 | 57,0<br>2.244 | 228,0<br>8.976 | 326,0<br>12.835 | 233,0<br>9.173 | 258,0<br>10.157 | 68,0<br>2.677 | 40,0<br>1.575 | 59,35<br>2.337 | SPGX1904   | SCGX150512     |
| SD524-58-232-40R7 | 03080387 | 58,0<br>2.283 | 232,0<br>9.134 | 330,0<br>12.992 | 237,0<br>9.331 | 262,0<br>10.315 | 68,0<br>2.677 | 40,0<br>1.575 | 63,0<br>2.480  | SPGX1904   | SCGX150512     |
| SD524-59-236-40R7 | 03080388 | 59,0<br>2.323 | 236,0<br>9.291 | 334,0<br>13.150 | 241,0<br>9.488 | 266,0<br>10.472 | 68,0<br>2.677 | 40,0<br>1.575 | 63,0<br>2.480  | SPGX1904   | SCGX150512     |

Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar   |   | Lapka kulcs   |
|------------------|----------------|---|---|
|                  |                |  |  |
|                  | Központi lapka | Perif. lapka  |   |
| 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   |

Kiegészítők

| Fúró átmérő (mm) | Nyomaték kulcs*  | Cserélhető betét   | Nyomaték érték |
|------------------|--|--|----------------|
|                  |  |  |                |
| 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         |

\*Betéttel együtt.

Bevezetés

Fúrás

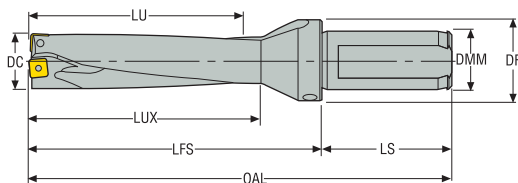
Dörzsárazás

Késztergálás

Melléklet

## SD524

Fúrási mélység ~ 4 x D – Inch






- ISO 9766 szár R7
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.


| Megnevezés            | Cikkszám | DC    | LU    | OAL    | LUX   | LFS   | LS    | DMM   | DF    | Lapka    |                |
|-----------------------|----------|-------|-------|--------|-------|-------|-------|-------|-------|----------|----------------|
|                       |          | Inch  | Inch  | Inch   | Inch  | Inch  | Inch  | Inch  | Inch  | Inch     | Központi lapka |
| 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     |

| Megnevezés            | Cikkszám | DC          | LU          | OAL         | LUX         | LFS         | LS          | DMM         | DF          | Lapka          |                 |
|-----------------------|----------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|----------------|-----------------|
|                       |          | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | Központi lapka | Periféria lapka |
| 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      |

### Pótalkatrészek

| Fúró átmérő<br>(inch) | Lapka csavar központi   | Lapka csavar periféria  | Kulcs   |
|-----------------------|---|---|---|
|                       |  |  |  |
| 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   |

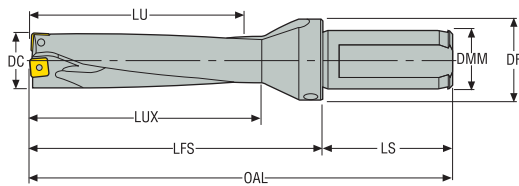
### Kiegészítők

| Fúró átmérő<br>(inch) | Nyomaték kulcs  |
|-----------------------|---|
|                       |  |
| 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

Fúrési mélység ~ 4 x D – Inch



- ISO 9766 szár R7-C
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.
- For stationary applications

| Megnevezés              | Cikkszám | DC    | LU    | OAL    | LUX   | LFS    | LS    | DMM   | DF    | Lapka          |                 |
|-------------------------|----------|-------|-------|--------|-------|--------|-------|-------|-------|----------------|-----------------|
|                         |          | Inch  | Inch  | Inch   | Inch  | Inch   | Inch  | Inch  | Inch  | Központi lapka | Periféria lapka |
| 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      |

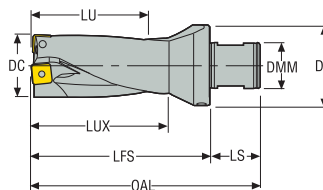
## Pótalkatrészek

## Kiegészítők

| Fúró átmérő (inch) | Hűtő adapter | Lapka csavar központi | Lapka csavar periféria | Kulcs   | Dugó | Nyomaték kulcs |
|--------------------|--------------|-----------------------|------------------------|---------|------|----------------|
| 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

Fúrási mélység ~ 4 x D



- ABS 50 kompatibilis szár, -2
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés           | Cikkszám | DC             | LU             | OAL            | LUX            | LFS            | LS            | DMM           | DF            | Lapka          |                 |
|----------------------|----------|----------------|----------------|----------------|----------------|----------------|---------------|---------------|---------------|----------------|-----------------|
|                      |          |                |                |                |                |                |               |               |               | Központi lapka | Periféria lapka |
| SD524-17-68-50R2     | 03080208 | 17,0<br>0.669  | 68,0<br>2.677  | 129,0<br>5.079 | 73,0<br>2.874  | 98,0<br>3.858  | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0502       | SCGX050204      |
| SD524-17.5-70-50R2   | 03080327 | 17,5<br>0.689  | 70,0<br>2.756  | 131,0<br>5.157 | 75,0<br>2.953  | 100,0<br>3.937 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-18-72-50R2     | 03080209 | 18,0<br>0.709  | 72,0<br>2.835  | 133,0<br>5.236 | 77,0<br>3.031  | 102,0<br>4.016 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-18.5-74-50R2   | 03080210 | 18,5<br>0.728  | 74,0<br>2.913  | 135,0<br>5.315 | 79,0<br>3.110  | 104,0<br>4.094 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-19-76-50R2     | 03080422 | 19,0<br>0.748  | 76,0<br>2.992  | 137,0<br>5.394 | 81,0<br>3.189  | 106,0<br>4.173 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-20-80-50R2     | 03080341 | 20,0<br>0.787  | 80,0<br>3.150  | 141,0<br>5.551 | 85,0<br>3.346  | 110,0<br>4.331 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX060204      |
| SD524-20.62-83-50R2  | 03080215 | 20.62<br>0.812 | 83,0<br>3.268  | 144,0<br>5.669 | 88,0<br>3.465  | 113,0<br>4.449 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX060204      |
| SD524-21-84-50R2     | 03080345 | 21,0<br>0.827  | 84,0<br>3.307  | 145,0<br>5.709 | 89,0<br>3.504  | 114,0<br>4.488 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0602       | SCGX060204      |
| SD524-22-88-50R2     | 03080193 | 22,0<br>0.866  | 88,0<br>3.465  | 149,0<br>5.866 | 93,0<br>3.661  | 118,0<br>4.646 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0703       | SCGX060204      |
| SD524-22.23-89-50R2  | 03080216 | 22.23<br>0.875 | 89,0<br>3.504  | 150,0<br>5.906 | 94,0<br>3.701  | 119,0<br>4.685 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0703       | SCGX060204      |
| SD524-23-92-50R2     | 03080194 | 23,0<br>0.906  | 92,0<br>3.622  | 153,0<br>6.024 | 97,0<br>3.819  | 122,0<br>4.803 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-24-96-50R2     | 03080195 | 24,0<br>0.945  | 96,0<br>3.780  | 157,0<br>6.181 | 101,0<br>3.976 | 126,0<br>4.961 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-25-100-50R2    | 03080196 | 25,0<br>0.984  | 100,0<br>3.937 | 161,0<br>6.339 | 105,0<br>4.134 | 130,0<br>5.118 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-25.4-102-50R2  | 03080217 | 25.4<br>1.000  | 102,0<br>4.016 | 163,0<br>6.417 | 107,0<br>4.213 | 132,0<br>5.197 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-26-104-50R2    | 03080423 | 26,0<br>1.024  | 104,0<br>4.094 | 165,0<br>6.496 | 109,0<br>4.291 | 134,0<br>5.276 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-27-108-50R2    | 03080197 | 27,0<br>1.063  | 108,0<br>4.252 | 169,0<br>6.654 | 113,0<br>4.449 | 138,0<br>5.433 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-28-112-50R2    | 03080424 | 28,0<br>1.102  | 112,0<br>4.409 | 173,0<br>6.811 | 117,0<br>4.606 | 142,0<br>5.591 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-28.59-115-50R2 | 03080218 | 28.59<br>1.126 | 115,0<br>4.528 | 176,0<br>6.929 | 120,0<br>4.724 | 145,0<br>5.709 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-29-116-50R2    | 03080198 | 29,0<br>1.142  | 116,0<br>4.567 | 177,0<br>6.969 | 121,0<br>4.764 | 146,0<br>5.748 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      |
| SD524-30-120-50R2    | 03080199 | 30,0<br>1.181  | 120,0<br>4.724 | 181,0<br>7.126 | 125,0<br>4.921 | 150,0<br>5.906 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      |
| SD524-31-124-50R2    | 03080200 | 31,0<br>1.220  | 124,0<br>4.882 | 185,0<br>7.283 | 129,0<br>5.079 | 154,0<br>6.063 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      |



| Megnevezés           | Cikkszám | DC             | LU             | OAL            | LUX            | LFS            | LS            | DMM           | DF            | Lapka          |                 |
|----------------------|----------|----------------|----------------|----------------|----------------|----------------|---------------|---------------|---------------|----------------|-----------------|
|                      |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | Központi lapka | Periféria lapka |
| SD524-31.75-127-50R2 | 03080359 | 31,75<br>1.250 | 127,0<br>5.000 | 188,0<br>7.402 | 132,0<br>5.197 | 157,0<br>6.181 | 31,0<br>1.220 | 50,0<br>1.969 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-32-128-50R2    | 03080425 | 32,0<br>1.260  | 128,0<br>5.039 | 189,0<br>7.441 | 133,0<br>5.236 | 158,0<br>6.220 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-33-132-50R2    | 03080201 | 33,0<br>1.299  | 132,0<br>5.197 | 193,0<br>7.598 | 137,0<br>5.394 | 162,0<br>6.378 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-34-136-50R2    | 03080207 | 34,0<br>1.339  | 136,0<br>5.354 | 197,0<br>7.756 | 141,0<br>5.551 | 166,0<br>6.535 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-35-140-50R2    | 03080202 | 35,0<br>1.378  | 140,0<br>5.512 | 201,0<br>7.913 | 145,0<br>5.709 | 170,0<br>6.693 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      |
| SD524-36-144-50R2    | 03080203 | 36,0<br>1.417  | 144,0<br>5.669 | 205,0<br>8.071 | 149,0<br>5.866 | 174,0<br>6.850 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      |
| SD524-37-148-50R2    | 03080204 | 37,0<br>1.457  | 148,0<br>5.827 | 209,0<br>8.228 | 153,0<br>6.024 | 178,0<br>7.008 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      |
| SD524-38-152-50R2    | 03080426 | 38,0<br>1.496  | 152,0<br>5.984 | 213,0<br>8.386 | 157,0<br>6.181 | 182,0<br>7.165 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      |
| SD524-39-156-50R2    | 03080205 | 39,0<br>1.535  | 156,0<br>6.142 | 217,0<br>8.543 | 161,0<br>6.339 | 186,0<br>7.323 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      |
| SD524-40-160-50R2    | 03080206 | 40,0<br>1.575  | 160,0<br>6.299 | 221,0<br>8.701 | 165,0<br>6.496 | 190,0<br>7.480 | 31,0<br>1.220 | 28,0<br>1.102 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      |

Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar   |              | Lapka kulcs |
|---------------------|----------------|--------------|-------------|
|                     | Központi lapka | Perif. lapka |             |
| 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     |

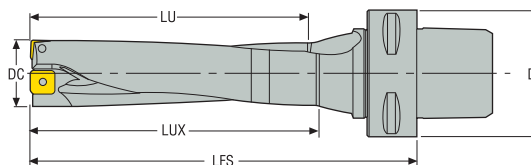
Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs* | Cserélhető<br>betét | Nyomaték érték |
|---------------------|-----------------|---------------------|----------------|
|                     |                 |                     |                |
| 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         |

\*Betéttel együtt.

## SD524

Fúrési mélység ~ 4 x D



- Seco-Capto™ C4 szár
- Belső hűtés
- Információ a lapkáról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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

Bevezetés

Fúrás

Dörzsárazás



Késztergálás

Melléklet

## Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar  |              | Lapka kulcs   |
|---------------------|---|--------------|---|
|                     |  |              |  |
|                     | Központi lapka  | Perif. lapka |   |
| 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   |

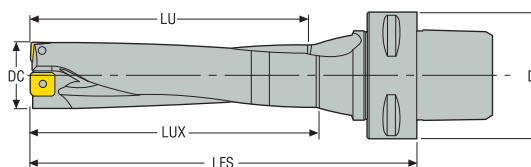
## Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs*  | Cserélhető<br>betét  | Nyomaték érték |
|---------------------|--|--|----------------|
|                     |  |  |                |
| 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         |

\*Betéttel együtt.

## SD524

Fúrési mélység ~ 4 x D



- Seco-Capto™ C5 szár
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés         | Cikkszám | DC             | LU             | LUX            | LFS            | DF            | Lapka          |                 |
|--------------------|----------|----------------|----------------|----------------|----------------|---------------|----------------|-----------------|
|                    |          |                |                |                |                |               | Központi lapka | Periféria lapka |
| SD524-17-68-C5     | 03080235 | 17,0<br>0.669  | 68,0<br>2.677  | 73,0<br>2.874  | 106,0<br>4.173 | 50,0<br>1.969 | SPGX0502       | SCGX050204      |
| SD524-17.5-70-C5   | 03080237 | 17,5<br>0.689  | 70,0<br>2.756  | 75,0<br>2.953  | 109,0<br>4.291 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-18-72-C5     | 03080238 | 18,0<br>0.709  | 72,0<br>2.835  | 77,0<br>3.031  | 111,0<br>4.370 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-18.5-74-C5   | 03080239 | 18,5<br>0.728  | 74,0<br>2.913  | 79,0<br>3.110  | 113,0<br>4.449 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-19-76-C5     | 03080240 | 19,0<br>0.748  | 76,0<br>2.992  | 81,0<br>3.189  | 115,0<br>4.528 | 50,0<br>1.969 | SPGX0602       | SCGX050204      |
| SD524-20-80-C5     | 03080241 | 20,0<br>0.787  | 80,0<br>3.150  | 85,0<br>3.346  | 121,0<br>4.764 | 50,0<br>1.969 | SPGX0602       | SCGX060204      |
| SD524-20.62-83-C5  | 03080408 | 20.62<br>0.812 | 83,0<br>3.268  | 88,0<br>3.465  | 124,0<br>4.882 | 50,0<br>1.969 | SPGX0602       | SCGX060204      |
| SD524-21-84-C5     | 03080242 | 21,0<br>0.827  | 84,0<br>3.307  | 89,0<br>3.504  | 125,0<br>4.921 | 50,0<br>1.969 | SPGX0602       | SCGX060204      |
| SD524-22-88-C5     | 03080243 | 22,0<br>0.866  | 88,0<br>3.465  | 93,0<br>3.661  | 129,0<br>5.079 | 50,0<br>1.969 | SPGX0703       | SCGX060204      |
| SD524-22.23-89-C5  | 03080409 | 22.23<br>0.875 | 89,0<br>3.504  | 94,0<br>3.701  | 130,0<br>5.118 | 50,0<br>1.969 | SPGX0703       | SCGX060204      |
| SD524-23-92-C5     | 03080244 | 23,0<br>0.906  | 92,0<br>3.622  | 97,0<br>3.819  | 134,0<br>5.276 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-24-96-C5     | 03080245 | 24,0<br>0.945  | 96,0<br>3.780  | 101,0<br>3.976 | 139,0<br>5.472 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-25-100-C5    | 03080246 | 25,0<br>0.984  | 100,0<br>3.937 | 105,0<br>4.134 | 144,0<br>5.669 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-25.4-102-C5  | 03080410 | 25.4<br>1.000  | 102,0<br>4.016 | 107,0<br>4.213 | 146,0<br>5.748 | 50,0<br>1.969 | SPGX0703       | SCGX070308      |
| SD524-26-104-C5    | 03080247 | 26,0<br>1.024  | 104,0<br>4.094 | 109,0<br>4.291 | 148,0<br>5.827 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-27-108-C5    | 03080248 | 27,0<br>1.063  | 108,0<br>4.252 | 113,0<br>4.449 | 152,0<br>5.984 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-28-112-C5    | 03080249 | 28,0<br>1.102  | 112,0<br>4.409 | 117,0<br>4.606 | 157,0<br>6.181 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-28.59-115-C5 | 03080411 | 28.59<br>1.126 | 115,0<br>4.528 | 120,0<br>4.724 | 160,0<br>6.299 | 50,0<br>1.969 | SPGX0903       | SCGX070308      |
| SD524-29-116-C5    | 03080250 | 29,0<br>1.142  | 116,0<br>4.567 | 121,0<br>4.764 | 161,0<br>6.339 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      |
| SD524-30-120-C5    | 03080251 | 30,0<br>1.181  | 120,0<br>4.724 | 125,0<br>4.921 | 165,0<br>6.496 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      |
| SD524-31-124-C5    | 03080252 | 31,0<br>1.220  | 124,0<br>4.882 | 129,0<br>5.079 | 169,0<br>6.654 | 50,0<br>1.969 | SPGX0903       | SCGX09T308      |

| Megnevezés         | Cikkszám | DC             | LU             | LUX            | LFS            | DF            | Lapka          |                 |
|--------------------|----------|----------------|----------------|----------------|----------------|---------------|----------------|-----------------|
|                    |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | Központi lapka | Periféria lapka |
| SD524-31.75-127-C5 | 03080412 | 31,75<br>1.250 | 127,0<br>5.000 | 132,0<br>5.197 | 173,0<br>6.811 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-32-128-C5    | 03080253 | 32,0<br>1.260  | 128,0<br>5.039 | 133,0<br>5.236 | 174,0<br>6.850 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-33-132-C5    | 03080254 | 33,0<br>1.299  | 132,0<br>5.197 | 137,0<br>5.394 | 178,0<br>7.008 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-34-136-C5    | 03080255 | 34,0<br>1.339  | 136,0<br>5.354 | 141,0<br>5.551 | 182,0<br>7.165 | 50,0<br>1.969 | SPGX11T3       | SCGX09T308      |
| SD524-35-140-C5    | 03080256 | 35,0<br>1.378  | 140,0<br>5.512 | 145,0<br>5.709 | 186,0<br>7.323 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      |
| SD524-36-144-C5    | 03080257 | 36,0<br>1.417  | 144,0<br>5.669 | 149,0<br>5.866 | 190,0<br>7.480 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      |
| SD524-37-148-C5    | 03080258 | 37,0<br>1.457  | 148,0<br>5.827 | 153,0<br>6.024 | 194,0<br>7.638 | 50,0<br>1.969 | SPGX11T3       | SCGX11T308      |
| SD524-38-152-C5    | 03080259 | 38,0<br>1.496  | 152,0<br>5.984 | 157,0<br>6.181 | 198,0<br>7.795 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      |
| SD524-39-156-C5    | 03080260 | 39,0<br>1.535  | 156,0<br>6.142 | 161,0<br>6.339 | 202,0<br>7.953 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      |
| SD524-40-160-C5    | 03080261 | 40,0<br>1.575  | 160,0<br>6.299 | 165,0<br>6.496 | 206,0<br>8.110 | 50,0<br>1.969 | SPGX12T3       | SCGX11T308      |

## Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar   |              | Lapka kulcs |
|---------------------|----------------|--------------|-------------|
|                     | Központi lapka | Perif. lapka |             |
| 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     |

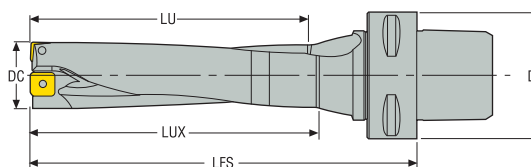
## Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs* | Cserélhető<br>betét | Nyomaték érték |
|---------------------|-----------------|---------------------|----------------|
|                     |                 |                     |                |
| 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         |

\*Betéttel együtt.

## SD524

Fúrási mélység ~ 4 x D



- Seco-Capto™ C6 szár
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 308, 309 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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

| Megnevezés         | Cikkszám | DC             | LU             | LUX            | LFS            | DF            | Lapka          |                 |
|--------------------|----------|----------------|----------------|----------------|----------------|---------------|----------------|-----------------|
|                    |          | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | Központi lapka | Periféria lapka |
| SD524-31.75-127-C6 | 03080421 | 31,75<br>1.250 | 127,0<br>5.000 | 132,0<br>5.197 | 175,0<br>6.890 | 63,0<br>2.480 | SPGX0903       | SCGX09T308      |
| SD524-32-128-C6    | 03080399 | 32,0<br>1.260  | 128,0<br>5.039 | 133,0<br>5.236 | 176,0<br>6.929 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      |
| SD524-33-132-C6    | 03080400 | 33,0<br>1.299  | 132,0<br>5.197 | 137,0<br>5.394 | 180,0<br>7.087 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      |
| SD524-34-136-C6    | 03080401 | 34,0<br>1.339  | 136,0<br>5.354 | 141,0<br>5.551 | 184,0<br>7.244 | 63,0<br>2.480 | SPGX11T3       | SCGX09T308      |
| SD524-35-140-C6    | 03080402 | 35,0<br>1.378  | 140,0<br>5.512 | 145,0<br>5.709 | 188,0<br>7.402 | 63,0<br>2.480 | SPGX11T3       | SCGX11T308      |
| SD524-36-144-C6    | 03080403 | 36,0<br>1.417  | 144,0<br>5.669 | 149,0<br>5.866 | 192,0<br>7.559 | 63,0<br>2.480 | SPGX11T3       | SCGX11T308      |
| SD524-37-148-C6    | 03080404 | 37,0<br>1.457  | 148,0<br>5.827 | 153,0<br>6.024 | 196,0<br>7.717 | 63,0<br>2.480 | SPGX11T3       | SCGX11T308      |
| SD524-38-152-C6    | 03080405 | 38,0<br>1.496  | 152,0<br>5.984 | 157,0<br>6.181 | 200,0<br>7.874 | 63,0<br>2.480 | SPGX12T3       | SCGX11T308      |
| SD524-39-156-C6    | 03080406 | 39,0<br>1.535  | 156,0<br>6.142 | 161,0<br>6.339 | 204,0<br>8.031 | 63,0<br>2.480 | SPGX12T3       | SCGX11T308      |
| SD524-40-160-C6    | 03080407 | 40,0<br>1.575  | 160,0<br>6.299 | 165,0<br>6.496 | 208,0<br>8.189 | 63,0<br>2.480 | SPGX12T3       | SCGX11T308      |

## Pótalkatrészek

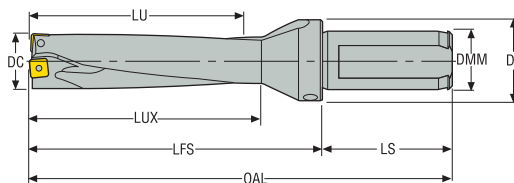
| Fúró átmérő<br>(mm) | Lapka csavar   |              | Lapka kulcs |
|---------------------|----------------|--------------|-------------|
|                     | Központi lapka | Perif. lapka |             |
| 15,00-17,45         | C02245-T07P    | C02245-T07P  | T07P-2      |
| 17,46-19,49         | 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     |

## Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs* | Cserélhető<br>betét | Nyomaték érték |
|---------------------|-----------------|---------------------|----------------|
|                     |                 |                     |                |
| 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         |

## SD525

Fúrási mélység ~ 5 x D



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 310, 311 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

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





| Megnevezés        | Cikkszám | DC            | LU             | OAL             | LUX            | LFS             | LS            | DMM           | DF            | Lapka      |                |
|-------------------|----------|---------------|----------------|-----------------|----------------|-----------------|---------------|---------------|---------------|------------|----------------|
|                   |          | mm<br>Inch    | mm<br>Inch     | mm<br>Inch      | mm<br>Inch     | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch | Központi lapka |
| SD525-40-200-40R7 | 03079603 | 40,0<br>1.575 | 200,0<br>7.874 | 298,0<br>11.732 | 205,0<br>8.071 | 230,0<br>9.055  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969 | SPGX12T3   | SCGX11T308     |
| SD525-41-205-40R7 | 03079604 | 41,0<br>1.614 | 205,0<br>8.071 | 303,0<br>11.929 | 210,0<br>8.268 | 235,0<br>9.252  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     |
| SD525-42-210-40R7 | 03079605 | 42,0<br>1.654 | 210,0<br>8.268 | 308,0<br>12.126 | 215,0<br>8.465 | 240,0<br>9.449  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     |
| SD525-43-215-40R7 | 03079606 | 43,0<br>1.693 | 215,0<br>8.465 | 313,0<br>12.323 | 220,0<br>8.661 | 245,0<br>9.646  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969 | SPGX12T3   | SCGX120408     |
| SD525-44-220-40R7 | 03079607 | 44,0<br>1.732 | 220,0<br>8.661 | 318,0<br>12.520 | 225,0<br>8.858 | 250,0<br>9.843  | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969 | SPGX1504   | SCGX120408     |
| SD525-45-225-40R7 | 03079608 | 45,0<br>1.772 | 225,0<br>8.858 | 323,0<br>12.717 | 230,0<br>9.055 | 255,0<br>10.039 | 68,0<br>2.677 | 40,0<br>1.575 | 50,0<br>1.969 | SPGX1504   | SCGX150512     |

### Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar  |              | Lapka kulcs   |
|---------------------|---|--------------|---|
|                     |  |              |  |
|                     | Központi lapka  | Perif. lapka |   |
| 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   |

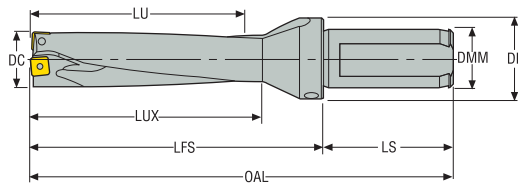
### Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs*   | Cserélhető<br>betét   | Nyomaték érték |
|---------------------|---|---|----------------|
|                     |  |  |                |
| 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         |

\*Betéttel együtt.

## SD525

Fúrási mélység ~ 5 x D – Inch



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 306-307 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés             | Cikkszám | DC    | LU     | OAL    | LUX    | LFS    | LS    | DMM   | DF    | Lapka          |                 |
|------------------------|----------|-------|--------|--------|--------|--------|-------|-------|-------|----------------|-----------------|
|                        |          |       |        |        |        |        |       |       |       | Központi lapka | Periféria lapka |
| 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      |

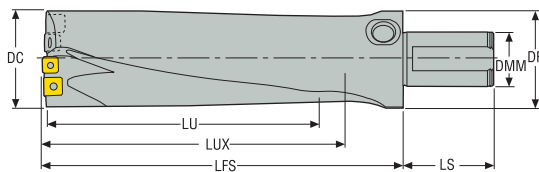
### Pótalkatrészek

### Kiegészítők

| Fúró átmérő (inch) | Lapka csavar központi   | Lapka csavar periféria  | Kulcs  | Nyomaték kulcs  |
|--------------------|---|---|--|---|
| 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

Fúrási mélység ~ 2,5 x D – Metrikus



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákrol a 297-303 old.
- Forgácsolási adatokat lásd a 312, 313 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés          | Cikkszám | DC   | LU    | LUX   | LFS   | LS   | DMM  | DF   | Lapka                          |
|---------------------|----------|------|-------|-------|-------|------|------|------|--------------------------------|
|                     |          | mm   | mm    | mm    | mm    | mm   | mm   | mm   | Központi lapka Periféria lapka |
| 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..       |

## Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar   | Lapka kulcs  | Dugó    | Hűtő adapter |
|------------------|----------------|--------------|---------|--------------|
|                  |                |              |         |              |
|                  | Központi lapka | Perif. lapka |         |              |
| 60,00-64,99      | C03007-T09P    | C03009-T09P  | T09P-2  | R3/8         |
| 65,00-68,99      | C03508-T15P    | C03508-T15P  | T15P-2D | R3/8         |
| 69,00-86,99      | C03508-T15P    | C05012-T15P  | T15P-2D | R3/8         |

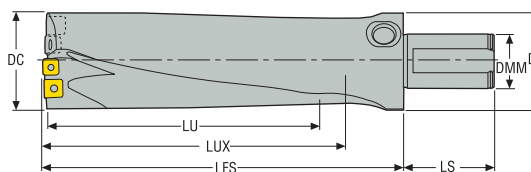
## Kiegészítők

| Fúró átmérő (mm) | Nyomaték kulcs* | Cserélhető betét | Nyomaték érték |
|------------------|-----------------|------------------|----------------|
|                  |                 |                  |                |
| 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         |

\*Betéttel együtt.

## SD542





Fúrási mélység ~ 2.5 X D – Inch





- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 312, 313 old.
- Kőzetes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés            | Cikkszám | DC    | LU    | LUX   | LFS    | LS    | DMM   | DF    | Lapka                          |
|-----------------------|----------|-------|-------|-------|--------|-------|-------|-------|--------------------------------|
|                       |          | Inch  | Inch  | Inch  | Inch   | Inch  | Inch  | Inch  | Központi lapka Periféria lapka |
| 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..     |

### Pótalkatrészek

| Fúró átmérő (inch) | Lapka csavar  | Lapka kulcs   | Dugó  | Hűtő adapter  |
|--------------------|---|---|---|---|
|                    |  |  |  |  |
|                    | Központi lapka  | Perif. lapka  |   |   |
| 2.250-2.500        | C03007-T09P   | C03009-T09P   | T09P-2  | R3/8  |
| 2.750-3.000        | C03508-T15P   | C03508-T15P   | T15P-2D   | R3/8  |
| 3.250-3.500        | C03508-T15P   | C05012-T15P   | T15P-2D   | R3/8  |

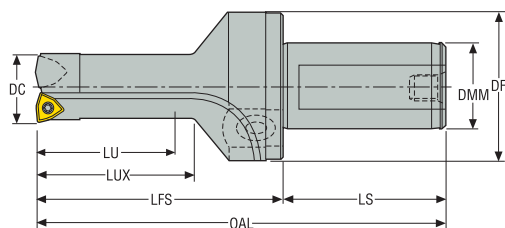
### Kiegészítők

| Fúró átmérő (inch) | Nyomaték kulcs*   | Cserélhető betét  | Nyomaték érték |
|--------------------|---|---|----------------|
|                    |  |  |                |
| 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    |

\*Betéttel együtt.

## SD572






Fúrési mélység ~ 2 x D – Metrikus





- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 314-315 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés       | Cikkszám | DC   | LU   | LUX  | LFS   | LS   | DMM  | DF   | Lapka          |                 |
|------------------|----------|------|------|------|-------|------|------|------|----------------|-----------------|
|                  |          | mm   | mm   | mm   | mm    | mm   | mm   | mm   | Központi lapka | Periféria lapka |
| 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..    |

### Pótalkatrészek

| Fúró átmérő (mm) | Lapka csavar  |   | Lapka kulcs   | Dugó  | Hűtő adapter  |
|------------------|---|---|---|---|---|
|                  |  |  |  |  |  |
|                  | Központi lapka  | Perif. lapka  |   |   |   |
| 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  |

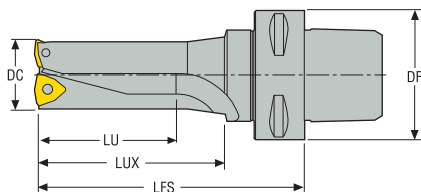
Kiegészítők

| Fúró átmérő (mm) | Nyomaték kulcs*   | Cserélhető betét  | Nyomaték érték |
|------------------|---|---|----------------|
| 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         |

\*Betéttel együtt.

# SD572

Fúrési mélység ~ 2 x D – Inch



- ISO 9766 szár -7
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 314-315 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés            | Cikkszám | Furat átmérő<br>mm-max (inch) | DC    | LU    | LUX   | LFS   | DF    | Lapka          |                 |
|-----------------------|----------|-------------------------------|-------|-------|-------|-------|-------|----------------|-----------------|
|                       |          |                               | Inch  | Inch  | Inch  | Inch  | Inch  | Központi lapka | Periféria lapka |
| 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..   |

## Pótalkatrészek

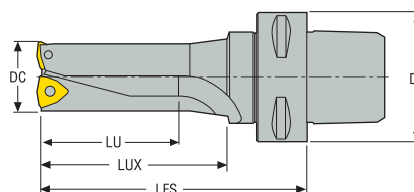
| Fúró átmérő<br>(inch) | Hűtő adapter | Lapka kulcs | Lapka csavar központi | Lapka csavar periféria | Kulcs (zászló) | Csavar |
|-----------------------|--------------|-------------|-----------------------|------------------------|----------------|--------|
| 0.591-0.748           | 1310         | 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   |

## Kiegészítők

| Fúró átmérő<br>(inch) | Cserélhető penge | Nyomaték kulcs |
|-----------------------|------------------|----------------|
| 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      |

## SD572

Fúrási mélység ~ 2 x D – Metrikus



- Seco-Capto™ C5 szár
- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 314-315 old.
- Köztes átmérőkhöz lásd a MyDesign szoftvert.

| Megnevezés     | Cikkszám | Furat átmérő<br>mm-max. | DC   | LU   | LUX  | LFS   | DF   | Lapka          |                 |
|----------------|----------|-------------------------|------|------|------|-------|------|----------------|-----------------|
|                |          |                         |      |      |      |       |      | Központi lapka | Periféria lapka |
| 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..    |

### Pótalkatrészek

| Fúró átmérő<br>(mm) | Lapka csavar   | Lapka kulcs  | Dugó            | Hűtő adapter |      |
|---------------------|----------------|--------------|-----------------|--------------|------|
|                     |                |              |                 |              |      |
|                     | Központi lapka | Perif. lapka |                 |              |      |
| 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 |

### Kiegészítők

| Fúró átmérő<br>(mm) | Nyomaték kulcs* | Cserélhető<br>betét | Nyomaték érték |
|---------------------|-----------------|---------------------|----------------|
|                     |                 |                     |                |
| 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         |

\*Betéttel együtt.





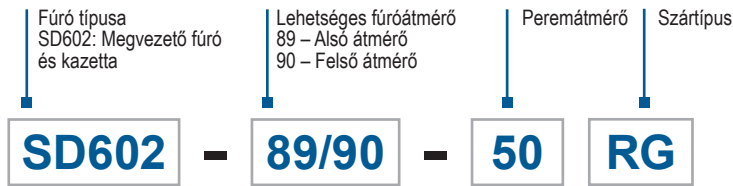
## Perfomax® SD602

A Seco Perfomax® SD602 egy moduláris fúrófej rendszer, kifejezetten mély furat alkalmazásokhoz, ahol nagy átmérőket kell fúrni biztonságosan és hatékonyan.

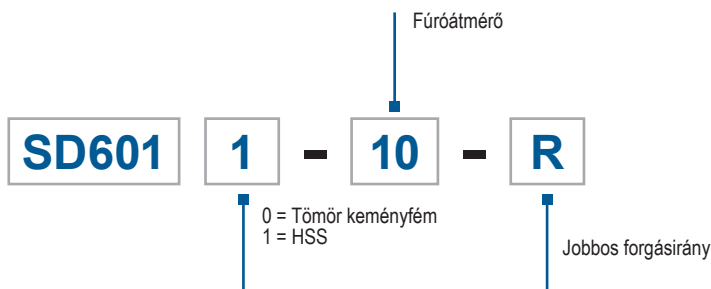
- A DP3000 lapkák megadják azt a szívósságot, ami a Perfomax® SD602 optimális használatához szükséges
- A minőség nagy előtolásokat és sebességeket tesz lehetővé
- Nagy rugalmasság a hosszabbítók révén, a kívánt fúrási mélység eléréséhez

## Jelmagyarázat

### Fúrótestek

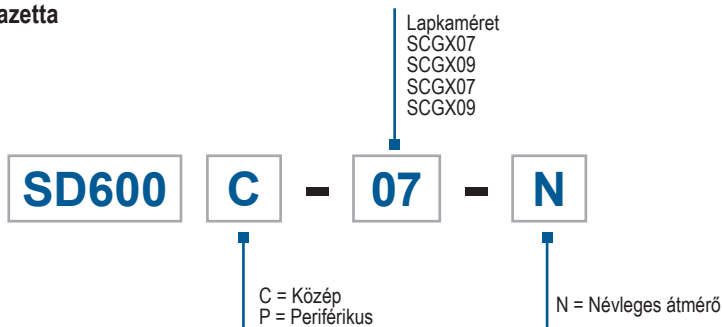


### Előfúró



(A megvezető fúrot külön kell beszerezni)

### Kazetta

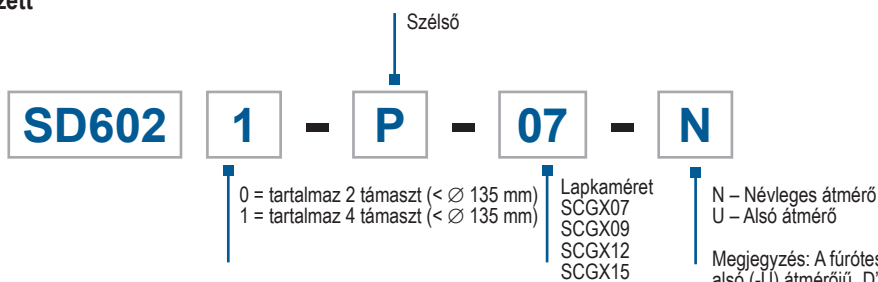


-N



-U

### Szett



-N

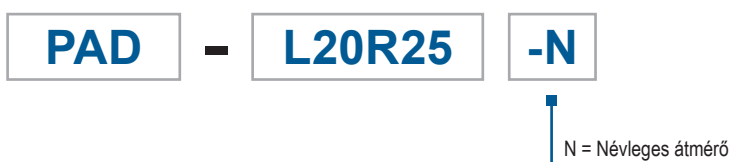


-U

### Inch

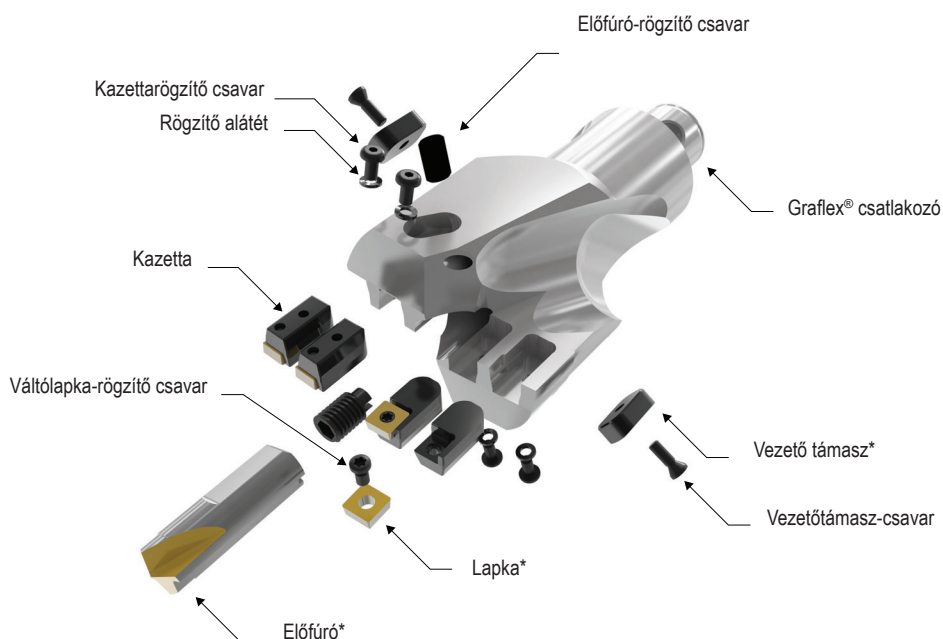


### Támasz



## Moduláris fúrófejegység

SD602-59/60-40RG



Példa: Átmérő 59; SD602-59-40RG  
A következő készlet használata: SD6020-P07\*



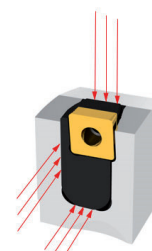
Példa: Átmérő 60; SD602-60-40RG  
A következő készlet használata: SD6020-P07-N\*

### Összeszerelési útmutató

### Kazetta és vezető támasz beszerelése

- Húzza meg a kazettarögzítő csavart
- Szerelje be a lapkákat
- Tegye be az előfúrót és rögzítse azt a furat aljára, ha szükséges a fúrót meghosszabbítani, használja az állító csavart
- Tegye fel a hosszabbítókat

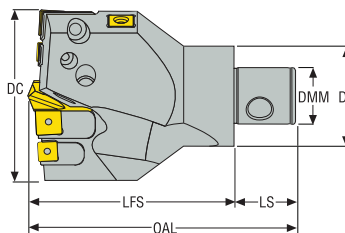
- Szerelje be a kazettát
- Bizonyosodjon meg, hogy nincs légrés a kazetta és a fal között
- Rögzítse a kazetta rögzítő csavart a nyomaték kulccsal:  
SD600-x-07: 3 Nm  
SD600-x-09: 3 Nm  
SD600-x-12: 8 Nm  
SD600-x-15: 8 Nm
- Szerelje be a vezető támaszt
- Húzza meg a támaszt rögzítő csavart



\* Nem tartozék. A periféria készletet, az előfúrót és a lapkákat külön kell megrendelni.

## SD602

SD602 - Moduláris fúró fej



- Belső hűtés
- Információ a lapkákról a 297-303 old.
- Forgácsolási adatokat lásd a 316-317 old.
- Állítható hosszúságú vezető fúró

### Tartomány

| Cikkszám | Megnevezés         | Graflex méret | DCN            | DCX            | OAL            | LFS            | LS            | DF            | DMM           | Súly          | Lapka     |
|----------|--------------------|---------------|----------------|----------------|----------------|----------------|---------------|---------------|---------------|---------------|-----------|
|          |                    |               | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |           |
| 02846688 | SD602-59/60-40RG   | G4            | 59,0<br>2.323  | 60,0<br>2.362  | 129,0<br>5.079 | 105,0<br>4.134 | 24,0<br>0.945 | 40,0<br>1.575 | 22,0<br>0.866 | 0,9<br>1.980  | SCGX07    |
| 02846689 | SD602-69/70-40RG   | G4            | 69,0<br>2.717  | 70,0<br>2.756  | 129,0<br>5.079 | 105,0<br>4.134 | 24,0<br>0.945 | 40,0<br>1.575 | 22,0<br>0.866 | 1,1<br>2.430  | SCGX09    |
| 02846690 | SD602-79/80-50RG   | G5            | 79,0<br>3.110  | 80,0<br>3.150  | 160,0<br>6.299 | 130,0<br>5.118 | 30,0<br>1.181 | 50,0<br>1.969 | 28,0<br>1.102 | 1,8<br>3.970  | SCGX09    |
| 02846691 | SD602-89/90-50RG   | G5            | 89,0<br>3.504  | 90,0<br>3.543  | 160,0<br>6.299 | 130,0<br>5.118 | 30,0<br>1.181 | 50,0<br>1.969 | 28,0<br>1.102 | 2,0<br>4.410  | SCGX09/12 |
| 02846692 | SD602-99/100-63RG  | G6            | 99,0<br>3.898  | 100,0<br>3.937 | 185,0<br>7.283 | 145,0<br>5.709 | 40,0<br>1.575 | 63,0<br>2.480 | 36,0<br>1.417 | 3,1<br>6.830  | SCGX12    |
| 02846693 | SD602-119/120-63RG | G6            | 119,0<br>4.685 | 120,0<br>4.724 | 185,0<br>7.283 | 145,0<br>5.709 | 40,0<br>1.575 | 63,0<br>2.480 | 36,0<br>1.417 | 3,5<br>7.720  | SCGX15    |
| 02846694 | SD602-139/140-90RG | G7            | 139,0<br>5.472 | 140,0<br>5.512 | 210,0<br>8.268 | 160,0<br>6.299 | 50,0<br>1.969 | 90,0<br>3.543 | 46,0<br>1.811 | 6,1<br>13.450 | SCGX12    |
| 02846695 | SD602-159/160-90RG | G7            | 159,0<br>6.260 | 160,0<br>6.299 | 210,0<br>8.268 | 160,0<br>6.299 | 50,0<br>1.969 | 90,0<br>3.543 | 46,0<br>1.811 | 6,6<br>14.550 | SCGX12/15 |
| 02846698 | SD602-2500-40RG    | G4            | 62,5<br>2.461  | 63,5<br>2.500  | 129,0<br>5.079 | 105,0<br>4.134 | 24,0<br>0.945 | 40,0<br>1.575 | 22,0<br>0.866 | 1,0<br>2.200  | SCGX07    |
| 02846699 | SD602-2750-40RG    | G4            | 68,85<br>2.711 | 69,85<br>2.750 | 129,0<br>5.079 | 105,0<br>4.134 | 24,0<br>0.945 | 40,0<br>1.575 | 22,0<br>0.866 | 1,1<br>2.430  | SCGX07/09 |
| 02846700 | SD602-3000-40RG    | G4            | 75,2<br>2.961  | 76,2<br>3.000  | 129,0<br>5.079 | 105,0<br>4.134 | 24,0<br>0.945 | 40,0<br>1.575 | 22,0<br>0.866 | 1,1<br>2.430  | SCGX09    |
| 02846701 | SD602-3250-50RG    | G5            | 81,55<br>3.211 | 82,55<br>3.250 | 160,0<br>6.299 | 130,0<br>5.118 | 30,0<br>1.181 | 50,0<br>1.969 | 28,0<br>1.102 | 1,8<br>3.970  | SCGX09/12 |
| 02846702 | SD602-3500-50RG    | G5            | 87,9<br>3.461  | 88,9<br>3.500  | 160,0<br>6.299 | 130,0<br>5.118 | 30,0<br>1.181 | 50,0<br>1.969 | 28,0<br>1.102 | 1,9<br>4.190  | SCGX09/12 |
| 02846703 | SD602-4000-63RG    | G6            | 100,6<br>3.961 | 101,6<br>4.000 | 185,0<br>7.283 | 145,0<br>5.709 | 40,0<br>1.575 | 63,0<br>2.480 | 36,0<br>1.417 | 3,2<br>7.050  | SCGX12    |

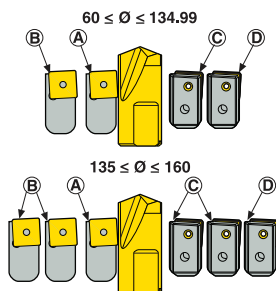
### Pótalkatrészek

| Kazetta    | Kazetta      | Kazetta csavar | Alátét | Lapka csavar | Lapka kulcs     | Vezető támasz* | Vezető támasz* | Támasz csavar |
|------------|--------------|----------------|--------|--------------|-----------------|----------------|----------------|---------------|
|            |              |                |        |              |                 |                |                |               |
| 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   |

\*Nem tartalmazza a szállítást

# SD602

SD602 - Moduláris fúró fej



## Pótalkatrészek

| Megnevezés         | Fúró átmérő (mm) | Fúró átmérő (inch) | Előfúró csavar | Állító csavar | Kazetta (A) | Kazetta (B) | Kazetta (C) | Periféria készlet* (D) | Előfúró*<br>x=0 Tömör keményfém<br>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                                |

\*Nem tartalmazza a szállítást. Periféria készlet, U-méret alatti, N-névleges  
Lapok méretét lásd a 297-303 old.

## Újraélezési utasítások az SD602 típusúhoz

### Utasítások:

Gyémánt korongokhoz javasolt előírások:

Kúp hátszög: korong típusa: 12A2, szemcse méret D54 (1.kép).

Vágás: korong típusa 1A1 vagy 1V1, szemcse mérete D64-D46 (2. és 3. kép).

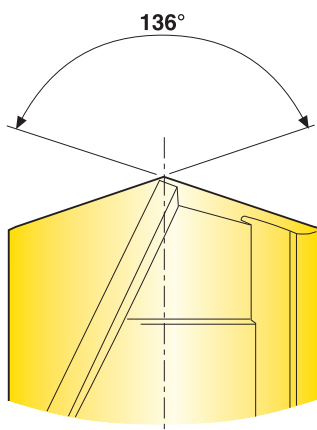
Sarok letörés: korong típusa 1A1 vagy 12A2 (1. kép).

Él kezelés: K-felület köszörülés vagy élettörés (2. kép).

### Fontos:

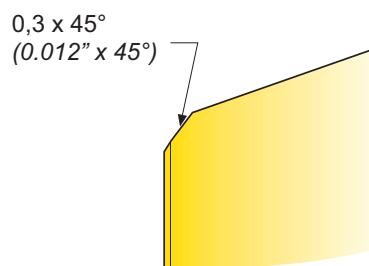
- A vágóéleknek szimmetrikusnak kell lenniük és az élalakításnak is egyeznie kell.
- Az élalakítást alkalmazni kell a teljes élhosszon.

#### 1. Csúcshög

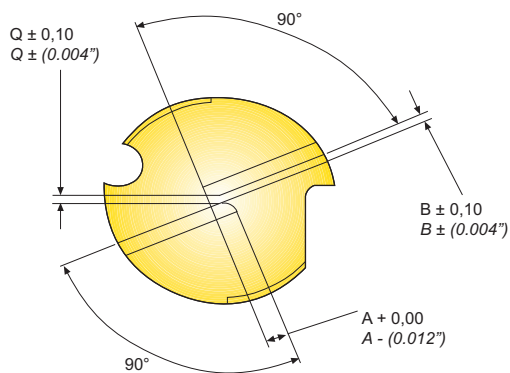


Élalakítás, 0–0,1 mm (0–0.004") x 20°. Fúróhegy hátszöge 10°.

#### 2. Élettörés



#### 3.

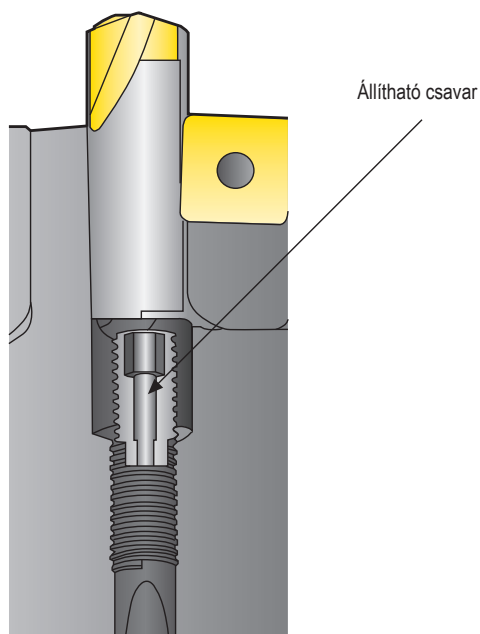


#### 4.

| Átmérő | Méretek mm-ben (inch) |                |                 |                 |
|--------|-----------------------|----------------|-----------------|-----------------|
|        | A                     | B              | C               | Minimális hossz |
| 10 mm  | 1,5<br>(0.059)        | 0,5<br>(0.020) | 0,57<br>(0.022) | 38<br>(1.496)   |
| 15 mm  | 1,5<br>(0.059)        | 0,6<br>(0.024) | 0,68<br>(0.027) | 45<br>(1.772)   |
| 25 mm  | 1,5<br>(0.059)        | 1,4<br>(0.055) | 1,6<br>(0.063)  | 57<br>(2.244)   |

## Moduláris fúrófejegység

## Tulajdonság: Állítható előfúró



## Állítható hosszávolsága ADJRG

| Fúró               | mm  | inch  |
|--------------------|-----|-------|
| 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 |

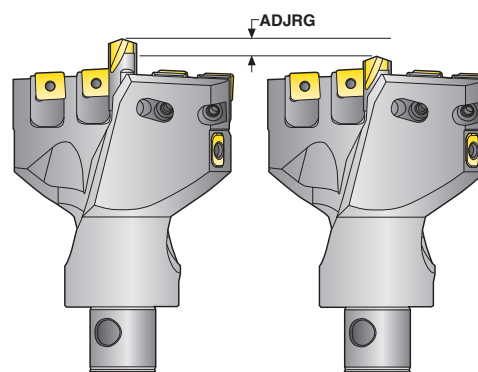
## Tulajdonság: Állítható hosszúságú

Előnyök: Az előfúró újraélezését követően azonos hosszbeállítás.

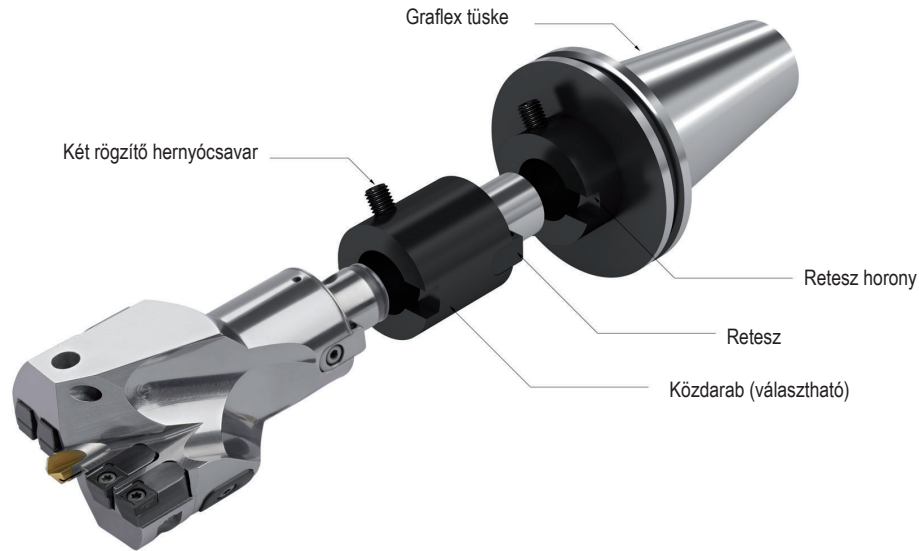
Az előfúró kinyúlási hosszának állítási lehetősége.

Az > 5 x D fúrási mélységek esetén javasolt 5 mm-rel (0.197") kifelé távolabbra állítani.

Javaslat: Ha az előfúró újra behatol a furatba, azt az eredeti pozíciójától 3 mm-rel (0.118") távolabb kell állítani, hogy biztosított legyen a jobb központosítás.

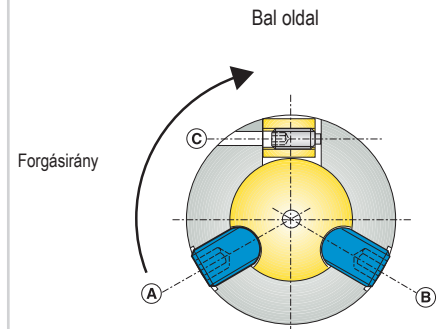
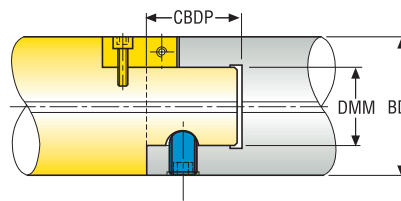


## Moduláris fúrófejegység



### Összeszerelési útmutató

1. Tisztítsa meg az összeszerelni kívánt alkatrészeket, és vigyen fel vékony, oxidációt gátló védőréteget.
2. Szerelje össze az alkatrészeket úgy, hogy a csap bal felülete a horony bal felületének szoruljon neki.
3. Húzza meg kissé az A csavart (a fúrófejet kissé előre-hátra mozgatva meg kell keresni az A csavar számára a legalacsonyabb pontot).
4. Húzza meg kissé a B csavart.
5. Húzza meg nyomatékkal a C rögzítő csavart.
6. Húzza meg nyomatékkal az A csavart.
7. Húzza meg nyomatékkal a B csavart.
8. Ellenőrizze újra a rögzítő csavar meghúzását.



### Graflex csatlakozók ajánlott meghúzási nyomatéka

| Graflex méret | DMM<br>mm<br>(inch) | BD<br>mm<br>(inch) | CBDDP<br>mm<br>(inch) | Gömbvégű csavarok, (A és B) | Retszrögzítő csavar (C) |
|---------------|---------------------|--------------------|-----------------------|-----------------------------|-------------------------|
| 4             | 22<br>(0.866)       | 40<br>(1.575)      | 24<br>(0.945)         | 20 Nm<br>(14.7 ft/lbs)      | 0,7 Nm<br>(0.5 ft/lbs)  |
| 5             | 28<br>(1.102)       | 50<br>(1.969)      | 30<br>(1.181)         | 25 Nm<br>(18.4 ft/lbs)      | 2 Nm<br>(1.5 ft/lbs)    |
| 6             | 36<br>(1.417)       | 63<br>(2.480)      | 40<br>(1.575)         | 35 Nm<br>(25.8 ft/lbs)      | 4 Nm<br>(2.9 ft/lbs)    |
| 7             | 46<br>(1.811)       | 90<br>(3.543)      | 50<br>(1.969)         | 60 Nm<br>(44.2 ft/lbs)      | 8 Nm<br>(5.9 ft/lbs)    |



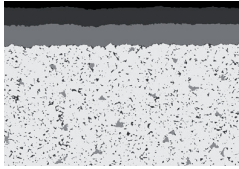
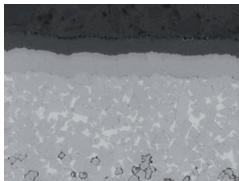
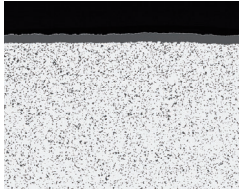
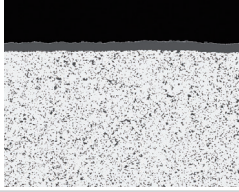
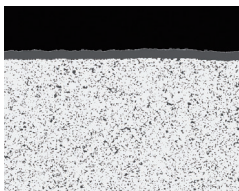
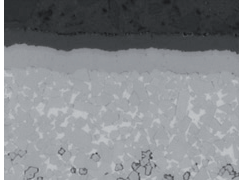
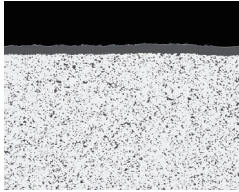
## Lapka minőségek

### Tulajdonságok:

- 4 vágóél lapkánként
- Erős négyszögletes lapka

### Előnyök:

- Gazdaságosság
- Megbízhatóság
- Teljesítmény
- Alacsony furatonkénti költség

| Periféria |   |   |
|-----------|---|---|
| DP2000    |    | DURATOMIC® bevonatolási technológia<br>Optimalizált minőség acél és öntöttvas megmunkálásra<br>Nagyon magas forgácsolási sebességekhez<br>Egyedi kombinációja a kiváló él szívósságnak és egy vastag kopásálló bevonatnak Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC® |
| DP3000    |    | DURATOMIC® technológiájú bevonat<br>Univezális minőség<br>Magas kopásállóság és élszívóság<br>Szívós minőség a maximális megmunkálási biztonságért<br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC®<br>Gradiens alapkeményfém   |
| T250D     |   | Alkalmas kemény anyagokhoz<br>Első választás alumíniumhoz<br>Szívós mikroszemcsés TiAlN bevonat biztosítja<br>- Kükönlegesen jó keménység<br>- Különösen ellenálló kémiai és oxidációs kopásnak<br>PVD bevonat<br>(Ti, Al)N + TiN   |
| DS2050    |  | Optimalizált minőség titánhoz, szuperötvözetekhez és nehezen megmunkálható korrózióálló acélokhoz<br>PVD bevonat<br>TiAlN + NbN   |
| Központi  |   |   |
| T400D     |  | Első választás<br>Szívós központi lapka minőség a megmunkálási biztonságért<br>PVD bevonatos<br>(Ti, Al)N + TiN   |
| DP3000    |  | DURATOMIC® technológiájú bevonat<br>Univezális minőség<br>Magas kopásállóság és élszívóság<br>Szívós minőség a maximális megmunkálási biztonságért<br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC®<br>Gradiens alapkeményfém   |
| DS4050    |  | Optimalizált minőség titánhoz, szuperötvözetekhez és nehezen megmunkálható korrózióálló acélokhoz<br>PVD bevonat<br>TiAlN + NbN   |

## Geometriák



| 1. Lapka alak   |                     |              | 2. Lapka hátszögek  |                   | 4. Típus  |                   |  |                  |                   |                    |                  |                    |                   |
|---|---------------------|--------------|---|-------------------|---|-------------------|--|------------------|-------------------|--------------------|------------------|--------------------|-------------------|
|   |                     |              |   |                   | X=Speciális   |                   |  |                  |                   |                    |                  |                    |                   |
| 3. Tűrések  |                     |              | 5. Forgácsoló él hossz  |                   |   |                   |  |                  |                   |                    |                  |                    |                   |
|   | Tűrés +/- mm (inch) |              | IC méret mm-ben (inch)  |                   |   |                   |  |                  |                   |                    |                  |                    |                   |
| Tűr. oszt.  |                     |              |   | 5,566<br>(0.2187) | 6,35<br>(0.2500)  | 7,937<br>(0.3125) |  | 7,94<br>(0.3126) | 9,525<br>(0.3750) | 11,509<br>(0.4531) | 12,7<br>(0.5000) | 15,875<br>(0.6250) | 19,05<br>(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)  |                   |   |                   |  |                  |                   | •                  |                  |                    |                   |
| 6. Vastagság  |                     |              | 7. Lapka élettörés/csúcs rádiusz  |                   | 10. Furatkés megnevezés   |                   |  |                  |                   |                    |                  |                    |                   |
| <p>02 = 2,38 mm (0.094")<br/>03 = 3,18 mm (0.125")<br/>T3 = 3,97 mm (0.156")</p> <p>04 = 4,76 mm (0.187")<br/>05 = 5,56 mm (0.219")</p> |                     |              | <p>04 = 0,4 mm (0.016")<br/>08 = 0,8 mm (0.031")<br/>12 = 1,2 mm (0.047")<br/>stb.</p> <p>csúcs rádiusz</p> |                   | pl. forgácsoló megnevezés<br><br>P1 = xx<br>P2 = xx<br>85 = xx<br>86 = xx |                   |  |                  |                   |                    |                  |                    |                   |

Bevezetés

Fúrás

Dörzsárazás

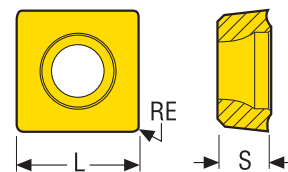
Késztergálás

Melléklet

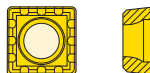
## Váltólapkák – Periféria lapka, P1\*

típus SD522, SD523, SD524, SD525, SD542, SD602

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



SCGX-P1

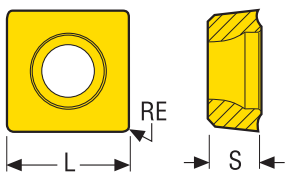


| Megnevezés    | Lapkák  | L      |       |       | S     |     |       | RE       |          |          | Minőségek |  |  |
|---------------|---------|--------|-------|-------|-------|-----|-------|----------|----------|----------|-----------|--|--|
|               |         | mm     | Inch  | mm    | Inch  | mm  | Inch  | 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 |           |  |  |

\*Forgácstörő alacsony előtolásokhoz és jó felületi minőséghez minden anyaghoz

## Váltólapkák – Periféria lapka, P2\*

tipus SD522, SD523, SD524, SD525, SD542, SD602



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

SCGX-P2



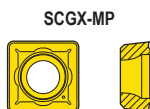
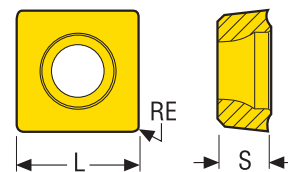
| Megnevezés    | Lapkák  | L      |       | S    |       | RE  |       | Minőségek |          |          |
|---------------|---------|--------|-------|------|-------|-----|-------|-----------|----------|----------|
|               |         | mm     | Inch  | mm   | Inch  | mm  | Inch  | T250D     | 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 |

\*\*Forgácstörő nagy előtolásokhoz acélban, korrózióállóacélban és öntöttvasban.

## Váltólapkák – Periféria lapka, típus MP

típus SD522, SD523, SD524, SD525, SD542, SD602

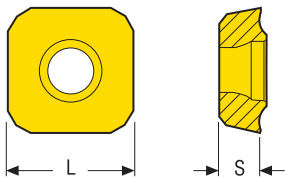
Tűrések:  
 $L = \pm 0,025$  (0.001 in)  
 $S = \pm 0,13$  (0.005 in)  
 $RE = \pm 0,1$  (0.004 in)



| Megnevezés    | Lapkák  | L      |       | S    |       | RE  |       | Minőségek |
|---------------|---------|--------|-------|------|-------|-----|-------|-----------|
|               |         | mm     | Inch  | mm   | Inch  | mm  | Inch  |           |
| 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  |

## Váltólapkák – Központi lapka, C1\*

tipus SD522, SD523, SD524, SD525, SD542



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

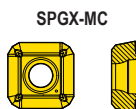
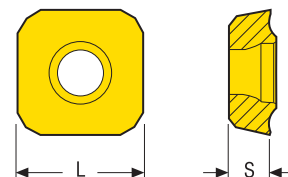
SPGX-C1



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

## Váltólapkák – Központi lapka, MC

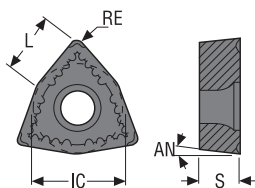
típus SD522, SD523, SD524, SD525, SD542

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

| Megnevezés  | Lapkák  | L      |       | S    |       | Minőségek |
|-------------|---------|--------|-------|------|-------|-----------|
|             |         | mm     | Inch  | mm   | Inch  |           |
|             |         |        |       |      |       | 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  |

## Váltólapkák – Periféria lapka, 85\*

tipus SD572



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

WCMX-85



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

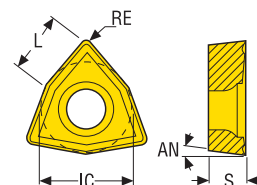
\* Forgácstörő alacsony előtolásokhoz és jó felületi minőséghez minden anyaghoz



## Központi lapka és periférikus lapka 86-típus\*\*

típus SD572

Tűrések:  
S =  $\pm 0,13$  (0.005 in)  
RE =  $\pm 0,1$  (0.004 in)



WCMX-86



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

\*\* Forgácstörő nagy előtolásokhoz acélban, korrózióálló acélban és öntöttvasban.

## SD522 Ø 15-60 mm / 0.590-2.375 inch

| SMG |           | f                              |                                |                                |                                |                                |                                |                                | v <sub>c</sub> |
|-----|-----------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|----------------|
|     |           | Ø 15,00-19,49<br>Ø 0.590-0.767 | Ø 19,50-22,49<br>Ø 0.768-0.885 | Ø 22,50-28,49<br>Ø 0.886-1.121 | Ø 28,50-34,49<br>Ø 1.122-1.357 | Ø 34,50-40,49<br>Ø 1.358-1.593 | Ø 40,49-44,49<br>Ø 1.594-1.751 | Ø 44,50-59,99<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD522 Vágósebesség

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

SMG = Seco anyag csoport V<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD523 Ø 15-60 mm / 0.590-2.375 inch

| SMG |           | f                              |                                |                                |                                |                                |                                |                                | v <sub>c</sub> |
|-----|-----------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|----------------|
|     |           | Ø 15,00-19,49<br>Ø 0.590-0.767 | Ø 19,50-22,49<br>Ø 0.768-0.885 | Ø 22,50-28,49<br>Ø 0.886-1.121 | Ø 28,50-34,49<br>Ø 1.122-1.357 | Ø 34,50-40,49<br>Ø 1.358-1.593 | Ø 40,49-44,49<br>Ø 1.594-1.751 | Ø 44,50-59,99<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD523 Vágósebesség

| SMG | v <sub>c</sub> |        |       |        |
|-----|----------------|--------|-------|--------|
|     | DP2000         | DP3000 | T250D | DS2050 |
| P1  | 415            | 370    | 265   | 370    |
|     | 1350           | 1225   | 870   | 1225   |
| P2  | 405            | 360    | 260   | 360    |
|     | 1325           | 1175   | 850   | 1175   |
| P3  | 345            | 310    | 225   | 310    |
|     | 1125           | 1025   | 740   | 1025   |
| P4  | 230            | 190    | 120   | —      |
|     | 750            | 620    | 395   | —      |
| P5  | 220            | 180    | 115   | —      |
|     | 720            | 590    | 375   | —      |
| P6  | 250            | 200    | 130   | —      |
|     | 820            | 660    | 425   | —      |
| P7  | 235            | 190    | 120   | —      |
|     | 770            | 620    | 395   | —      |
| P8  | 220            | 180    | 115   | —      |
|     | 720            | 590    | 375   | —      |
| P11 | 225            | 185    | 115   | —      |
|     | 740            | 610    | 375   | —      |
| P12 | 135            | 110    | 70    | —      |
|     | 445            | 360    | 230   | —      |
| M1  | —              | 245    | 135   | —      |
|     | —              | 800    | 445   | —      |
| M2  | —              | 195    | 110   | —      |
|     | —              | 640    | 360   | —      |
| M3  | —              | 150    | 85    | 150    |
|     | —              | 490    | 280   | 490    |
| M4  | —              | 115    | 65    | 120    |
|     | —              | 375    | 215   | 395    |
| M5  | —              | 95     | 55    | 100    |
|     | —              | 310    | 180   | 330    |
| K1  | 225            | 215    | —     | —      |
|     | 740            | 710    | —     | —      |
| K2  | 195            | 185    | —     | —      |
|     | 640            | 610    | —     | —      |
| K3  | 165            | 160    | —     | —      |
|     | 540            | 520    | —     | —      |
| K4  | 160            | 150    | —     | —      |
|     | 520            | 490    | —     | —      |
| K5  | 95             | 90     | —     | —      |
|     | 310            | 295    | —     | —      |
| N1  | —              | 360    | 310   | 310    |
|     | —              | 1175   | 1025  | 1025   |
| N2  | —              | 230    | 200   | 200    |
|     | —              | 750    | 660   | 660    |
| N3  | —              | 155    | 135   | 135    |
|     | —              | 510    | 445   | 445    |
| N11 | —              | 300    | 260   | 260    |
|     | —              | 980    | 850   | 850    |
| S1  | —              | —      | 34    | 55     |
|     | —              | —      | 110   | 180    |
| S2  | —              | —      | 25    | 43     |
|     | —              | —      | 80    | 140    |
| S3  | —              | —      | 25    | 37     |
|     | —              | —      | 80    | 120    |
| S11 | —              | —      | 65    | 75     |
|     | —              | —      | 215   | 245    |
| S12 | —              | —      | 50    | 60     |
|     | —              | —      | 165   | 195    |
| S13 | —              | —      | 39    | 45     |
|     | —              | —      | 130   | 150    |
| H3  | —              | 60     | 60    | —      |
|     | —              | 195    | 195   | —      |
| H5  | —              | 115    | 110   | —      |
|     | —              | 375    | 360   | —      |
| H7  | —              | 60     | 60    | —      |
|     | —              | 195    | 195   | —      |
| H8  | —              | 115    | 110   | —      |
|     | —              | 375    | 360   | —      |
| H11 | —              | 145    | 140   | —      |
|     | —              | 475    | 460   | —      |
| H12 | —              | 65     | 130   | —      |
|     | —              | 215    | 425   | —      |
| H21 | —              | 115    | 110   | —      |
|     | —              | 375    | 360   | —      |

SMG = Seco anyag csoport v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD524 Ø 17-60 mm / 0.590-2.375 inch

| SMG |           | f                              |                                |                                |                                |                                |                                |                                | v <sub>c</sub> |
|-----|-----------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|----------------|
|     |           | Ø 15,00-19,49<br>Ø 0.590-0.767 | Ø 19,50-22,49<br>Ø 0.768-0.885 | Ø 22,50-28,49<br>Ø 0.886-1.121 | Ø 28,50-34,49<br>Ø 1.122-1.357 | Ø 34,50-40,49<br>Ø 1.358-1.593 | Ø 40,49-44,49<br>Ø 1.594-1.751 | Ø 44,50-59,99<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsarázás

Képzőtergálás

Melléklet

## SD524 Vágósebesség

| SMG | v <sub>c</sub> |        |       |        |
|-----|----------------|--------|-------|--------|
|     | DP2000         | DP3000 | T250D | DS2050 |
| P1  | 380            | 340    | 230   | 340    |
|     | 1250           | 1125   | 750   | 1125   |
| P2  | 370            | 330    | 225   | 330    |
|     | 1225           | 1075   | 740   | 1075   |
| P3  | 320            | 285    | 195   | 285    |
|     | 1050           | 940    | 640   | 940    |
| P4  | 195            | 165    | 105   | —      |
|     | 640            | 540    | 345   | —      |
| P5  | 185            | 160    | 100   | —      |
|     | 610            | 520    | 330   | —      |
| P6  | 210            | 180    | 110   | —      |
|     | 690            | 590    | 360   | —      |
| P7  | 195            | 170    | 105   | —      |
|     | 640            | 560    | 345   | —      |
| P8  | 185            | 160    | 100   | —      |
|     | 610            | 520    | 330   | —      |
| P11 | 190            | 165    | 100   | —      |
|     | 620            | 540    | 330   | —      |
| P12 | 110            | 95     | 60    | —      |
|     | 360            | 310    | 195   | —      |
| M1  | —              | 235    | 120   | —      |
|     | —              | 770    | 395   | —      |
| M2  | —              | 190    | 95    | —      |
|     | —              | 620    | 310   | —      |
| M3  | —              | 145    | 75    | 145    |
|     | —              | 475    | 245   | 475    |
| M4  | —              | 110    | 55    | 105    |
|     | —              | 360    | 180   | 345    |
| M5  | —              | 90     | 46    | 90     |
|     | —              | 295    | 150   | 295    |
| K1  | 210            | 200    | —     | —      |
|     | 690            | 660    | —     | —      |
| K2  | 180            | 170    | —     | —      |
|     | 590            | 560    | —     | —      |
| K3  | 155            | 145    | —     | —      |
|     | 510            | 475    | —     | —      |
| K4  | 145            | 140    | —     | —      |
|     | 475            | 460    | —     | —      |
| K5  | 85             | 85     | —     | —      |
|     | 280            | 280    | —     | —      |
| N1  | —              | 315    | 270   | 270    |
|     | —              | 1025   | 890   | 890    |
| N2  | —              | 205    | 175   | 175    |
|     | —              | 670    | 570   | 570    |
| N3  | —              | 135    | 115   | 115    |
|     | —              | 445    | 375   | 375    |
| N11 | —              | 265    | 230   | 230    |
|     | —              | 870    | 750   | 750    |
| S1  | —              | —      | 29    | 48     |
|     | —              | —      | 95    | 155    |
| S2  | —              | —      | 22    | 39     |
|     | —              | —      | 70    | 130    |
| S3  | —              | —      | 22    | 33     |
|     | —              | —      | 70    | 110    |
| S11 | —              | —      | 55    | 70     |
|     | —              | —      | 180   | 230    |
| S12 | —              | —      | 44    | 55     |
|     | —              | —      | 145   | 180    |
| S13 | —              | —      | 34    | 41     |
|     | —              | —      | 110   | 135    |
| H3  | —              | 55     | 50    | —      |
|     | —              | 180    | 165   | —      |
| H5  | —              | 100    | 95    | —      |
|     | —              | 330    | 310   | —      |
| H7  | —              | 55     | 50    | —      |
|     | —              | 180    | 165   | —      |
| H8  | —              | 100    | 95    | —      |
|     | —              | 330    | 310   | —      |
| H11 | —              | 125    | 125   | —      |
|     | —              | 410    | 410   | —      |
| H12 | —              | 55     | 110   | —      |
|     | —              | 180    | 360   | —      |
| H21 | —              | 100    | 95    | —      |
|     | —              | 330    | 310   | —      |

SMG = Seco anyag csoport v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD525 Ø 19-45 mm / 0.768-2.000 inch

| SMG |           | f                              |                                |                                |                                |                                | v <sub>c</sub> |
|-----|-----------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|----------------|
|     |           | Ø 19,50-22,49<br>Ø 0.768-0.885 | Ø 22,50-28,49<br>Ø 0.886-1.121 | Ø 28,50-34,49<br>Ø 1.122-1.357 | Ø 34,50-40,49<br>Ø 1.358-1.593 | Ø 40,49-45,00<br>Ø 1.594-2.000 |                |
| P1  | P2 DP3000 | 0,070                          | 0,085                          | 0,095                          | 0,11                           | 0,12                           | 320            |
|     | P2 DP3000 | 0,0028                         | 0,0034                         | 0,0038                         | 0,0044                         | 0,0048                         | 1050           |
| P2  | P2 DP3000 | 0,070                          | 0,085                          | 0,10                           | 0,11                           | 0,12                           | 310            |
|     | P2 DP3000 | 0,0028                         | 0,0034                         | 0,0040                         | 0,0044                         | 0,0048                         | 1025           |
| P3  | P2 DP3000 | 0,14                           | 0,17                           | 0,19                           | 0,22                           | 0,22                           | 265            |
|     | P2 DP3000 | 0,0055                         | 0,0065                         | 0,0075                         | 0,0085                         | 0,0085                         | 870            |
| P4  | P2 DP3000 | 0,13                           | 0,16                           | 0,19                           | 0,22                           | 0,22                           | 150            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0075                         | 0,0085                         | 0,0085                         | 490            |
| P5  | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 140            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 460            |
| P6  | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 160            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 520            |
| P7  | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 150            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 490            |
| P8  | P2 DP3000 | 0,14                           | 0,17                           | 0,19                           | 0,22                           | 0,22                           | 140            |
|     | P2 DP3000 | 0,0055                         | 0,0065                         | 0,0075                         | 0,0085                         | 0,0085                         | 460            |
| P11 | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 145            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 475            |
| P12 | P2 DP3000 | 0,090                          | 0,11                           | 0,12                           | 0,14                           | 0,15                           | 85             |
|     | P2 DP3000 | 0,0036                         | 0,0044                         | 0,0048                         | 0,0055                         | 0,0060                         | 280            |
| M1  | P2 DP3000 | 0,10                           | 0,12                           | 0,14                           | 0,16                           | 0,17                           | 225            |
|     | P2 DP3000 | 0,0040                         | 0,0048                         | 0,0055                         | 0,0065                         | 0,0065                         | 740            |
| M2  | P2 DP3000 | 0,090                          | 0,11                           | 0,13                           | 0,14                           | 0,15                           | 180            |
|     | P2 DP3000 | 0,0036                         | 0,0044                         | 0,0050                         | 0,0055                         | 0,0060                         | 590            |
| M3  | MP DS2050 | 0,075                          | 0,090                          | 0,10                           | 0,12                           | 0,13                           | 140            |
|     | MP DS2050 | 0,0030                         | 0,0036                         | 0,0040                         | 0,0048                         | 0,0050                         | 460            |
| M4  | MP DS2050 | 0,065                          | 0,080                          | 0,090                          | 0,10                           | 0,11                           | 95             |
|     | MP DS2050 | 0,0026                         | 0,0032                         | 0,0036                         | 0,0040                         | 0,0044                         | 310            |
| M5  | MP DS2050 | 0,065                          | 0,080                          | 0,090                          | 0,10                           | 0,11                           | 80             |
|     | MP DS2050 | 0,0026                         | 0,0032                         | 0,0036                         | 0,0040                         | 0,0044                         | 260            |
| K1  | P2 DP3000 | 0,14                           | 0,17                           | 0,20                           | 0,22                           | 0,24                           | 185            |
|     | P2 DP3000 | 0,0055                         | 0,0065                         | 0,0080                         | 0,0085                         | 0,0095                         | 610            |
| K2  | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 160            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 520            |
| K3  | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 135            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 445            |
| K4  | P2 DP3000 | 0,13                           | 0,16                           | 0,18                           | 0,20                           | 0,22                           | 130            |
|     | P2 DP3000 | 0,0050                         | 0,0065                         | 0,0070                         | 0,0080                         | 0,0085                         | 425            |
| K5  | P2 DP3000 | 0,11                           | 0,14                           | 0,16                           | 0,18                           | 0,19                           | 80             |
|     | P2 DP3000 | 0,0044                         | 0,0055                         | 0,0065                         | 0,0070                         | 0,0075                         | 260            |
| N1  | P1 T250D  | 0,14                           | 0,17                           | 0,20                           | 0,22                           | 0,24                           | 240            |
|     | P1 T250D  | 0,0055                         | 0,0065                         | 0,0080                         | 0,0085                         | 0,0095                         | 790            |
| N2  | P1 T250D  | 0,14                           | 0,17                           | 0,20                           | 0,22                           | 0,24                           | 155            |
|     | P1 T250D  | 0,0055                         | 0,0065                         | 0,0080                         | 0,0085                         | 0,0095                         | 510            |
| N3  | P1 T250D  | 0,14                           | 0,17                           | 0,20                           | 0,22                           | 0,24                           | 100            |
|     | P1 T250D  | 0,0055                         | 0,0065                         | 0,0080                         | 0,0085                         | 0,0095                         | 330            |
| N11 | P1 T250D  | 0,14                           | 0,17                           | 0,20                           | 0,22                           | 0,24                           | 200            |
|     | P1 T250D  | 0,0055                         | 0,0065                         | 0,0080                         | 0,0085                         | 0,0095                         | 660            |
| S1  | MP DS2050 | 0,11                           | 0,13                           | 0,15                           | 0,17                           | 0,18                           | 44             |
|     | MP DS2050 | 0,0044                         | 0,0050                         | 0,0060                         | 0,0065                         | 0,0070                         | 145            |
| S2  | MP DS2050 | 0,11                           | 0,13                           | 0,15                           | 0,17                           | 0,18                           | 36             |
|     | MP DS2050 | 0,0044                         | 0,0050                         | 0,0060                         | 0,0065                         | 0,0070                         | 120            |
| S3  | MP DS2050 | 0,10                           | 0,12                           | 0,14                           | 0,16                           | 0,17                           | 31             |
|     | MP DS2050 | 0,0040                         | 0,0048                         | 0,0055                         | 0,0065                         | 0,0065                         | 100            |
| S11 | MP DS2050 | 0,12                           | 0,15                           | 0,17                           | 0,19                           | 0,20                           | 65             |
|     | MP DS2050 | 0,0048                         | 0,0060                         | 0,0065                         | 0,0075                         | 0,0080                         | 215            |
| S12 | MP DS2050 | 0,12                           | 0,15                           | 0,17                           | 0,19                           | 0,20                           | 49             |
|     | MP DS2050 | 0,0048                         | 0,0060                         | 0,0065                         | 0,0075                         | 0,0080                         | 160            |
| S13 | MP DS2050 | 0,11                           | 0,13                           | 0,15                           | 0,17                           | 0,18                           | 38             |
|     | MP DS2050 | 0,0044                         | 0,0050                         | 0,0060                         | 0,0065                         | 0,0070                         | 125            |
| H3  | P1 T250D  | 0,060                          | 0,070                          | 0,085                          | 0,095                          | 0,10                           | 46             |
|     | P1 T250D  | 0,0024                         | 0,0028                         | 0,0034                         | 0,0038                         | 0,0040                         | 150            |
| H5  | P1 T250D  | 0,090                          | 0,11                           | 0,12                           | 0,14                           | 0,15                           | 85             |
|     | P1 T250D  | 0,0036                         | 0,0044                         | 0,0048                         | 0,0055                         | 0,0060                         | 280            |
| H7  | P1 T250D  | 0,060                          | 0,070                          | 0,085                          | 0,095                          | 0,10                           | 46             |
|     | P1 T250D  | 0,0024                         | 0,0028                         | 0,0034                         | 0,0038                         | 0,0040                         | 150            |
| H8  | P1 T250D  | 0,070                          | 0,085                          | 0,095                          | 0,11                           | 0,11                           | 85             |
|     | P1 T250D  | 0,0028                         | 0,0034                         | 0,0038                         | 0,0044                         | 0,0044                         | 280            |
| H11 | P1 T250D  | 0,090                          | 0,11                           | 0,12                           | 0,14                           | 0,15                           | 110            |
|     | P1 T250D  | 0,0036                         | 0,0044                         | 0,0048                         | 0,0055                         | 0,0060                         | 360            |
| H12 | P1 T250D  | 0,070                          | 0,085                          | 0,095                          | 0,11                           | 0,11                           | 100            |
|     | P1 T250D  | 0,0028                         | 0,0034                         | 0,0038                         | 0,0044                         | 0,0044                         | 330            |
| H21 | P1 T250D  | 0,070                          | 0,085                          | 0,095                          | 0,11                           | 0,11                           | 85             |
|     | P1 T250D  | 0,0028                         | 0,0034                         | 0,0038                         | 0,0044                         | 0,0044                         | 280            |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték



## SD525 Vágósebesség

| SMG | v <sub>c</sub> |        |       |        |
|-----|----------------|--------|-------|--------|
|     | DP2000         | DP3000 | T250D | DS2050 |
| P1  | 355            | 320    | 205   | 320    |
|     | 1175           | 1050   | 670   | 1050   |
| P2  | 345            | 310    | 200   | 310    |
|     | 1125           | 1025   | 660   | 1025   |
| P3  | 295            | 265    | 170   | 265    |
|     | 970            | 870    | 560   | 870    |
| P4  | 165            | 150    | 90    | —      |
|     | 540            | 490    | 295   | —      |
| P5  | 155            | 140    | 90    | —      |
|     | 510            | 460    | 295   | —      |
| P6  | 175            | 160    | 100   | —      |
|     | 570            | 520    | 330   | —      |
| P7  | 165            | 150    | 95    | —      |
|     | 540            | 490    | 310   | —      |
| P8  | 155            | 140    | 90    | —      |
|     | 510            | 460    | 295   | —      |
| P11 | 160            | 145    | 90    | —      |
|     | 520            | 475    | 295   | —      |
| P12 | 95             | 85     | 55    | —      |
|     | 310            | 280    | 180   | —      |
| M1  | —              | 225    | 105   | —      |
|     | —              | 740    | 345   | —      |
| M2  | —              | 180    | 85    | —      |
|     | —              | 590    | 280   | —      |
| M3  | —              | 140    | 65    | 140    |
|     | —              | 460    | 215   | 460    |
| M4  | —              | 105    | 49    | 95     |
|     | —              | 345    | 160   | 310    |
| M5  | —              | 85     | 41    | 80     |
|     | —              | 280    | 135   | 260    |
| K1  | 195            | 185    | —     | —      |
|     | 640            | 610    | —     | —      |
| K2  | 170            | 160    | —     | —      |
|     | 560            | 520    | —     | —      |
| K3  | 145            | 135    | —     | —      |
|     | 475            | 445    | —     | —      |
| K4  | 140            | 130    | —     | —      |
|     | 460            | 425    | —     | —      |
| K5  | 80             | 80     | —     | —      |
|     | 260            | 260    | —     | —      |
| N1  | —              | 285    | 240   | 240    |
|     | —              | 940    | 790   | 790    |
| N2  | —              | 185    | 155   | 155    |
|     | —              | 610    | 510   | 510    |
| N3  | —              | 120    | 100   | 100    |
|     | —              | 395    | 330   | 330    |
| N11 | —              | 235    | 200   | 200    |
|     | —              | 770    | 660   | 660    |
| S1  | —              | —      | 26    | 44     |
|     | —              | —      | 85    | 145    |
| S2  | —              | —      | 20    | 36     |
|     | —              | —      | 65    | 120    |
| S3  | —              | —      | 20    | 31     |
|     | —              | —      | 65    | 100    |
| S11 | —              | —      | 50    | 65     |
|     | —              | —      | 165   | 215    |
| S12 | —              | —      | 39    | 49     |
|     | —              | —      | 130   | 160    |
| S13 | —              | —      | 30    | 38     |
|     | —              | —      | 100   | 125    |
| H3  | —              | 48     | 46    | —      |
|     | —              | 155    | 150   | —      |
| H5  | —              | 90     | 85    | —      |
|     | —              | 295    | 280   | —      |
| H7  | —              | 48     | 46    | —      |
|     | —              | 155    | 150   | —      |
| H8  | —              | 90     | 85    | —      |
|     | —              | 295    | 280   | —      |
| H11 | —              | 115    | 110   | —      |
|     | —              | 375    | 360   | —      |
| H12 | —              | 50     | 100   | —      |
|     | —              | 165    | 330   | —      |
| H21 | —              | 90     | 85    | —      |
|     | —              | 295    | 280   | —      |

SMG = Seco anyag csoport v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD542 Ø 60-85 mm / 2.250-3.500 inch

| SMG |                  | f                             |                               | v <sub>c</sub> |
|-----|------------------|-------------------------------|-------------------------------|----------------|
|     |                  | Ø60,00-65,00<br>Ø 2.250-2.559 | Ø70,00-85,00<br>Ø 2.750-3.500 |                |
| P1  | P2 DP3000        | 0,095                         | 0,12                          | 390            |
|     | <i>P2 DP3000</i> | <i>0.0038</i>                 | <i>0.0048</i>                 | 1275           |
| P2  | P2 DP3000        | 0,10                          | 0,12                          | 380            |
|     | <i>P2 DP3000</i> | <i>0.0040</i>                 | <i>0.0048</i>                 | 1250           |
| P3  | P2 DP3000        | 0,19                          | 0,22                          | 325            |
|     | <i>P2 DP3000</i> | <i>0.0075</i>                 | <i>0.0085</i>                 | 1075           |
| P4  | P2 DP3000        | 0,19                          | 0,22                          | 205            |
|     | <i>P2 DP3000</i> | <i>0.0075</i>                 | <i>0.0085</i>                 | 670            |
| P5  | P2 DP3000        | 0,18                          | 0,22                          | 195            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 640            |
| P6  | P2 DP3000        | 0,18                          | 0,22                          | 220            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 720            |
| P7  | P2 DP3000        | 0,18                          | 0,22                          | 205            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 670            |
| P8  | P2 DP3000        | 0,19                          | 0,22                          | 195            |
|     | <i>P2 DP3000</i> | <i>0.0075</i>                 | <i>0.0085</i>                 | 640            |
| P11 | P2 DP3000        | 0,18                          | 0,22                          | 200            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 660            |
| P12 | P2 DP3000        | 0,12                          | 0,15                          | 120            |
|     | <i>P2 DP3000</i> | <i>0.0048</i>                 | <i>0.0060</i>                 | 395            |
| M1  | P2 DP3000        | 0,14                          | 0,17                          | 250            |
|     | <i>P2 DP3000</i> | <i>0.0055</i>                 | <i>0.0065</i>                 | 820            |
| M2  | P2 DP3000        | 0,13                          | 0,15                          | 205            |
|     | <i>P2 DP3000</i> | <i>0.0050</i>                 | <i>0.0060</i>                 | 670            |
| M3  | P1 T250D         | 0,10                          | 0,12                          | 90             |
|     | <i>P1 T250D</i>  | <i>0.0040</i>                 | <i>0.0048</i>                 | 295            |
| M4  | P1 T250D         | 0,090                         | 0,11                          | 70             |
|     | <i>P1 T250D</i>  | <i>0.0036</i>                 | <i>0.0044</i>                 | 230            |
| M5  | P1 T250D         | 0,090                         | 0,11                          | 55             |
|     | <i>P1 T250D</i>  | <i>0.0036</i>                 | <i>0.0044</i>                 | 180            |
| K1  | P2 DP3000        | 0,20                          | 0,24                          | 225            |
|     | <i>P2 DP3000</i> | <i>0.0080</i>                 | <i>0.0095</i>                 | 740            |
| K2  | P2 DP3000        | 0,18                          | 0,22                          | 195            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 640            |
| K3  | P2 DP3000        | 0,18                          | 0,22                          | 165            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 540            |
| K4  | P2 DP3000        | 0,18                          | 0,22                          | 160            |
|     | <i>P2 DP3000</i> | <i>0.0070</i>                 | <i>0.0085</i>                 | 520            |
| K5  | P2 DP3000        | 0,16                          | 0,19                          | 95             |
|     | <i>P2 DP3000</i> | <i>0.0065</i>                 | <i>0.0075</i>                 | 310            |
| N1  | P1 T250D         | 0,20                          | 0,24                          | 335            |
|     | <i>P1 T250D</i>  | <i>0.0080</i>                 | <i>0.0095</i>                 | 1100           |
| N2  | P1 T250D         | 0,20                          | 0,24                          | 215            |
|     | <i>P1 T250D</i>  | <i>0.0080</i>                 | <i>0.0095</i>                 | 710            |
| N3  | P1 T250D         | 0,20                          | 0,24                          | 145            |
|     | <i>P1 T250D</i>  | <i>0.0080</i>                 | <i>0.0095</i>                 | 475            |
| N11 | P1 T250D         | 0,20                          | 0,24                          | 285            |
|     | <i>P1 T250D</i>  | <i>0.0080</i>                 | <i>0.0095</i>                 | 940            |
| S1  | MP DS2050        | 0,15                          | 0,18                          | 55             |
|     | <i>MP DS2050</i> | <i>0.0060</i>                 | <i>0.0070</i>                 | 180            |
| S2  | MP DS2050        | 0,15                          | 0,18                          | 45             |
|     | <i>MP DS2050</i> | <i>0.0060</i>                 | <i>0.0070</i>                 | 150            |
| S3  | MP DS2050        | 0,14                          | 0,17                          | 39             |
|     | <i>MP DS2050</i> | <i>0.0055</i>                 | <i>0.0065</i>                 | 130            |
| S11 | MP DS2050        | 0,17                          | 0,20                          | 80             |
|     | <i>MP DS2050</i> | <i>0.0065</i>                 | <i>0.0080</i>                 | 260            |
| S12 | MP DS2050        | 0,17                          | 0,20                          | 60             |
|     | <i>MP DS2050</i> | <i>0.0065</i>                 | <i>0.0080</i>                 | 195            |
| S13 | MP DS2050        | 0,15                          | 0,18                          | 48             |
|     | <i>MP DS2050</i> | <i>0.0060</i>                 | <i>0.0070</i>                 | 155            |
| H3  | P1 T250D         | 0,080                         | 0,10                          | 65             |
|     | <i>P1 T250D</i>  | <i>0.0032</i>                 | <i>0.0040</i>                 | 215            |
| H5  | P1 T250D         | 0,12                          | 0,15                          | 120            |
|     | <i>P1 T250D</i>  | <i>0.0048</i>                 | <i>0.0060</i>                 | 395            |
| H7  | P1 T250D         | 0,080                         | 0,10                          | 65             |
|     | <i>P1 T250D</i>  | <i>0.0032</i>                 | <i>0.0040</i>                 | 215            |
| H8  | P1 T250D         | 0,095                         | 0,11                          | 120            |
|     | <i>P1 T250D</i>  | <i>0.0038</i>                 | <i>0.0044</i>                 | 395            |
| H11 | P1 T250D         | 0,12                          | 0,15                          | 155            |
|     | <i>P1 T250D</i>  | <i>0.0048</i>                 | <i>0.0060</i>                 | 510            |
| H12 | P1 T250D         | 0,095                         | 0,11                          | 140            |
|     | <i>P1 T250D</i>  | <i>0.0038</i>                 | <i>0.0044</i>                 | 460            |
| H21 | P1 T250D         | 0,095                         | 0,11                          | 120            |
|     | <i>P1 T250D</i>  | <i>0.0038</i>                 | <i>0.0044</i>                 | 395            |

SMG = Seco anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD542 Vágósebesség

| SMG | v <sub>c</sub> |        |       |        |
|-----|----------------|--------|-------|--------|
|     | DP2000         | DP3000 | T250D | DS2050 |
| P1  | 435            | 390    | 290   | 390    |
|     | 1425           | 1275   | 950   | 1275   |
| P2  | 425            | 380    | 280   | 380    |
|     | 1400           | 1250   | 920   | 1250   |
| P3  | 365            | 325    | 240   | 325    |
|     | 1200           | 1075   | 790   | 1075   |
| P4  | 255            | 205    | 130   | —      |
|     | 840            | 670    | 425   | —      |
| P5  | 245            | 195    | 125   | —      |
|     | 800            | 640    | 410   | —      |
| P6  | 275            | 220    | 140   | —      |
|     | 900            | 720    | 460   | —      |
| P7  | 260            | 205    | 130   | —      |
|     | 850            | 670    | 425   | —      |
| P8  | 245            | 195    | 125   | —      |
|     | 800            | 640    | 410   | —      |
| P11 | 250            | 200    | 125   | —      |
|     | 820            | 660    | 410   | —      |
| P12 | 150            | 120    | 75    | —      |
|     | 490            | 395    | 245   | —      |
| M1  | —              | 250    | 150   | —      |
|     | —              | 820    | 490   | —      |
| M2  | —              | 205    | 120   | —      |
|     | —              | 670    | 395   | —      |
| M3  | —              | 155    | 90    | 155    |
|     | —              | 510    | 295   | 510    |
| M4  | —              | 115    | 70    | 130    |
|     | —              | 375    | 230   | 425    |
| M5  | —              | 95     | 55    | 105    |
|     | —              | 310    | 180   | 345    |
| K1  | 235            | 225    | —     | —      |
|     | 770            | 740    | —     | —      |
| K2  | 205            | 195    | —     | —      |
|     | 670            | 640    | —     | —      |
| K3  | 175            | 165    | —     | —      |
|     | 570            | 540    | —     | —      |
| K4  | 165            | 160    | —     | —      |
|     | 540            | 520    | —     | —      |
| K5  | 100            | 95     | —     | —      |
|     | 330            | 310    | —     | —      |
| N1  | —              | 390    | 335   | 335    |
|     | —              | 1275   | 1100  | 1100   |
| N2  | —              | 250    | 215   | 215    |
|     | —              | 820    | 710   | 710    |
| N3  | —              | 165    | 145   | 145    |
|     | —              | 540    | 475   | 475    |
| N11 | —              | 325    | 285   | 285    |
|     | —              | 1075   | 940   | 940    |
| S1  | —              | —      | 37    | 55     |
|     | —              | —      | 120   | 180    |
| S2  | —              | —      | 27    | 45     |
|     | —              | —      | 90    | 150    |
| S3  | —              | —      | 27    | 39     |
|     | —              | —      | 90    | 130    |
| S11 | —              | —      | 70    | 80     |
|     | —              | —      | 230   | 260    |
| S12 | —              | —      | 55    | 60     |
|     | —              | —      | 180   | 195    |
| S13 | —              | —      | 43    | 48     |
|     | —              | —      | 140   | 155    |
| H3  | —              | 65     | 65    | —      |
|     | —              | 215    | 215   | —      |
| H5  | —              | 120    | 120   | —      |
|     | —              | 395    | 395   | —      |
| H7  | —              | 65     | 65    | —      |
|     | —              | 215    | 215   | —      |
| H8  | —              | 120    | 120   | —      |
|     | —              | 395    | 395   | —      |
| H11 | —              | 155    | 155   | —      |
|     | —              | 510    | 510   | —      |
| H12 | —              | 70     | 140   | —      |
|     | —              | 230    | 460   | —      |
| H21 | —              | 120    | 120   | —      |
|     | —              | 395    | 395   | —      |

SMG = Seco anyag csoport v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SD572 Ø 15-52 mm / 0.590-2.0472 inch

| SMG |           | f                             |                               |                               |                               |                               |                               | V <sub>c</sub> |
|-----|-----------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|-------------------------------|----------------|
|     |           | Ø15,00-17,00<br>Ø 0.590-0.669 | Ø18,00-20,00<br>Ø 0.670-0.787 | Ø21,00-24,00<br>Ø 0.788-0.944 | Ø25,00-32,00<br>Ø 0.945-1.259 | Ø33,00-36,00<br>Ø 1.260-1.417 | Ø37,00-52,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD572 Vágósebesség

| 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 anyag csoport  $v_c = \text{m/min}$  (sf/min) Minden forgácsolási paraméter kezdeti érték

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## SD602 Ø 60-160 mm / 2.362-6.300 inch

| SMG |           | f                             |                               |                                |                                 |                                 | v <sub>c</sub> |
|-----|-----------|-------------------------------|-------------------------------|--------------------------------|---------------------------------|---------------------------------|----------------|
|     |           | Ø60,00-69,99<br>Ø 2.362-2.755 | Ø70,00-91,99<br>Ø 2.756-3.621 | Ø92,00-110,99<br>Ø 3.622-4.369 | Ø111,00-134,99<br>Ø 4.370-4.314 | Ø135,00-160,00<br>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 anyag csoport f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

## SD602 Vágósebesség

| SMG | $v_c$ |        |
|-----|-------|--------|
|     | T250D | DS2050 |
| P1  | 180   | 295    |
|     | 590   | 970    |
| P2  | 175   | 285    |
|     | 570   | 940    |
| P3  | 150   | 245    |
|     | 490   | 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    | 135    |
|     | 180   | 445    |
| M4  | 43    | 85     |
|     | 140   | 280    |
| M5  | 36    | 70     |
|     | 120   | 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 anyag csoport  $v_c = \text{m/min (sf/min)}$  Minden forgácsolási paraméter kezdeti érték

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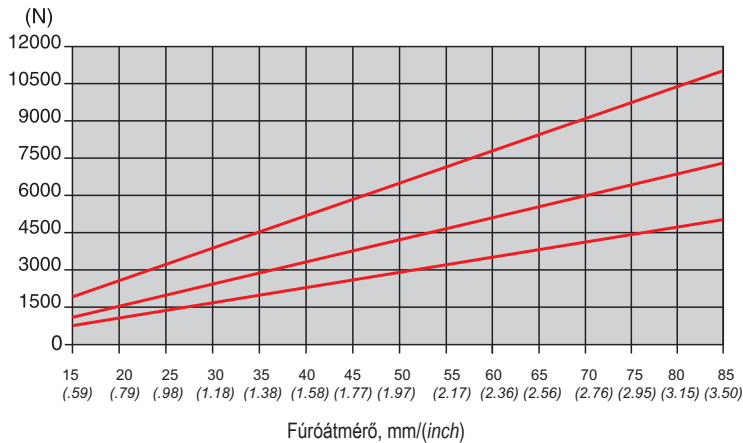
Melléklet

## Forgácsolási paraméterek, SD522, SD523, SD524, SD525, SD542 és SD572 - Teljesítményfelvétel, hűtő-kenő folyadék igény és erőgrafikonok

A feltüntetett értékek változhatnak pl. a forgácsolási paraméterek, anyagminőség, a gép hatásfoka és a szerszámkopás függvényében.

Az alábbi grafikonok P5–P6 Seco anyagcsoportra (SMG) és 200 m/perc (655 sf/perc) forgácsolási sebességre vannak meghatározva.

### Előtolási erő

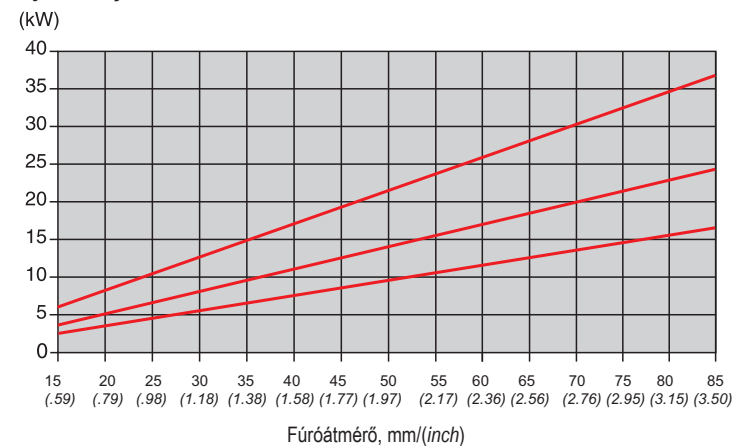


f = 0,18 mm/ford  
(f = 0.007 inch/rev)

f = 0,12 mm/ford  
(f = 0.005 inch/rev)

f = 0,08 mm/ford  
(f = 0.003 inch/rev)

### Teljesítményfelvétel

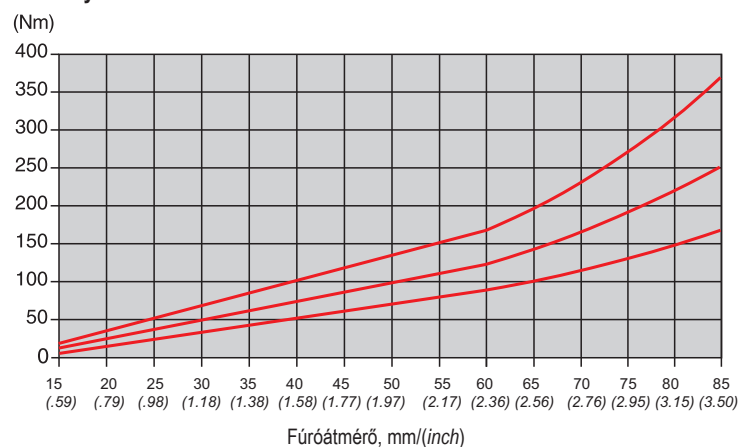


f = 0,18 mm/ford  
(f = 0.007 inch/rev)

f = 0,12 mm/ford  
(f = 0.005 inch/rev)

f = 0,08 mm/ford  
(f = 0.003 inch/rev)

### Fúrási nyomaték



f = 0,18 mm/ford  
(f = 0.007 inch/rev)

f = 0,12 mm/ford  
(f = 0.005 inch/rev)

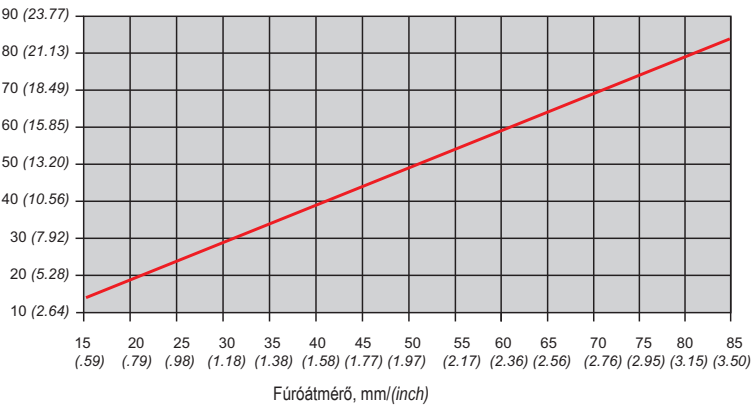
f = 0,08 mm/ford  
(f = 0.003 inch/rev)



## Forgácsolási paraméterek

### Hűtőfolyadékigény

Liter/perc (Gallon/perc)

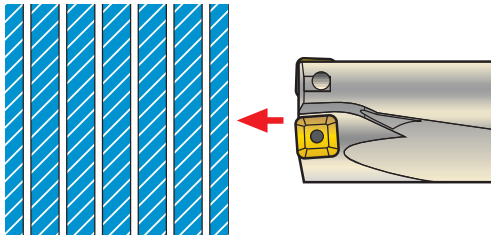


### Hűtőfolyadék-nyomás igény

#### Javasolt nyomás, bar (PSI)

| Fúrási mélység | Fúró átmérő mm (inch)  |                          |                 |
|----------------|------------------------|--------------------------|-----------------|
|                | 15–25<br>(0.591–0.984) | > 25–40<br>> 0.984–1.575 | > 40<br>> 1.575 |
| < 3 x D        | 6<br>(87)              | 4,5<br>(65)              | 3<br>(44)       |
| ≥ 3 x D        | 12<br>(174)            | 9<br>(130)               | 6<br>(87)       |

### Rétegelt anyagok fúrása



Rétegelt anyagok fúrása SD522 2 x D, SD523 3 x D, valamint SD542 2,5 x D és SD542 2,5 x D fúrókkal lehetséges, ha nincs légréz a rétegek között, max. 0,2 mm (0.008"). A rögzítésre külön figyelni kell, hogy ne fordulhasson elő rugózás a különböző rétegek átszakításánál (alátámasztással).

### Forgácsolási paraméterek és váltólapka javaslatok rétegelt anyagok fúrásánál

| Lapka geometria: | Lapka geometria | Keményfém minőség |
|------------------|-----------------|-------------------|
| Központi lapka   | SPGX-C1         | T400D             |
| Perif. lapka     | SCGX-P2         | DP3000            |

#### Figyelem!

A furat átszakadásánál a leszakadó fém korong nagy sebességgel távozhat a munkadarabról a fúró álló alkalmazásánál (forgó munkadarab). Fontos, hogy a gép megfelelő védelmi eszközökkel legyen ellátva a gépkezelő védelmének érdekében.

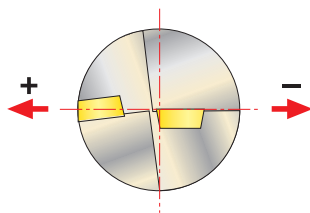
**Forgácsolási sebesség:** Lásd DP3000 keményfém minőséghez a javaslatokat  
**Fordulatonkénti előtolás:** Lásd a P2 geometriához a javaslatokat

Amennyiben az egyes rétegek áttöréseinél problémát észlel, csökkentse a fordulatonkénti előtolást 30–50%-kal az átlépéseknél.

### Beállítás

#### Furatátmérő beállítási ajánlás

A váltólapkás fúrók középvonalra eltolható, hogy nagyobb vagy kisebb furatátmérőt lehessen készíteni, mint a fúró.  
A radiális állíthatóság mértékét megtalálja az adattáblázatában a katalógusban.



#### Forgó alkalmazásnál

Az SD522 és SD523 3 x D-s fúrók forgó alkalmazásához a Seco állítható befogóit javasoljuk precíziós, IT10-es pontosságú furatok készítéséhez.

#### Álló alkalmazásnál

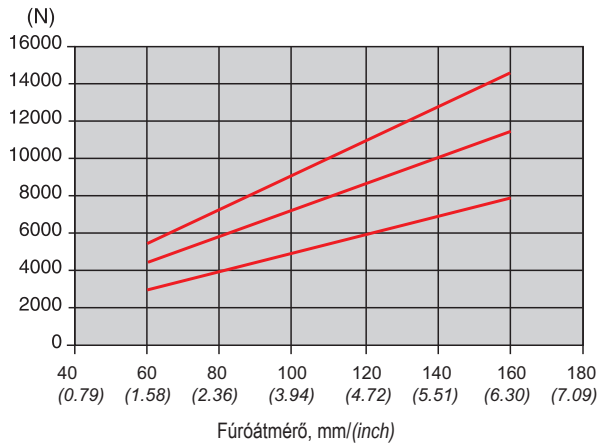
A fúró befogásakor gondoskodjon róla, hogy a vágóélek párhuzamosak legyenek a keresztzánnal, a fúró tengelye és a furat tengelye egy vonalba essen. Nagyobb furatátmérő eléréséhez mozgassa a fúrót úgy, hogy a periférikus lapka távolodjon a központi tengelytől.

## Forgácsolási paraméterek, SD602 – Teljesítményfelvétel, hűtő-kenő folyadék igény , és erőgrafikonok

A feltüntetett értékek változhatnak a forgácsolási paraméterek, anyagminőség, a gép hatásfoka (80%) függvényében.

Az alábbi grafikonok P5–P6 SMG-re és 200 m/perc (655 sf/perc) forgácsolási sebességre vannak meghatározva.

### Előtolási erő

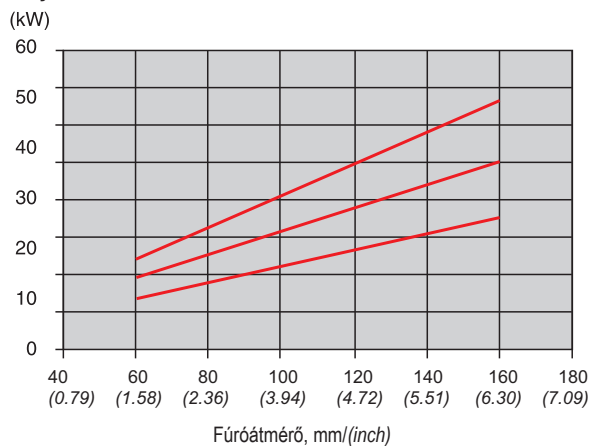


f = 0,18 mm/ford  
(f = 0.007 inch/rev)

f = 0,12 mm/ford  
(f = 0.005 inch/rev)

f = 0,08 mm/ford  
(f = 0.003 inch/rev)

### Teljesítményfelvétel

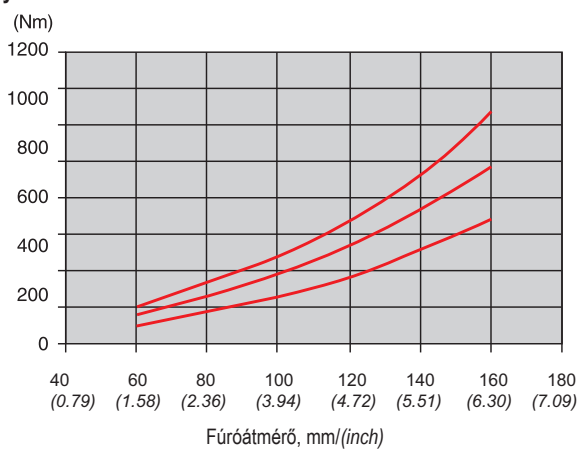


f = 0,18 mm/ford  
(f = 0.007 inch/rev)

f = 0,12 mm/ford  
(f = 0.005 inch/rev)

f = 0,08 mm/ford  
(f = 0.003 inch/rev)

### Fúrési nyomaték



f = 0,18 mm/ford  
(f = 0.007 inch/rev)

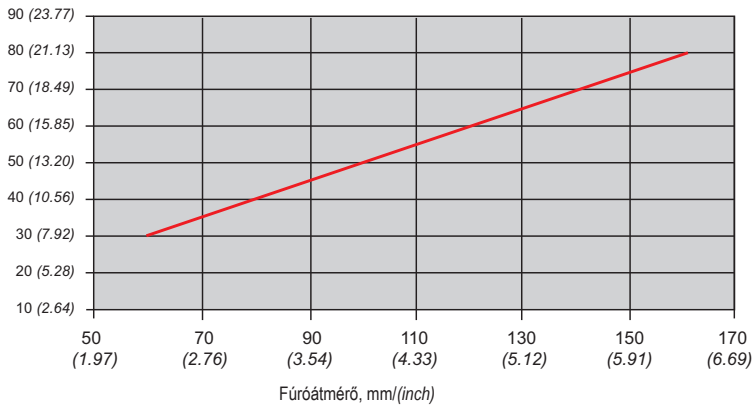
f = 0,12 mm/ford  
(f = 0.005 inch/rev)

f = 0,08 mm/ford  
(f = 0.003 inch/rev)

## Forgácsolási paraméterek, SD602

### Hűtőfolyadékigény

Liter/perc (Gallon/perc)



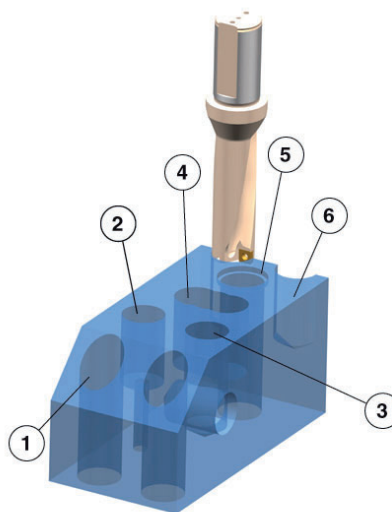
### Megmunkálások

| Nem ajánlott | Megoldás                              |
|--------------|---------------------------------------|
|              | <p>1. </p> <p>2. </p>                 |
|              | <p>1. </p> <p>2. </p>                 |
|              | <p>1. </p> <p>2. </p> <p>&gt; 5xD</p> |

## Sokoldalúság

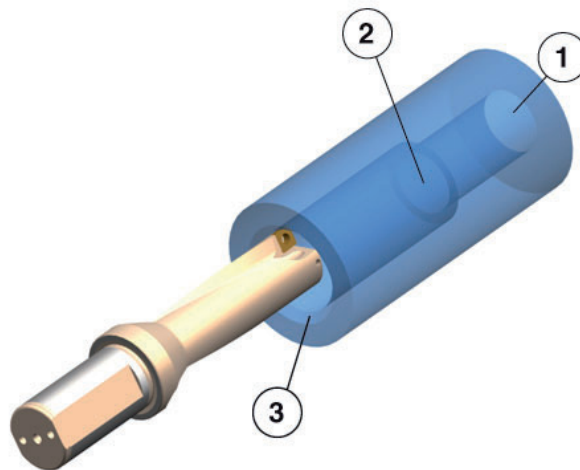
### Alkalmazások

1. Ferde furat
2. Kiesztérgálás
3. Már létező furat keresztűfúrása
4. Fúrás és axiális marás
5. Fúrás és furatmarás körkörös interpolációval
6. Axiális marás



### Alkalmazási lehetőségek álló szerszámként

1. Fúrás
2. Kiesztérgálás / kúpos furat
3. Élettörés



### Javaslatok

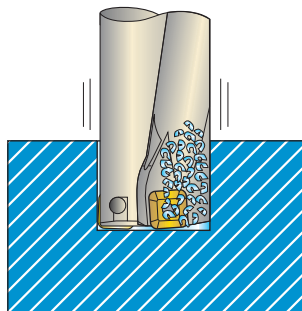
- 2 x D és 3 x D fúrók (SD522, SD523)
- Csökkentse az előtolást ~ 50%-kal, amikor a fúró nincs teljesen az anyagban.
- Használja a DP3000 minőséget
- Használjon -P2 forgácstörőt

## Problémamegoldás

### Vibrációk

#### Alkalmazások

- Ellenőrizze a fúró befogását
- Ellenőrizze a munkadarab befogását
- Növelje az előtolást. Nagyon lágy anyag esetén csökkentse az előtolást és növelje a sebességet.
- Csökkentse a vágósebességet.



#### Nem elegendő motornyomaték

- Csökkentse az előtolást.
- Válasszon a kisebb előtolásokhoz jobb forgácstörő képességű geometriát

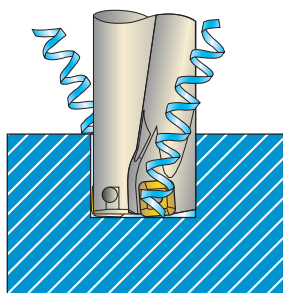
#### Nem elegendő teljesítmény

- Csökkentse a forgácsolási sebességet
- Csökkentse az előtolást
- Válasszon jobb forgácstörő képességű geometriát a kisebb előtolásokhoz (SCGX-P1)

### Forgács beragadási problémák

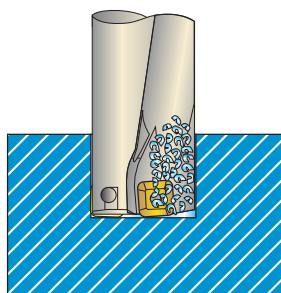
#### Forgácsberagadás a hosszú forgács miatt.

- Növelje az előtolást. Nagyon lágy anyag esetén csökkentse az előtolást és növelje a sebességet
- Válasszon jobb forgácstörő képességű geometriát a kisebb előtolásokhoz (SCGX-P1)



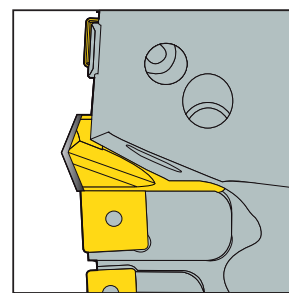
#### Forgács beragadás apró forgács ellenére.

- Növelje a hűtési nyomást/mennyiséget
- Csökkentse a forgácsolási sebességet



#### Gyors hátkopás az előfúrón

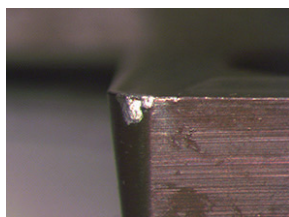
- Csökkentse a vágósebességet.
- Növelje a hűtőfolyadék koncentrációját.



### Szerszám élettartamával kapcsolatos problémák

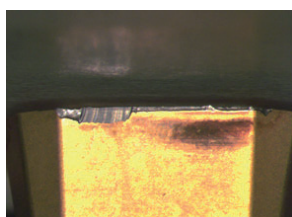
#### Periférikus lapka sérülése

- Csökkentse az előtolást belépésnél
- Válasszon szívósabb minőséget
- Válasszon jobb forgácstörő képességű geometriát a nagyobb előtolásokhoz (SCGX-P2)
- Csökkentse az előtolást
- Csökkentse a forgácsolási sebességet



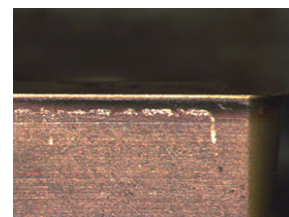
#### Középső lapka sérülése

- Ellenőrizze a fúró rögzítését
- Ellenőrizze a munkadarab rögzítését
- Csökkentse az előtolást belépésnél
- Növelje az előtolást
- Csökkentse a forgácsolási sebességet



#### Gyors hátkopás a periférikus lapkánál

- Csökkentse a vágósebességet.
- Növelje a hűtőközeg mennyiségét.
- Válasszon kopásállóbb minőséget.



## Állítható befogók fúrókhoz

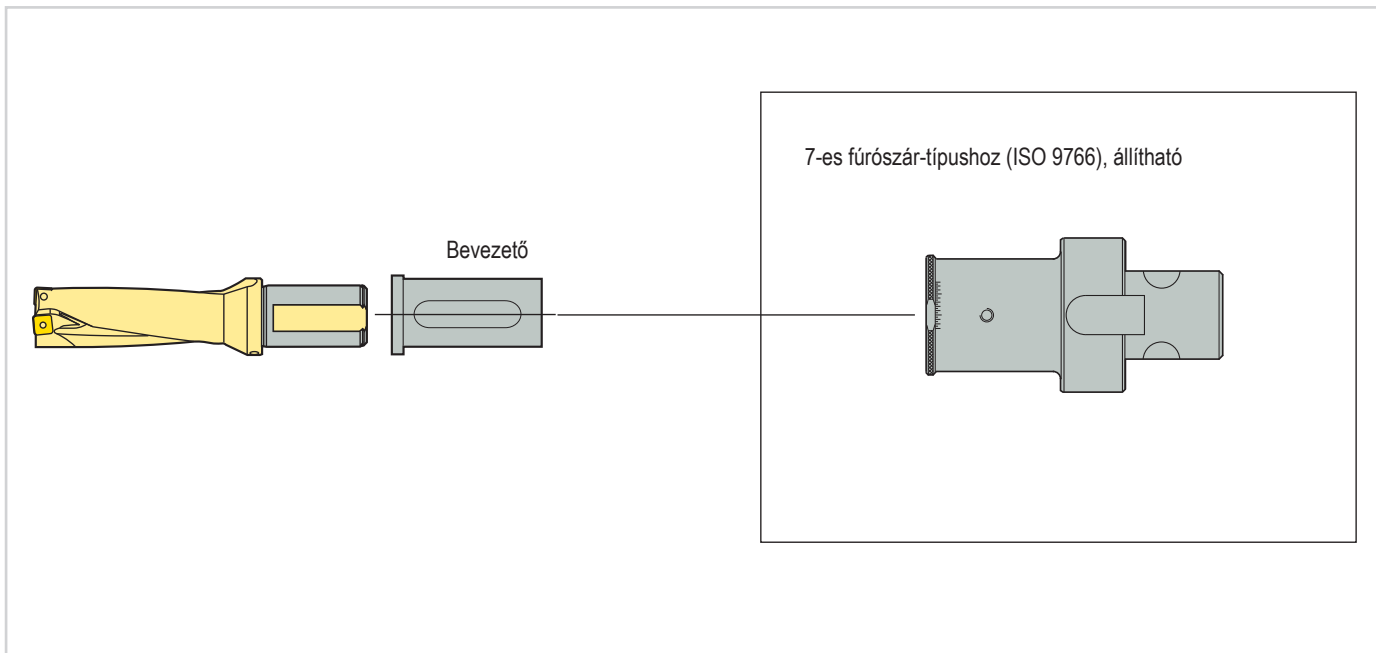
Bevezetés

Fúrás

Dörzsárazás

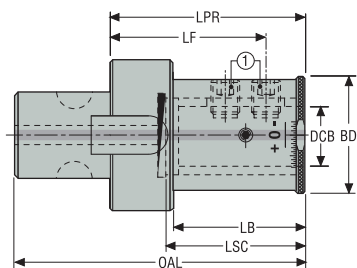
Késztergálás

Melléklet



## ADH 6101 – Állítható fúró befogó, a 7-es típusú szárakhoz

Graflex®



1. Rögzítő csavar



- Performax® fúrókhoz
- Állítható -0,3 mm – +0,8 mm között átmérőn

| Cikkszám | Megnevezés  | Gép oldal<br>Graflex<br>szár méret | Munkadarab oldal<br>Szár típus | DCB  |       | OAL   |       | LPR  |       | BD   |       | LF   |       | LB   |       | LSC  |       | Súly<br>kg<br>lbs | Egys.<br>faktor |    |
|----------|-------------|------------------------------------|--------------------------------|------|-------|-------|-------|------|-------|------|-------|------|-------|------|-------|------|-------|-------------------|-----------------|----|
|          |             |                                    |                                | mm   | Inch  | mm    | Inch  | mm   | Inch  | mm   | Inch  | mm   | Inch  | mm   | Inch  | mm   | Inch  |                   |                 | mm |
| 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 |

### Pótalkatrészek

| DCB        | Rögzítő csavar | Retesz |
|------------|----------------|--------|
| 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  |

### Kiegészítők

| DCB        | Kulcs (T-típus) | Kulcs     | Csökkentő hüvely | Csökkentő hüvely 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= Előgyensúlyozott kivitel (nézze meg a Kiegyensúlyozási útmutatót a Felszerszámozás katalógusban a további részletekért).

# DÖRZSÁRAZÁS



## PRECIMASTER™ PLUS CSERÉLHETŐ DÖRZSÁRFEJ A GYORS ÉS KÖNNYŰ KEZELHETŐSÉG ÉRDEKÉBEN

A Precimaster™ Plus egy moduláris dörzsár rendszer, amely nagyobb dörzsárazási sebességet, stabilitást és sokoldalúságot biztosít a pontosabb, költséghatékony furatkészítéshez. Az eredeti Precimaster™ sikerére épülő rendszer innovatív, nagy pontosságú csatlakozással, eldobható tömör keményfém fejekkel, valamint közös befogókkal rendelkezik a zsák- és átmenő furat készítési alkalmazásokhoz.

### TŰRÉSEK

- A rendszer 15–25 mikronos tűrésre és Ra 0,4 – Ra 0,8  $\mu\text{m}$  (RMS 15 – 35 micro/inch) felületi minőségre képes

### JELLEMZŐK

- A rendszer innovatív, nagy pontosságú csatlakozással, eldobható tömör keményfém fejekkel, valamint közös befogókkal rendelkezik a zsák- és átmenő furat készítési alkalmazásokhoz.

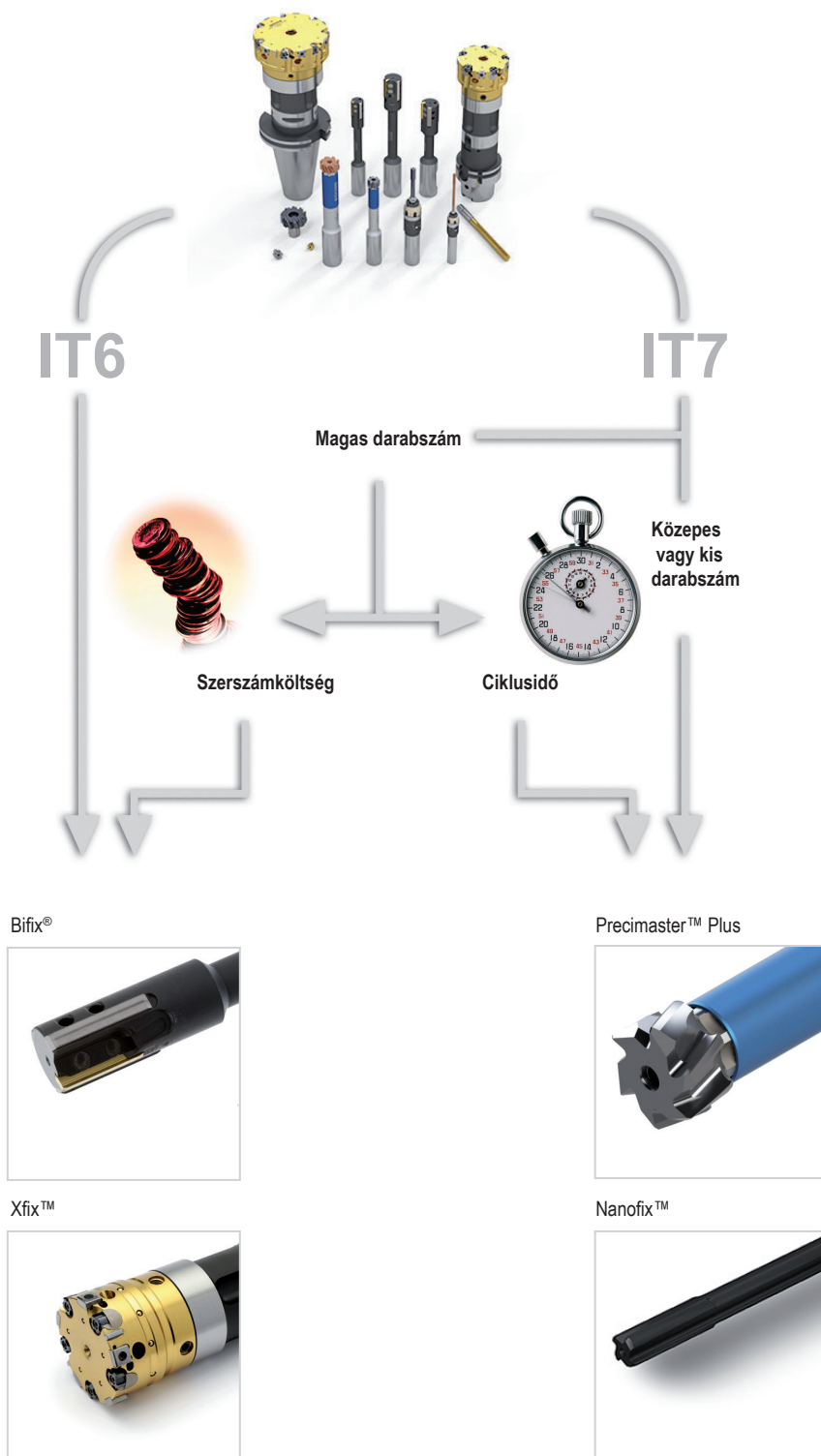




## Többélű fej vagy cserélhető lapka – A legjobb megoldás kiválasztása

Minőség, teljesítmény és szerszámköltség, ezeknek a követelményeknek mind megfelelni. A dörzsár választása függ a furat tűrésétől, gyártási mennyiségtől és a ciklusidőtől. A Seco furatkészítő rendszer megfelel ezen követelményeknek. A Precimaster, a Bifix, valamint az új Xfix és Nanofix dörzsárákkal minden dörzsárazási művelettel kapcsolatos probléma megoldható.

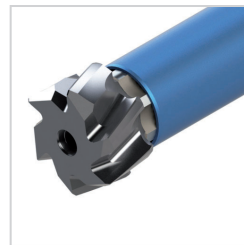
Az alábbi táblázat segít önnek a megfelelő szerszám kiválasztásában.



Bifix®



Precimaster™ Plus



Xfix™



Nanofix™



## Választék áttekintés

|   | ∅ Választék                           | Dörzsárazási mélység | Fúró ∅ furat | Köztes átmérő                     | Felületi minőség  |
|---|---------------------------------------|----------------------|--------------|-----------------------------------|---|
| <p><b>Precimaster™ Plus</b></p>  <p>Oldal 329-367 old.</p> | 7,75-60,500 mm<br>(0.3051-2.3818")    | ~ 2-10 x D           | IT 6-7-8     | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,2-1,2 μm<br>(R <sub>a</sub> 7.87-47.2 μin) |
| <p><b>Nanofix™</b></p>  <p>Oldal 368-397 old.</p>         | 2,970-12,050 mm<br>(0.1169-0.4744")   | ~ 5-12 x D           | IT 7         | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,2-1,2 μm<br>(R <sub>a</sub> 7.87-47.2 μin) |
| <p><b>Bifix®</b></p>  <p>Oldal 398-424 old.</p>          | 5,900-60,500 mm<br>(0.2323-2.3819")   | ~ 2-7 x D            | IT 6-7       | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,2-0,8 μm<br>(R <sub>a</sub> 7.87-31.5 μin) |
| <p><b>Xfix™</b></p>  <p>Oldal 425-465 old.</p>           | 39,500-154,500 mm<br>(1.5551-6.0827") | ~ 2,5-6,5 x D        | IT 6         | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,8-1,6 μm<br>(R <sub>a</sub> 31-63 μin)     |



## Precimaster™ Plus

A Precimaster™ Plus egy moduláris dörzsár rendszer, amely nagyobb dörzsárazási sebességet, stabilitást és sokoldalúságot biztosít a pontosabb, költséghatékony furatkészítéshez.

- A rendszer innovatív, nagy pontosságú csatlakozást, tömör keményfém eldobható fejeket és közös befogót kínál zsák- és átmenő furatok készítő alkalmazásokhoz
- A segítségével 15 és 25 mikron közti tűrés és Ra 0,4 – Ra 0,8  $\mu\text{m}$  (RMS 15 – 35 micro/inch) felületi minőség is elérhető

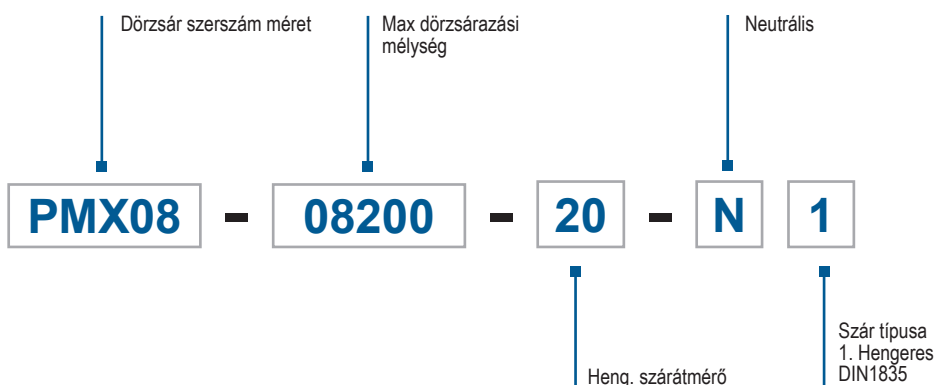
## Precimaster™ Plus – Választék áttekintés

|   | ∅ Választék                    | Dörzsárazási mélység | Fúró ∅ furat | Köztes átmérő                     | Felületi minőség  |
|---|--------------------------------|----------------------|--------------|-----------------------------------|---|
| Bevezetés<br>    | 7,75-60 mm<br>(0.3051-2.3622") | ~ 2-3 x D            | IT 6-7-8     | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,4-0,8 μm<br>(R <sub>a</sub> 15.7-31.5 μin) |
| Fúrás<br>        | 7,75-60 mm<br>(0.3051-2.3622") | ~ 4-5 x D            | IT 6-7-8     | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,4-0,8 μm<br>(R <sub>a</sub> 15.7-31.5 μin) |
| Dörzsárazás<br> | 7,75-60 mm<br>(0.3051-2.3622") | ~ 8-10 x D           | IT 6-7-8     | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,4-0,8 μm<br>(R <sub>a</sub> 15.7-31.5 μin) |

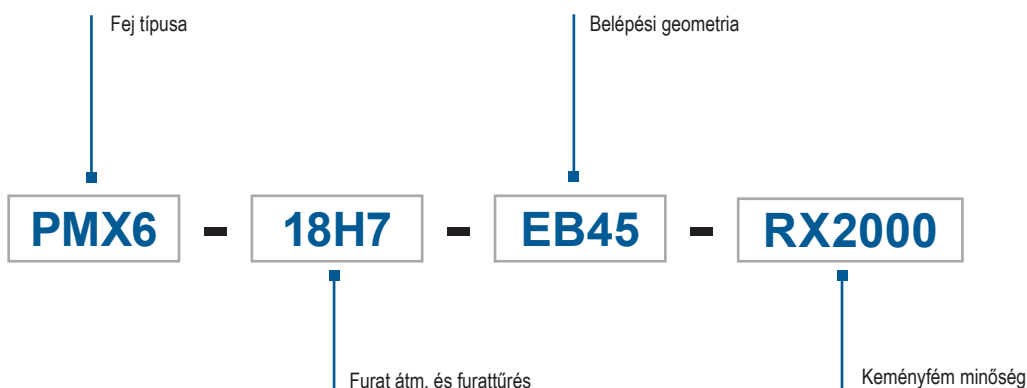
## Jelmagyarázat

Precimaster Plus szárok alkalmasak mind zsák- és átmenőfuratokhoz.

### Szerszám szár

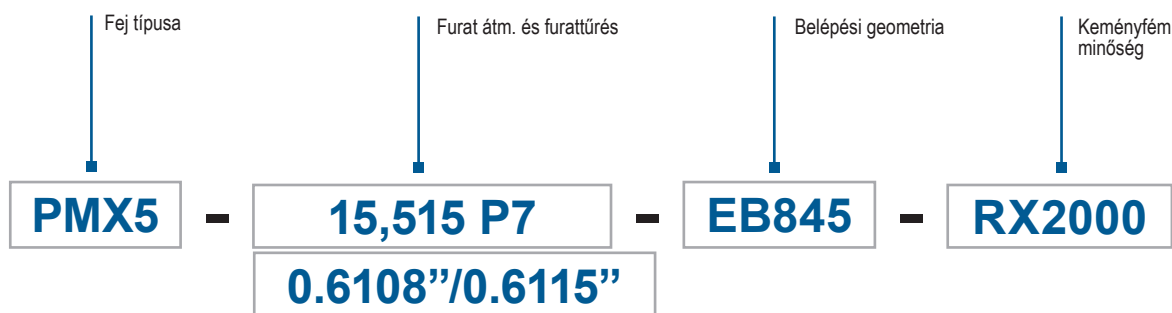


### Fej

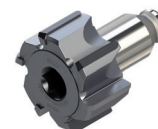


PMX6

### Fej köztes átmérője



PMX5

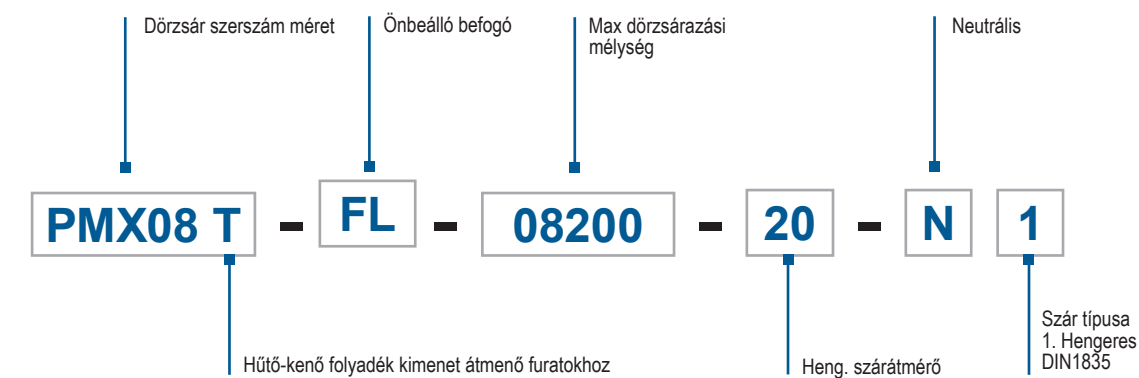
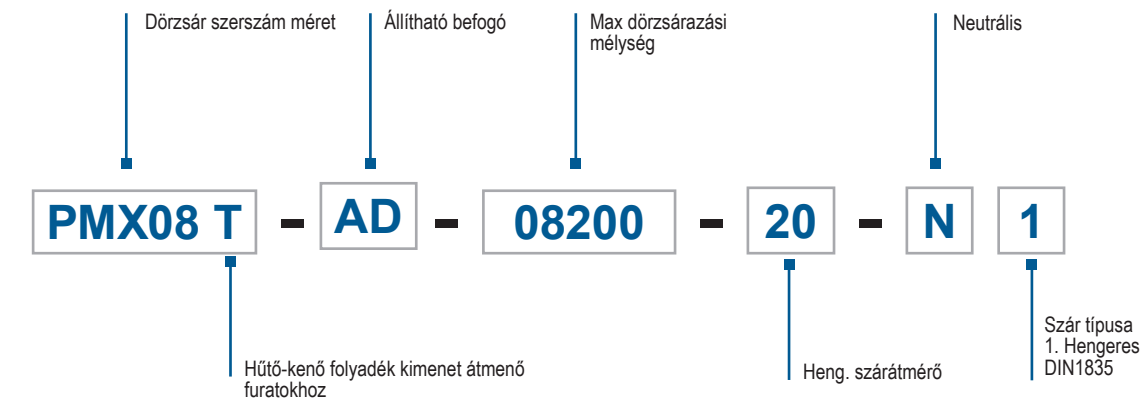
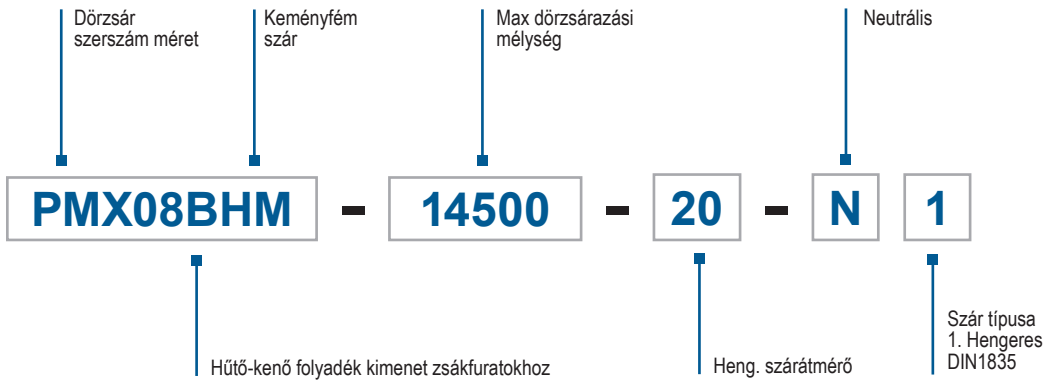


PMX8

PMX5: Egyenes forgácshornyú, zsák- és átmenő furatokhoz alkalmazható.  
PMX6: Csavart forgácshornyú kialakítás, csak átmenő furatokhoz alkalmazható.  
PMX8: Egyenes forgácshornyú, zsák- és átmenő furatokhoz alkalmazható  
A balos horonykivitel javítja a forgács előretolását.  
Lásd a Precimaster Plus fejeválasztó oldalt 338 old..

## Jelmagyarázat

Precimaster Plus szárok alkalmasak mind zsák- és átmenőfuratokhoz.

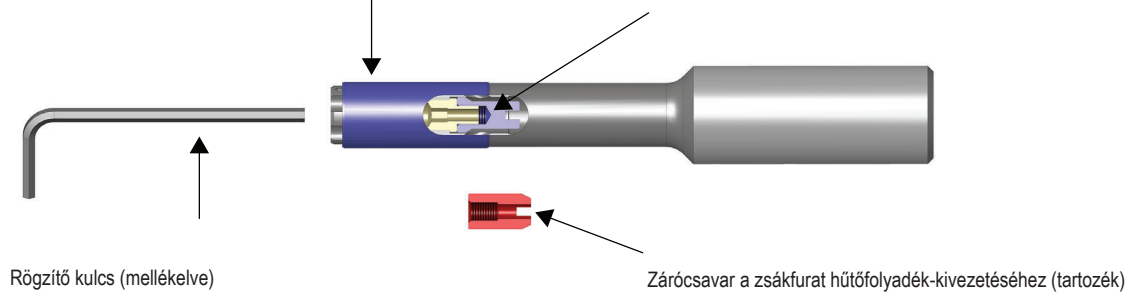


## Hűtőfolyadék beállítása

### Hűtészkezelés beállítása Pótalkatrészek leírása

Hűtőfolyadék-persely átmenő furat hűtőfolyadék-kivezetéséhez

Zárócsavar átmenő furat hűtőfolyadék-kivezetéséhez



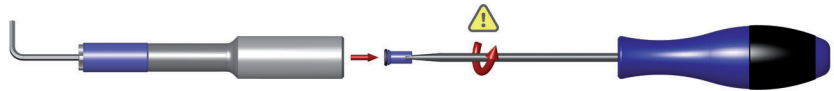
Rögzítő kulcs (mellékelve)

Zárócsavar a zsákfurat hűtőfolyadék-kivezetéséhez (tartozék)

### Hűtészkezelés beállítása Zsákfuratok hűtészkezelésének beállítása

1.

Távolítsa el az átmenő furat zárócsavarját  
**Megj.:** a zárócsavar balmenetes



| Test mérete | Lapos csavarhúzó mérete, mm | Lapos csavarhúzó mérete, inch | Imbuszkulcs méret, mm | Imbuszkulcs méret, inch |
|-------------|-----------------------------|-------------------------------|-----------------------|-------------------------|
|             |                             |                               |                       |                         |
| 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             | 0.05 x 0.16 x 4.72            | 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              |

Használjon lapos csavarhúzót VAGY imbuszkulcsot, a kéziszerszámok javasolt méretét a táblázat tartalmazza

2.

Távolítsa el a hűtőfolyadék-perselyt



3.

Szerelje be az átmenő furatok (piros) zárócsavarját  
**Megj.:** a zárócsavar balmenetes



## Fej összeszerelés

Bevezetés

1.

Győződjön meg róla, hogy a fejgeometria megfelel a hűtés típusának



PMX5/PMX8



PMX6



PMX5/PMX8



Átmenő furatok

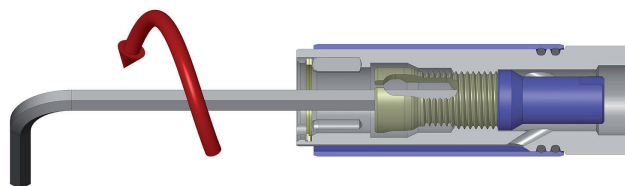


Zsákfuratok

Fúrás

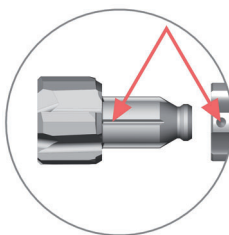
2.

Igazítsa a körmöt a fejrögzítés elé

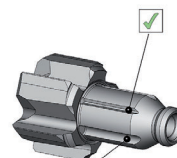


3.

Igazítsa a jelzőhornyot a testen lévő piros ponthoz



Kis hornyok

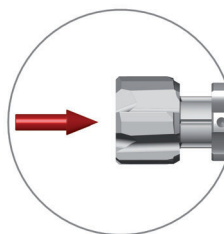


Nagy hornyok

Dörzsárazás

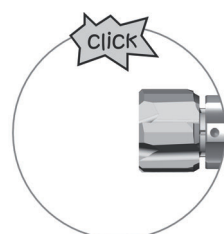
4.

Helyezze a fejet a testbe



5.

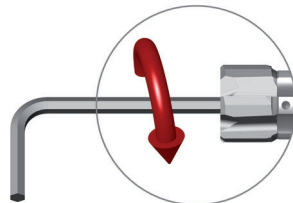
Nyomja be a fejet a testbe amíg „kattanás” nem hallatszik



Kiesztérgálás

6.

Imbuszkulccsal rögzítse a fejet



| PMX Szár Méret | Recommended clamping torque |
|----------------|-----------------------------|
| PMX05          | 0,5 Nm                      |
| PMX06          | 0,9 Nm                      |
| PMX08          | 1,2 Nm                      |
| PMX12          | 2,0 Nm                      |
| PMX16          | 5,0 Nm                      |

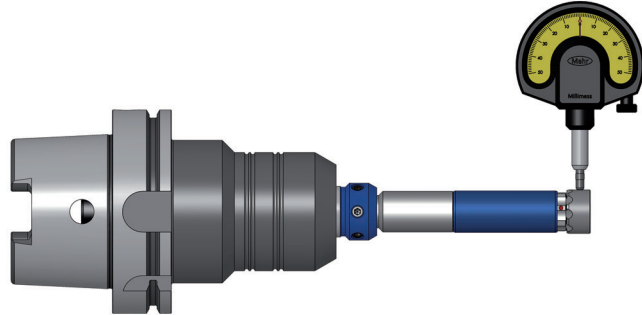
Melléklet



## Befogás – Ütés

## Forgó szerszám

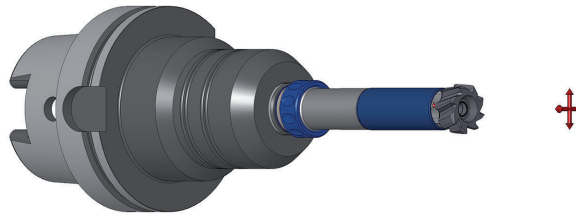
Max. ajánlott ütés: 10–15  $\mu\text{m}$  (393.7008–590.5512  $\mu\text{in}$ ).  
Hidraulikus befogó, Shrinkfit befogó vagy precíziós patronos befogó javasolt.  
A legjobb ütés ellenőrzéshez a Precimaster Plus PMX-AD állítható adapterek használatát javasoljuk, lásd a következő oldalakat: 351-352.



## Álló szerszám

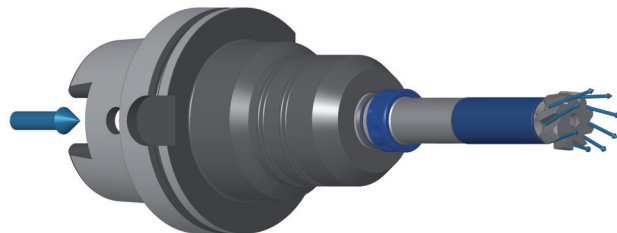
Használjon Precimaster Plus PMX - FL önbeálló befogókat, lásd a következő oldalakat: 353-354.

Az önbeálló befogók központozítják a dörzsárat az előfuratban.



## Hűtőfolyadékkal kapcsolatos követelmények

Maximális szerszámettartam és furatminőség eléréséhez a következő hűtőfolyadék-igényeket vizsgálja meg.  
Belső hűtés javasolt.  
Külső hűtés <math>2 \times D</math> mélységig használható.  
Minőségi oldódó olaj minimum 40%-os ásványolaj-tartalommal.  
Korrózióálló acélhoz tiszta olaj ajánlott.  
Minimális koncentráció 6-8 %  
Szűrés 30–50  $\mu\text{m}$  (1200–2000  $\mu\text{in}$ ).  
Mennyiség min. 0,5 l/perc/mm (3.35 gal/min/inch) szerszámtátrő.  
(Pl.:  $\varnothing 10$  dörzsár, min. mennyiség 5 l/perc (1.3 gal/min).



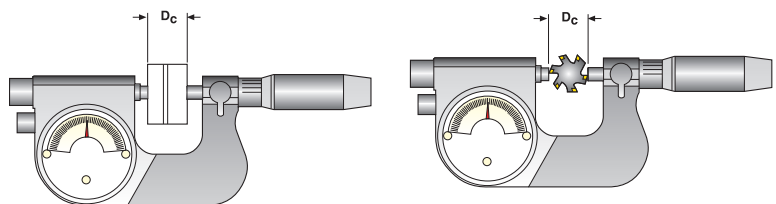
## Átmérőmérés

Kalibrálja az óras mikrométert az  $\varnothing$  mérés előtt.

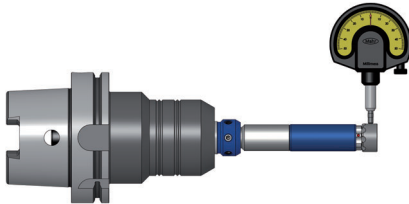

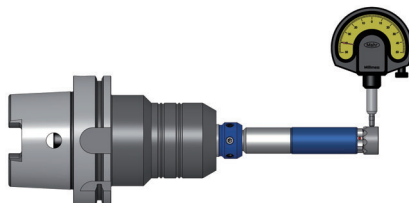

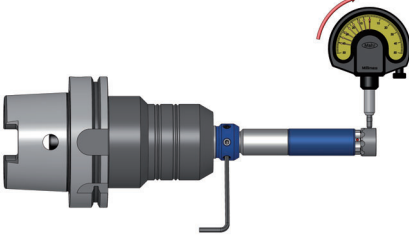

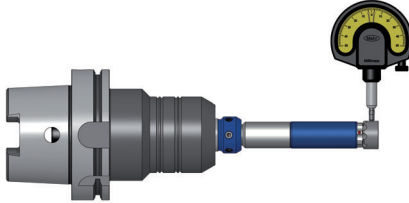

**Fontos!**

A Precimaster dörzsáraz fogtávolsága egyenlőtlen osztású  
Átmérő mérésénél ellenőrizze, hogy a 2 mért fog 180°-ra van egymástól.

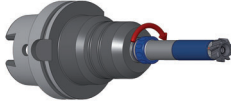
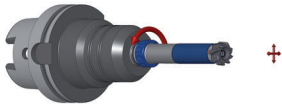
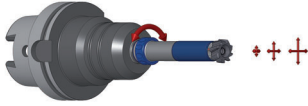
Használja az mérőóras mikrométert és mérőhasábot a kalibráláshoz.



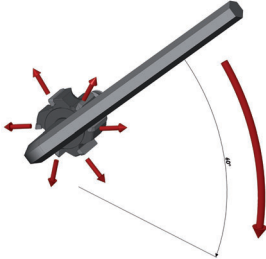
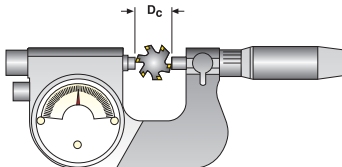
## A szár beállítása:

|   |  |   |
|---|--|---|
| <p><b>1.</b><br/>Szerelje fel a beállító etalont (a beállító befogóhoz mellékelve).<br/>Helyezze a szerszámot a főorsóba.</p> <p><b>2.</b><br/>Állítsa be az órát az alábbi módon.</p>                    |    |    |
| <p><b>3.</b><br/>Forgassa el kézzel a szerszámot a legalacsonyabb pontba.</p>   |    |    |
| <p><b>4.</b><br/>A csavarok állításával folytassa az ütés kompenzálását. Az irányokat a nyilak mutatják.</p> <p><b>5.</b><br/>Ellenőrizze az ütést, és ismételje meg szükség szerint a kiegyenlítést.</p> |  |  |
| <p><b>6.</b><br/>Ha a maximális ütés kevesebb mint <math>5 \mu\text{m}</math> (<math>0.0002''</math>), rögzítse az állítócsavarokat a beállítás kilazulásának elkerülése érdekében</p>                    |  |  |

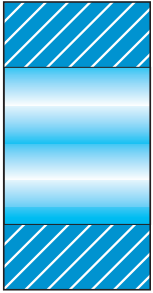


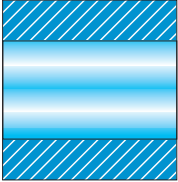


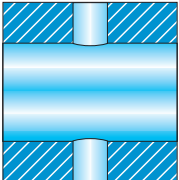


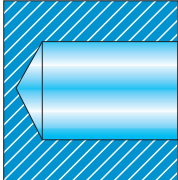
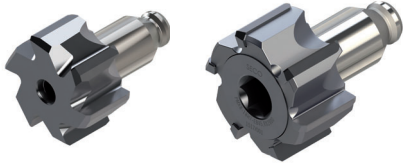

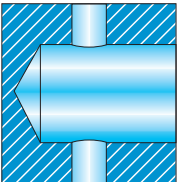
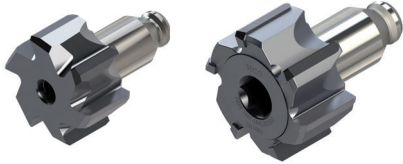

## Önbeálló szár beállítása:

|  |  |
|--|--|
| <p><b>1.</b><br/>Az állítógyűrűt az óramutató járásával megegyező irányba forgatva húzza meg teljesen az önbeálló szárat.</p>  |    |
| <p><b>2.</b><br/>Az állítógyűrűt lazítsa meg 2 vagy 3 kattanásnnyit az óramutató járásával ellentétesen elforgatva.</p>  |    |
| <p><b>3.</b><br/>Szükség esetén állítson be nagyobb önbeállási értéket. A túl nagy önbeállási érték instabil körülményeket eredményezhet a furat bemeneténél. Túl kicsi lebegési érték rezgést és kúpos furatot eredményezhet.</p> |  |

## Tágítható dörzsár kopáskompenzálása

|   |  |
|---|--|
| <p><b>1.</b><br/>Imbuszkulcs használatával kompenzálja a szerszám Ø kopását (60° elfordítás = kb. 0,005 mm (0.0002") átmérőkompenzálás)</p> |  |
| <p><b>2.</b><br/>Óras mikrométerrel ellenőrizze az átmérőt a meghosszabbítás után</p>   |  |

## Fejválasztás

| Munkadarab   | Dörzsárazandó átmérő $\varnothing$ 8–60 mm (0.3150–2.3622")   |   |
|--|---|---|
| <p>Rövid átmenő furat &lt; 3 x D</p>    | <p><b>PMX5 / PMX8</b></p>   |   |
| <p>Hosszú átmenő furat &gt; 3 x D</p>  | <p><b>PMX6</b><br/>Átmenő furat művelet esetén a szerszámbefogó hűtés-kivezetése átmenő furat hűtésére legyen beállítva: lásd a hűtésbeállítás oldalakat.</p>    |   |
| <p>Keresztező furat</p>               |    |   |
| <p>Zsákfurat</p>                      | <p><b>PMX5 / PMX8</b><br/>Zsákfurat művelet esetén a szerszámbefogó hűtés-kivezetése zsákfurat hűtésére legyen beállítva: lásd a hűtésbeállítás oldalakat.</p>  |  |
| <p>Zsák- és keresztező furat</p>      |   |  |

Bevezetés

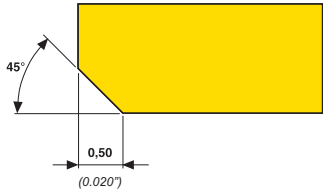
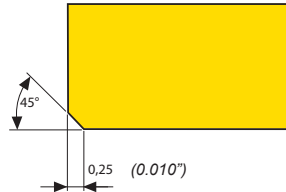
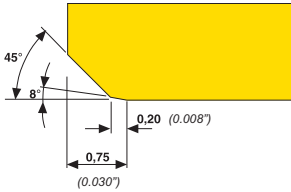
Fúrás

Dörzsárazás

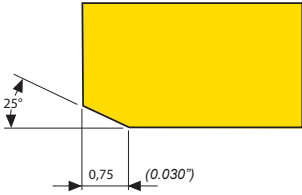
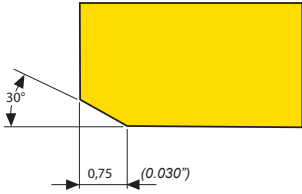
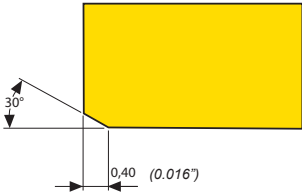
Késztergálás

Melléklet

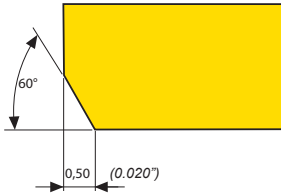
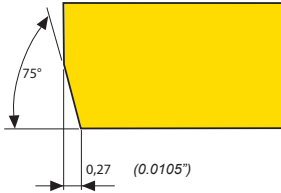
## Geometriaválaszték – Alkalmazások

| Forgácsolási geometria – EB45  |  |
|--|--|
| <p>Forgácsolási szabályozás ++<br/>           Felületi minőség +++ <math>R_a</math> 0,8–1,2 <math>\mu\text{m}</math><br/>           (Felületi minőség +++ <math>R_a</math> 31–47 <math>\mu\text{in}</math>)<br/>           Sokoldalú</p> |    |
| Forgácsolási geometria – EBS45   |  |
| <p>Forgácsolási szabályozás +++<br/>           Felületi minőség + <math>R_a</math> 0,8–1,2<br/>           (Felületi minőség + <math>R_a</math> 31–47 <math>\mu\text{in}</math>)<br/>           Rövid EB45</p>                            |   |
| Forgácsolási geometria – EB845   |  |
| <p>Forgácsolási szabályozás ++<br/>           Felületi minőség +++ <math>R_a</math> 0,2–0,8 <math>\mu\text{m}</math><br/>           (Felületi minőség +++ <math>R_a</math> 8–31 <math>\mu\text{in}</math>)</p>                           |  |

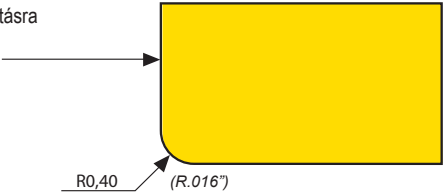
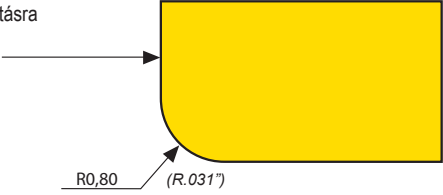
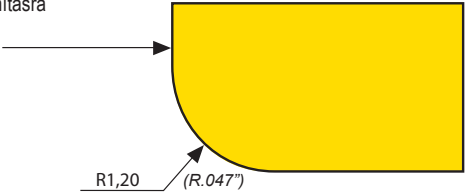
## Geometriaválaszték – Alkalmazások

| Forgácsolási geometria – EB25   |  |
|---|--|
| <p>Előtolási teljesítmény +++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +</p>                |    |
| Forgácsolási geometria – EB30   |  |
| <p>Előtolási teljesítmény +++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +</p>                |   |
| Forgácsolási geometria – EBS30  |  |
| <p>Előtolási teljesítmény +++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +<br/>Rövid EB30</p> |  |












## Geometriaválaszték – Alkalmazások

| Forgácsolási geometria – EB60   |   |
|---|---|
| <p>Előtolási teljesítmény +<br/>Felületi minőség ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 31-47 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás ++</p> |   |
| Forgácsolási geometria – EB75   |   |
| <p>Előtolási teljesítmény +<br/>Felületi minőség ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 31-47 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás ++</p> |  |

## Geometriaválaszték – Alkalmazások

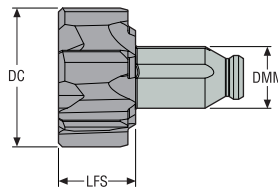
| Forgácsolási geometria – RE040  |  |
|---|--|
| <p>Előtolási teljesítmény ++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +</p>                                       | <p>Nem alkalmas simításra</p>    |
| Forgácsolási geometria – RE080  |  |
| <p>Előtolási teljesítmény ++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +</p>                                       | <p>Nem alkalmas simításra</p>   |
| Forgácsolási geometria – RE120  |  |
| <p>Előtolási teljesítmény ++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +<br/>Ø 14 mm (0.551") mérettől kapható</p> | <p>Nem alkalmas simításra</p>  |



| Minőségek   |        |   |
|---|--------|---|
|    | RX2000 | <b>Bevonatos</b><br>Nagy teljesítményű bevonatos minden anyaghoz.   |
|    | CP20   | <b>Bevonatos</b><br>Sokoldalú minőség a legtöbb anyaghoz, az alumíniumon kívül.<br>TiN  |
|    | H15    | <b>Bevonat nélküli</b><br>Egy szívós minőség minden anyaghoz. Alkalmas finom dörzsárazáshoz az élességének köszönhetően.      |
|    | CF     | <b>Cermet</b><br>Kopásálló minőség, acélok megmunkálásához optimális.   |
|   | RX1500 | <b>Bevonatos Cermet</b><br>Egy kopásálló minőség acél és öntöttvas optimalizálásához.   |
|  | RN2010 | <b>Bevonat nélküli</b><br>Egy sub-mikroszemcsés bevonat nélküli minőség optimalizált geometriával N-anyagokhoz (színesfémek). |
|  | RM2020 | <b>Bevonatos</b><br>Egy szívós bevonatos minőség simító dörzsárazáshoz optimalizált geometriával M anyagokhoz.                |
|  | RM2090 | <b>Bevonatos</b><br>Egy kopásálló bevonatos minőség speciális geometriával az M anyagokhoz. Optimalizálás M anyagokban.       |
|  | RK2050 | <b>Bevonatos</b><br>Egy szívós minőség simító művelethez optimalizált geometriával K anyagokhoz.                              |
|  | RK1550 | <b>Bevonatos Cermet</b><br>Egy kopásálló bevonatos minőség speciális geometriával K anyagokhoz. Optimalizálás K anyagokban.   |
|  | RS2090 | <b>Bevonatos</b><br>Egy kopásálló bevonatos minőség speciális geometriával S anyagokhoz. Optimalizálás S anyagokban.          |


## Fejek zsák- és átmenő furatokhoz

Ø 8-32 mm / 0.315-1.260"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

| Megnevezés     | Cikkszám | DC   | Fúró méret* |    | LFS  | DMM  | Test méret | Geometriák |       |      | Minőségek |      |        |    |        |
|----------------|----------|------|-------------|----|------|------|------------|------------|-------|------|-----------|------|--------|----|--------|
|                |          |      | 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   | □          | □     | ■    | □         | □    | ■      | □  | □      |

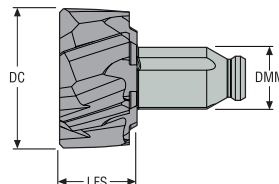
| Megnevezés     | Cikkszám | DC   | Fúró méret* |    | LFS  | DMM  | Test méret | Geometriák  |                          |                                     | Minőségek                |                          |                                     |                          |                          |
|----------------|----------|------|-------------|----|------|------|------------|---|--------------------------|-------------------------------------|--------------------------|--------------------------|-------------------------------------|--------------------------|--------------------------|
|                |          |      | mm          | mm |      |      |            |  | mm                       | mm                                  | EB45                     | EB845                    | EB30                                | H15                      | CP20                     |
| PMX5-28H7-EB45 | 02925771 | 28,0 | 27,8/27,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input checked="" type="checkbox"/>   | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-29H7-EB45 | 02925772 | 29,0 | 28,8/28,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input checked="" type="checkbox"/>   | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-30H7-EB30 | 10019495 | 30,0 | 29,8/29,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input type="checkbox"/>  | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-30H7-EB45 | 02925773 | 30,0 | 29,8/29,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input checked="" type="checkbox"/>   | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-31H7-EB45 | 02925774 | 31,0 | 30,8/30,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input checked="" type="checkbox"/>   | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-32H7-EB30 | 10019496 | 32,0 | 31,8/31,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input type="checkbox"/>  | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-32H7-EB45 | 02925775 | 32,0 | 31,8/31,9   | 8  | 12,0 | 12,0 | PMX12-xx   | <input checked="" type="checkbox"/>   | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

\*További információért a fúrókkal kapcsolatban lapozzon a 7 old.

Raktári szabványos.  Nem raktári szabványos.

## Fejek zsák- és átmenő furatokhoz

Ø 8-32 mm / 0.315-1.260"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

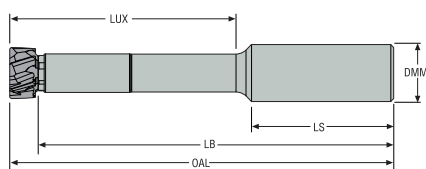
| Megnevezés     | Cikkszám | DC   | Fúró méret* |    | LFS  | DMM  | Test méret | Geometriák |       |      | Minőségek |      |        |    |        |
|----------------|----------|------|-------------|----|------|------|------------|------------|-------|------|-----------|------|--------|----|--------|
|                |          |      | 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   | ■          | □     | □    | □         | □    | ■      | □  | □      |

\*További információért a fúrókkal kapcsolatban lapozzon a 7 old.

■ Raktári szabványos. □ Nem raktári szabványos.

## Szárak zsák- és átmenő furatokhoz

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

| Megnevezés         | Cikkszám | Szerszám tartó anyaga | DC             | OAL   | LB    | LS   | LUX   | DMM  |
|--------------------|----------|-----------------------|----------------|-------|-------|------|-------|------|
|                    |          |                       | mm             | mm    | mm    | mm   | mm    | mm   |
| PMX05-02800-10N1   | 03123012 | Acél                  | 7,75 - 9,9     | 69,0  | 63,0  | 40,0 | 28,0  | 10,0 |
| PMX05-04100-10N1   | 02929923 | Acél                  | 7,75 - 9,9     | 84,0  | 78,0  | 40,0 | 41,0  | 10,0 |
| PMX05-10000-10N1   | 03123013 | Acél                  | 7,75 - 9,9     | 143,0 | 137,0 | 40,0 | 100,0 | 10,0 |
| PMX06-03700-12N1   | 02925828 | Acél                  | 9,901 - 14,499 | 84,0  | 77,0  | 45,0 | 37,0  | 12,0 |
| PMX06-05700-12N1   | 02925829 | Acél                  | 9,901 - 14,499 | 104,0 | 97,0  | 45,0 | 57,0  | 12,0 |
| PMX06-12000-12N1   | 02925830 | Acél                  | 9,901 - 14,499 | 167,0 | 160,0 | 45,0 | 120,0 | 12,0 |
| PMX06HM-12000-12N1 | 02925831 | Keményfém             | 9,901 - 14,499 | 167,0 | 160,0 | 45,0 | 120,0 | 12,0 |
| PMX08-04600-20N1   | 02925832 | Acél                  | 14,5 - 21,499  | 99,0  | 89,0  | 50,0 | 46,0  | 20,0 |
| PMX08-08200-20N1   | 02925833 | Acél                  | 14,5 - 21,499  | 135,0 | 125,0 | 50,0 | 82,0  | 20,0 |
| PMX08-14500-20N1   | 02925834 | Acél                  | 14,5 - 21,499  | 198,0 | 188,0 | 50,0 | 145,0 | 20,0 |
| PMX08HM-14500-20N1 | 02925835 | Keményfém             | 14,5 - 21,499  | 198,0 | 188,0 | 50,0 | 145,0 | 20,0 |
| PMX12-06800-25N1   | 02925836 | Acél                  | 21,5 - 32,499  | 127,0 | 115,0 | 56,0 | 68,0  | 25,0 |
| PMX12-10400-25N1   | 02925837 | Acél                  | 21,5 - 32,499  | 163,0 | 151,0 | 56,0 | 104,0 | 25,0 |
| PMX12-17000-25N1   | 02925838 | Acél                  | 21,5 - 32,499  | 229,0 | 217,0 | 56,0 | 170,0 | 25,0 |
| PMX12HM-17000-25N1 | 02925839 | Keményfém             | 21,5 - 32,499  | 229,0 | 217,0 | 56,0 | 170,0 | 25,0 |
| PMX16-06300-32N1   | 02925840 | Acél                  | 32,5 - 60,5    | 124,0 | 110,0 | 61,0 | 63,0  | 32,0 |
| PMX16-12700-32N1   | 02925841 | Acél                  | 32,5 - 60,5    | 188,0 | 174,0 | 61,0 | 127,0 | 32,0 |
| PMX16-17000-32N1   | 02925842 | Acél                  | 32,5 - 60,5    | 231,0 | 217,0 | 61,0 | 170,0 | 32,0 |
| PMX16HM-17000-32N1 | 02925843 | Keményfém             | 32,5 - 60,5    | 231,0 | 217,0 | 61,0 | 170,0 | 32,0 |

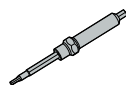
### Pótalkatrészek

| Szár  | Ø (mm)       | Rögzítő kulcs | Rögzítő készlet | Hűtőfolyadék készlet | Dugó csavar, zsák furat | Dugó csavar, átmenő furat |
|-------|--------------|---------------|-----------------|----------------------|-------------------------|---------------------------|
| 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                      |

\* Alkatrészek csak a PMX16 szerszámhoz. A PMX16-hoz a dugó csavar használható a rögzítéshez.

Kiegészítők

| For dia. (mm) | Szár Méret | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Nyomaték kulcs | Rendelési és termék szám | Nyomaték kulcs | Nyomaték érték |
|---------------|------------|--------------------------|------------------|--------------------------|------------------|--------------------------|----------------|--------------------------|----------------|----------------|
| 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         |



Bevezetés

Fűrés

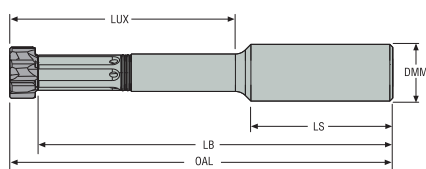
Dörzsárazás

Késztergálás

Melléklet

## Szárak zsák furatokhoz

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriához lásd a 339 old.

| Megnevezés          | Cikkszám | Szerszám tartó anyaga | DC             | OAL   | LB    | LS   | LUX   | DMM  |
|---------------------|----------|-----------------------|----------------|-------|-------|------|-------|------|
|                     |          |                       | mm             | mm    | mm    | mm   | mm    | mm   |
| PMX05B-02800-10N1   | 03144322 | Acél                  | 7,75 - 9,9     | 69,0  | 63,0  | 40,0 | 28,0  | 10,0 |
| PMX05B-04100-10N1   | 03144323 | Acél                  | 7,75 - 9,9     | 84,0  | 78,0  | 40,0 | 41,0  | 10,0 |
| PMX05B-10000-10N1   | 03144324 | Acél                  | 7,75 - 9,9     | 143,0 | 137,0 | 40,0 | 100,0 | 10,0 |
| PMX06B-03700-12N1   | 03075433 | Acél                  | 9,901 - 14,499 | 84,0  | 77,0  | 45,0 | 37,0  | 12,0 |
| PMX06B-05700-12N1   | 03075434 | Acél                  | 9,901 - 14,499 | 104,0 | 97,0  | 45,0 | 57,0  | 12,0 |
| PMX06B-12000-12N1   | 03075435 | Acél                  | 9,901 - 14,499 | 167,0 | 160,0 | 45,0 | 120,0 | 12,0 |
| PMX06BHM-12000-12N1 | 03075436 | Keményfém             | 9,901 - 14,499 | 167,0 | 160,0 | 45,0 | 120,0 | 12,0 |
| PMX08B-04600-20N1   | 03075437 | Acél                  | 14,5 - 21,499  | 99,0  | 89,0  | 50,0 | 46,0  | 20,0 |
| PMX08B-08200-20N1   | 03075438 | Acél                  | 14,5 - 21,499  | 135,0 | 125,0 | 50,0 | 82,0  | 20,0 |
| PMX08B-14500-20N1   | 03075439 | Acél                  | 14,5 - 21,499  | 198,0 | 188,0 | 50,0 | 145,0 | 20,0 |
| PMX08BHM-14500-20N1 | 03075440 | Keményfém             | 14,5 - 21,499  | 198,0 | 188,0 | 50,0 | 145,0 | 20,0 |
| PMX12B-06800-25N1   | 03075441 | Acél                  | 21,5 - 32,499  | 127,0 | 115,0 | 56,0 | 68,0  | 25,0 |
| PMX12B-10400-25N1   | 03075442 | Acél                  | 21,5 - 32,499  | 163,0 | 151,0 | 56,0 | 104,0 | 25,0 |
| PMX12B-17000-25N1   | 03075443 | Acél                  | 21,5 - 32,499  | 229,0 | 217,0 | 56,0 | 170,0 | 25,0 |
| PMX12BHM-17000-25N1 | 03075444 | Keményfém             | 21,5 - 32,499  | 229,0 | 217,0 | 56,0 | 170,0 | 25,0 |
| PMX16B-06300-32N1   | 03075445 | Acél                  | 32,5 - 60,5    | 124,0 | 110,0 | 61,0 | 63,0  | 32,0 |
| PMX16B-12700-32N1   | 03075446 | Acél                  | 32,5 - 60,5    | 188,0 | 174,0 | 61,0 | 127,0 | 32,0 |
| PMX16B-17000-32N1   | 03075447 | Acél                  | 32,5 - 60,5    | 231,0 | 217,0 | 61,0 | 170,0 | 32,0 |
| PMX16BHM-17000-32N1 | 03075448 | Keményfém             | 32,5 - 60,5    | 231,0 | 217,0 | 61,0 | 170,0 | 32,0 |

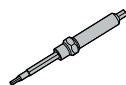
## Pótalkatrészek

| Szár   | Ø (mm)        | Rögzítő kulcs | Rögzítő készlet | Dugó csavar, zsák furat |
|--------|---------------|---------------|-----------------|-------------------------|
|        |               |               |                 |                         |
| 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                    |

\* Alkatrészek csak a PMX16 szerszámhoz. A PMX16-hoz a dugó csavar használható a rögzítéshez.

Kiegészítők

| For dia. (mm) | Szár Méret | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Nyomaték kulcs | Rendelési és termék szám | Nyomaték kulcs | Nyomaték érték |
|---------------|------------|--------------------------|------------------|--------------------------|------------------|--------------------------|----------------|--------------------------|----------------|----------------|
| 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         |



Bevezetés

Fűrés

Dörzsárazás

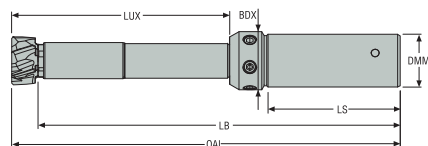
Késztergálás

Melléklet



## Állítható szárok átmenő furatokhoz

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

| Megnevezés           | Cikkszám | 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 |

### Pótalkatrészek

| Szár   | Ø (mm)       | Rögzítő kulcs | Hűtőfolyadék gyűrű | Beállító kulcs | Beállító   |
|--------|--------------|---------------|--------------------|----------------|------------|
|        |              |               |                    |                |            |
| 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        | -          |

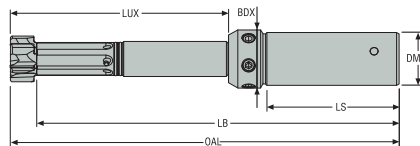
### Kiegészítők

| For dia. (mm) | Szár Méret | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Nyomaték kulcs | Rendelési és termék szám | Nyomaték kulcs | Nyomaték érték |
|---------------|------------|--------------------------|------------------|--------------------------|------------------|--------------------------|----------------|--------------------------|----------------|----------------|
|               |            |                          |                  |                          |                  |                          |                |                          |                |                |
| 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         |

Note: Repair clamp kit PMxx-CLKI are not suitable for PMX FL & AD type

## Állítható száraz zsák furatokhoz

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhöz lásd a 339 old.

| Megnevezés           | Cikkszám | 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 |

### Pótalkatrészek

| Szár   | Ø (mm)       | Rögzítő kulcs | Beállító kulcs | Beállító   |
|--------|--------------|---------------|----------------|------------|
|        |              |               |                |            |
| 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        | -          |

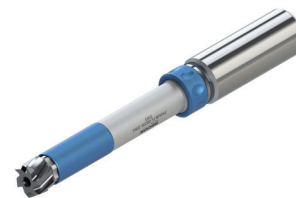
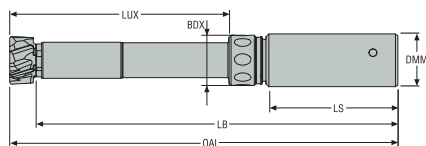
### Kiegészítők

| For dia. (mm) | Szár Méret | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Nyomaték kulcs | Rendelési és termék szám | Nyomaték kulcs | Nyomaték érték |
|---------------|------------|--------------------------|------------------|--------------------------|------------------|--------------------------|----------------|--------------------------|----------------|----------------|
|               |            |                          |                  |                          |                  |                          |                |                          |                |                |
| 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         |

Note: Repair clamp kit PMxx-CLKI are not suitable for PMX FL & AD type

## Úszó szárak átmenő furatokhoz

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

| Megnevezés           | Cikkszám | 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 |

### Pótalkatrészek

| Szár   | Ø (mm)       | Rögzítő kulcs | Hűtőfolyadék gyűrű |
|--------|--------------|---------------|--------------------|
|        |              |               |                    |
| 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       | -                  |

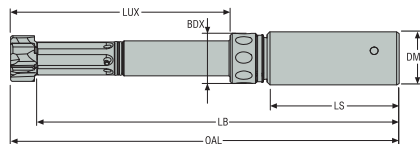
### Kiegészítők

| For dia. (mm) | Szár Méret | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Nyomaték kulcs | Rendelési és termék szám | Nyomaték kulcs | Nyomaték érték |
|---------------|------------|--------------------------|------------------|--------------------------|------------------|--------------------------|----------------|--------------------------|----------------|----------------|
|               |            |                          |                  |                          |                  |                          |                |                          |                |                |
| 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         |

Note: Repair clamp kit PMxx-CLKI are not suitable for PMX FL & AD type

## Úszó szárak zsák furatokhoz

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriához lásd a 339 old.

| Megnevezés           | Cikkszám | 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 |

### Pótalkatrészek

| Szár   | Ø (mm)       | Rögzítő kulcs |
|--------|--------------|---------------|
|        |              |               |
| 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       |

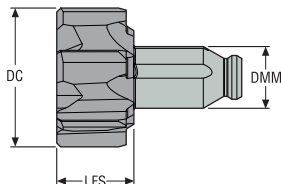
### Kiegészítők

| For dia. (mm) | Szár Méret | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Cserélhető betét | Rendelési és termék szám | Nyomaték kulcs | Rendelési és termék szám | Nyomaték kulcs | Nyomaték érték |
|---------------|------------|--------------------------|------------------|--------------------------|------------------|--------------------------|----------------|--------------------------|----------------|----------------|
|               |            |                          |                  |                          |                  |                          |                |                          |                |                |
| 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         |

Note: Repair clamp kit PMxx-CLKI are not suitable for PMx FL & AD type

## Fejek zsák- és átmenő furatokhoz, Egyedi kivitel

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

| Megnevezés        | DCN           | DCX             | LFS           | DMM           | Test méret | Geometriák | Minőségek |       |        |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |
|-------------------|---------------|-----------------|---------------|---------------|------------|------------|-----------|-------|--------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
|                   |               |                 |               |               |            |            | H15       | CP20  | RX2000 | RK2050                   | RK1550                   | CF                       | RX1500                   | RN2010                   | RM2020                   | RM2090                   | RS2090                   |                          |                          |                          |
| PMX5-7.75-XX-XXXX | 7,75<br>0.305 | 9,999<br>0.394  | 6,0<br>0.236  | 4,5<br>0.177  | 6          | PMX05-xx   | EB45      | EB845 | EB30   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-10.0-XX-XXXX | 10,0<br>0.394 | 14,499<br>0.571 | 7,0<br>0.276  | 6,0<br>0.236  | 6          | PMX06-xx   | EB45      | EB845 | EB30   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-14.5-XX-XXXX | 14,5<br>0.571 | 21,499<br>0.846 | 10,0<br>0.394 | 8,0<br>0.315  | 6          | PMX08-xx   | EB45      | EB845 | EB30   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-21.5-XX-XXXX | 21,5<br>0.846 | 32,499<br>1.279 | 12,0<br>0.472 | 12,0<br>0.472 | 8          | PMX12-xx   | EB45      | EB845 | EB30   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX5-32.5-XX-XXXX | 32,5<br>1.280 | 60,5<br>2.382   | 14,0<br>0.551 | 16,0<br>0.630 | 10         | PMX16-xx   | EB45      | EB845 | EB30   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

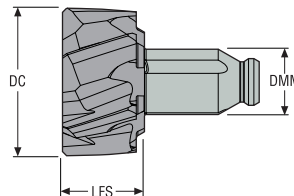
= Nem raktári szabványos. A változtatás jogát fenntartjuk az érvényes ár- és raktárlista szerint

Megjegyzés: Mikor köztes méretű Precimaster Plus dörzsárat rendel, kérjük jelezze az átmérőt és a dörzsárazási kívánt furat türet.

Rendelési példa: PMX5-16.515 P7-EB45 RM2020. PMX6-16.515 P7-EB45 RM2020.

## Fejek átmenő furatokhoz, Egyedi kivitel

Ø 7,75-60,500 mm / 0.305-2.381"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

| Megnevezés        | DCN           | DCX             | LFS           | DMM           | Test méret | Geometriák | Minőségek   |  |
|-------------------|---------------|-----------------|---------------|---------------|------------|------------|---|--|
|                   | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    |            |            | H15<br>CP20<br>RX2000<br>RX2050<br>RX1550<br>CF<br>RX1500<br>RN2010<br>RM2020<br>RM2090<br>RS2090 |  |
| PMX6-7.75-XX-XXXX | 7,75<br>0.305 | 9,999<br>0.394  | 6,0<br>0.236  | 4,5<br>0.177  | 6          | PMX05-xx   | EB45 EB845 EB30   | <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |
| PMX6-10.0-XX-XXXX | 10,0<br>0.394 | 14,499<br>0.571 | 7,0<br>0.276  | 6,0<br>0.236  | 6          | PMX06-xx   | EB45 EB845 EB30   | <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |
| PMX6-14.5-XX-XXXX | 14,5<br>0.571 | 21,499<br>0.846 | 10,0<br>0.394 | 8,0<br>0.315  | 6          | PMX08-xx   | EB45 EB845 EB30   | <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |
| PMX6-21.5-XX-XXXX | 21,5<br>0.846 | 32,499<br>1.279 | 12,0<br>0.472 | 12,0<br>0.472 | 8          | PMX12-xx   | EB45 EB845 EB30   | <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |
| PMX6-32.5-XX-XXXX | 32,5<br>1.280 | 60,5<br>2.382   | 14,0<br>0.551 | 16,0<br>0.630 | 10         | PMX16-xx   | EB45 EB845 EB30   | <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> |

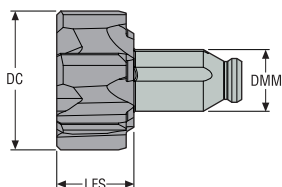
= Nem raktári szabványos. A változtatás jogát fenntartjuk az érvényes ár- és raktárlista szerint

Megjegyzés: Mikor köztes méretű Precimaster Plus dörzsárat rendel, kérjük jelezze az átmérőt és a dörzsárazni kívánt furat tűrését.

Rendelési példa: PMX5-16.515 P7-EB45 RM2020. PMX6-16.515 P7-EB45 RM2020.

## Bővíthető fejek átmenő és zsák furatokhoz

Ø 10,00-32,500 mm / 0.393-1.279"



- Forgácsolási adatokat lásd a 360-367 old.
- Az EB45, EB845 vagy EB30 forgácsolási geometriákhoz lásd a 339 old.

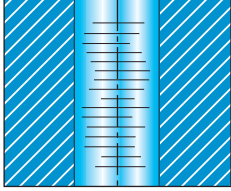
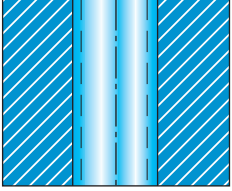
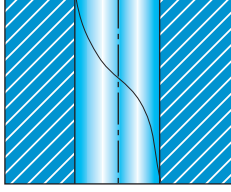
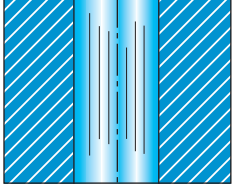
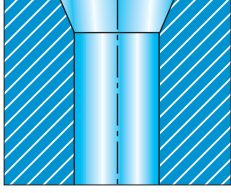
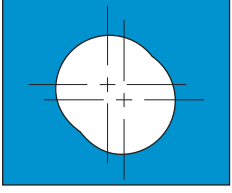
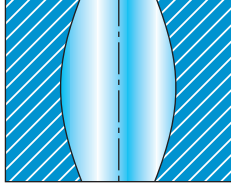
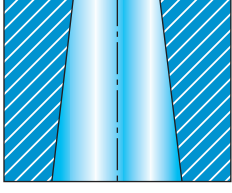
| Megnevezés        | DCN           | DCX             | LFS           | DMM           | Test méret | Geometriák | Minőségek       |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |                          |
|-------------------|---------------|-----------------|---------------|---------------|------------|------------|-----------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
|                   | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    |            |            | H15             | CP20                     | RX2000                   | RK2050                   | RK1550                   | CF                       | RX1500                   | RN2010                   | RM2020                   | RM2090                   | RS2090                   |                          |                          |
| PMX8-10.0-XX-XXXX | 10,0<br>0.394 | 14,499<br>0.571 | 7,0<br>0.276  | 6,0<br>0.236  | 6          | PMX06-xx   | EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX8-14.5-XX-XXXX | 14,5<br>0.571 | 21,499<br>0.846 | 10,0<br>0.394 | 8,0<br>0.315  | 6          | PMX08-xx   | EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| PMX8-21.5-XX-XXXX | 21,5<br>0.846 | 32,499<br>1.279 | 12,0<br>0.472 | 12,0<br>0.472 | 8          | PMX12-xx   | EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

= Nem raktári szabványos. A változtatás jogát fenntartjuk az érvényes ár- és raktárlista szerint

Megjegyzés: Mikor köztes méretű Precimaster Plus dörzsárat rendel, kérjük jelezzé az átmérőt és a dörzsárazni kívánt furat típusát.

Rendelési példa: PMX8-16.515 P7-EB45 RM2020.

## Problémamegoldás

|   |   |
|---|---|
| <p><b>Gyenge felületi minőség</b></p> <ul style="list-style-type: none"> <li>• Ellenőrizze az anyagráhagyást</li> <li>• Javítsa a hűtési körülményeket (kiömlő nyílás típusa, nyomás, minőség)</li> <li>• Csökkentse az előtolási sebességet</li> </ul>        | <p><b>Túl nagy átmérő</b></p> <ul style="list-style-type: none"> <li>• Javítsa a központosságot (darab/ szerszám)</li> </ul>   |
| <p><b>Barázdák</b></p> <ul style="list-style-type: none"> <li>• Javítsa a hűtési körülményeket (kiömlő nyílás típusa, nyomás, minőség)</li> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Csökkentse a kilépési előtolás sebességét</li> </ul>  | <p><b>Függőleges barázdák</b></p> <ul style="list-style-type: none"> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Ellenőrizze az anyagráhagyást</li> </ul>   |
| <p><b>Kúpos bemeneti nyílás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse az előtolási sebességet</li> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Csökkentse a radiális ütést</li> </ul>                                      | <p><b>Nem pontos központ/ovalitás</b></p> <ul style="list-style-type: none"> <li>• Javítsa a darab rögzítését (munkadarab-deformáció)</li> <li>• Ellenőrizze az anyagráhagyást</li> <li>• Javítsa a központosságot (darab/ szerszám)</li> </ul>  |
| <p><b>Deformált furat</b></p> <ul style="list-style-type: none"> <li>• Javítsa a darab rögzítését (munkadarab-deformáció)</li> </ul>   | <p><b>Kúpos furat</b></p> <ul style="list-style-type: none"> <li>• Javítsa a központosságot (darab/ szerszám)</li> </ul>   |



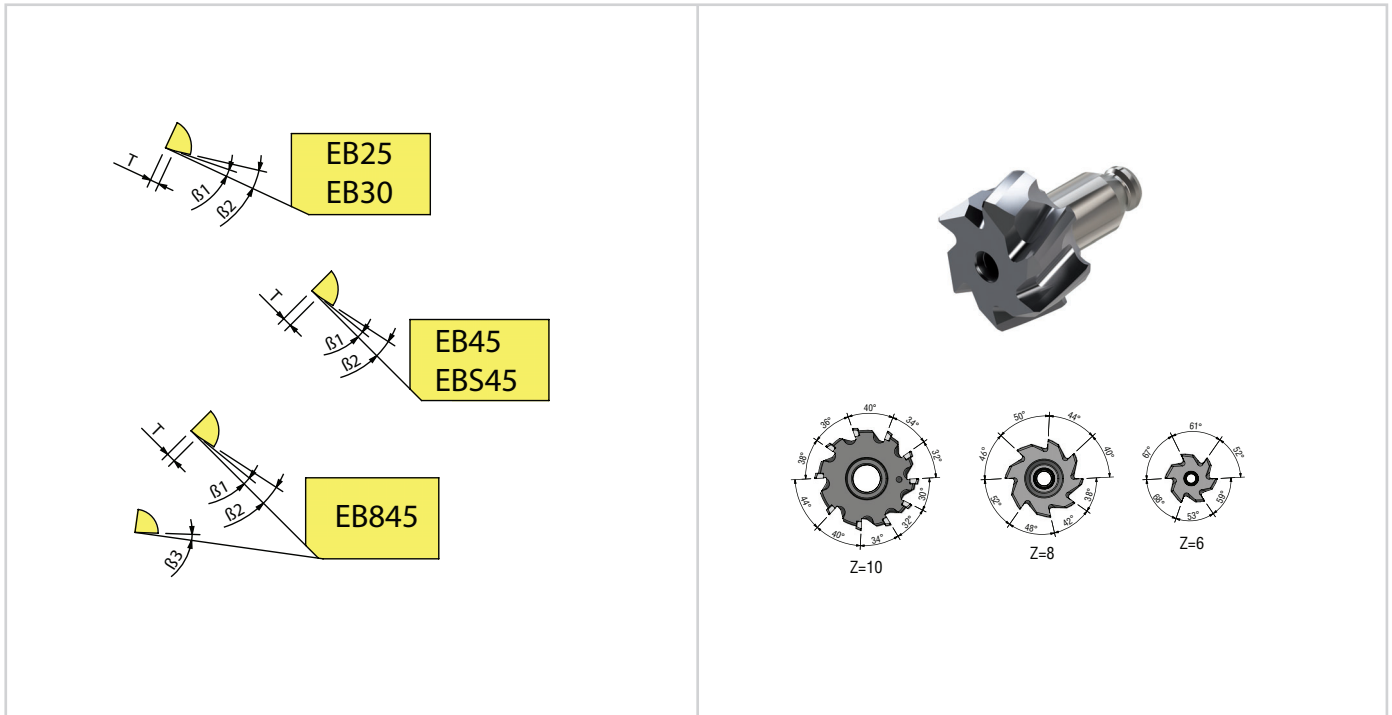
## Újraélezési utasítások

### Utasítások

Gyémánt köszörűkorong  
Szemcseméret:  
**D6** – Az első hátszöghöz ( $\beta_1$ – $\beta_3$ )  
**D64** – A második hátszöghöz ( $\beta_2$ )

### Fontos:

A köszörülés csökkenti a dörzsár átmérőjét.  
Az újrabevonolás túl nagy átmérőt eredményezhet.  
Max. ütés a vezető letöréseken 10  $\mu\text{m}$  (394  $\mu\text{in}$ )



| $\varnothing$ Precimaster Plus mm (inch) | $\beta_1$ | $\beta_2$ | $\beta_3$ | T mm (inch)  |
|--|-----------|-----------|-----------|--------------|
| 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) |

Forgácsolási adatok – PM Plus... -EB45 metrikus

| SMG |                  | $a_p (\varnothing)$ |               | f             |               |               | $v_c$          |                |                |                |                 |                  |                  |                |               |               |        |
|-----|------------------|---------------------|---------------|---------------|---------------|---------------|----------------|----------------|----------------|----------------|-----------------|------------------|------------------|----------------|---------------|---------------|--------|
|     |                  | z=6                 | z=8<br>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<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30)  | 60<br>(30-100) | 80<br>(30-150) | -              | 180<br>(90-200) | 220<br>(120-300) | -                | -              | -             | -             | -      |
| P2  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30)  | 60<br>(30-100) | 80<br>(30-150) | -              | 180<br>(90-200) | 220<br>(120-300) | -                | -              | -             | -             | -      |
| P3  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30)  | 60<br>(30-100) | 80<br>(30-150) | -              | 180<br>(90-200) | 220<br>(120-300) | -                | -              | -             | -             | -      |
| P4  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -              | -             | -             | -      |
| P5  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -              | -             | -             | -      |
| P6  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -              | -             | -             | -      |
| P7  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -              | -             | -             | -      |
| P8  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 15<br>(10-20)  | 35<br>(20-60)  | 40<br>(20-80)  | -              | 80<br>(60-120)  | 120<br>(80-180)  | -                | -              | -             | -             | -      |
| P11 | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 15<br>(10-20)  | 35<br>(20-60)  | 40<br>(20-80)  | -              | 80<br>(60-120)  | 120<br>(80-180)  | -                | -              | -             | -             | -      |
| P12 | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 12<br>(8-15)   | 25<br>(15-45)  | 30<br>(15-65)  | -              | 65<br>(45-95)   | 95<br>(65-145)   | -                | -              | -             | -             | -      |
| M1  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 12<br>(9-15)   | 25<br>(15-45)  | 35<br>(20-70)  | -              | -               | -                | -                | -              | 25<br>(15-40) | 40<br>(25-80) | -      |
| M2  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 25<br>(15-45)  | 35<br>(20-70)  | -              | -               | -                | -                | -              | 25<br>(15-40) | 40<br>(25-80) | -      |
| M3  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 25<br>(15-45)  | 35<br>(20-70)  | -              | -               | -                | -                | -              | 25<br>(15-40) | 40<br>(25-80) | -      |
| M4  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 20<br>(10-30)  | 25<br>(15-50)  | -              | -               | -                | -                | -              | 20<br>(10-30) | 30<br>(20-60) | -      |
| M5  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 20<br>(10-30)  | 25<br>(15-50)  | -              | -               | -                | -                | -              | 20<br>(10-30) | 30<br>(20-60) | -      |
| K1  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30)  | 60 (40-100)    | 80<br>(30-150) | 90<br>(35-170) | -               | 220<br>(120-300) | 245<br>(135-335) | -              | -             | -             | -      |
| K2  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -              | 25<br>(20-40)  | 40<br>(30-70)  | 45<br>(35-80)  | -               | 80<br>(50-100)   | 90<br>(55-110)   | -              | -             | -             | -      |
| K3  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30)  | 60 (40-100)    | 80<br>(30-150) | 90<br>(35-170) | -               | 220<br>(120-300) | 245<br>(135-335) | -              | -             | -             | -      |
| K4  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(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<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(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<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -              | 60 (40-100)    | 80 (30-150)    | 90 (35-170)    | -               | 220 (120-300)    | 245 (135-335)    | -              | -             | -             | -      |
| K7  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -              | 60 (40-100)    | 80 (30-150)    | 90 (35-170)    | -               | 220 (120-300)    | 245 (135-335)    | -              | -             | -             | -      |
| N1  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 50<br>(30-100) | -              | 80<br>(30-150) | -              | -               | -                | -                | 50<br>(30-100) | -             | -             | -      |
| N2  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 50<br>(30-100) | -              | 80<br>(30-150) | -              | -               | -                | -                | 50<br>(30-100) | -             | -             | -      |
| N3  | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 50<br>(30-100) | -              | 80<br>(30-150) | -              | -               | -                | -                | 50<br>(30-100) | -             | -             | -      |
| N11 | PMX5...6..8-EB45 | 0,10<br>-0,20       | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 50<br>(30-100) | -              | 80<br>(30-150) | -              | -               | -                | -                | 50<br>(30-100) | -             | -             | -      |
| S1  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 20<br>(10-25)  | 20<br>(10-25)  | -              | -               | -                | -                | -              | -             | -             | -      |
| S2  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 20<br>(10-25)  | 20<br>(10-25)  | -              | -               | -                | -                | -              | -             | -             | -      |
| S3  | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -              | 20<br>(10-25)  | 20<br>(10-25)  | -              | -               | -                | -                | -              | -             | -             | -      |
| S11 | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -              | -               | -                | -                | -              | -             | -             | -      |
| S12 | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -              | -               | -                | -                | -              | -             | -             | -      |
| S13 | PMX5...6..8-EB45 | 0,08<br>-0,15       | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -              | -               | -                | -                | -              | -             | -             | -      |

The table continues on next page.

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Forgácsolási adatok – PM Plus... -EB45 metrikus

| SMG |                  | $a_p$ (°)     |               | f             |               |               | $v_c$         |               |                |        |    |        |        |        |        |        |        |
|-----|------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|--------|----|--------|--------|--------|--------|--------|--------|
|     |                  | z=6           | z=8<br>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<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H5  | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H7  | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H8  | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H11 | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H12 | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H21 | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| H31 | PMX5 .6 .8 -EB45 | 0,08<br>-0,15 | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -             | 10<br>(8-15)   | -      | -  | -      | -      | -      | -      | -      | -      |
| PM1 | PMX5 .6 .8 -EB45 | 0,10<br>-0,20 | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 50<br>(30-80) | 70<br>(40-100) | -      | -  | -      | -      | -      | -      | -      | -      |
| PM2 | PMX5 .6 .8 -EB45 | 0,10<br>-0,20 | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 50<br>(30-80) | 70<br>(40-100) | -      | -  | -      | -      | -      | -      | -      | -      |
| PM3 | PMX5 .6 .8 -EB45 | 0,10<br>-0,20 | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 50<br>(30-80) | 70<br>(40-100) | -      | -  | -      | -      | -      | -      | -      | -      |
| TS1 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TS2 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TS3 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TS4 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP1 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP2 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP3 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP4 | PMX5 .6 .8 -EB45 | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -  | -      | -      | -      | -      | -      | -      |
| GR1 | PMX5 .6 .8 -EB45 | 0,10<br>-0,30 | 0,10<br>-0,40 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 40<br>(80-20) | -             | 60<br>(30-120) | -      | -  | -      | -      | -      | -      | -      | -      |

SMG = Seco anyagcsoport

$a_p$  = mm

f = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – PM Plus...-EB45 inch

| SMG |                  | a <sub>p</sub> (°) |               | f             |               |               | v <sub>c</sub>   |                  |                  |                  |                  |                  |                   |                  |                |                 |                 |
|-----|------------------|--------------------|---------------|---------------|---------------|---------------|------------------|------------------|------------------|------------------|------------------|------------------|-------------------|------------------|----------------|-----------------|-----------------|
|     |                  | z=6                | z=8<br>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<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 195<br>(100-330) | 260<br>(100-490) | -                | 590<br>(295-655) | 720<br>(395-985) | -                 | -                | -              | -               | -               |
| P2  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 195<br>(100-330) | 260<br>(100-490) | -                | 590<br>(295-655) | 720<br>(395-985) | -                 | -                | -              | -               | -               |
| P3  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 195<br>(100-330) | 260<br>(100-490) | -                | 590<br>(295-655) | 720<br>(395-985) | -                 | -                | -              | -               | -               |
| P4  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)    | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -                | -              | -               | -               |
| P5  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)    | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -                | -              | -               | -               |
| P6  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)    | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -                | -              | -               | -               |
| P7  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)    | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -                | -              | -               | -               |
| P8  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 50<br>(35-65)    | 115<br>(65-195)  | 130<br>(65-260)  | -                | 260<br>(195-395) | 395<br>(260-590) | -                 | -                | -              | -               | -               |
| P11 | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 50<br>(35-65)    | 115<br>(65-195)  | 130<br>(65-260)  | -                | 260<br>(195-395) | 395<br>(260-590) | -                 | -                | -              | -               | -               |
| P12 | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.008 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 40<br>(25-50)    | 80<br>(50-130)   | 100<br>(50-215)  | -                | 215<br>(150-315) | 315<br>(215-480) | -                 | -                | -              | -               | -               |
| M1  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 40<br>(30-50)    | 80<br>(50-130)   | 115<br>(65-230)  | -                | -                | -                | -                 | -                | 80<br>(50-130) | 130<br>(80-260) | -               |
| M2  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 80<br>(50-130)   | 115<br>(65-230)  | -                | -                | -                | -                 | -                | 80<br>(50-130) | 130<br>(80-260) | -               |
| M3  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 80<br>(50-130)   | 115<br>(65-230)  | -                | -                | -                | -                 | -                | 80<br>(50-130) | 130<br>(80-260) | -               |
| M4  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 65<br>(35-100)   | 80<br>(50-165)   | -                | -                | -                | -                 | -                | 65<br>(35-100) | 100<br>(65-195) | -               |
| M5  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 65<br>(35-100)   | 80<br>(50-165)   | -                | -                | -                | -                 | -                | 65<br>(35-100) | 100<br>(65-195) | -               |
| K1  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -                | -              | -               | -               |
| K2  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -                | 80<br>(65-130)   | 130<br>(100-230) | 145<br>(110-260) | -                | 260<br>(165-330) | 290<br>(185-370)  | -                | -              | -               | -               |
| K3  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -                | -              | -               | -               |
| K4  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 150<br>(100-230) | 230<br>(130-395) | 260<br>(145-440) | 330<br>(230-490) | 490<br>(260-655) | 550<br>(290-735)  | -                | -              | -               | -               |
| K5  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100)   | 150<br>(100-230) | 230<br>(130-395) | 260<br>(145-440) | 330<br>(230-490) | 490<br>(260-655) | 550<br>(290-735)  | -                | -              | -               | -               |
| K6  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -                | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -                | -              | -               | -               |
| K7  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -                | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -                | -              | -               | -               |
| N1  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 165<br>(100-330) | -                | 260<br>(100-490) | -                | -                | -                | -                 | 165<br>(100-330) | -              | -               | -               |
| N2  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 165<br>(100-330) | -                | 260<br>(100-490) | -                | -                | -                | -                 | 165<br>(100-330) | -              | -               | -               |
| N3  | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 165<br>(100-330) | -                | 260<br>(100-490) | -                | -                | -                | -                 | 165<br>(100-330) | -              | -               | -               |
| N11 | PMX5...6..8-EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 165<br>(100-330) | -                | 260<br>(100-490) | -                | -                | -                | -                 | 165<br>(100-330) | -              | -               | -               |
| S1  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 65<br>(35-80)    | 65<br>(35-80)    | -                | -                | -                | -                 | -                | -              | -               | 80<br>(40-100)  |
| S2  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 65<br>(35-80)    | 65<br>(35-80)    | -                | -                | -                | -                 | -                | -              | -               | 80<br>(40-100)  |
| S3  | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -                | 65<br>(35-80)    | 65<br>(35-80)    | -                | -                | -                | -                 | -                | -              | -               | 80<br>(40-100)  |
| S11 | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 65<br>(50-100)   | 100<br>(50-130)  | 130<br>(65-165)  | -                | -                | -                | -                 | -                | -              | -               | 165<br>(80-215) |
| S12 | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 65<br>(50-100)   | 100<br>(50-130)  | 130<br>(65-165)  | -                | -                | -                | -                 | -                | -              | -               | 165<br>(80-215) |
| S13 | PMX5...6..8-EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 65<br>(50-100)   | 100<br>(50-130)  | 130<br>(65-165)  | -                | -                | -                | -                 | -                | -              | -               | 165<br>(80-215) |

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Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## Forgácsolási adatok – PM Plus...-EB45 inch

| SMG |                    | a <sub>p</sub> (°) |               | f             |               |               | v <sub>c</sub>  |                  |                  |        |    |        |        |        |        |        |        |
|-----|--------------------|--------------------|---------------|---------------|---------------|---------------|-----------------|------------------|------------------|--------|----|--------|--------|--------|--------|--------|--------|
|     |                    | z=6                | z=8<br>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<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| H7  | PMX5 ..6 ..8 -EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| H8  | PMX5 ..6 ..8 -EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| H11 | PMX5 ..6 ..8 -EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| H12 | PMX5 ..6 ..8 -EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| H21 | PMX5 ..6 ..8 -EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| H31 | PMX5 ..6 ..8 -EB45 | .003<br>-.006      | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -               | -                | 35<br>(25-50)    | -      | -  | -      | -      | -      | -      | -      | -      |
| PM1 | PMX5 ..6 ..8 -EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -               | 165<br>(100-260) | 230<br>(130-330) | -      | -  | -      | -      | -      | -      | -      | -      |
| PM2 | PMX5 ..6 ..8 -EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -               | 165<br>(100-260) | 230<br>(130-330) | -      | -  | -      | -      | -      | -      | -      | -      |
| PM3 | PMX5 ..6 ..8 -EB45 | .004<br>-.008      | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -               | 165<br>(100-260) | 230<br>(130-330) | -      | -  | -      | -      | -      | -      | -      | -      |
| TS1 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TS2 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TS3 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TS4 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP1 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP2 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP3 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| TP4 | PMX5 ..6 ..8 -EB45 | .004<br>-.006      | .004<br>-.008 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -  | -      | -      | -      | -      | -      | -      |
| GR1 | PMX5 ..6 ..8 -EB45 | .004<br>-.012      | .004<br>-.016 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 130<br>(260-65) | -                | 195<br>(100-395) | -      | -  | -      | -      | -      | -      | -      | -      |

SMG = Seco anyagcsoport

 a<sub>p</sub> = inch

f = in/ford

 v<sub>c</sub> = sf/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – PM Plus...-EB845 metrikus

| SMG |                     | $a_p (\text{°})$ |               | f             |               |               | $v_c$         |                |                |                |                 |                  |                  |               |               |               |
|-----|---------------------|------------------|---------------|---------------|---------------|---------------|---------------|----------------|----------------|----------------|-----------------|------------------|------------------|---------------|---------------|---------------|
|     |                     | z=6              | z=8<br>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<br>-0,20    | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30) | 60<br>(30-100) | 80<br>(30-150) | -              | 180<br>(90-200) | 220<br>(120-300) | -                | -             | -             | -             |
| P4  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25) | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -             | -             | -             |
| P5  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25) | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -             | -             | -             |
| P6  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25) | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -             | -             | -             |
| P7  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 20<br>(10-25) | 50<br>(30-80)  | 60<br>(30-120) | -              | 120<br>(80-150) | 180<br>(90-200)  | -                | -             | -             | -             |
| P8  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 15<br>(10-20) | 35<br>(20-60)  | 40<br>(20-80)  | -              | 80<br>(60-120)  | 120<br>(80-180)  | -                | -             | -             | -             |
| P11 | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 15<br>(10-20) | 35<br>(20-60)  | 40<br>(20-80)  | -              | 80<br>(60-120)  | 120<br>(80-180)  | -                | -             | -             | -             |
| P12 | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,30 | 0,20<br>-0,70 | 0,30<br>-1,00 | 0,40<br>-1,20 | 12<br>(8-15)  | 25<br>(15-45)  | 30<br>(15-65)  | -              | 65<br>(45-95)   | 95<br>(65-145)   | -                | -             | -             | -             |
| M1  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 12<br>(9-15)  | 25<br>(15-45)  | 35<br>(20-70)  | -              | -               | -                | -                | 25<br>(15-40) | 35<br>(20-70) | -             |
| M2  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 25<br>(15-45)  | 35<br>(20-70)  | -              | -               | -                | -                | 25<br>(15-40) | 35<br>(20-70) | -             |
| M3  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 25<br>(15-45)  | 35<br>(20-70)  | -              | -               | -                | -                | 25<br>(15-40) | 35<br>(20-70) | -             |
| M4  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 20<br>(10-30)  | 25<br>(15-50)  | -              | -               | -                | -                | 20<br>(10-30) | 25<br>(15-50) | -             |
| M5  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,20 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 20<br>(10-30)  | 25<br>(15-50)  | -              | -               | -                | -                | 20<br>(10-30) | 25<br>(15-50) | -             |
| K1  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30) | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -               | 220<br>(120-300) | 245<br>(135-335) | -             | -             | -             |
| K2  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 25<br>(20-40)  | 40<br>(30-70)  | 45<br>(35-80)  | -               | 80<br>(50-100)   | 90<br>(55-110)   | -             | -             | -             |
| K3  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30) | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -               | 220<br>(120-300) | 245<br>(135-335) | -             | -             | -             |
| K4  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30) | 45<br>(30-70)  | 70<br>(40-120) | 80<br>(45-135) | 100<br>(70-150) | 150<br>(80-200)  | 170<br>(90-225)  | -             | -             | -             |
| K5  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | 25<br>(15-30) | 45<br>(30-70)  | 70<br>(40-120) | 80<br>(45-135) | 100<br>(70-150) | 150<br>(80-200)  | 170<br>(90-225)  | -             | -             | -             |
| K6  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -               | 220<br>(120-300) | 245<br>(135-335) | -             | -             | -             |
| K7  | PMX5 ..6 ..8 -EB845 | 0,10<br>-0,20    | 0,10<br>-0,25 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -               | 220<br>(120-300) | 245<br>(135-335) | -             | -             | -             |
| S1  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 20<br>(10-25)  | 20<br>(10-25)  | -              | -               | -                | -                | -             | -             | 25<br>(12-30) |
| S2  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 20<br>(10-25)  | 20<br>(10-25)  | -              | -               | -                | -                | -             | -             | 25<br>(12-30) |
| S3  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | -             | 20<br>(10-25)  | 20<br>(10-25)  | -              | -               | -                | -                | -             | -             | 25<br>(12-30) |
| S11 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 20<br>(15-30) | 30<br>(15-40)  | 40<br>(20-50)  | -              | -               | -                | -                | -             | -             | 50<br>(25-65) |
| S12 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 20<br>(15-30) | 30<br>(15-40)  | 40<br>(20-50)  | -              | -               | -                | -                | -             | -             | 50<br>(25-65) |
| S13 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,60 | 0,30<br>-0,80 | 0,40<br>-1,00 | 20<br>(15-30) | 30<br>(15-40)  | 40<br>(20-50)  | -              | -               | -                | -                | -             | -             | 50<br>(25-65) |
| H3  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H5  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H7  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H8  | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H11 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H12 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H21 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| H31 | PMX5 ..6 ..8 -EB845 | 0,08<br>-0,15    | 0,10<br>-0,15 | 0,20<br>-0,40 | 0,30<br>-0,60 | 0,40<br>-0,75 | -             | -              | 10<br>(8-15)   | -              | -               | -                | -                | -             | -             | -             |
| PM1 | PMX5 ..6 ..8 -EB845 | 0,10<br>0,20     | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 50<br>(30-80)  | 70<br>(40-100) | -              | -               | -                | -                | -             | -             | -             |
| PM2 | PMX5 ..6 ..8 -EB845 | 0,10<br>0,20     | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 50<br>(30-80)  | 70<br>(40-100) | -              | -               | -                | -                | -             | -             | -             |
| PM3 | PMX5 ..6 ..8 -EB845 | 0,10<br>0,20     | 0,10<br>-0,30 | 0,30<br>-0,90 | 0,40<br>-1,20 | 0,50<br>-1,50 | -             | 50<br>(30-80)  | 70<br>(40-100) | -              | -               | -                | -                | -             | -             | -             |

SMG = Seco anyagcsoport  
 $a_p$  = mm  
 f = mm/ford  
 $v_c$  = m/perc  
 Minden forgácsolási paraméter kezdeti érték

**Forgácsolási adatok – PM Plus...-EB845 inch**

| SMG |                 | $a_p$ (°)     |               | f             |               |               | $v_c$          |                  |                  |                  |                  |                  |                   |                |                 |                 |
|-----|-----------------|---------------|---------------|---------------|---------------|---------------|----------------|------------------|------------------|------------------|------------------|------------------|-------------------|----------------|-----------------|-----------------|
|     |                 | z=6           | z=8<br>z=10   | z=6           | z=8           | z=10          | H15            | CP20             | RX2000           | RK2050           | CF               | RX1500           | RK1550            | RM2020         | RM2090          | RS2090          |
| P3  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100) | 195<br>(100-330) | 260<br>(100-490) | -                | 590<br>(295-655) | 720<br>(395-985) | -                 | -              | -               | -               |
| P4  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -              | -               | -               |
| P5  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -              | -               | -               |
| P6  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -              | -               | -               |
| P7  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | 395<br>(260-490) | 590<br>(295-655) | -                 | -              | -               | -               |
| P8  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 50<br>(35-65)  | 115<br>(65-195)  | 130<br>(65-260)  | -                | 260<br>(195-395) | 395<br>(260-590) | -                 | -              | -               | -               |
| P11 | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 50<br>(35-65)  | 115<br>(65-195)  | 130<br>(65-260)  | -                | 260<br>(195-395) | 395<br>(260-590) | -                 | -              | -               | -               |
| P12 | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .008<br>-.028 | .012<br>-.039 | .016<br>-.047 | 40<br>(25-50)  | 80<br>(50-130)   | 100<br>(50-215)  | -                | 215<br>(150-315) | 315<br>(215-480) | -                 | -              | -               | -               |
| M1  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 40<br>(30-50)  | 80<br>(50-130)   | 115<br>(65-230)  | -                | -                | -                | -                 | 80<br>(50-130) | 115<br>(65-230) | -               |
| M2  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 80<br>(50-130)   | 115<br>(65-230)  | -                | -                | -                | -                 | 80<br>(50-130) | 115<br>(65-230) | -               |
| M3  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 80<br>(50-130)   | 115<br>(65-230)  | -                | -                | -                | -                 | 80<br>(50-130) | 115<br>(65-230) | -               |
| M4  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 65<br>(35-100)   | 80<br>(50-165)   | -                | -                | -                | -                 | 65<br>(35-100) | 80<br>(50-165)  | -               |
| M5  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.008 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 65<br>(35-100)   | 80<br>(50-165)   | -                | -                | -                | -                 | 65<br>(35-100) | 80<br>(50-165)  | -               |
| K1  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100) | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -              | -               | -               |
| K2  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -              | 80<br>(65-130)   | 130<br>(100-230) | 145<br>(110-260) | -                | 260<br>(165-330) | 290<br>(185-370)  | -              | -               | -               |
| K3  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100) | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -              | -               | -               |
| K4  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100) | 150<br>(100-230) | 230<br>(130-395) | 260<br>(145-440) | 330<br>(230-490) | 490<br>(260-655) | 550<br>(290-735)  | -              | -               | -               |
| K5  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | 80<br>(50-100) | 150<br>(100-230) | 230<br>(130-395) | 260<br>(145-440) | 330<br>(230-490) | 490<br>(260-655) | 550<br>(290-735)  | -              | -               | -               |
| K6  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -              | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -              | -               | -               |
| K7  | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.010 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -              | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -                | 720<br>(395-985) | 805<br>(440-1105) | -              | -               | -               |
| S1  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 65<br>(35-80)    | 65<br>(35-80)    | -                | -                | -                | -                 | -              | -               | 80<br>(40-100)  |
| S2  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 65<br>(35-80)    | 65<br>(35-80)    | -                | -                | -                | -                 | -              | -               | 80<br>(40-100)  |
| S3  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | -              | 65<br>(35-80)    | 65<br>(35-80)    | -                | -                | -                | -                 | -              | -               | 80<br>(40-100)  |
| S11 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 65<br>(50-100) | 100<br>(50-130)  | 130<br>(65-165)  | -                | -                | -                | -                 | -              | -               | 165<br>(80-215) |
| S12 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 65<br>(50-100) | 100<br>(50-130)  | 130<br>(65-165)  | -                | -                | -                | -                 | -              | -               | 165<br>(80-215) |
| S13 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.024 | .012<br>-.031 | .016<br>-.039 | 65<br>(50-100) | 100<br>(50-130)  | 130<br>(65-165)  | -                | -                | -                | -                 | -              | -               | 165<br>(80-215) |
| H3  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H5  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H7  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H8  | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H11 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H12 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H21 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| H31 | PMX5..6..8-EB45 | .003<br>-.006 | .004<br>-.006 | .008<br>-.016 | .012<br>-.024 | .016<br>-.030 | -              | -                | 35<br>(25-50)    | -                | -                | -                | -                 | -              | -               | -               |
| PM1 | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -              | 165<br>(100-260) | 230<br>(130-330) | -                | -                | -                | -                 | -              | -               | -               |
| PM2 | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -              | 165<br>(100-260) | 230<br>(130-330) | -                | -                | -                | -                 | -              | -               | -               |
| PM3 | PMX5..6..8-EB45 | .004<br>-.008 | .004<br>-.012 | .012<br>-.035 | .016<br>-.047 | .020<br>-.059 | -              | 165<br>(100-260) | 230<br>(130-330) | -                | -                | -                | -                 | -              | -               | -               |

SMG = Seco anyagcsoport  
 $a_p$  = inch  
 f = in/ford  
 $v_c$  = sf/perc  
 Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fűrés

Dörzsárász

Készletgátlás

Melléklet

Forgácsolási adatok – Plus... -EB25/EB30 metrikus

| SMG |                         | $a_p$ (°) |             | f         |           |           | $v_c$       |             |             |             |              |               |               |
|-----|-------------------------|-----------|-------------|-----------|-----------|-----------|-------------|-------------|-------------|-------------|--------------|---------------|---------------|
|     |                         | z=6       | z=8<br>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 anyagcsoport

$a_p$  = mm

f = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet



**Forgácsolási adatok – PM Plus... -EB25/EB30 inch**

| SMG |                      | $a_p$ (Z) |             | f         |           |           | $v_c$         |               |               |               |               |               |                |
|-----|----------------------|-----------|-------------|-----------|-----------|-----------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|
|     |                      | z=6       | z=8<br>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 anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték



## Nanofix™

A Nanofix™ tömör keményfém dörzsárazak kis, 2,97 és 12,05 mm (0.117" – 0.474") átmérőkhöz készültek.

- Belső hűtőrendszere egyszerűen állítható, hogy a zsák- és átmenőfuratok hűtése megfelelő legyen, a művelettől függően
- Az elérhető tűrésmező 10–15 µm (0.0004-0.0006')
- Háromféle geometria kapható: EB45, EB845 és EB25

## Választék áttekintés

|  | ∅ Választék                       | Dörzsárazási mélység | Fúró ∅ túrése | Köztes átmérő                     | Felületi minőség  |
|--|-----------------------------------|----------------------|---------------|-----------------------------------|---|
| <b>Nanofix™</b><br> | 2,97-12,05 mm<br>(0.1169-0.4744") | 5-12 x D             | IT 7          | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,8-1,2 μm<br>(R <sub>a</sub> 31-47 μin) |

A Nanofix a Seco keményfém dörzsár programja kis átmérőjű furatokhoz, ∅ 2,97 - 12,05 mm (0.1169 to 0.4744") tartományban.

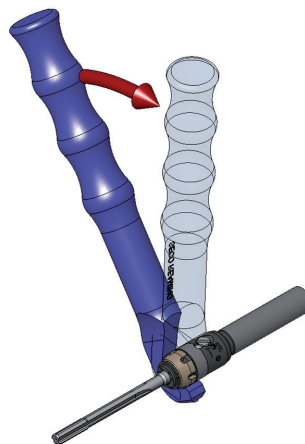
A Quick-Fit a Seco szabadalmaztatott rögzítő rendszere, mely 2 szerszám befogóval lefedi az átmérő tartományt.

A szerszámtartó hűtőrendszere egyszerűen állítható, hogy a zsák- és átmenőfuratok hűtése megfelelő legyen, a művelettől függően.

## Quick-fit rögzítés

### Quick-fit rögzítés

Gyors és egyszerű szerszám csere.  
Pontos újrapozicionálás ütésben és hosszban.



### 2 Quick-fit méret lefedi az összes átmérőt

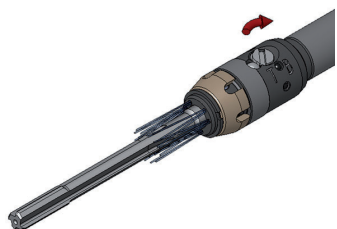


Quick-fit  $\varnothing$  10 mm  
 $\varnothing$  6,051–12,050 mm  
( $\varnothing$  0.2382–0.4744") méretekhez



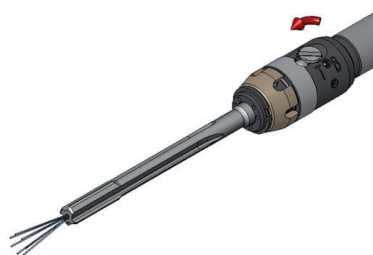
Quick-fit  $\varnothing$  6 mm  
 $\varnothing$  2,97–6 050 mm  
( $\varnothing$  0.1169–0.2382") méretekhez

### Ugyanaz a szerszám zsák és átmenőfuratokhoz.



átmenő

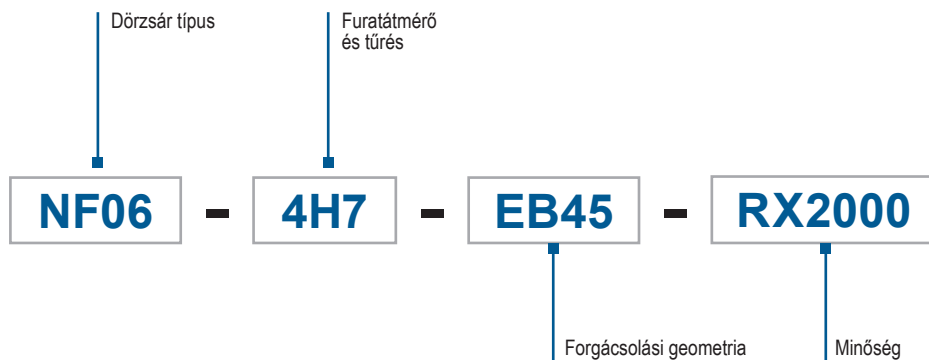
A hűtés állító csavarjának 1/4 fordulattal való állítása megváltoztatja a hűtést zsák- vagy átmenőfurathoz és fordítva.



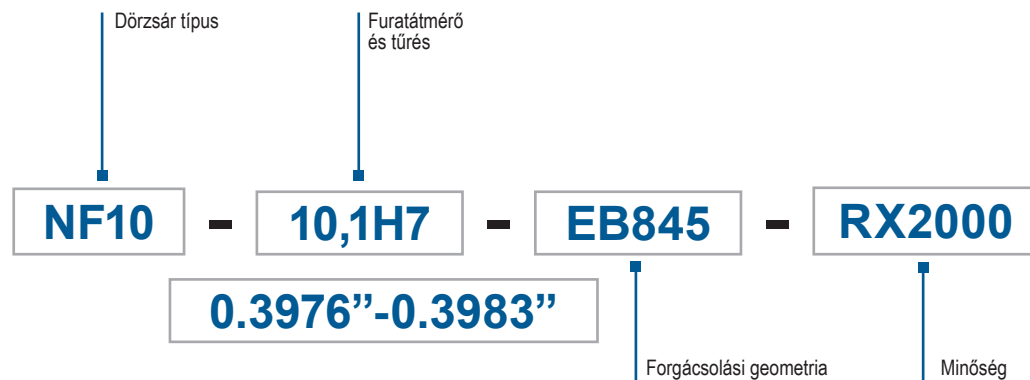
zsák

## Jelmagyarázat

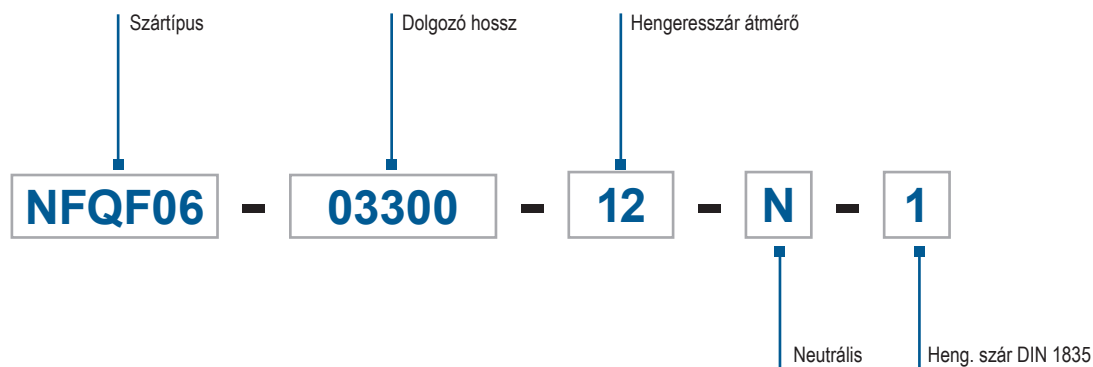
### Dörzsárak



### Köztes átmérőjű dörzsárak



### Szárak

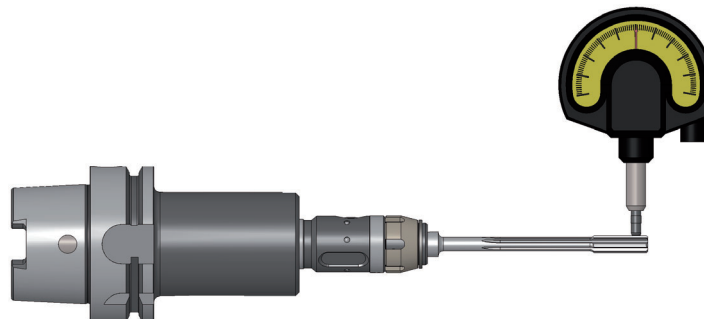


## Ütés

### Forgó szerszám

Ajánlott max. ütés: 5  $\mu\text{m}$  (197  $\mu\text{in}$ ).  
Precíziós befogó ajánlott: Hidraulikus befogó, D-típusú patronos befogó vagy 5672 patronos befogó.

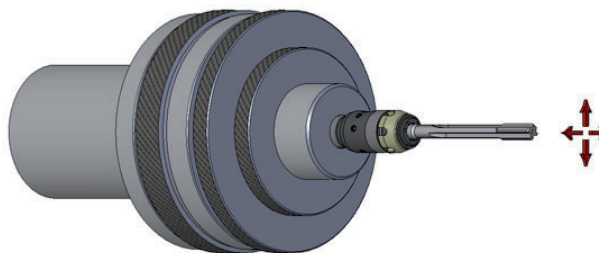
Megjegyzés: Shrinkfit befogó használata esetén a hűtésállító tömítő O-gyűrű használata nem javasolt.



### Álló szerszám

Használjon Seco önbeálló befogót, lásd: 480-484 old..

Az önbeálló befogók központosítják a dörzsárat az előfuratban.



### Hűtőfolyadékkal kapcsolatos követelmények

Maximális szerszámélettartam és furatminőség eléréséhez a következő hűtőfolyadék-igényeket vizsgálja meg.

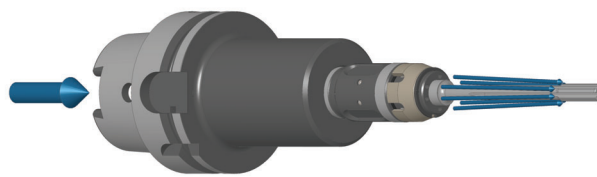
Belső hűtés javasolt.

Külső hűtés használata esetén a paramétereket 75%-kal kell csökkenteni.

Minőségi oldódó olaj minimum 40%-os ásványolaj tartalommal.  
Korrózióálló acélhoz tiszta olaj ajánlott.

Minimális koncentráció 6–8%  
Szűrés 30–50  $\mu\text{m}$  (1181–1969  $\mu\text{in}$ ).

Mennyiség min. 0,5 l/perc/mm (0.13 gal/min/inch) szerszám átmérő (Pl.:  $\varnothing$  10 dörzsár, min. mennyiség 5 l/perc (1,3 gal/min)).



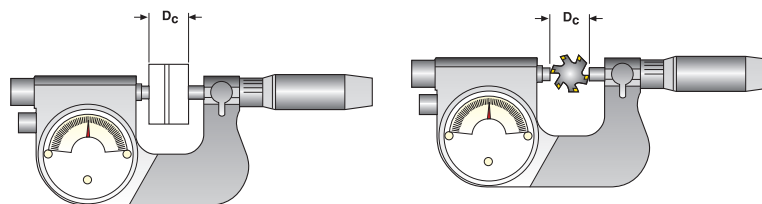
### Átmérőmérés

Kalibrálja az óras mikrométert az  $\varnothing$  mérés előtt.

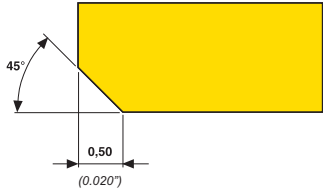
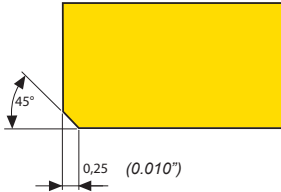
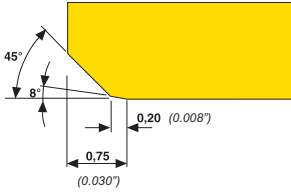
#### Fontos!

A Nanofix dörzsárok egyenlőtlen fogsztásúak.  
Átmérő mérésénél ellenőrizze, hogy a 2 mért fog 180°-ra van egymástól.

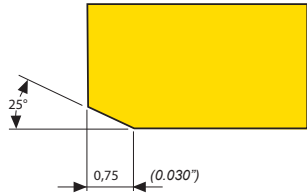
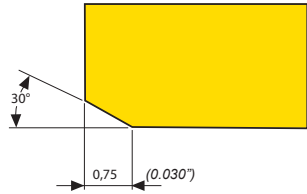
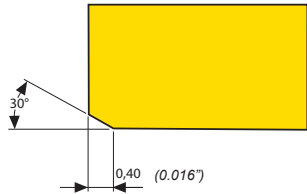
Használja az mérőóras mikrométert és mérőhasábot a kalibráláshoz.



## Geometriaválaszték – Alkalmazások

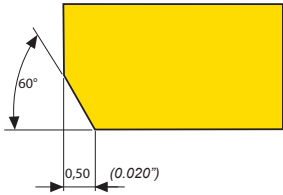
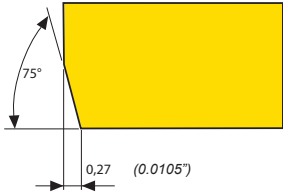
| Forgácsolási geometria – EB45  |  |
|--|--|
| <p>Forgácsolási szabályozás ++<br/>           Felületi minőség +++ <math>R_a</math> 0,8–1,2 <math>\mu\text{m}</math><br/>           (Felületi minőség +++ <math>R_a</math> 31–47 <math>\mu\text{in}</math>)<br/>           Sokoldalú</p> |    |
| Forgácsolási geometria – EBS45   |  |
| <p>Forgácsolási szabályozás +++<br/>           Felületi minőség + <math>R_a</math> 0,8–1,2<br/>           (Felületi minőség + <math>R_a</math> 31–47 <math>\mu\text{in}</math>)<br/>           Rövid EB45</p>                            |   |
| Forgácsolási geometria – EB845   |  |
| <p>Forgácsolási szabályozás ++<br/>           Felületi minőség +++ <math>R_a</math> 0,2–0,8 <math>\mu\text{m}</math><br/>           (Felületi minőség +++ <math>R_a</math> 8–31 <math>\mu\text{in}</math>)</p>                           |  |

## Geometriaválaszték – Alkalmazások

| Forgácsolási geometria – EB25   |  |
|---|--|
| <p>Előtolási teljesítmény +++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +</p>                |    |
| Forgácsolási geometria – EB30   |  |
| <p>Előtolási teljesítmény +++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +</p>                |   |
| Forgácsolási geometria – EBS30  |  |
| <p>Előtolási teljesítmény +++<br/>Felületi minőség ++ <math>R_a</math> 0,4–0,8 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 16–31 <math>\mu\text{in}</math></i>)<br/>Forgácsirányítás +<br/>Rövid EB30</p> |  |



## Geometriaválaszték – Alkalmazások

| Forgácsolási geometria – EB60  |  |
|--|--|
| <p>Előtolási teljesítmény +<br/>Felületi minőség ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math><br/>(Felületi minőség ++ <math>R_a</math> 31-47 <math>\mu\text{in}</math>)<br/>Forgácsirányítás ++</p> |  <p>The diagram illustrates the EB60 cutting geometry. It shows a yellow rectangular chip being removed from a workpiece. The cutting angle is indicated as 60 degrees. The chip thickness is labeled as 0.50 mm (0.020 inches).</p>   |
| Forgácsolási geometria – EB75  |  |
| <p>Előtolási teljesítmény +<br/>Felületi minőség ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math><br/>(Felületi minőség ++ <math>R_a</math> 31-47 <math>\mu\text{in}</math>)<br/>Forgácsirányítás ++</p> |  <p>The diagram illustrates the EB75 cutting geometry. It shows a yellow rectangular chip being removed from a workpiece. The cutting angle is indicated as 75 degrees. The chip thickness is labeled as 0.27 mm (0.0105 inches).</p> |

| Minőségek   |               |   |
|---|---------------|---|
|    | <b>RX2000</b> | <b>Bevonatos</b><br>Nagy teljesítményű bevonatos minden anyaghoz.   |
|    | <b>CP20</b>   | <b>Bevonatos</b><br>Sokoldalú minőség a legtöbb anyaghoz, az alumíniumon kívül.<br>TiN  |
|    | <b>H15</b>    | <b>Bevonat nélküli</b><br>Egy szívós minőség minden anyaghoz. Alkalmas finom dörzsárazáshoz az élességének köszönhetően.      |
|    | <b>RN2010</b> | <b>Bevonat nélküli</b><br>Egy sub-mikroszemcsés bevonat nélküli minőség optimalizált geometriával N-anyagokhoz (színesfémek). |
|   | <b>RM2020</b> | <b>Bevonatos</b><br>Egy szívós bevonatos minőség simító dörzsárazáshoz optimalizált geometriával M anyagokhoz.                |
|  | <b>RM2090</b> | <b>Bevonatos</b><br>Egy kopásálló bevonatos minőség speciális geometriával az M anyagokhoz. Optimalizálás M anyagokban.       |
|  | <b>RK2050</b> | <b>Bevonatos</b><br>Egy szívós minőség simító művelethez optimalizált geometriával K anyagokhoz.                              |
|  | <b>RS2090</b> | <b>Bevonatos</b><br>Egy kopásálló bevonatos minőség speciális geometriával S anyagokhoz. Optimalizálás S anyagokban.          |

Bevezetés

Fúrás

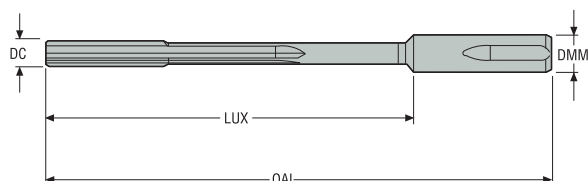
Dörzsárazás

Késztergálás

Melléklet

## Dörzsár zsák- és átmenő furatokhoz

Ø 2,97-12,05 mm / 0.116-0.474"



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

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

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

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| Megnevezés        | Cikkszám | DC              | Hole dia min-max |                  |                 | LUX            | DMM             | OAL |                                     | Geometriák               |                          |                                     | Minőségek                |                          |       |
|-------------------|----------|-----------------|------------------|------------------|-----------------|----------------|-----------------|-----|-------------------------------------|--------------------------|--------------------------|-------------------------------------|--------------------------|--------------------------|-------|
|                   |          |                 | mm<br>Inch       | mm<br>Inch       | mm<br>Inch      |                |                 |     |                                     | mm<br>Inch               | mm<br>Inch               | mm<br>Inch                          | mm<br>Inch               | EB45                     | EB845 |
| NF10-12.01H7-EB45 | 02729012 | 12,01<br>0.4728 | 12,01<br>0.4728  | 12,028<br>0.4735 | 114,0<br>4.4880 | 10,0<br>0.3940 | 125,0<br>4.9210 | 6   | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |       |
| NF10-12.02H7-EB45 | 02729013 | 12,02<br>0.4732 | 12,02<br>0.4732  | 12,038<br>0.4739 | 114,0<br>4.4880 | 10,0<br>0.3940 | 125,0<br>4.9210 | 6   | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |       |
| NF10-12.03H7-EB45 | 02729014 | 12,03<br>0.4736 | 12,03<br>0.4736  | 12,048<br>0.4743 | 114,0<br>4.4880 | 10,0<br>0.3940 | 125,0<br>4.9210 | 6   | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |       |
| NF10-12.04H7-EB45 | 02729015 | 12,04<br>0.4740 | 12,04<br>0.4740  | 12,058<br>0.4747 | 114,0<br>4.4880 | 10,0<br>0.3940 | 125,0<br>4.9210 | 6   | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |       |
| NF10-12.05H7-EB45 | 02729016 | 12,05<br>0.4744 | 12,05<br>0.4744  | 12,068<br>0.4751 | 114,0<br>4.4880 | 10,0<br>0.3940 | 125,0<br>4.9210 | 6   | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |       |

Raktári szabványos.  Nem raktári szabványos.

Megjegyzés: Mikor köztes méretű Nanofix dörzsárat rendel, kérjük jelezze az átmérőt és a dörzsárazni kívánt furat tűrését.

Rendelési példa: NF10-10,187/10,213-EB845, RX2000.

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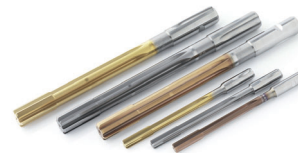
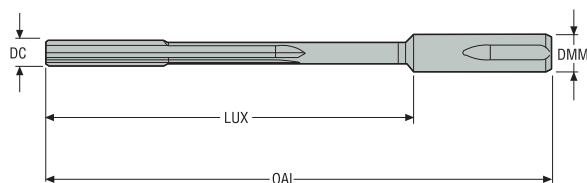
Dörzsárazás

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## Köztes átmérő

Egyenes horony, hosszú verzió



- Forgácsolási adatokat lásd a 391-396 old.
- Az forgácsolási geometriák kiválasztásához lásd a 373-375 old.

| Megnevezés          | DCN                    | DCX                   | LUX                   | DMM                  | OAL                   | Test méret | Geometriák                | Minőségek                |                          |                          |                          |                          |                          |                          |
|---------------------|------------------------|-----------------------|-----------------------|----------------------|-----------------------|------------|---------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
|                     | mm<br><i>Inch</i>      | mm<br><i>Inch</i>     | mm<br><i>Inch</i>     | mm<br><i>Inch</i>    | mm<br><i>Inch</i>     |            |                           |                          | H15                      | RK2050                   | RX2000                   | RN2010                   | RM2020                   | RM2090                   |
| NF06-2.970-XX-XXXX  | 2,97<br><i>0.117</i>   | 3,05<br><i>0.120</i>  | 40,0<br><i>1.575</i>  | 6,0<br><i>0.236</i>  | 60,0<br><i>2.362</i>  | 4          | NFQF06-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NF06-3.051-XX-XXXX  | 3,051<br><i>0.120</i>  | 6,05<br><i>0.238</i>  | 60,0<br><i>2.362</i>  | 6,0<br><i>0.236</i>  | 80,0<br><i>3.150</i>  | 4          | NFQF06-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NF10-6.051-XX-XXXX  | 6,051<br><i>0.238</i>  | 8,05<br><i>0.317</i>  | 83,0<br><i>3.268</i>  | 10,0<br><i>0.394</i> | 115,0<br><i>4.528</i> | 6          | NFQF10-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NF10-8.051-XX-XXXX  | 8,051<br><i>0.317</i>  | 10,05<br><i>0.396</i> | 93,0<br><i>3.661</i>  | 10,0<br><i>0.394</i> | 125,0<br><i>4.921</i> | 6          | NFQF10-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NF10-10.051-XX-XXXX | 10,051<br><i>0.396</i> | 12,05<br><i>0.474</i> | 114,0<br><i>4.488</i> | 10,0<br><i>0.394</i> | 145,0<br><i>5.709</i> | 6          | NFQF10-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

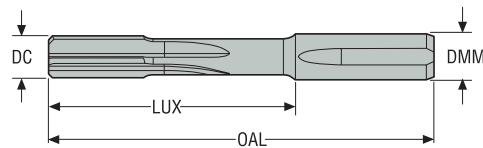
= Nem raktári szabványos. A változtatás jogát fenntartjuk az érvényes ár- és raktárlista szerint

Megjegyzés: Mikor köztes méretű Nanofix dörzsárat rendel, kérjük jelezze az átmérőt és a dörzsárazni kívánt furat típusát.

Rendelési példa: NF10-10,187/10,213-EB845, RX2000.

## Dörzsár zsák- és átmenő furatokhoz – rövid verzió

Ø 2,97-12,05 mm / 0.116-0.474"



| Megnevezés         | Cikkszám | DC              | Hole dia min-max |                |                | LUX           | DMM            | OAL |                          | Geometriák               |                                     |                                     | Minőségek                |                          |      |
|--------------------|----------|-----------------|------------------|----------------|----------------|---------------|----------------|-----|--------------------------|--------------------------|-------------------------------------|-------------------------------------|--------------------------|--------------------------|------|
|                    |          |                 | mm<br>Inch       | mm<br>Inch     | mm<br>Inch     |               |                |     |                          | mm<br>Inch               | mm<br>Inch                          | mm<br>Inch                          | EB45                     | EB845                    | EB30 |
| NS06-2.97H7-EB...  | -        | 2,97<br>0.1169  | 2,97<br>0.1169   | 2,98<br>0.1173 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-2.98H7-EB...  | -        | 2,98<br>0.1173  | 2,98<br>0.1173   | 2,99<br>0.1177 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-2.99H7-EB...  | -        | 2,99<br>0.1177  | 2,99<br>0.1177   | 3,00<br>0.1181 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.00H7-EB...  | -        | 3,0<br>0.1181   | 3,00<br>0.1181   | 3,01<br>0.1185 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3H7-EB30      | 10019456 | 3,0<br>0.1181   | 3,01<br>0.1185   | 3,00<br>0.1181 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.01H7-EB...  | -        | 3,01<br>0.1185  | 3,01<br>0.1185   | 3,02<br>0.1190 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.02H7-EB...  | -        | 3,02<br>0.1189  | 3,02<br>0.1189   | 3,03<br>0.1194 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.03H7-EB...  | -        | 3,03<br>0.1193  | 3,03<br>0.1193   | 3,04<br>0.1198 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.04H7-EB...  | -        | 3,04<br>0.1197  | 3,04<br>0.1197   | 3,05<br>0.1202 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.05H7-EB...  | -        | 3,05<br>0.1201  | 3,05<br>0.1201   | 3,06<br>0.1206 | 25,0<br>0.9840 | 6,0<br>0.2360 | 45,0<br>1.7720 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.167H7-EB... | -        | 3,167<br>0.1247 | 3,18<br>0.1252   | 3,17<br>0.1247 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.175H7-EB... | -        | 3,175<br>0.1250 | 3,18<br>0.1250   | 3,19<br>0.1255 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.49H7-EB...  | -        | 3,49<br>0.1374  | 3,49<br>0.1374   | 3,50<br>0.1379 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.50H7-EB...  | -        | 3,5<br>0.1378   | 3,50<br>0.1378   | 3,51<br>0.1383 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.51H7-EB...  | -        | 3,51<br>0.1382  | 3,51<br>0.1382   | 3,52<br>0.1387 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.52H7-EB...  | -        | 3,52<br>0.1386  | 3,52<br>0.1386   | 3,53<br>0.1391 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.97H7-EB...  | -        | 3,97<br>0.1563  | 3,97<br>0.1563   | 3,98<br>0.1568 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.98H7-EB...  | -        | 3,98<br>0.1567  | 3,98<br>0.1567   | 3,99<br>0.1572 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-3.99H7-EB...  | -        | 3,99<br>0.1571  | 3,99<br>0.1571   | 4,00<br>0.1576 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-4.00H7-EB...  | -        | 4,0<br>0.1575   | 4,00<br>0.1575   | 4,01<br>0.1580 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-4H7-EB30      | 10019457 | 4,0<br>0.1575   | 4,01<br>0.1580   | 4,00<br>0.1575 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-4.01H7-EB...  | -        | 4,01<br>0.1579  | 4,01<br>0.1579   | 4,02<br>0.1583 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |
| NS06-4.02H7-EB...  | -        | 4,02<br>0.1583  | 4,02<br>0.1583   | 4,03<br>0.1587 | 30,0<br>1.1810 | 6,0<br>0.2360 | 50,0<br>1.9690 | 4   | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |      |



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

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

| Megnevezés          | Cikkszám | DC               |                |                | Hole dia min-max |                |                | LUX | DMM | OAL                      | Geometriák               |                                     |                                     | Minőségek                |                          |            |
|---------------------|----------|------------------|----------------|----------------|------------------|----------------|----------------|-----|-----|--------------------------|--------------------------|-------------------------------------|-------------------------------------|--------------------------|--------------------------|------------|
|                     |          | mm<br>Inch       | mm<br>Inch     | mm<br>Inch     | mm<br>Inch       | mm<br>Inch     | mm<br>Inch     |     |     |                          | mm<br>Inch               | mm<br>Inch                          | mm<br>Inch                          | mm<br>Inch               | mm<br>Inch               | mm<br>Inch |
| NS10-6.350H7-EB...  | -        | 6,35<br>0.2500   | 6,35<br>0.2500 | 6,37<br>0.2506 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-6.375H7-EB...  | -        | 6,375<br>0.2510  | 6,38<br>0.2510 | 6,39<br>0.2516 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-6.3754H7-EB30  | 10019462 | 6,375<br>0.2510  | 6,39<br>0.2516 | 6,38<br>0.2510 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 4   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-6.5H7-EB...    | -        | 6,5<br>0.2559    | 6,50<br>0.2559 | 6,52<br>0.2565 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-6.97H7-EB...   | -        | 6,97<br>0.2744   | 6,97<br>0.2744 | 6,99<br>0.2750 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-6.98H7-EB...   | -        | 6,98<br>0.2748   | 6,98<br>0.2748 | 7,00<br>0.2754 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-6.99H7-EB...   | -        | 6,99<br>0.2752   | 6,99<br>0.2752 | 7,01<br>0.2758 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.00H7-EB...   | -        | 7,0<br>0.2756    | 7,00<br>0.2756 | 7,02<br>0.2762 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7H7-EB30       | 10019463 | 7,0<br>0.2756    | 7,02<br>0.2762 | 7,00<br>0.2756 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 4   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.01H7-EB...   | -        | 7,01<br>0.2760   | 7,01<br>0.2760 | 7,03<br>0.2766 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.02H7-EB...   | -        | 7,02<br>0.2764   | 7,02<br>0.2764 | 7,04<br>0.2770 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.03H7-EB...   | -        | 7,03<br>0.2768   | 7,03<br>0.2768 | 7,05<br>0.2774 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.04H7-EB...   | -        | 7,04<br>0.2772   | 7,04<br>0.2772 | 7,06<br>0.2778 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.05H7-EB...   | -        | 7,05<br>0.2776   | 7,05<br>0.2776 | 7,07<br>0.2781 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.50H7-EB...   | -        | 7,5<br>0.2953    | 7,50<br>0.2953 | 7,52<br>0.2959 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.9375H7-EB... | -        | 7,9375<br>0.3125 | 7,94<br>0.3125 | 7,95<br>0.3131 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.97H7-EB...   | -        | 7,97<br>0.3138   | 7,97<br>0.3138 | 7,99<br>0.3144 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.98H7-EB...   | -        | 7,98<br>0.3142   | 7,98<br>0.3142 | 8,00<br>0.3148 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-7.99H7-EB...   | -        | 7,99<br>0.3146   | 7,99<br>0.3146 | 8,01<br>0.3152 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.00H7-EB...   | -        | 8,0<br>0.3150    | 8,00<br>0.3150 | 8,02<br>0.3156 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8H7-EB30       | 10019464 | 8,0<br>0.3150    | 8,02<br>0.3156 | 8,00<br>0.3150 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 4   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.01H7-EB...   | -        | 8,01<br>0.3154   | 8,01<br>0.3154 | 8,03<br>0.3159 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.02H7-EB...   | -        | 8,02<br>0.3157   | 8,02<br>0.3157 | 8,04<br>0.3163 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.03H7-EB...   | -        | 8,03<br>0.3161   | 8,03<br>0.3161 | 8,05<br>0.3167 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.04H7-EB...   | -        | 8,04<br>0.3165   | 8,04<br>0.3165 | 8,06<br>0.3171 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.05H7-EB...   | -        | 8,05<br>0.3169   | 8,05<br>0.3169 | 8,07<br>0.3175 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.50H7-EB...   | -        | 8,5<br>0.3346    | 8,50<br>0.3346 | 8,52<br>0.3352 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.97H7-EB...   | -        | 8,97<br>0.3531   | 8,97<br>0.3531 | 8,99<br>0.3537 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.98H7-EB...   | -        | 8,98<br>0.3535   | 8,98<br>0.3535 | 9,00<br>0.3541 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |
| NS10-8.99H7-EB...   | -        | 8,99<br>0.3539   | 8,99<br>0.3539 | 9,01<br>0.3545 | 46,0<br>1.8110   | 10,0<br>0.3940 | 78,0<br>3.0710 | 6   |     | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |            |

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

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

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| Megnevezés          | Cikkszám | DC               |                 | Hole dia min-max |                | LUX            | DMM            | OAL |  | Geometriák               |                          |                                     | Minőségek                           |                          |                          |
|---------------------|----------|------------------|-----------------|------------------|----------------|----------------|----------------|-----|--|--------------------------|--------------------------|-------------------------------------|-------------------------------------|--------------------------|--------------------------|
|                     |          | mm<br>Inch       | mm<br>Inch      | mm<br>Inch       | mm<br>Inch     |                |                |     |  | mm<br>Inch               | mm<br>Inch               | mm<br>Inch                          | mm<br>Inch                          | mm<br>Inch               | mm<br>Inch               |
| NS10-11.05H7-EB...  | -        | 11,05<br>0.4350  | 11,05<br>0.4350 | 11,07<br>0.4357  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-11.112H7-EB... | -        | 11,112<br>0.4375 | 11,11<br>0.4375 | 11,13<br>0.4382  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-11.50H7-EB...  | -        | 11,5<br>0.4528   | 11,50<br>0.4528 | 11,52<br>0.4535  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-11.97H7-EB...  | -        | 11,97<br>0.4713  | 11,97<br>0.4713 | 11,99<br>0.4720  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-11.98H7-EB...  | -        | 11,98<br>0.4717  | 11,98<br>0.4717 | 12,00<br>0.4724  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-11.99H7-EB...  | -        | 11,99<br>0.4720  | 11,99<br>0.4720 | 12,01<br>0.4728  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12.00H7-EB...  | -        | 12,0<br>0.4724   | 12,00<br>0.4724 | 12,02<br>0.4731  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12H7-EB30      | 10019468 | 12,0<br>0.4724   | 12,02<br>0.4731 | 12,00<br>0.4724  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 4   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12.01H7-EB...  | -        | 12,01<br>0.4728  | 12,01<br>0.4728 | 12,03<br>0.4735  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12.02H7-EB...  | -        | 12,02<br>0.4732  | 12,02<br>0.4732 | 12,04<br>0.4739  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12.03H7-EB...  | -        | 12,03<br>0.4736  | 12,03<br>0.4736 | 12,05<br>0.4743  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12.04H7-EB...  | -        | 12,04<br>0.4740  | 12,04<br>0.4740 | 12,06<br>0.4747  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-12.05H7-EB...  | -        | 12,05<br>0.4744  | 12,05<br>0.4744 | 12,07<br>0.4751  | 57,0<br>2.2440 | 10,0<br>0.3940 | 88,0<br>3.4650 | 6   |  | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/>            | <input type="checkbox"/>            | <input type="checkbox"/> | <input type="checkbox"/> |

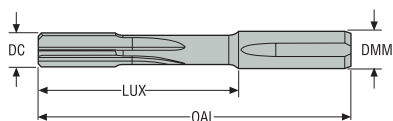
■ Raktári szabványos. □ Nem raktári szabványos.

Megjegyzés: Mikor köztes méretű Nanofix dörzsárat rendel, kérjük jelezze az átmérőt és a dörzsárazni kívánt furat tűrését.

Rendelési példa: NF10-10,187/10,213-EB845, RX2000.

## Köztes átmérő

Egyenes horony, rövid verzió



- Forgácsolási adatokat lásd a 391-396 old.
- Az forgácsolási geometriák kiválasztásához lásd a 373-375 old.

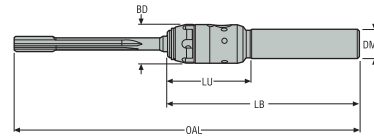
| Megnevezés          | DCN             | DCX            | LUX           | DMM           | OAL           | Test méret | Geometriák                | Minőségek                |                          |                          |                          |                          |                          |                          |
|---------------------|-----------------|----------------|---------------|---------------|---------------|------------|---------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|
|                     | mm<br>Inch      | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |            |                           | H15                      | RK2050                   | RX2000                   | RN2010                   | RM2020                   | RM2090                   | RS2090                   |
| NS06-2.970-XX-XXXX  | 2,97<br>0.117   | 3,05<br>0.120  | 25,0<br>0.984 | 6,0<br>0.236  | 45,0<br>1.772 | 4          | NFQF06-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NS06-3.051-XX-XXXX  | 3,051<br>0.120  | 6,05<br>0.238  | 30,0<br>1.181 | 6,0<br>0.236  | 50,0<br>1.969 | 4          | NFQF06-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-6.051-XX-XXXX  | 6,051<br>0.238  | 10,05<br>0.396 | 46,0<br>1.811 | 10,0<br>0.394 | 78,0<br>3.071 | 6          | NFQF10-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |
| NS10-10.051-XX-XXXX | 10,051<br>0.396 | 12,05<br>0.474 | 57,0<br>2.244 | 10,0<br>0.394 | 88,0<br>3.465 | 6          | NFQF10-xx EB45 EB845 EB30 | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> |

= Nem raktári szabványos. A változtatás jogát fenntartjuk az érvényes ár- és raktárlista szerint

Megjegyzés: Mikor köztes méretű Nanofix dörzsárat rendel, kérjük jelezze az átmérőt és a dörzsárazni kívánt furat tűrést.

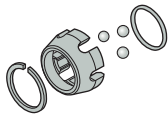

Rendelési példa: NS10-10,187/10,213-EB845, RS2090.

## Nanofix szerszám befogó



| Cikkszám | Megnevezés        | 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 | -   |

### Pótalkatrészek

| DC           | Alkatrész készlet   | Kulcs   |
|--------------|---|---|
| 2,97-6,050   |  |  |
| 6,051-12,050 | NF10-CLKI   | CLC10KEY  |

Alkatrész készlet a Nanofix befogókhoz tartalmaz:

- 1 rögzítő anya
- 1 axiális végállás rugós gyűrű
- 3 rögzítő golyók (átmérő 3,5 mm az NF06 mérethez & átmérő 5 mm az NF10 mérethez)
- 1 tájoló golyó (átmérő 3 mm az NF06 mérethez & átmérő 4 mm az NF10 mérethez)
- 1 o-gyűrű

Megj.: tájoló golyót nem mutatja a felső ábra.

Forgácsolási adatok – NF/NS...-EB45 metrikus

| SMG |            | a <sub>p</sub> (Z) |           | f         |           | v <sub>c</sub> |                |                |               |               |               |               |
|-----|------------|--------------------|-----------|-----------|-----------|----------------|----------------|----------------|---------------|---------------|---------------|---------------|
|     |            | 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<br>(15-30)  | 60<br>(30-100) | 80<br>(30-150) | -             | -             | -             | -             |
| P2  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,30 | 0,20-0,60 | 25<br>(15-30)  | 60<br>(30-100) | 80<br>(30-150) | -             | -             | -             | -             |
| P3  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,30 | 0,20-0,60 | 25<br>(15-30)  | 60<br>(30-100) | 80<br>(30-150) | -             | -             | -             | -             |
| P4  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -             | -             | -             | -             |
| P5  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -             | -             | -             | -             |
| P6  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -             | -             | -             | -             |
| P7  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -             | -             | -             | -             |
| P8  | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 15<br>(10-20)  | 35<br>(20-60)  | 40<br>(20-80)  | -             | -             | -             | -             |
| P11 | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 15<br>(10-20)  | 35<br>(20-60)  | 40<br>(20-80)  | -             | -             | -             | -             |
| P12 | NF/NS-EB45 | 0,10-0,15          | 0,1-0,20  | 0,10-0,20 | 0,20-0,50 | 12<br>(8-15)   | 25<br>(15-45)  | 30<br>(15-65)  | -             | -             | -             | -             |
| M1  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,50 | 12<br>(9-15)   | 25<br>(15-40)  | 35<br>(20-60)  | -             | 25<br>(15-40) | 40<br>(20-60) | -             |
| M2  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,50 | -              | 25<br>(15-40)  | 35<br>(20-60)  | -             | 25<br>(15-40) | 40<br>(20-60) | -             |
| M3  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,50 | -              | 25<br>(15-40)  | 35<br>(20-60)  | -             | 25<br>(15-40) | 40<br>(20-60) | -             |
| M4  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,50 | -              | 20<br>(10-30)  | 25<br>(15-40)  | -             | 25<br>(10-30) | 30<br>(15-40) | -             |
| M5  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,50 | -              | 20<br>(10-30)  | 25<br>(15-40)  | -             | 25<br>(10-30) | 30<br>(15-40) | -             |
| K1  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | 25<br>(15-30)  | 60<br>(40-100) | 80<br>(30-150) | -             | -             | -             | -             |
| K2  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | -              | 25<br>(20-40)  | 40<br>(30-70)  | -             | -             | -             | -             |
| K3  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | 25<br>(15-30)  | 60<br>(40-100) | 80<br>(30-150) | -             | -             | -             | -             |
| K4  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | 25<br>(15-30)  | 45<br>(30-70)  | 70<br>(40-120) | -             | -             | -             | -             |
| K5  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | 25<br>(15-30)  | 45<br>(30-70)  | 70<br>(40-120) | -             | -             | -             | -             |
| K6  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | -              | 60<br>(40-100) | 80<br>(30-150) | -             | -             | -             | -             |
| K7  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,25 | 0,10-0,30 | 0,20-0,60 | -              | 60<br>(40-100) | 80<br>(30-150) | -             | -             | -             | -             |
| N1  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,30 | 0,10-0,30 | 0,20-0,60 | 50<br>(20-80)  | -              | 80<br>(30-150) | 50<br>(20-80) | -             | -             | -             |
| N2  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,30 | 0,10-0,30 | 0,20-0,60 | 50<br>(20-80)  | -              | 80<br>(30-150) | 50<br>(20-80) | -             | -             | -             |
| N3  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,30 | 0,10-0,30 | 0,20-0,60 | 50<br>(20-80)  | -              | 80<br>(30-150) | 50<br>(20-80) | -             | -             | -             |
| N4  | NF/NS-EB45 | 0,10-0,20          | 0,10-0,30 | 0,10-0,30 | 0,20-0,60 | 50<br>(20-80)  | -              | 80<br>(30-150) | 50<br>(20-80) | -             | -             | -             |
| S1  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,30 | -              | 15<br>(8-20)   | 20<br>(10-25)  | -             | -             | -             | 20<br>(10-25) |
| S2  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,30 | -              | 15<br>(8-20)   | 20<br>(10-25)  | -             | -             | -             | 20<br>(10-25) |
| S3  | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,30 | -              | 15<br>(8-20)   | 20<br>(10-25)  | -             | -             | -             | 25<br>(10-25) |
| S11 | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,30 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -             | -             | -             | 30<br>(20-50) |
| S12 | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,30 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -             | -             | -             | 30<br>(20-50) |
| S13 | NF/NS-EB45 | 0,08-0,15          | 0,10-0,15 | 0,10-0,20 | 0,20-0,30 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -             | -             | -             | 30<br>(20-50) |

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Forgácsolási adatok – NF/NS...-EB45 metrikus

| SMG |            | $a_p$ (∅)     |               | f             |               | $v_c$         |               |                |        |        |        |        |
|-----|------------|---------------|---------------|---------------|---------------|---------------|---------------|----------------|--------|--------|--------|--------|
|     |            | z=4           | z=6           | z=4           | z=6           | H15           | CP20          | RX2000         | RK2050 | RM2020 | RM2090 | RS2090 |
| H3  | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H5  | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H7  | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H8  | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H11 | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H12 | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H21 | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| H31 | NF/NS-EB45 | 0,08-<br>0,15 | 0,10-<br>0,15 | 0,10-<br>0,20 | 0,20-<br>0,30 | -             | -             | 10<br>(8-15)   | -      | -      | -      | -      |
| PM1 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,20 | 0,20-<br>0,50 | -             | 50<br>(30-80) | 70<br>(40-100) | -      | -      | -      | -      |
| PM2 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,20 | 0,20-<br>0,50 | -             | 50<br>(30-80) | 70<br>(40-100) | -      | -      | -      | -      |
| PM3 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,20 | 0,20-<br>0,50 | -             | 50<br>(30-80) | 70<br>(40-100) | -      | -      | -      | -      |
| TS1 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TS2 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TS3 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TS4 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TP1 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TP2 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TP3 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| TP4 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 20<br>(15-25) | -             | 40<br>(20-60)  | -      | -      | -      | -      |
| GR1 | NF/NS-EB45 | 0,10-<br>0,15 | 0,1-<br>0,20  | 0,10-<br>0,30 | 0,20-<br>0,60 | 40<br>(80-20) | -             | 60<br>(30-120) | -      | -      | -      | -      |

SMG = Seco anyagcsoport

$a_p$  = mm

f = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

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Késztergálás

Melléklet



Forgácsolási adatok – NF/NS...-EB45 inch

| SMG |            | a <sub>p</sub> (Z) |             | f           |             | v <sub>c</sub>  |                  |                  |                 |                |                 |                 |
|-----|------------|--------------------|-------------|-------------|-------------|-----------------|------------------|------------------|-----------------|----------------|-----------------|-----------------|
|     |            | 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<br>(50-100)  | 195<br>(100-330) | 260<br>(100-490) | -               | -              | -               | -               |
| P2  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 80<br>(50-100)  | 195<br>(100-330) | 260<br>(100-490) | -               | -              | -               | -               |
| P3  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 80<br>(50-100)  | 195<br>(100-330) | 260<br>(100-490) | -               | -              | -               | -               |
| P4  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 65<br>(35-80)   | 165<br>(100-260) | 195<br>(100-395) | -               | -              | -               | -               |
| P5  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 65<br>(35-80)   | 165<br>(100-260) | 195<br>(100-395) | -               | -              | -               | -               |
| P6  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 65<br>(35-80)   | 165<br>(100-260) | 195<br>(100-395) | -               | -              | -               | -               |
| P7  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 65<br>(35-80)   | 165<br>(100-260) | 195<br>(100-395) | -               | -              | -               | -               |
| P8  | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 50<br>(35-65)   | 115<br>(65-195)  | 130<br>(65-260)  | -               | -              | -               | -               |
| P11 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 50<br>(35-65)   | 115<br>(65-195)  | 130<br>(65-260)  | -               | -              | -               | -               |
| P12 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | 40<br>(25-50)   | 80<br>(50-150)   | 100<br>(50-215)  | -               | -              | -               | -               |
| M1  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.020 | 40<br>(30-50)   | 80<br>(50-130)   | 115<br>(65-195)  | -               | 80<br>(50-130) | 130<br>(65-195) | -               |
| M2  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.020 | -               | 80<br>(50-130)   | 115<br>(65-195)  | -               | 80<br>(50-130) | 130<br>(65-195) | -               |
| M3  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.020 | -               | 80<br>(50-130)   | 115<br>(65-195)  | -               | 80<br>(50-130) | 130<br>(65-195) | -               |
| M4  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.020 | -               | 65<br>(35-100)   | 80<br>(50-130)   | -               | 65<br>(35-100) | 100<br>(50-130) | -               |
| M5  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.020 | -               | 65<br>(35-100)   | 80<br>(50-130)   | -               | 65<br>(35-100) | 100<br>(50-130) | -               |
| K1  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | 80<br>(50-100)  | 195<br>(130-330) | 260<br>(100-490) | -               | -              | -               | -               |
| K2  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | -               | 80<br>(65-130)   | 130<br>(100-230) | -               | -              | -               | -               |
| K3  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | 80<br>(50-100)  | 195<br>(130-330) | 260<br>(100-490) | -               | -              | -               | -               |
| K4  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | 80<br>(50-100)  | 150<br>(100-230) | 230<br>(130-395) | -               | -              | -               | -               |
| K5  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | 80<br>(50-100)  | 150<br>(100-230) | 230<br>(130-395) | -               | -              | -               | -               |
| K6  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | -               | 195<br>(130-330) | 260<br>(100-490) | -               | -              | -               | -               |
| K7  | NF/NS-EB45 | 0.004-0.008        | 0.004-0.010 | 0.004-0.012 | 0.008-0.024 | -               | 195<br>(130-330) | 260<br>(100-490) | -               | -              | -               | -               |
| N1  | NF/NS-EB45 | 0.004-0.787        | 0.004-0.012 | 0.004-0.012 | 0.008-0.024 | 165<br>(65-260) | -                | 260<br>(100-490) | 165<br>(65-260) | -              | -               | -               |
| N2  | NF/NS-EB45 | 0.004-0.787        | 0.004-0.012 | 0.004-0.012 | 0.008-0.024 | 165<br>(65-260) | -                | 260<br>(100-490) | 165<br>(65-260) | -              | -               | -               |
| N3  | NF/NS-EB45 | 0.004-0.787        | 0.004-0.012 | 0.004-0.012 | 0.008-0.024 | 165<br>(65-260) | -                | 260<br>(100-490) | 165<br>(65-260) | -              | -               | -               |
| N4  | NF/NS-EB45 | 0.004-0.787        | 0.004-0.012 | 0.004-0.012 | 0.008-0.024 | 165<br>(65-260) | -                | 260<br>(100-490) | 165<br>(65-260) | -              | -               | -               |
| S1  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | 50<br>(25-65)    | 65<br>(35-80)    | -               | -              | -               | 65<br>(35-80)   |
| S2  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | 50<br>(25-65)    | 65<br>(35-80)    | -               | -              | -               | 65<br>(35-80)   |
| S3  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | 50<br>(25-65)    | 65<br>(35-80)    | -               | -              | -               | 80<br>(35-80)   |
| S11 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | 65<br>(50-100)  | 100<br>(50-130)  | 130<br>(65-165)  | -               | -              | -               | 100<br>(65-165) |
| S12 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | 65<br>(50-100)  | 100<br>(50-130)  | 130<br>(65-165)  | -               | -              | -               | 100<br>(65-165) |
| S13 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | 65<br>(50-100)  | 100<br>(50-130)  | 130<br>(65-165)  | -               | -              | -               | 100<br>(65-165) |

The table continues on next page.

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

Forgácsolási adatok – NF/NS...-EB45 inch

| SMG |            | a <sub>p</sub> (∅) |             | f           |             | v <sub>c</sub>  |                  |                  |        |        |        |        |
|-----|------------|--------------------|-------------|-------------|-------------|-----------------|------------------|------------------|--------|--------|--------|--------|
|     |            | 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<br>(25-50)    | -      | -      | -      | -      |
| H5  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| H7  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| H8  | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| H11 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| H12 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| H21 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| H31 | NF/NS-EB45 | 0.003-0.006        | 0.004-0.006 | 0.004-0.008 | 0.008-0.012 | -               | -                | 35<br>(25-50)    | -      | -      | -      | -      |
| PM1 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | -               | 165<br>(100-260) | 230<br>(130-350) | -      | -      | -      | -      |
| PM2 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | -               | 165<br>(100-260) | 230<br>(130-350) | -      | -      | -      | -      |
| PM3 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.008 | 0.008-0.020 | -               | 165<br>(100-260) | 230<br>(130-350) | -      | -      | -      | -      |
| TS1 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TS2 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TS3 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TS4 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TP1 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TP2 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TP3 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| TP4 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 65<br>(50-80)   | -                | 130<br>(65-195)  | -      | -      | -      | -      |
| GR1 | NF/NS-EB45 | 0.004-0.006        | 0.004-0.008 | 0.004-0.012 | 0.008-0.024 | 130<br>(65-260) | -                | 195<br>(100-395) | -      | -      | -      | -      |

SMG = Seco anyagcsoport

a<sub>p</sub> = inch

f = in/ford

v<sub>c</sub> = sf/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

Forgácsolási adatok – NF/NS...-EB845 metrikus

| SMG |             | a <sub>p</sub> (°) |               | f             |               | v <sub>c</sub> |                |                |                |               |               |               |
|-----|-------------|--------------------|---------------|---------------|---------------|----------------|----------------|----------------|----------------|---------------|---------------|---------------|
|     |             | z=4                | z=6           | z=4           | z=6           | H15            | CP20           | RX2000         | RK2050         | RM2020        | RM2090        | RS2090        |
| P3  | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,30 | 0,20<br>-0,60 | -              | 60<br>(30-100) | 80<br>(30-150) | -              | -             | -             | -             |
| P4  | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 50<br>(30-80)  | 60<br>(30-120) | -              | -             | -             | -             |
| P5  | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | -             | -             | -             |
| P6  | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | -             | -             | -             |
| P7  | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | 20<br>(10-25)  | 50<br>(30-80)  | 60<br>(30-120) | -              | -             | -             | -             |
| P8  | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | 15<br>(10-20)  | 35<br>(20-60)  | 40<br>(20-80)  | -              | -             | -             | -             |
| P11 | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | 15<br>(10-20)  | 35<br>(20-60)  | 40<br>(20-80)  | -              | -             | -             | -             |
| P12 | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | 12<br>(8-15)   | 25<br>(15-45)  | 30<br>(15-65)  | -              | -             | -             | -             |
| M1  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20<br>-0,50 | 12<br>(9-15)   | 25<br>(15-45)  | 35<br>(20-60)  | -              | 25<br>(15-40) | 40<br>(20-60) | -             |
| M2  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 25<br>(15-45)  | 35<br>(20-60)  | -              | 25<br>(15-40) | 40<br>(20-60) | -             |
| M3  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 25<br>(15-45)  | 35<br>(20-60)  | -              | 25<br>(15-40) | 40<br>(20-60) | -             |
| M4  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 20<br>(10-30)  | 25<br>(15-40)  | -              | 25<br>(10-30) | 30<br>(15-40) | -             |
| M5  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 20<br>(10-30)  | 25<br>(15-40)  | -              | 25<br>(10-30) | 30<br>(15-40) | -             |
| K1  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | 25<br>(15-30)  | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -             | -             | -             |
| K2  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | -              | 25<br>(20-40)  | 40<br>(30-70)  | 45<br>(35-80)  | -             | -             | -             |
| K3  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | 25<br>(15-30)  | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -             | -             | -             |
| K4  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | 25<br>(15-30)  | 45<br>(30-70)  | 70<br>(40-120) | 80<br>(30-150) | -             | -             | -             |
| K5  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | 25<br>(15-30)  | 45<br>(30-70)  | 70<br>(40-120) | 80<br>(45-135) | -             | -             | -             |
| K6  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | -              | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -             | -             | -             |
| K7  | NF/NS-EB845 | 0,10<br>-0,20      | 0,10<br>-0,25 | 0,10<br>-0,30 | 0,20<br>-0,60 | -              | 60<br>(40-100) | 80<br>(30-150) | 90<br>(35-170) | -             | -             | -             |
| S1  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | 15<br>(8-20)   | 20<br>(10-25)  | -              | -             | -             | 20<br>(10-25) |
| S2  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | 15<br>(8-20)   | 20<br>(10-25)  | -              | -             | -             | 20<br>(10-25) |
| S3  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | 15<br>(8-20)   | 20<br>(10-25)  | -              | -             | -             | 25<br>(10-25) |
| S11 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -              | -             | -             | 30<br>(20-50) |
| S12 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -              | -             | -             | 30<br>(20-50) |
| S13 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | 20<br>(15-30)  | 30<br>(15-40)  | 40<br>(20-50)  | -              | -             | -             | 30<br>(20-50) |
| H3  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H5  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H7  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H8  | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H11 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H12 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H21 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| H31 | NF/NS-EB845 | 0,08<br>-0,15      | 0,10<br>-0,15 | 0,10<br>-0,20 | 0,20-<br>0,30 | -              | -              | 10<br>(8-15)   | -              | -             | -             | -             |
| PM1 | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 50<br>(30-80)  | 70<br>(40-100) | -              | -             | -             | -             |
| PM2 | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 50<br>(30-80)  | 70<br>(40-100) | -              | -             | -             | -             |
| PM3 | NF/NS-EB845 | 0,10<br>-0,15      | 0,1<br>-0,20  | 0,10<br>-0,20 | 0,20<br>-0,50 | -              | 50<br>(30-80)  | 70<br>(40-100) | -              | -             | -             | -             |

SMG = Seco anyagcsoport  
a<sub>p</sub> = mm  
f = mm/ford  
v<sub>c</sub> = m/perc  
Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

Forgácsolási adatok – NF/NS...EB845 inch

| SMG |             | $a_p$ (°)       |                 | f               |                 | $v_c$          |                  |                  |                  |                |                 |                 |
|-----|-------------|-----------------|-----------------|-----------------|-----------------|----------------|------------------|------------------|------------------|----------------|-----------------|-----------------|
|     |             | z=4             | z=6             | z=4             | z=6             | H15            | CP20             | RX2000           | RK2050           | RM2020         | RM2090          | RS2090          |
| P3  | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.012 | 0.008<br>-0.024 | -              | 195<br>(100-330) | 260<br>(100-490) | -                | -              | -               | -               |
| P4  | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | -              | 165<br>(100-260) | 195<br>(100-395) | -                | -              | -               | -               |
| P5  | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | -              | -               | -               |
| P6  | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | -              | -               | -               |
| P7  | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | 65<br>(35-80)  | 165<br>(100-260) | 195<br>(100-395) | -                | -              | -               | -               |
| P8  | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | 50<br>(35-65)  | 115<br>(65-195)  | 130<br>(65-260)  | -                | -              | -               | -               |
| P11 | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | 50<br>(35-65)  | 115<br>(65-195)  | 130<br>(65-260)  | -                | -              | -               | -               |
| P12 | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | 40<br>(25-50)  | 80<br>(50-150)   | 100<br>(50-125)  | -                | -              | -               | -               |
| M1  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.02  | 40<br>(30-50)  | 80<br>(50-150)   | 115<br>(65-200)  | -                | 80<br>(50-130) | 130<br>(65-195) | -               |
| M2  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.02  | -              | 80<br>(50-150)   | 115<br>(65-200)  | -                | 80<br>(50-130) | 130<br>(65-195) | -               |
| M3  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.02  | -              | 80<br>(50-150)   | 115<br>(65-200)  | -                | 80<br>(50-130) | 130<br>(65-195) | -               |
| M4  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.02  | -              | 65<br>(30-100)   | 80<br>(50-135)   | -                | 80<br>(35-100) | 100<br>(50-130) | -               |
| M5  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.02  | -              | 65<br>(30-100)   | 80<br>(50-135)   | -                | 80<br>(35-100) | 100<br>(50-130) | -               |
| K1  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | 80<br>(50-100) | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -              | -               | -               |
| K2  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | -              | 80<br>(65-130)   | 130<br>(100-230) | 145<br>(110-260) | -              | -               | -               |
| K3  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | 80<br>(50-100) | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -              | -               | -               |
| K4  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | 80<br>(50-100) | 150<br>(100-330) | 230<br>(130-395) | 260<br>(145-440) | -              | -               | -               |
| K5  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | 80<br>(50-100) | 150<br>(100-330) | 230<br>(130-395) | 260<br>(145-440) | -              | -               | -               |
| K6  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | -              | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -              | -               | -               |
| K7  | NF/NS-EB845 | 0.004<br>-0.008 | 0.004<br>-0.010 | 0.004<br>-0.012 | 0.008<br>-0.024 | -              | 195<br>(130-330) | 260<br>(100-490) | 290<br>(110-550) | -              | -               | -               |
| S1  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | 50<br>(25-65)    | 65<br>(35-80)    | -                | -              | -               | 65<br>(35-80)   |
| S2  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | 50<br>(25-65)    | 65<br>(35-80)    | -                | -              | -               | 65<br>(35-80)   |
| S3  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | 50<br>(25-65)    | 65<br>(35-80)    | -                | -              | -               | 65<br>(35-80)   |
| S11 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | 65<br>(50-100) | 100<br>(50-130)  | 130<br>(65-165)  | -                | -              | -               | 100<br>(65-165) |
| S12 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | 65<br>(50-100) | 100<br>(50-130)  | 130<br>(65-165)  | -                | -              | -               | 100<br>(65-165) |
| S13 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | 65<br>(50-100) | 100<br>(50-130)  | 130<br>(65-165)  | -                | -              | -               | 100<br>(65-165) |
| H3  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H5  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H7  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H8  | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H11 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H12 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H21 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| H31 | NF/NS-EB845 | 0.003<br>-0.006 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.008<br>-0.012 | -              | -                | 35<br>(25-50)    | -                | -              | -               | -               |
| PM1 | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | -              | 165<br>(100-260) | 230<br>(130-350) | -                | -              | -               | -               |
| PM2 | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | -              | 165<br>(100-260) | 230<br>(130-350) | -                | -              | -               | -               |
| PM3 | NF/NS-EB845 | 0.004<br>-0.006 | 0.004<br>-0.008 | 0.004<br>-0.008 | 0.008<br>-0.020 | -              | 165<br>(100-260) | 230<br>(130-350) | -                | -              | -               | -               |

SMG = Seco anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

## Forgácsolási adatok – NF/NS...-EB25/EB30 metrikus

| SMG |                 | $a_p$ (°) |           | 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 | 0,10-0,20 | 0,10-0,30 | 0,3-0,9 | 0,5-1,2 | 50 (20-80) | -           | -           | -           |
| N2  | NF/NS-EB25/EB30 | 0,10-0,20 | 0,10-0,30 | 0,3-0,9 | 0,5-1,2 | 50 (20-80) | -           | -           | -           |
| N3  | NF/NS-EB25/EB30 | 0,10-0,20 | 0,10-0,30 | 0,3-0,9 | 0,5-1,2 | 50 (20-80) | -           | -           | -           |
| N11 | NF/NS-EB25/EB30 | 0,10-0,20 | 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 anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – EB25/EB30 inch

| SMG |                 | $a_p$ (∅)   |             | 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 anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

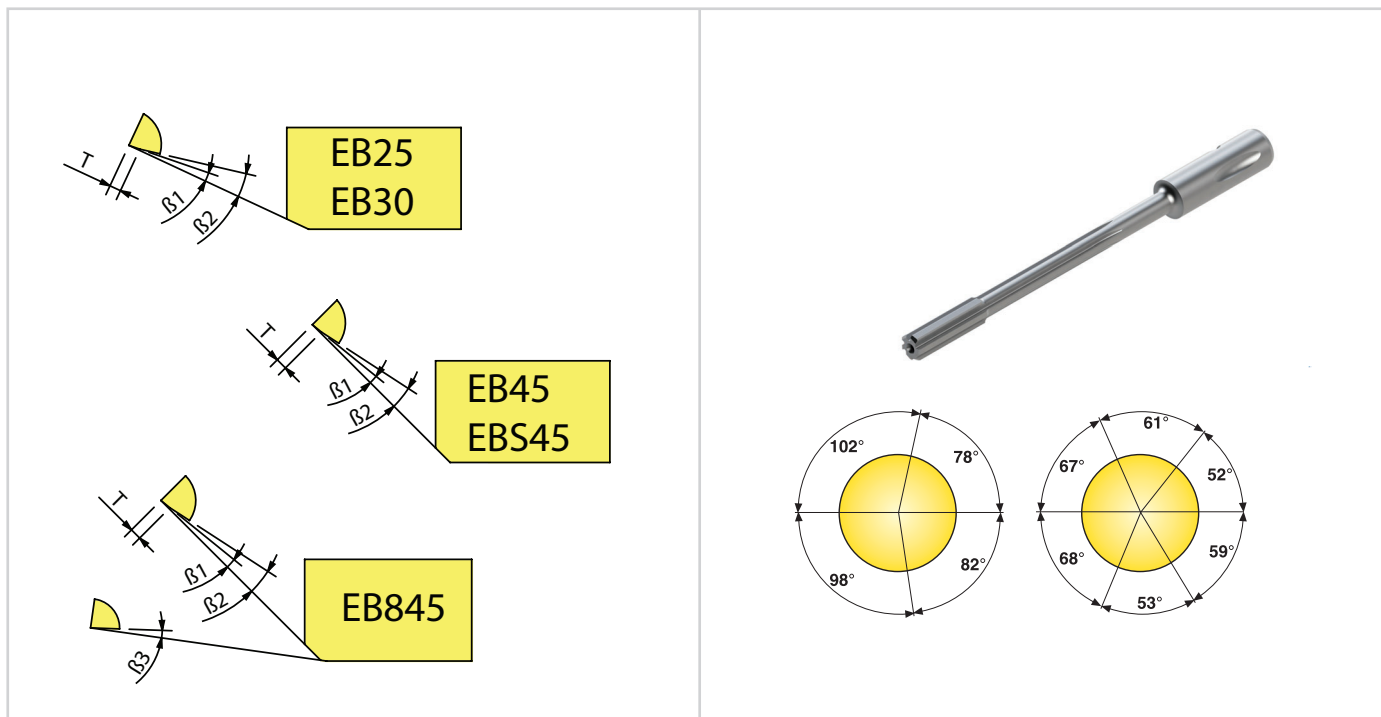
## Újraélezési utasítások

### Utasítások

Gyémánt köszörűkorong  
Szemcseméret:  
D6 az 1. hátszöghöz ( $\beta_1 - \beta_3$ )  
D64 a 2. hátszöghöz ( $\beta_2$ )

### Fontos!

A köszörülés csökkenti a dörzsár átmérőjét.  
Az újrabevonolás túl nagy átmérőt eredményezhet.  
Max. ütés a vezető letöréseken 10  $\mu\text{m}$  (394  $\mu\text{in}$ ).



| $\varnothing$ Nanofix mm (inch) | $\beta_1$ | $\beta_2$ | $\beta_3$ | T mm (inch)  |
|---------------------------------|-----------|-----------|-----------|--------------|
| 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®

A Bifix® váltólapkás dörzsárazók nagy pontosságot nyújtanak minden munkadarab anyagcsoportnál

- 8 és 16 µm közti tűrést és Ra 0,25 (RMS 12 micro/inch) felületi minőséget nyújtanak
- A váltólapkás kivitel két vágóélet biztosít lapkánként
- Három cermet vezető támasz és nagyon pontos beállítási rendszer



## Választék áttekintés

|   | ∅ Választék                         | Dörzsárazási mélység | Fúró ∅ túrése | Köztes átmérő                     | Felületi minőség                                       |
|---|-------------------------------------|----------------------|---------------|-----------------------------------|--|
| <b>SR80 Átmenő furatokhoz</b><br>              | 6,875-60,500 mm<br>(0.2707-2.3819") | 5-7 x D              | IT 6          | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,2-0,8 μm<br>(R <sub>a</sub> 8-31 μin) |
| <b>SR81 Zsák furatokhoz</b><br>                | 7,875-60,500 mm<br>(0.3100-2.3819") | 5-7 x D              | IT 6-7        | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,2-0,8 μm<br>(R <sub>a</sub> 8-31 μin) |
| <b>SR82 Zsák furatokhoz rövid verzió</b><br> | 7,875-60,500 mm<br>(0.3100-2.3819") | 3-5 x D              | IT 6-7        | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,2-0,8 μm<br>(R <sub>a</sub> 8-31 μin) |

## Jelmagyarázat

### Dörzsárak

Dörzsár típus:  
80 típus: átmenő furat  
81-es típus: zsákfurat  
82-es típus: zsákfurat, rövid kivitel



Dörzsár típus:  
80 típus: átmenő furat  
81-es típus: zsákfurat  
82-es típus: zsákfurat, rövid kivitel

Furatátmérő  
és tűrés

Forgácsolási geometria  
EN1, EN2, EN3

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

**0.6624"-0.6628"**

Szár típus: (meghatározandó nem szabványos rendelésénél)  
SR80 és SR81: R1 lapolás nélkül szabványos  
SR82: R9 lapolással szabványos

### Lapkák

**Fontos:**  
A dörzsárnak és a lapkának ugyanolyan geometriával kell rendelkeznie.

Lapkaméret:  
P0, P1, P2, P4

Dőlésszög:  
0°, 6°, 12°

**P2** - **EN1** - **06** - **CP20**

Forgácsolási geometria  
EN1, EN2, EN3

Tömör keményfém minőség:  
CP20, H15

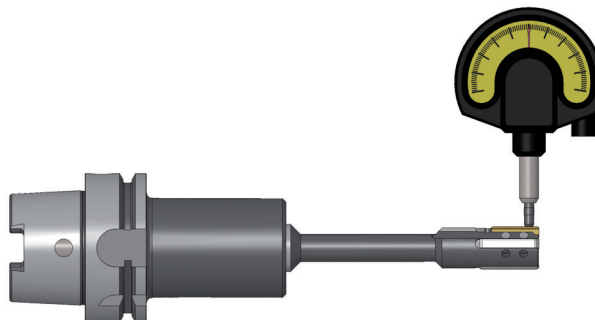
## Beállítási és megmunkálási paraméterek

## Forgó szerszám

Ajánlott max. ütés: 0,02 mm (0.0008")  
 Precíziós befogó ajánlott: Hidraulikus befogó, D-típusú patronos befogó, 5672 patronos befogó vagy shrink-fit.

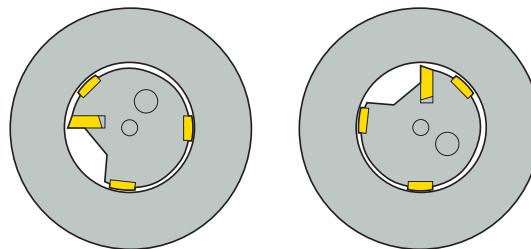
## Álló szerszám esetén

Használjon Seco önbeálló befogót, lásd: 480-484 old..



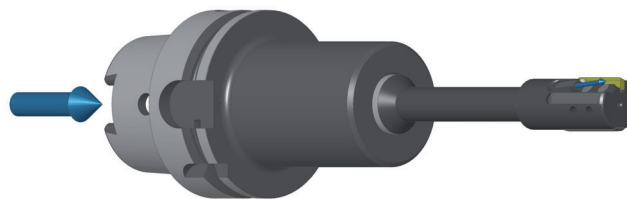
## Az optimális forgácsolótávolsághoz

Ajánlott lapka beállítás álló szerszámokhoz (lásd a rajzot, a szerszámok előlnézetét).



## Hűtőfolyadékkal kapcsolatos követelmények

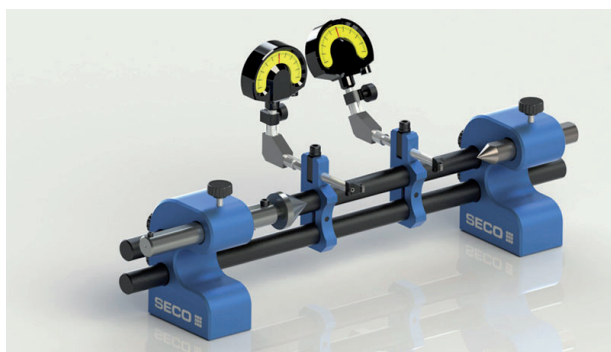
Maximális szerszámelettartam és furatminőség eléréséhez a következő hűtőfolyadék-igényeket vizsgálja meg.  
 Belső hűtés javasolt. Külső hűtés < 2 x D mélységig használható.  
 Minőségi oldódó olaj minimum 40%-os ásványolaj-tartalommal.  
 Korrozíóálló acélhoz tiszta olaj ajánlott.  
 Szűrés 30–50 µm (1200–2000 µin).  
 Mennyiség min. 0,5 l/perc/mm (3.35 gal/min/inch) szerszámtátrő.  
 Pl.: Ø 10 dörzsár, min. mennyiség 5 l/perc (13 gal/min).



## Beállító készülék

## SF-60200-C160C190: Cikksz. 02885396

- Vízszintes állvány
- Elsődleges választás ha az Ø kisebb mint 60 mm (2.362")
- 2 mérőóra
- Maximális szerszámtátrő: 60,5 mm (2.382")
- Maximális szerszámhossz: 200 mm (7.784")



## Geometriaválaszték – Lapkák

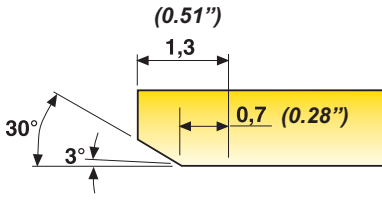
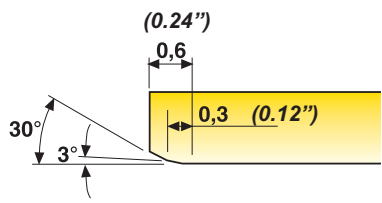
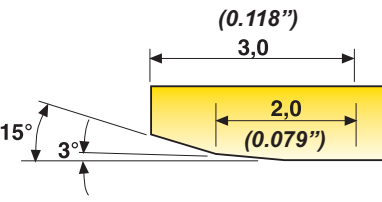
A szárnak és a lapkának ugyanolyan geometriával kell rendelkeznie.

### Minőség és dőlésszög

Használja az alábbi oldalakon található táblázatokat a munkadarab anyagának SMG-besorolásához: 666-672 old..

Használja a 413-415 old. oldalon lévő lapka és forgácsolási adatajánlásokat a minőség és a dőlésszög kiválasztásához.

A lapkaprogram az alábbi oldalakon található: 411, 412 old..

| EN1 – Alkalmazás  |  |
|---|--|
| <p>Maximális megmunkálási ráhagyás <math>\varnothing</math> 0,5 mm (0.020") esetén<br/>                     Felületi minőség + <math>R_a</math> 0,3–0,8 <math>\mu</math>m<br/>                     (Felületi minőség + <math>R_a</math> 12–31 <math>\mu</math>in)</p>   |    |
| EN2 – Rövid bevezetőél  |  |
| <p>Maximális megmunkálási ráhagyás <math>\varnothing</math> 0,3 mm (0.012") esetén<br/>                     Felületi minőség + <math>R_a</math> 0,4–1,2 <math>\mu</math>m<br/>                     (Felületi minőség + <math>R_a</math> 16–47 <math>\mu</math>in)<br/>                     Maximális előtolás 0,2 mm/ford (0008" in/rev).<br/>                     Csak akkor használja ha a rövid bevezető él szükséges<br/>                     Simításra tervezve</p>  |  |
| EN3 – Extrém felületi minőség   |  |
| <p>Maximális megmunkálási ráhagyás <math>\varnothing</math> 0,5 mm (0.020") esetén<br/>                     Felületi minőség + <math>R_a</math> 0,2–0,6 <math>\mu</math>m<br/>                     (Felületi minőség + <math>R_a</math> 8–24 <math>\mu</math>in)<br/>                     Minden anyaghoz megfelelő, kivéve az alumíniumot<br/>                     Akkor használatos, ha a szükséges <math>R_a</math> érték &lt; 0,3–0,4 <math>\mu</math>m<br/>                     (12–16 <math>\mu</math>in)</p> |  |

## Optimalizálás / Minőségek

Használja a lapka választási táblázatot alternatív lapkák választásához és nagyobb termelékenység vagy biztonság eléréséhez.

### Penge választék

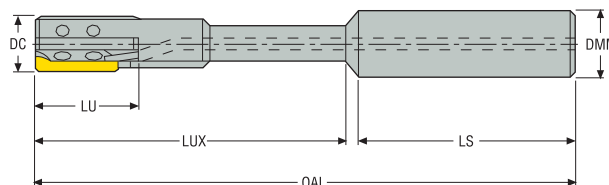
| Lapkaméret | Acél | Korrózióálló acél | Öntvény | Nem vas alapú | Alumínium | Kopásállóság ↔ Szívóosság |              |            | Megnevezés |         |
|------------|------|-------------------|---------|---------------|-----------|---------------------------|--------------|------------|------------|---------|
|            |      |                   |         |               |           | Termelékenység            | Sokoldalúság | Biztonság  | Lapka      | Minőség |
|            |      |                   |         |               |           | 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       |         |

### Minőségek

|  |      |  |
|--|------|--|
|  | CP15 | <b>Bevonatos</b><br>A CP20 minőség kopásálló alternatívája. Optimalizálásra öntöttvasban és acélban. Szintén alkalmazható színesfémekben. Ti(C, N) |
|  | CP20 | <b>Bevonatos</b><br>Sokoldalú minőség a legtöbb anyaghoz, az alumíniumon kívül. TiN  |
|  | H15  | <b>Bevonat nélküli</b><br>Egy szívós minőség minden anyaghoz. Alkalmas finom dörzsárazáshoz az élességének köszönhetően.                           |

## Átmenő furatokhoz Ø 7H6-26H6

Szár típus R1, hengeres sík nélkül, SR80



- Információ a lapkáról a 411, 412 old.
- Belső hűtés

| Megnevezés    | DC | OAL | LS | LUX | LU | DMM | Lapka méret |
|---------------|----|-----|----|-----|----|-----|-------------|
|               | 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   |

### Pótalkatrészek

| Ø (mm) | Állító csavar | Rögzítés | Rögzítő csavar | Beállító kulcs | Támasztó golyó | Nyomaték kulcs* | Nyomaték érték |
|--------|---------------|----------|----------------|----------------|----------------|-----------------|----------------|
| 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         |

\*Torque key is delivered with driving blade

Bevezetés

Fúrás

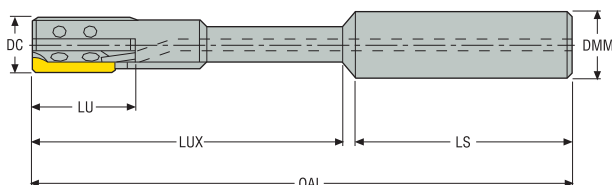
Dörzsárazás

Késztergálás

Melléklet

## Átmenő furatokhoz Ø 27H6–60H6

Szár típus R1, hengeres sík nélkül, SR80



- Információ a lapkákról a 411, 412 old.
- Belső hűtés

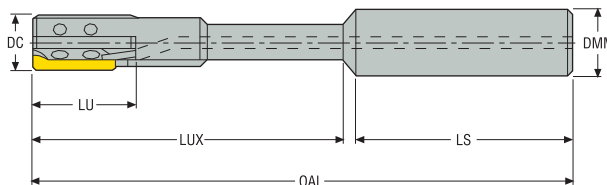
| Megnevezés    | DC | OAL | LS | LUX | LU | DMM | Lapka méret |
|---------------|----|-----|----|-----|----|-----|-------------|
|               | mm | mm  | mm | mm  | mm | mm  |             |
| SR80-27H6-EN1 | 27 | 221 | 56 | 159 | 30 | 25  | P4-EN1-xx   |
| SR80-28H6-EN1 | 28 | 221 | 56 | 159 | 30 | 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   |

### Pótalkatrészek

| Ø (mm) | Állító csavar | Rögzítés | Rögzítő csavar | Beállító kulcs | Támasztó golyó | Nyomaték kulcs* | Nyomaték érték |
|--------|---------------|----------|----------------|----------------|----------------|-----------------|----------------|
| 20-60  | SH4060        | SR-B5    | LH4010         | 2SMS795        | BB3.0          | H00-2020        | 2,0 Nm         |

## Átmenő furatokhoz – Köztes átmérő

Szár típus R1, hengeres sík nélkül, SR80




























- Információ a lapkákról a 411, 412 old.
- Fontos! A dörzsárak és a lapkák ugyanolyan geometriával kell rendelkeznie.
- Megvezető geometria kiválasztásához EN1, EN2 vagy EN3 lásd a 402 old.

| Megnevezés             | DC             | OAL   | LS   | LUX   | LU   | DMM  | Lapka méret |
|------------------------|----------------|-------|------|-------|------|------|-------------|
|                        | 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    |

### Pótalkatrészek

### Kiegészítők

| Ø (mm)        | Állító csavar  | Rögzítő   | Rögzítő csavar   | Beállító kulcs  | Támasztó golyó  | Nyomaték kulcs |
|---------------|--|---|--|---|---|----------------|
| 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       |

\*Torque key is delivered with driving blade

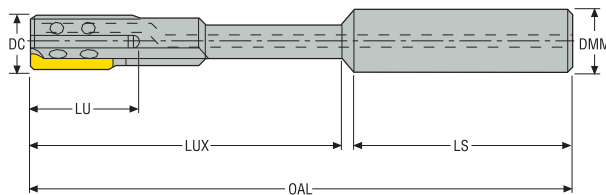
Figyelem! Köztes átmérőjű dörzsárak rendelésénél jelezze az átmérőt: a furat tűrését, illetve a forgácsolási geometriát (EN1, EN2 vagy EN3).

Rendelési példa: SR80-11.50 H7-EN2, P1-EN2-06, CP20.



## Zsák furatokhoz Ø 8H6-26H6

Szár típus R1, hengeres sík nélkül, SR81



- Információ a lapkáról a 411, 412 old.
- Belső hűtés

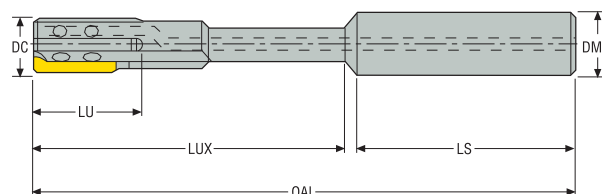
| Megnevezés    | DC | OAL | LS | LUX | LU | DMM | Lapka méret |
|---------------|----|-----|----|-----|----|-----|-------------|
|               | mm | mm  | mm | mm  | mm | mm  |             |
| SR81-8H6-EN1  | 8  | 115 | 40 | 73  | 25 | 10  | P0-EN1-xx   |
| SR81-9H6-EN1  | 9  | 115 | 40 | 73  | 25 | 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   |

### Pótalkatrészek

| Ø (mm) | Állító csavar | Rögzítés | Rögzítő csavar | Beállító kulcs | Támasztó golyó | Nyomaték kulcs* | Nyomaték érték |
|--------|---------------|----------|----------------|----------------|----------------|-----------------|----------------|
|        |               |          |                |                |                |                 |                |
| 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         |

## Zsák furatokhoz Ø 27H6–60H6







Szár típus R1, hengeres sík nélkül, SR81



- Információ a lapkákról a 411, 412 old.
- Belső hűtés

| Megnevezés    | DC | OAL | LS | LUX | LU | DMM | Lapka méret |
|---------------|----|-----|----|-----|----|-----|-------------|
|               | 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   |

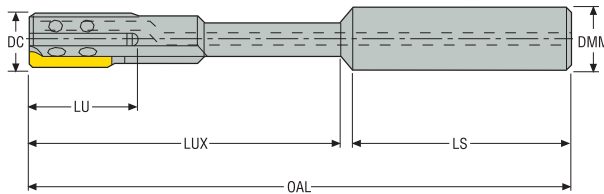
### Pótalkatrészek

| Ø (mm) | Állító csavar  | Rögzítés  | Rögzítő csavar   | Beállító kulcs  | Támasztó golyó   | Nyomaték kulcs*  | Nyomaték érték |
|--------|--|---|--|---|--|--|----------------|
| 20-60  |  SH4060 |  SR-B5 |  LH4010 |  2SMS795 |  BB3.0 |  H00-2020 | 2,0 Nm         |

\*Torque key is delivered with driving blade

## Zsák furatokhoz – Köztes átmérő

Szár típus R1, hengeres sík nélkül, SR81



- Információ a lapkákról a 411, 412 old.
- Fontos! A dörzsárnak és a lapkának ugyanolyan geometriával kell rendelkeznie.
- Megvezető geometria kiválasztásához EN1, EN2 vagy EN3 lásd a 402 old.

| Megnevezés             | DC             | OAL   | LS   | LUX   | LU   | DMM  | Lapka méret |
|------------------------|----------------|-------|------|-------|------|------|-------------|
|                        | 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    |

### Pótalkatrészek

### Kiegészítők

| Ø (mm)       | Állító csavar | Rögzőtő | Rögzőtő csavar | Beállító kulcs | Támasztó golyó | Nyomaték kulcs |
|--------------|---------------|---------|----------------|----------------|----------------|----------------|
| 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       |

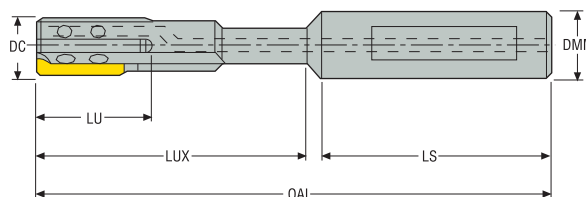
\*Torque key is delivered with driving blade

Figyelem! Köztes átmérőjű dörzsárazás rendelésénél jelezze az átmérőt: a furat túsését, illetve a forgácsolási geometriát (EN1, EN2 vagy EN3).

Rendelési példa: SR81-11.50 H7-EN2, P1-EN2-06, CP20.

## Zsák furatokhoz – Rövid típus esztergálási műveletekhez

Szár típus R9, hengeres sikkal, SR82



- Információ a lapkáról a 411, 412 old.
- Fontos! A dörzsárak és a lapkák ugyanolyan geometriával kell rendelkeznie.
- Megvezető geometria kiválasztásához EN1, EN2 vagy EN3 lásd a 402 old.

| Megnevezés             | DC             | OAL   | LS   | LUX   | LU   | DMM  | Lapka méret |
|------------------------|----------------|-------|------|-------|------|------|-------------|
|                        | 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    |

### Pótalkatrészek

### Kiegészítők

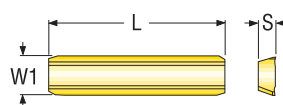
| Ø (mm)       | Állító csavar | Rögzítő | Rögzítő csavar | Beállító kulcs | Támasztó golyó | Nyomaték kulcs |
|--------------|---------------|---------|----------------|----------------|----------------|----------------|
| 9,75-12,749  | SH2525        | SR-B2   | LH2540         | 1.3SMS795      | BB2.0          | 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       |

\*Torque key is delivered with driving blade

Figyelem! Köztes átmérőjű dörzsárak rendelésénél jelezze az átmérőt: a furat tűrését, illetve a forgácsolási geometriát (EN1, EN2 vagy EN3).

Rendelési példa: SR82-11.50 H7EN2, P1-EN2-06, CP20.

## P0-P4 Pengék



| Megnevezés | Lapka | L           |              | S            |            | W1       |          | Minőségek |  |
|------------|-------|-------------|--------------|--------------|------------|----------|----------|-----------|--|
|            |       | mm<br>Inch  | mm<br>Inch   | mm<br>Inch   | mm<br>Inch | H15      | CP20     |           |  |
| P0-EN1-0   | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098229 | 00098244 |           |  |
| P0-EN1-06  | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00091786 | 00091762 |           |  |
| P0-EN1-12  | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00097299 | 00091971 |           |  |
| P0-EN2-0   | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098234 | 00098249 |           |  |
| P0-EN2-06  | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098160 | 00098170 |           |  |
| P0-EN2-12  | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098165 | 00098175 |           |  |
| P0-EN3-0   | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098239 | 00098254 |           |  |
| P0-EN3-06  | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098185 | 00098195 |           |  |
| P0-EN3-12  | P0    | 20<br>0.787 | 1,2<br>0.047 | 2,5<br>0.098 |            | 00098190 | 00098200 |           |  |
| P1-EN1-0   | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098230 | 00098245 |           |  |
| P1-EN1-06  | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00091787 | 00091764 |           |  |
| P1-EN1-12  | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00097300 | 00091972 |           |  |
| P1-EN2-0   | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098235 | 00098250 |           |  |
| P1-EN2-06  | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098161 | 00098171 |           |  |
| P1-EN2-12  | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098166 | 00098176 |           |  |
| P1-EN3-0   | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098240 | 00098255 |           |  |
| P1-EN3-06  | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098186 | 00094702 |           |  |
| P1-EN3-12  | P1    | 20<br>0.787 | 1,5<br>0.059 | 3,0<br>0.118 |            | 00098191 | 00098201 |           |  |
| P2-EN1-0   | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00098231 | 00098246 |           |  |
| P2-EN1-06  | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00091788 | 00091765 |           |  |
| P2-EN1-12  | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00097301 | 00091973 |           |  |
| P2-EN2-0   | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00098236 | 00098251 |           |  |
| P2-EN2-06  | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00098162 | 00098172 |           |  |
| P2-EN2-12  | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00098167 | 00098177 |           |  |
| P2-EN3-0   | P2    | 20<br>0.787 | 2,0<br>0.079 | 4,5<br>0.177 |            | 00098241 | 00098256 |           |  |

| Megnevezés | Lapka | L                 |                   | S                 |                   | W1       |      | Minőségek |  |
|------------|-------|-------------------|-------------------|-------------------|-------------------|----------|------|-----------|--|
|            |       | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | H15      | CP20 |           |  |
| P2_EN3-06  | P2    | 20<br>0.787       | 2,0<br>0.079      | 4,5<br>0.177      |                   | 00098187 |      | 00098197  |  |
| P2-EN3-12  | P2    | 20<br>0.787       | 2,0<br>0.079      | 4,5<br>0.177      |                   | 00098192 |      | 00098202  |  |
| P4-EN1-0   | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098232 |      | 00098247  |  |
| P4-EN1-06  | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00091789 |      | 00091766  |  |
| P4-EN1-12  | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098128 |      | 00091974  |  |
| P4-EN2-0   | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098237 |      | 00098252  |  |
| P4-EN2-06  | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098163 |      | 00098173  |  |
| P4-EN2-12  | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098168 |      | 00098178  |  |
| P4-EN3-0   | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098242 |      | 00098257  |  |
| P4-EN3-06  | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098188 |      | 00098198  |  |
| P4-EN3-12  | P4    | 25,0<br>0.984     | 2,3<br>0.091      | 7,0<br>0.276      |                   | 00098193 |      | 00098203  |  |

Bevezetés

Fűrés

Dörzsárazás

Késztergálás

Melléklet

## Forgácsolási adatok – Pxx-EN1/EN2-00 metrikus

| SMG |                | $a_p$ (∅)         |                      | f         | $v_c$       |              |
|-----|----------------|-------------------|----------------------|-----------|-------------|--------------|
|     |                | $\varnothing < 9$ | $\varnothing \geq 9$ |           | 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 anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

## Forgácsolási adatok – Pxx-EN1/EN2-00 inch

| SMG |                | $a_p$ (∅)         |                      | f           | $v_c$         |               |
|-----|----------------|-------------------|----------------------|-------------|---------------|---------------|
|     |                | $\varnothing < 9$ | $\varnothing \geq 9$ |             | 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 anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – Pxx-EN1/EN2-06 metrikus

| SMG |                | $a_p (\varnothing)$ |                      | $f$       | $v_c$       |              |              |
|-----|----------------|---------------------|----------------------|-----------|-------------|--------------|--------------|
|     |                | $\varnothing < 9$   | $\varnothing \geq 9$ |           | 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 anyagcsoport

$a_p$  = mm

$f$  = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet



## Forgácsolási adatok – Pxx-EN1/EN2-06 inch

| SMG |                | $a_p$ (°)         |                      | f           | $v_c$         |               |               |
|-----|----------------|-------------------|----------------------|-------------|---------------|---------------|---------------|
|     |                | $\varnothing < 9$ | $\varnothing \geq 9$ |             | 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 anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – Pxx-EN1/EN2-12 metrikus

| SMG |                | $a_p (\varnothing)$ |                      | $f$       | $v_c$       |              |              |
|-----|----------------|---------------------|----------------------|-----------|-------------|--------------|--------------|
|     |                | $\varnothing < 9$   | $\varnothing \geq 9$ |           | 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 anyagcsoport

$a_p$  = mm

$f$  = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

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## Forgácsolási adatok – Pxx-EN1/EN2-12 inch

| SMG |                | $a_p$ (°)         |                      | f           | $v_c$         |               |               |
|-----|----------------|-------------------|----------------------|-------------|---------------|---------------|---------------|
|     |                | $\varnothing < 9$ | $\varnothing \geq 9$ |             | 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 anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

### Forgácsolási adatok – Pxx-EN3-00 metrikus

| SMG |            | $a_p$ (°)         |                      | f         | $v_c$       |              |
|-----|------------|-------------------|----------------------|-----------|-------------|--------------|
|     |            | $\varnothing < 9$ | $\varnothing \geq 9$ |           | 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 anyagcsoport

$a_p$  = mm

f = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

### Forgácsolási adatok – Pxx-EN3-00 inch

| SMG |            | $a_p$ (°)         |                      | f           | $v_c$         |               |
|-----|------------|-------------------|----------------------|-------------|---------------|---------------|
|     |            | $\varnothing < 9$ | $\varnothing \geq 9$ |             | 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 anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

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## Forgácsolási adatok – Pxx-EN3-06 metrikus

| SMG |            | $a_p$ (°)         |                      | f         | $v_c$      |              |              |
|-----|------------|-------------------|----------------------|-----------|------------|--------------|--------------|
|     |            | $\varnothing < 9$ | $\varnothing \geq 9$ |           | 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 anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – Pxx-E3-06 inch

| SMG |            | $a_p (\varnothing)$ |                      | f           | $v_c$         |               |               |
|-----|------------|---------------------|----------------------|-------------|---------------|---------------|---------------|
|     |            | $\varnothing < 9$   | $\varnothing \geq 9$ |             | 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 anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## Forgácsolási adatok – Pxx-EN3-12 metrikus

| SMG |            | $a_p$ (°)         |                      | f         | $v_c$      |              |              |
|-----|------------|-------------------|----------------------|-----------|------------|--------------|--------------|
|     |            | $\varnothing < 9$ | $\varnothing \geq 9$ |           | 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 anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

## Forgácsolási adatok – Pxx-EN3-12 inch

| SMG |            | $a_p$ (°)         |                      | f           | $v_c$         |               |               |
|-----|------------|-------------------|----------------------|-------------|---------------|---------------|---------------|
|     |            | $\varnothing < 9$ | $\varnothing \geq 9$ |             | 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 anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

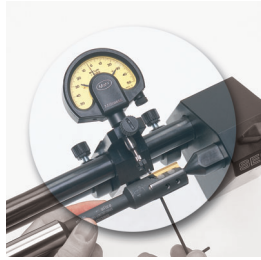
## Beállítási utasítások

|              |   |  |
|--------------|---|--|
| Bevezetés    | <p>1.</p>    | <p>Lazítsa meg a két beállító csavart(7) 1/4 fordulattal.</p>  |
| Fűrés        | <p>2.</p>    | <p>Lazítsa meg a két rögzítőcsavart (5).</p>   |
| Dörzsárazás  | <p>3.</p>   | <p>Tisztítsa ki a lapkaülékeket végig, majd fordítsa meg a lapkát (2) vagy cserélje ki.</p>                                  |
| Kisztergálás | <p>4.</p>  | <p>Nyomja a lapkát határozottan az axiális végpontra és az állító golyókra (6).</p>  |
| Melléklet    | <p>5.</p>  | <p>Húzza meg határozottan a rögzítőcsavarokat.<br/>(Fogja a kulcsot a rövidebb végénél a megfelelő nyomaték eléréséhez).</p> |
| Melléklet    | <p>6.</p>  | <p>Állítsa a <math>\mu\text{m}</math> órát nullára a hengeres vezető támaszok (3) hátsó végének segítségével.</p>            |




Beállítási utasítások

**7.**




Állítsa a lapka másik végét olyan átmérőre, hogy a hátsó kúposág 0,01 mm/10 mm (0.0004"/0.394") lapkahossz legyen (2. ábra).

**8.**



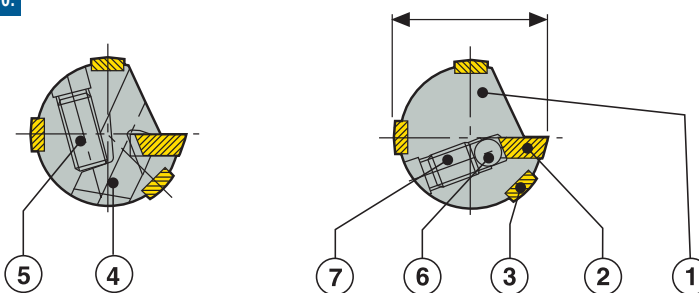
Állítsa a  $\mu\text{m}$  órát nullára a hengeres vezető támaszok (3) első részének segítségével.

**9.**

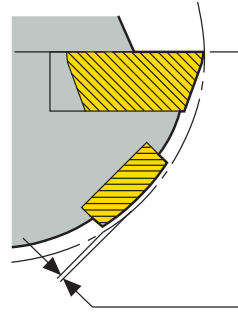


Állítsa a lapka elejét 0,02 mm vagy 0,015 mm-rel (0.0008" vagy 0.0006") a vezető támaszok (3) fölé, A óra, 1. ábra.  
Ellenőrizze újra a hátsó kúposág értékét (6. és 7. lépés), B óra.

**10.**



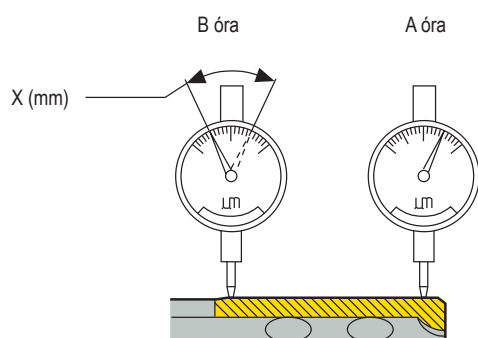
Megjegyzés: Amennyiben az átmérő nagyobb lett állítva a szükségesnél, kezdje előlről a folyamatot a beállítócsavar hibájának elkerüléséért.



1. ábra

0,015 mm ( $\varnothing \leq 10$  mm)  
0,020 mm ( $\varnothing > 10$  mm)  
Az A óra értéke az  $\varnothing$  beállításához

0.0006" ( $\varnothing \leq 0.394$ ")  
0.0008" ( $\varnothing > 0.394$ ")  
Az A óra értéke az  $\varnothing$  beállításához

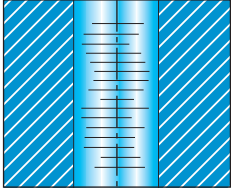
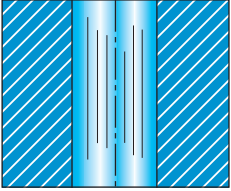
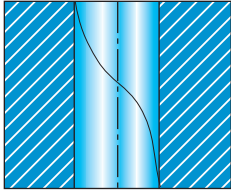
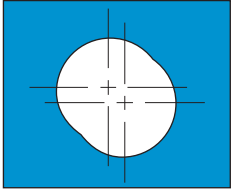
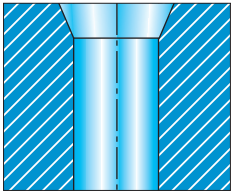
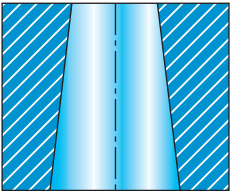
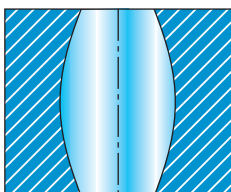
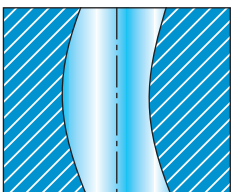
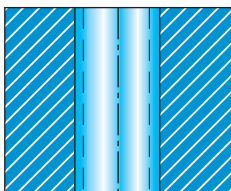
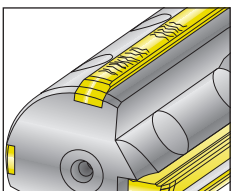


2. ábra

| Beállítási táblázat         |             |            |             |
|-----------------------------|-------------|------------|-------------|
| Átmérőtartomány, mm (inch)  | Lapka méret | Első A óra | Hátsó B óra |
| 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           |

- Óraegység = 1  $\mu\text{m}$  (39  $\mu\text{in}$ )
- Az első és hátsó óra értékek akkor érvényesek, ha nulla van beállítva a mellette lévő támaszon
- A hátsó óra értékek kiszámítása úgy történik, hogy a hátsó kúposág 1  $\mu\text{m}/\text{mm}$  (0.0004") lapkahossz

## Problémamegoldás

|   |   |
|---|---|
| <p><b>Gyenge felületi minőség</b></p> <ul style="list-style-type: none"> <li>• Ellenőrizze az anyagráhagyást</li> <li>• Javítsa a hűtési körülményeket (kiömlő nyílás típusa, nyomás, minőség)</li> <li>• Csökkentse az előtolási sebességet</li> <li>• Cseréljen lapkát (rossz forgácsolási geometria vagy dőlésszög)</li> <li>• Ellenőrizze a lapka axiális pozícióját</li> </ul>  | <p><b>Függőleges barázdák</b></p> <ul style="list-style-type: none"> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Növelje a szerszám hátsó kúposágát</li> </ul>   |
| <p><b>Barázdák</b></p> <ul style="list-style-type: none"> <li>• Javítsa a hűtési körülményeket (kiömlő nyílás típusa, nyomás, minőség)</li> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Növelje a szerszám hátsó kúposágát</li> </ul>    | <p><b>Nem pontos központ/ovalítás</b></p> <ul style="list-style-type: none"> <li>• Javítsa a darab rögzítését (munkadarab-deformáció)</li> <li>• Ellenőrizze az anyagráhagyást</li> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Ellenőrizze a lapka axiális pozícióját</li> </ul>  |
| <p><b>Kúpos bemeneti nyílás</b></p> <ul style="list-style-type: none"> <li>• Csökkentse az előtolást</li> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Ellenőrizze a szerszám hátsó kúposágát</li> <li>• Csökkentse a radiális ütést</li> </ul>   | <p><b>Kúpos furat</b></p> <ul style="list-style-type: none"> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Ellenőrizze a szerszám hátsó kúposágát</li> </ul>   |
| <p><b>Deformált furat</b></p> <ul style="list-style-type: none"> <li>• Javítsa a darab rögzítését (munkadarab-deformáció)</li> </ul>   | <p><b>Íves furat</b></p> <ul style="list-style-type: none"> <li>• Cseréljen lapkát (rossz a forgácsolási geometria)</li> <li>• Ellenőrizze a lapka axiális pozícióját</li> </ul>   |
| <p><b>Túl nagy átmérő</b></p> <ul style="list-style-type: none"> <li>• Javítsa a központosságot (darab/ szerszám)</li> <li>• Állítson az átmérőn (túl nagy)</li> </ul>   | <p><b>Anyagfelrakódás</b></p> <ul style="list-style-type: none"> <li>• Javítsa a hűtési körülményeket (kiömlő nyílás típusa, nyomás, minőség)</li> <li>• Állítson az átmérőn (túl kicsi)</li> </ul>    |




## Xfix™

Az Xfix™ nagy átmérőjű többélű dörzsárazás célja a lehető legnagyobb teljesítmény és pontosság elérése a furatgyártásban.

- Akár 6,5xD forgácsolási mélység 39,5–154,5 mm (2.03' – 6.083') átméretartományban
- Gyors és egyszerű beállítás, foganként csak egy csavar kell az átmérő beállításához és az egyes fogak beállítása is csak egyetlen csavart igényel
- Pontos beállítórendszer a szűk, 16 és 25 μm (0.0006 – 0.0010') tűrések eléréséhez
- A lapkák négy vagy nyolc számított éllel rendelkeznek

## Választék áttekintés

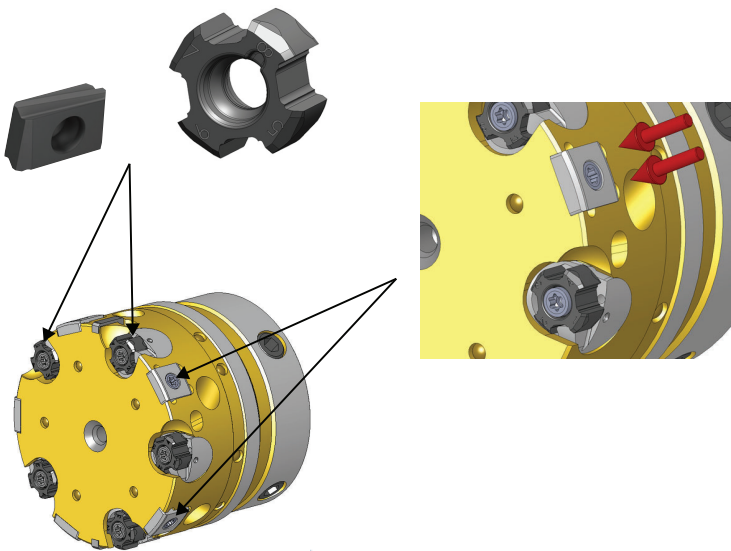
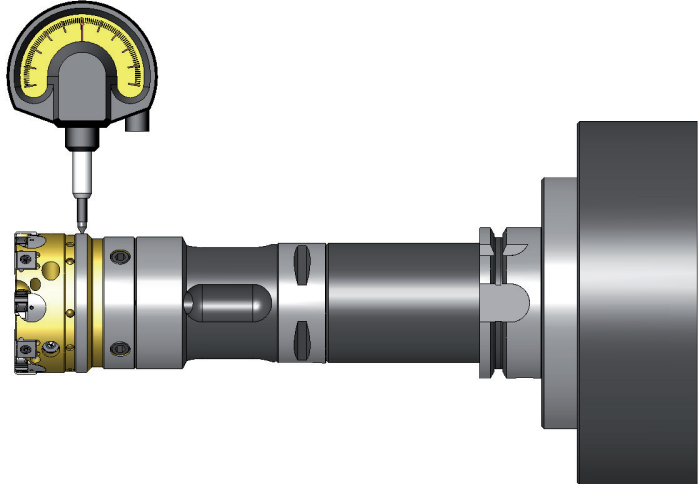
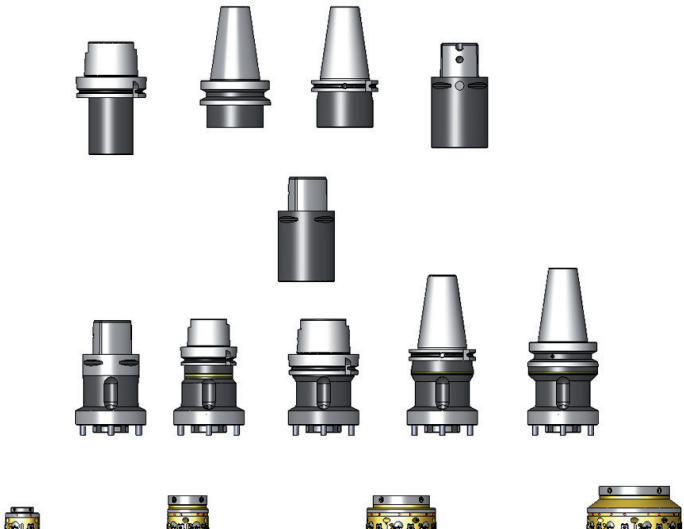
|   | ∅ Választék                           | Dörzsárazási mélység | Fúró ∅ tűrése | Köztes átmérő                     | Felületi minőség  |
|---|---------------------------------------|----------------------|---------------|-----------------------------------|---|
| <p><b>Xfix™</b></p>  | 39,500-154,500 mm<br>(1.5551-6.0827") | 2,5-6,5 x D          | IT 6          | Igen, elérhető a Custom design-al | R <sub>a</sub> 0,8-1,2 μm<br>(R <sub>a</sub> 31-47 μin) |

Az Xfix™ a Seco dörzsár programjának egy speciálisan fejlesztett terméke, nagy átmérőkhöz ∅ 39,5 - 154,5 mm-ig (1.555" – 6.083").

Állítható és cserélhető váltólapokkal biztosítja az IT6 tűrés pontosságát a beépített ütőmérési adapterrel, mely garantálja a munkadarab jó minőségét.

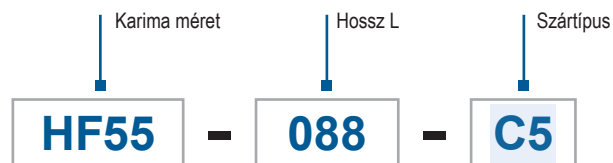
A több fogú kivitel és a cserélhető megvezető biztosítja a maximális stabilitást és termelékenységet a nagy átmérőjű dörzsárazási megmunkálásoknál.

## Tulajdonságok

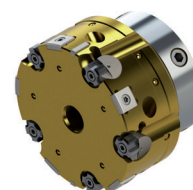
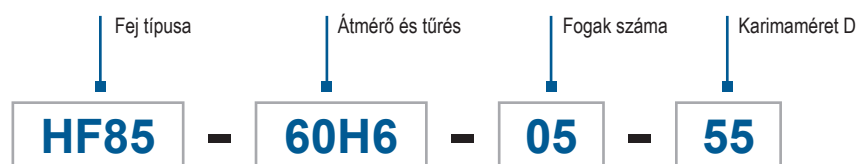
|  |  |              |
|--|--|--------------|
| <ul style="list-style-type: none"> <li>• 4 vagy 8 vágóél a gazdaságosságért</li> <li>• Stabil rögzítőrendszer</li> <li>• Könnyű beállítás 1 állítócsavar alkalmazásával</li> <li>• Minőség és geometria választéka különböző megmunkálásokhoz</li> </ul><br><ul style="list-style-type: none"> <li>• Szabadalmaztatott támasz rendszer a műveleti biztonságért</li> <li>• Támaszok kenése a teljesítményért és biztonságért</li> </ul> |    | Bevezetés    |
| <ul style="list-style-type: none"> <li>• Integrált állítható adapter a tökéletes ütés-szabályozáshoz</li> </ul>  |   | Fűrés        |
| <ul style="list-style-type: none"> <li>• Szárak és hosszabbítók a Seco Felszerszámozás katalógus illusztráció összeállításához</li> </ul>  |  | Dörzsárazás  |
|  |  | Késztergálás |
|  |  | Melléklet    |

## Jelmagyarázat

### Adapterek



### Standard fejek



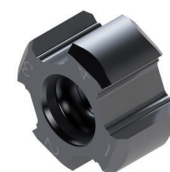
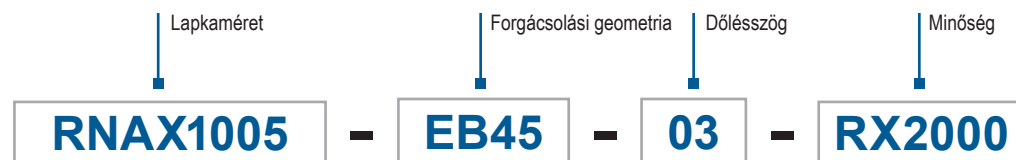
### Fejek Köztes



#### Fejtípus információk:

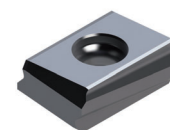
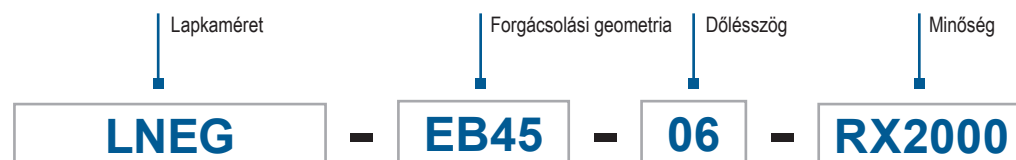
- HF85, átmenő furat, rövid forgácsú agyag
- HF85B, zsákfurat, rövid forgácsú anyag
- HF86, átmenő furat, minden anyag
- HF86B, zsákfurat, minden anyag

### Lapkák



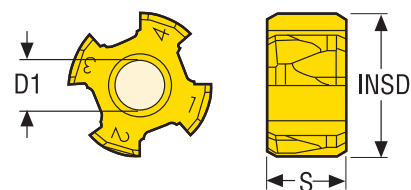
RNAX lapka a HF85 és HF 85B Xfix fejekhez

### Lapkák



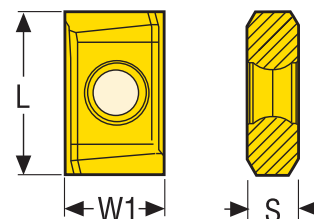
LNEG lapkák a HF86 és HF86B Xfix fejekhez

## RNAX



| Megnevezés         | Lapkák | INSD          | S            | D1           | Minőségek |          | Szög  |
|--------------------|--------|---------------|--------------|--------------|-----------|----------|-------|
|                    |        |               |              |              | RX1500    | RX2000   |       |
| RNAX1005-EB1570-03 | RNAX   | 10,0<br>0.394 | 5,5<br>0.217 | 3,5<br>0.138 | 02687601  | 02687603 | 3,0 ° |
| RNAX1005-EB45-03   | RNAX   | 10,0<br>0.394 | 5,5<br>0.217 | 3,5<br>0.138 | 02687600  | 02688608 | 3,0 ° |
| RNAX1005-EB845-03  | RNAX   | 10,0<br>0.394 | 5,5<br>0.217 | 3,5<br>0.138 | 02687593  | 02688606 | 3,0 ° |

## LNEG



| Megnevezés        | Lapkák | L             | S            | W1            | Minőségek |          |          | Szög  |
|-------------------|--------|---------------|--------------|---------------|-----------|----------|----------|-------|
|                   |        |               |              |               | RX1500    | RX2000   | CF       |       |
| LNEG1003-EB45-03  | LNEG   | 10,0<br>0.394 | 3,5<br>0.138 | 6,35<br>0.250 |           | 02781311 |          | 3,0 ° |
| LNEG1003-EB45-06  | LNEG   | 10,0<br>0.394 | 3,5<br>0.138 | 6,35<br>0.250 | 02904277  | 02781313 | 02904276 | 6,0 ° |
| LNEG1003-EB845-03 | LNEG   | 10,0<br>0.394 | 3,5<br>0.138 | 6,35<br>0.250 |           | 02781314 |          | 3,0 ° |
| LNEG1003-EB845-06 | LNEG   | 10,0<br>0.394 | 3,5<br>0.138 | 6,35<br>0.250 |           | 02781315 |          | 6,0 ° |

## Forgácsolási geometria

| Forgácsolási geometria, EB45 – Alkalmazás   |  |
|---|--|
| <p>Forgácsirányítás +++<br/>Felületi minőség + <math>R_a</math> 1,2–2 <math>\mu\text{m}</math><br/>(<i>Felületi minőség + <math>R_a</math> 0.047–0.0787 <math>\mu\text{in}</math></i>)<br/>Elsődlegesen választandó geometria</p>             |  |
| Forgácsolási geometria, EB845 – Alkalmazás  |  |
| <p>Forgácsirányítás ++<br/>Felületi minőség +++ <math>R_a</math> 0,4–1,2 <math>\mu\text{m}</math><br/>(<i>Felületi minőség +++ <math>R_a</math> 0.0157–0.047 <math>\mu\text{in}</math></i>)</p>   |  |
| Forgácsolási geometria, EB1570 – Alkalmazás   |  |
| <p>Forgácsirányítás ++<br/>Felületi minőség ++ <math>R_a</math> 0,8–1,6 <math>\mu\text{m}</math><br/>(<i>Felületi minőség ++ <math>R_a</math> 0.031–0.0630 <math>\mu\text{in}</math></i>)<br/>Stabilitás nagy kinyúlású alkalmazásnál +++</p> |  |

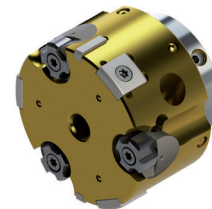
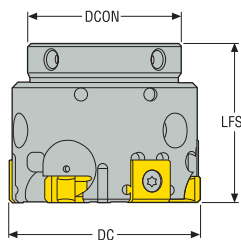
## Minőségek

| Minőségek |               |   |
|-----------|---------------|---|
|           | <b>RX1500</b> | <b>Bevonatos Cermet</b><br>Egy kopásálló minőség acél és öntöttvas optimalizálásához. |
|           | <b>RX2000</b> | <b>Bevonatos</b><br>Nagy teljesítményű bevonatos minden anyaghoz.                     |
|           | <b>CF</b>     | <b>Cermet</b><br>Kopásálló minőség, acélok megmunkálásához optimális.                 |




# HF85



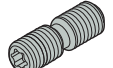




Fejek az RNAX lapkák, átmenő furat  $\varnothing$  39,5-59,499 mm / 1.555-2.342"





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés             | DCN           | DCX             | LFS           | DCON          | Súly          | Lapka   |
|------------------------|---------------|-----------------|---------------|---------------|---------------|---|
|                        | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF85-39.5/44.499-03-32 | 39,5<br>1.555 | 44,499<br>1.752 | 33,0<br>1.299 | 32,0<br>1.260 | 0,41<br>0.900 | 3 RNAX1005...   |
| HF85-44.5/49.499-03-32 | 44,5<br>1.752 | 49,499<br>1.949 | 33,0<br>1.299 | 32,0<br>1.260 | 0,51<br>1.120 | 3 RNAX1005...   |
| HF85-49.5/54.499-03-32 | 49,5<br>1.949 | 54,499<br>2.146 | 33,0<br>1.299 | 32,0<br>1.260 | 0,62<br>1.370 | 3 RNAX1005...   |
| HF85-54.5/59.499-03-32 | 54,5<br>2.146 | 59,499<br>2.342 | 33,0<br>1.299 | 32,0<br>1.260 | 0,74<br>1.630 | 3 RNAX1005...   |

## Pótalkatrészek

| Fej        | Állító csavar   | Kazetta  | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|------------|---|--|---|---|---|---|---|
| HF85 03-32 |  SH4075S |  CARTCYHF16 |  LDH4010 |  C03010-T09P |  H2.0-2D |  2SMS795 |  B6027 |

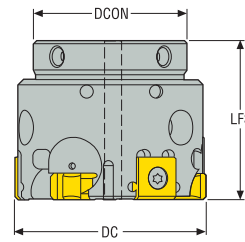
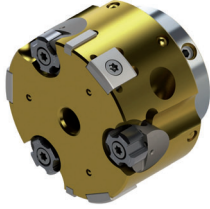
## Kiegészítők

| Fej        | Nyomaték kulcs   | Torx kulcs a lapka/befogó csavarhoz   |
|------------|--|---|
| HF85 03-32 |  H00-2020 |  T00-09P20 |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF85B



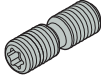




Fejek az RNAX lapkák, zsák furat  $\varnothing$  39,5-59,499 mm / 1.555-2.342"





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés              | DCN           | DCX             | LFS           | DCN           | Súly          | Lapka   |
|-------------------------|---------------|-----------------|---------------|---------------|---------------|---|
|                         | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF85B-39.5/44.499-03-32 | 39,5<br>1.555 | 44,499<br>1.752 | 33,0<br>1.299 | 32,0<br>1.260 | 0,41<br>0.900 | 3 RNAX1005...   |
| HF85B-44.5/49.499-03-32 | 44,5<br>1.752 | 49,499<br>1.949 | 33,0<br>1.299 | 32,0<br>1.260 | 0,51<br>1.120 | 3 RNAX1005...   |
| HF85B-49.5/54.499-03-32 | 49,5<br>1.949 | 54,499<br>2.146 | 33,0<br>1.299 | 32,0<br>1.260 | 0,62<br>1.370 | 3 RNAX1005...   |
| HF85B-54.5/59.499-03-32 | 54,5<br>2.146 | 59,499<br>2.342 | 33,0<br>1.299 | 32,0<br>1.260 | 0,74<br>1.630 | 3 RNAX1005...   |

### Pótalkatrészek

| Fej         | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|-------------|---|---|---|---|---|---|---|
|             |  |  |  |  |  |  |  |
| HF85B 03-32 | SH4075S   | CARTCYHF16B   | LDH4010   | C03010-T09P   | H2.0-2D   | 2SMS795   | B6027   |

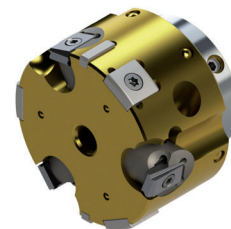
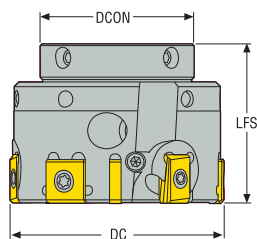
### Kiegészítők

| Fej         | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|-------------|---|---|
|             |  |  |
| HF85B 03-32 | H00-2020  | T00-09P20   |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

# HF86



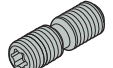




Fejek az LNEG lapkák, átmenő furat Ø 39,5-59,499 mm / 1.555-2.342"





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés             | DCN           | DCX             | LFS           | DCON          | Súly          | Lapka   |
|------------------------|---------------|-----------------|---------------|---------------|---------------|---|
|                        | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF86-39.5/44.499-03-32 | 39,5<br>1.555 | 44,499<br>1.752 | 33,0<br>1.299 | 32,0<br>1.260 | 0,41<br>0.900 | 3 LNEG1003...   |
| HF86-44.5/49.499-03-32 | 44,5<br>1.752 | 49,499<br>1.949 | 33,0<br>1.299 | 32,0<br>1.260 | 0,51<br>1.120 | 3 LNEG1003...   |
| HF86-49.5/54.499-03-32 | 49,5<br>1.949 | 54,499<br>2.146 | 33,0<br>1.299 | 32,0<br>1.260 | 0,62<br>1.370 | 3 LNEG1003...   |
| HF86-54.5/59.499-03-32 | 54,5<br>2.146 | 59,499<br>2.342 | 33,0<br>1.299 | 32,0<br>1.260 | 0,74<br>1.630 | 3 LNEG1003...   |

## Pótalkatrészek

| Fej        | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|------------|---|---|---|---|---|---|---|
|            |  |  |  |  |  |  |  |
| HF86 03-32 | SH4075S   | CARTCYLN16  | LDH4010   | C02506-T07P   | H2.0-2D   | 2SMS795   | B6027   |

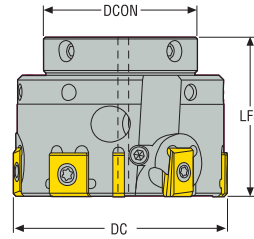
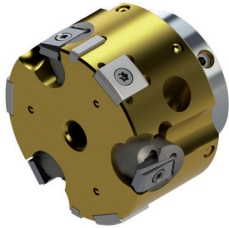
## Kiegészítők

| Fej        | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|------------|---|---|
|            |  |  |
| HF86 03-32 | H00-2020  | T00-07P09   |


Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF86B



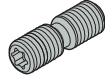





Fejek az LNEG lapkák, zsák furat  $\varnothing$  39,5-59,499 mm / 1.555-2.342"






- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés              | DCN           | DCX             | LFS           | DCN           | Súly          | Lapka   |
|-------------------------|---------------|-----------------|---------------|---------------|---------------|---|
|                         | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF86B-39.5/44.499-03-32 | 39,5<br>1.555 | 44,499<br>1.752 | 33,0<br>1.299 | 32,0<br>1.260 | 0,41<br>0.900 | 3 LNEG1003...   |
| HF86B-44.5/49.499-03-32 | 44,5<br>1.752 | 49,499<br>1.949 | 33,0<br>1.299 | 32,0<br>1.260 | 0,51<br>1.120 | 3 LNEG1003...   |
| HF86B-49.5/54.499-03-32 | 49,5<br>1.949 | 54,499<br>2.146 | 33,0<br>1.299 | 32,0<br>1.260 | 0,62<br>1.370 | 3 LNEG1003...   |
| HF86B-54.5/59.499-03-32 | 54,5<br>2.146 | 59,499<br>2.342 | 33,0<br>1.299 | 32,0<br>1.260 | 0,74<br>1.630 | 3 LNEG1003...   |

### Pótalkatrészek

| Fej   | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|---|---|---|---|---|---|---|---|
|  |  |  |  |  |  |  |  |
| HF86B 03-32   | SH4075S   | CARTCYLN16B   | LDH4010   | C02506-T07P   | H2.0-2D   | 2SMS795   | B6027   |

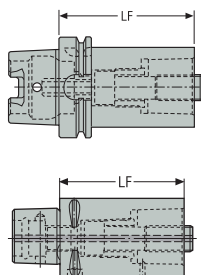
### Kiegészítők

| Fej   | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|---|---|---|
|  |  |  |
| HF86B 03-32   | H00-2020  | T00-07P09   |

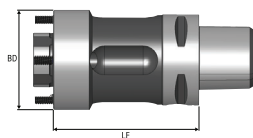
Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF32

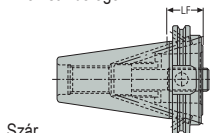
Seco-Capto™ szár a Ø 39,5-59,499 mm



Hosszabbító



Dörzsár befogó



Szár



| Megnevezés      | Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD | Súly |
|-----------------|-----------------|----------|--------|--------|----------|----|------|
|                 |                 |          | 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  |

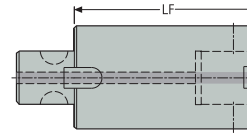
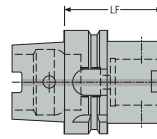
Szárak és hosszabbítók a HF32-050-C3 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés         | Szár | Cikkszám | LF | Kúp       | Seco-Capto méret | Súly |
|--------------------|------|----------|----|-----------|------------------|------|
|                    |      |          | 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  |

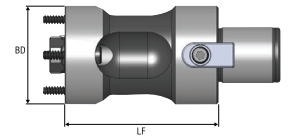
| Megnevezés       | Hosszabbító | Cikkszám | LF | Kúp | Seco-Capto méret | Súly |
|------------------|-------------|----------|----|-----|------------------|------|
|                  |             |          | mm |     |                  | kg   |
| C3-391.01-32060A |             | 75039884 | –  | C3  | 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

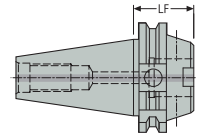
Graflex® szár a Ø 39,5-59,499 mm



Hosszabbító



Dörzsár befogó



Szár

| Megnevezés Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD | Súly |
|----------------------------|----------|--------|--------|----------|----|------|
|                            |          | 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  |

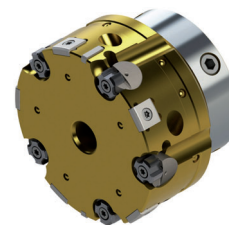
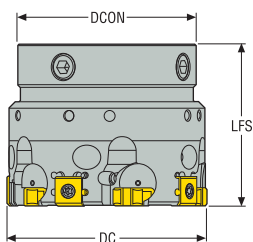
Szárak és hosszabbítók a HF32-050-G3 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés Szár | Cikkszám | LF  | Kúp       | Graflex méret | Súly |
|-----------------|----------|-----|-----------|---------------|------|
|                 |          | 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  |

| Megnevezés Hosszabbító | Cikkszám | LF | Kúp | Graflex méret | Súly |
|------------------------|----------|----|-----|---------------|------|
|                        |          | mm |     |               | kg   |
| M402330                | 00056758 | -  | G3  | G3            | 0,24 |
| M402331                | 75056759 | -  | G3  | G3            | 0,36 |

# HF85

Fejek az RNAX lapkák, átmenő furat Ø 59,5-84,499 mm / 2.343-3.327"



- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés             | DCN           | DCX             | LFS           | DCON          | Súly          | Lapka         |
|------------------------|---------------|-----------------|---------------|---------------|---------------|---------------|
|                        | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |               |
| HF85-59.5/64.499-05-55 | 59,5<br>2.343 | 64,499<br>2.539 | 50,0<br>1.969 | 55,0<br>2.165 | 1,3<br>2.870  | 5 RNAX1005... |
| HF85-64.5/69.499-05-55 | 64,5<br>2.539 | 69,499<br>2.736 | 50,0<br>1.969 | 55,0<br>2.165 | 1,5<br>3.310  | 5 RNAX1005... |
| HF85-69.5/74.499-05-55 | 69,5<br>2.736 | 74,499<br>2.933 | 50,0<br>1.969 | 55,0<br>2.165 | 1,75<br>3.860 | 5 RNAX1005... |
| HF85-74.5/79.499-05-55 | 74,5<br>2.933 | 79,499<br>3.130 | 50,0<br>1.969 | 55,0<br>2.165 | 2,0<br>4.410  | 5 RNAX1005... |
| HF85-79.5/84.499-05-55 | 79,5<br>3.130 | 84,499<br>3.327 | 50,0<br>1.969 | 55,0<br>2.165 | 2,2<br>4.850  | 5 RNAX1005... |

## Pótalkatrészek

| Fej        | Állító csavar | Kazetta    | Rögzítő csavar | Lapka csavar | Kulcs (zásló) | Beállító kulcs | Ék rögzítő |
|------------|---------------|------------|----------------|--------------|---------------|----------------|------------|
| HF85 05-55 | SH4075S       | CARTCYHF20 | LDH4012        | C03010-T09P  | H2.0-2D       | 4SMS795        | B6027      |

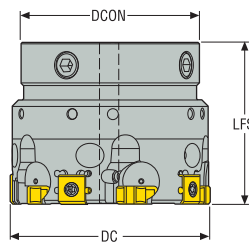
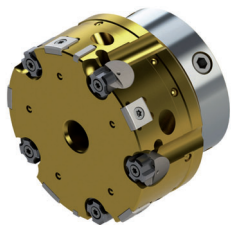
## Kiegészítők

| Fej        | Nyomaték kulcs | Torx kulcs a lapka/befogó csavarhoz |
|------------|----------------|-------------------------------------|
| HF85 05-55 | H00-2020       | T00-09P20                           |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF85B

Fejek az RNAX lapkák, zsák furat  $\varnothing$  59,5-84,499 mm / 2.343-3.327"



- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés              | DCN           | DCX             | LFS           | DCN           | Súly          | Lapka   |
|-------------------------|---------------|-----------------|---------------|---------------|---------------|---|
|                         | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF85B-59.5/64.499-05-55 | 59,5<br>2.343 | 64,499<br>2.539 | 50,0<br>1.969 | 55,0<br>2.165 | 1,3<br>2.870  | 5 RNAX1005...   |
| HF85B-64.5/69.499-05-55 | 64,5<br>2.539 | 69,499<br>2.736 | 50,0<br>1.969 | 55,0<br>2.165 | 1,5<br>3.310  | 5 RNAX1005...   |
| HF85B-69.5/74.499-05-55 | 69,5<br>2.736 | 74,499<br>2.933 | 50,0<br>1.969 | 55,0<br>2.165 | 1,75<br>3.860 | 5 RNAX1005...   |
| HF85B-74.5/79.499-05-55 | 74,5<br>2.933 | 79,499<br>3.130 | 50,0<br>1.969 | 55,0<br>2.165 | 2,0<br>4.410  | 5 RNAX1005...   |
| HF85B-79.5/84.499-05-55 | 79,5<br>3.130 | 84,499<br>3.327 | 50,0<br>1.969 | 55,0<br>2.165 | 2,2<br>4.850  | 5 RNAX1005...   |

### Pótalkatrészek

| Fej         | Állító csavar | Kazetta     | Rögzítő csavar | Lapka csavar | Kulcs (zászló) | Beállító kulcs | Ék rögzítő |
|-------------|---------------|-------------|----------------|--------------|----------------|----------------|------------|
| HF85B 05-55 | SH4075S       | CARTCYHF20B | LDH4012        | C03010-T09P  | H2.0-2D        | 2SMS795        | B6027      |

### Kiegészítők

| Fej         | Nyomaték kulcs | Torx kulcs a lapka/befogó csavarhoz |
|-------------|----------------|-------------------------------------|
| HF85B 05-55 | H00-2020       | T00-09P20                           |

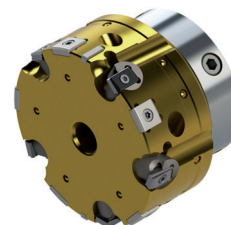
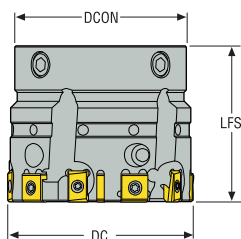
Nyomaték érték T00-09P20: 2 Nm.

Nyomaték érték H00-2020: 2 Nm.



# HF86

Fejek az LNEG lapkák, átmenő furat Ø 59,5-84,499 mm / 2.343-3.327"



• Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés             | DCN           | DCX             | LFS           | DCON          | Súly          | Lapka         |
|------------------------|---------------|-----------------|---------------|---------------|---------------|---------------|
|                        | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |               |
| HF86-59.5-64.499-05-55 | 59,5<br>2.343 | 64,499<br>2.539 | 50,0<br>1.969 | 55,0<br>2.165 | 1,3<br>2.870  | 5 LNEG1003... |
| HF86-64.5-69.499-05-55 | 64,5<br>2.539 | 69,499<br>2.736 | 50,0<br>1.969 | 55,0<br>2.165 | 1,5<br>3.310  | 5 LNEG1003... |
| HF86-69.5-74.499-05-55 | 69,5<br>2.736 | 74,499<br>2.933 | 50,0<br>1.969 | 55,0<br>2.165 | 1,75<br>3.860 | 5 LNEG1003... |
| HF86-74.5-79.499-05-55 | 74,5<br>2.933 | 94,499<br>3.720 | 50,0<br>1.969 | 55,0<br>2.165 | 2,0<br>4.410  | 5 LNEG1003... |
| HF86-79.5-84.499-05-55 | 79,5<br>3.130 | 84,499<br>3.327 | 50,0<br>1.969 | 55,0<br>2.165 | 2,2<br>4.850  | 5 LNEG1003... |

## Pótalkatrészek

| Fej        | Állító csavar | Kazetta    | Rögzítő csavar | Lapka csavar | Kulcs (zásló) | Beállító kulcs | Ék rögzítő |
|------------|---------------|------------|----------------|--------------|---------------|----------------|------------|
|            |               |            |                |              |               |                |            |
| HF86 05-55 | SH4075S       | CARTCYLN20 | LDH4010        | C02506-T07P  | H2.0-2D       | 2SMS795        | B6027      |

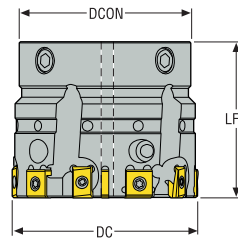
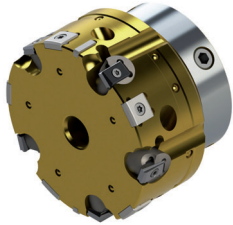
## Kiegészítők

| Fej        | Nyomaték kulcs | Torx kulcs a lapka/befogó csavarhoz |
|------------|----------------|-------------------------------------|
|            |                |                                     |
| HF86 05-55 | H00-2020       | T00-07P09                           |


Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF86B

Fejek az LNEG lapkák, zsák furat  $\varnothing$  59,5-84,499 mm / 2.343-3.327"



- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés              | DCN           | DCX             | LFS           | DCN           | Súly          | Lapka   |
|-------------------------|---------------|-----------------|---------------|---------------|---------------|---|
|                         | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF86B-59.5/64.499-05-55 | 59,5<br>2.343 | 64,499<br>2.539 | 50,0<br>1.969 | 55,0<br>2.165 | 1,3<br>2.870  | 5 LNEG1003...   |
| HF86B-64.5/69.499-05-55 | 64,5<br>2.539 | 69,499<br>2.736 | 50,0<br>1.969 | 55,0<br>2.165 | 1,5<br>3.310  | 5 LNEG1003...   |
| HF86B-69.5/74.499-05-55 | 69,5<br>2.736 | 74,499<br>2.933 | 50,0<br>1.969 | 55,0<br>2.165 | 1,75<br>3.860 | 5 LNEG1003...   |
| HF86B-74.5/79.499-05-55 | 74,5<br>2.933 | 79,499<br>3.130 | 50,0<br>1.969 | 55,0<br>2.165 | 2,0<br>4.410  | 5 LNEG1003...   |
| HF86B-79.5/84.499-05-55 | 79,5<br>3.130 | 84,499<br>3.327 | 50,0<br>1.969 | 55,0<br>2.165 | 2,2<br>4.850  | 5 LNEG1003...   |

### Pótalkatrészek

| Fej         | Állító csavar | Kazetta     | Rögzítő csavar | Lapka csavar | Kulcs (zászló) | Beállító kulcs | Ék rögzítő |
|-------------|---------------|-------------|----------------|--------------|----------------|----------------|------------|
| HF86B 05-55 | SH4075S       | CARTCYLN20B | LDH4010        | C02506-T07P  | H2.0-2D        | 2SMS795        | B6027      |

### Kiegészítők

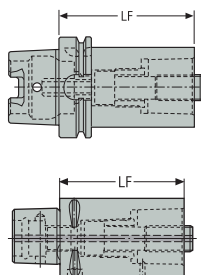
| Fej         | Nyomaték kulcs | Torx kulcs a lapka/befogó csavarhoz |
|-------------|----------------|-------------------------------------|
| HF86B 05-55 | H00-2020       | T00-07P09                           |

Nyomaték érték T00-07P09: 2 Nm.

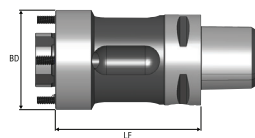
Nyomaték érték H00-2020: 2 Nm.

## HF55

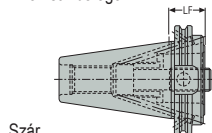
Seco-Capto™ szár a Ø 59,5-84,499 mm



Hosszabbító



Dörzsár befogó



Szár



| Megnevezés Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD | Súly |
|----------------------------|----------|--------|--------|----------|----|------|
|                            |          | 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  |

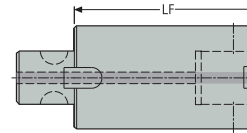
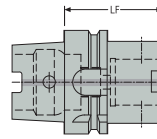
Szárak és hosszabbítók a HF55-080-C5 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés Szár    | Cikkszám | LF  | Kúp       | Seco-Capto méret | Súly |
|--------------------|----------|-----|-----------|------------------|------|
|                    |          | 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  |

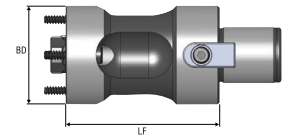
| Megnevezés Hosszabbító | Cikkszám | LF | Kúp | Seco-Capto méret | Súly |
|------------------------|----------|----|-----|------------------|------|
|                        |          | mm |     |                  | kg   |
| C5-391.01-50080A       | 75039886 | –  | C5  | C5               | 1,12 |
| 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

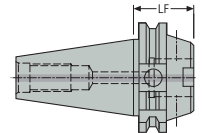
Graflex® szár a Ø 59,5-84,499 mm



Hosszabbító



Dörzsár befogó



Szár

| Megnevezés Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD | Súly |
|----------------------------|----------|--------|--------|----------|----|------|
|                            |          | 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  |

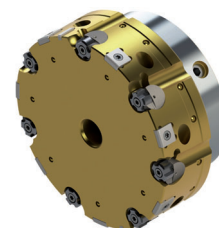
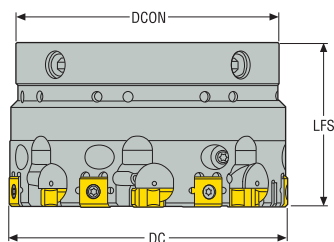
Szárak és hosszabbítók a HF55-080-G5 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés Szár | Cikkszám | LF  | Kúp       | Graflex méret | Súly |
|-----------------|----------|-----|-----------|---------------|------|
|                 |          | 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  |


| Megnevezés Hosszabbító | Cikkszám | LF | Kúp | Graflex méret | Súly |
|------------------------|----------|----|-----|---------------|------|
|                        |          | mm |     |               | kg   |
| M402550                | 00056762 | -  | G5  | G5            | 0,72 |
| M402551                | 00056763 | -  | G5  | G5            | 1,12 |
| M402552                | 00056764 | -  | G5  | G5            | 1,48 |

# HF85



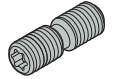




Fejek az RNAX lapkák, átmenő furat Ø 84,5-119,499 mm / 3.327-4.705"





• Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés               | DCN            | DCX              | LFS           | DCON          | Súly          | Lapka   |
|--------------------------|----------------|------------------|---------------|---------------|---------------|---|
|                          | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF85-84.5/89.499-07-80   | 84,5<br>3.327  | 89,499<br>3.524  | 50,0<br>1.969 | 80,0<br>3.150 | 1,68<br>3.700 | 7 RNAX1005...   |
| HF85-89.5/94.499-07-80   | 89,5<br>3.524  | 94,499<br>3.720  | 50,0<br>1.969 | 80,0<br>3.150 | 1,85<br>4.080 | 7 RNAX1005...   |
| HF85-94.5/99.499-07-80   | 94,5<br>3.720  | 99,499<br>3.917  | 50,0<br>1.969 | 80,0<br>3.150 | 2,02<br>4.450 | 7 RNAX1005...   |
| HF85-99.5/104.499-07-80  | 99,5<br>3.917  | 104,499<br>4.114 | 50,0<br>1.969 | 80,0<br>3.150 | 2,2<br>4.850  | 7 RNAX1005...   |
| HF85-104.5/109.499-07-80 | 104,5<br>4.114 | 109,499<br>4.311 | 50,0<br>1.969 | 80,0<br>3.150 | 2,4<br>5.290  | 7 RNAX1005...   |
| HF85-109.5/114.499-07-80 | 109,5<br>4.311 | 114,499<br>4.508 | 50,0<br>1.969 | 80,0<br>3.150 | 2,61<br>5.750 | 7 RNAX1005...   |
| HF85-114.5/119.499-07-80 | 114,5<br>4.508 | 119,499<br>4.705 | 50,0<br>1.969 | 80,0<br>3.150 | 2,82<br>6.220 | 7 RNAX1005...   |

## Pótalkatrészek

| Fej        | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zásló)   | Beállító kulcs  | Ék rögzítő  |
|------------|---|---|---|---|---|---|---|
|            |  |  |  |  |  |  |  |
| HF85 07-80 | SH4075S   | CARTCYHF20  | LDH4012   | C03010-T09P   | H2.0-2D   | 4SMS795   | B6027   |

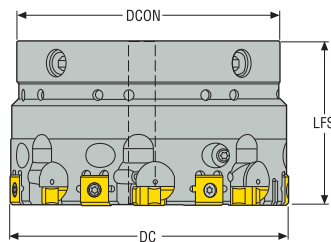
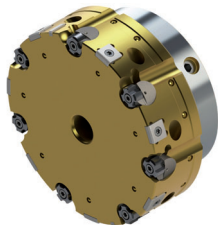
## Kiegészítők

| Fej        | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|------------|---|---|
|            |  |  |
| HF85 07-80 | H00-2020  | T00-09P20   |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF85B



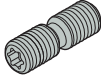




Fejek az RNAX lapkák, zsák furat  $\varnothing$  84,5-119,499 mm / 3.327-4.705"





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés                | DCN            | DCX              | LFS           | DCN           | Súly          | Lapka   |
|---------------------------|----------------|------------------|---------------|---------------|---------------|---|
|                           | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF85B-84.5/89.499-07-80   | 84,5<br>3.327  | 89,499<br>3.524  | 50,0<br>1.969 | 80,0<br>3.150 | 1,68<br>3.700 | 7 RNAX1005...   |
| HF85B-89.5/94.499-07-80   | 89,5<br>3.524  | 94,499<br>3.720  | 50,0<br>1.969 | 80,0<br>3.150 | 1,85<br>4.080 | 7 RNAX1005...   |
| HF85B-94.5/99.499-07-80   | 94,5<br>3.720  | 99,499<br>3.917  | 50,0<br>1.969 | 80,0<br>3.150 | 2,02<br>4.450 | 7 RNAX1005...   |
| HF85B-99.5/104.499-07-80  | 99,5<br>3.917  | 104,499<br>4.114 | 50,0<br>1.969 | 80,0<br>3.150 | 2,2<br>4.850  | 7 RNAX1005...   |
| HF85B-104.5/109.499-07-80 | 104,5<br>4.114 | 109,499<br>4.311 | 50,0<br>1.969 | 80,0<br>3.150 | 2,4<br>5.290  | 7 RNAX1005...   |
| HF85B-109.5/114.499-07-80 | 109,5<br>4.311 | 114,499<br>4.508 | 50,0<br>1.969 | 80,0<br>3.150 | 2,61<br>5.750 | 7 RNAX1005...   |
| HF85B-114.5/119.499-07-80 | 114,5<br>4.508 | 119,499<br>4.705 | 50,0<br>1.969 | 80,0<br>3.150 | 2,82<br>6.220 | 7 RNAX1005...   |

### Pótalkatrészek

| Fej         | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|-------------|---|---|---|---|---|---|---|
|             |  |  |  |  |  |  |  |
| HF85B 07-80 | SH4075S   | CARTCYHF20B   | LDH4010   | C03010-T09P   | H2.0-2D   | 2SMS795   | B6027   |

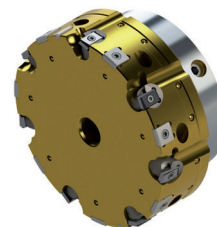
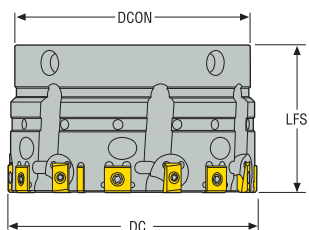
### Kiegészítők

| Fej         | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|-------------|---|---|
|             |  |  |
| HF85B 07-80 | H00-2020  | T00-09P20   |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

# HF86



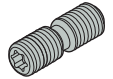




Fejek az LNEG lapkák, átmenő furat Ø 84,5-119,499 mm / 3.327-4.705"





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés               | DCN            | DCX              | LFS           | DCON          | Súly          | Lapka   |
|--------------------------|----------------|------------------|---------------|---------------|---------------|---|
|                          | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |  |
| HF86-84.5/89.499-07-80   | 84,5<br>3.327  | 89,499<br>3.524  | 50,0<br>1.969 | 80,0<br>3.150 | 1,68<br>3.700 | 7 LNEG1003...   |
| HF86-89.5/94.499-07-80   | 89,5<br>3.524  | 94,499<br>3.720  | 50,0<br>1.969 | 80,0<br>3.150 | 1,85<br>4.080 | 7 LNEG1003...   |
| HF86-94.5/99.499-07-80   | 94,5<br>3.720  | 99,499<br>3.917  | 50,0<br>1.969 | 80,0<br>3.150 | 2,02<br>4.450 | 7 LNEG1003...   |
| HF86-99.5/104.499-07-80  | 99,5<br>3.917  | 104,499<br>4.114 | 50,0<br>1.969 | 80,0<br>3.150 | 2,2<br>4.850  | 7 LNEG1003...   |
| HF86-104.5/109.499-07-80 | 104,5<br>4.114 | 109,499<br>4.311 | 50,0<br>1.969 | 80,0<br>3.150 | 2,4<br>5.290  | 7 LNEG1003...   |
| HF86-109.5/114.499-07-80 | 109,5<br>4.311 | 114,499<br>4.508 | 50,0<br>1.969 | 80,0<br>3.150 | 2,61<br>5.750 | 7 LNEG1003...   |
| HF86-114.5/119.499-07-80 | 114,5<br>4.508 | 119,499<br>4.705 | 50,0<br>1.969 | 80,0<br>3.150 | 2,82<br>6.220 | 7 LNEG1003...   |

## Pótalkatrészek

| Fej        | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zásló)   | Beállító kulcs  | Ék rögzítő  |
|------------|---|---|---|---|---|---|---|
|            |  |  |  |  |  |  |  |
| HF86 07-80 | SH4075S   | CARTCYLN20  | LDH4010   | C02506-T07P   | H2.0-2D   | 2SMS795   | B6027   |

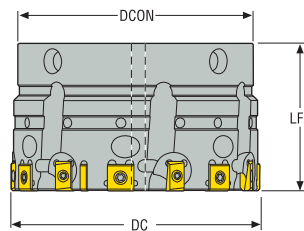
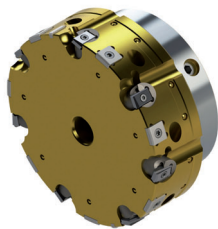
## Kiegészítők

| Fej        | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|------------|---|---|
|            |  |  |
| HF86 07-80 | H00-2020  | T00-07P09   |

Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF86B

Fejek az LNEG lapkák, zsák furat  $\varnothing$  84,5-119,499 mm / 3.327-4.705"



- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés                | DCN            | DCX              | LFS           | DCN           | Súly          | Lapka         |
|---------------------------|----------------|------------------|---------------|---------------|---------------|---------------|
|                           | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |               |
| HF86B-84.5/89.499-07-80   | 84,5<br>3.327  | 89,499<br>3.524  | 50,0<br>1.969 | 80,0<br>3.150 | 1,68<br>3.700 | 7 LNEG1003... |
| HF86B-89.5/94.499-07-80   | 89,5<br>3.524  | 94,499<br>3.720  | 50,0<br>1.969 | 80,0<br>3.150 | 1,85<br>4.080 | 7 LNEG1003... |
| HF86B-94.5/99.499-07-80   | 94,5<br>3.720  | 99,499<br>3.917  | 50,0<br>1.969 | 80,0<br>3.150 | 2,02<br>4.450 | 7 LNEG1003... |
| HF86B-99.5/104.499-07-80  | 99,5<br>3.917  | 104,499<br>4.114 | 50,0<br>1.969 | 80,0<br>3.150 | 2,2<br>4.850  | 7 LNEG1003... |
| HF86B-104.5/109.499-07-80 | 104,5<br>4.114 | 109,499<br>4.311 | 50,0<br>1.969 | 80,0<br>3.150 | 2,4<br>5.290  | 7 LNEG1003... |
| HF86B-109.5/114.499-07-80 | 109,5<br>4.311 | 114,499<br>4.508 | 50,0<br>1.969 | 80,0<br>3.150 | 2,61<br>5.750 | 7 LNEG1003... |
| HF86B-114.5/119.499-07-80 | 114,5<br>4.508 | 119,499<br>4.705 | 50,0<br>1.969 | 80,0<br>3.150 | 2,82<br>6.220 | 7 LNEG1003... |

### Pótalkatrészek

| Fej   | Állító csavar | Kazetta     | Rögzítő csavar | Lapka csavar | Kulcs (zászló) | Beállító kulcs | Ék rögzítő |
|-------|---------------|-------------|----------------|--------------|----------------|----------------|------------|
| HF86B | SH4075S       | CARTCYLN20B | LDH4010        | C02506-T07P  | H2.0-2D        | 2SMS795        | B6027      |

### Kiegészítők

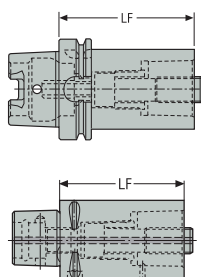
| Fej   | Nyomaték kulcs | Torx kulcs a lapka/befogó csavarhoz |
|-------|----------------|-------------------------------------|
| HF86B | H00-2020       | T00-07P09                           |

Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

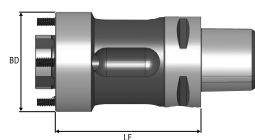


## HF80

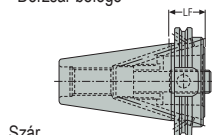
Seco-Capto™ szár a Ø 84,5-119,499 mm



Hosszabbító



Dörzsár befogó



Szár



| Megnevezés      | Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD | Súly |
|-----------------|-----------------|----------|--------|--------|----------|----|------|
|                 |                 |          | 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  |

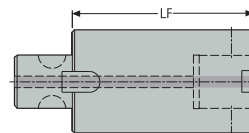
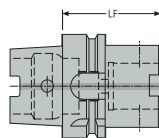
Szárak és hosszabbítók a HF80-080-C6 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés         | Szár | Cikkszám | LF  | Kúp       | Seco-Capto méret | Súly |
|--------------------|------|----------|-----|-----------|------------------|------|
|                    |      |          | 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  |

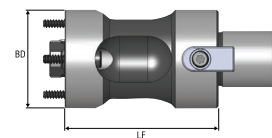
| Megnevezés       | Hosszabbító | Cikkszám | LF | Kúp | Seco-Capto méret | Súly |
|------------------|-------------|----------|----|-----|------------------|------|
|                  |             |          | mm |     |                  | kg   |
| C6-391.01-63100A |             | 75039887 | -  | C6  | C6               | 2,2  |
| C6-391.01-63140A |             | 00004840 | -  | C6  | C6               | 3,1  |
| C6-391.01-63060  |             | 02300834 | -  | C6  | C6               | 1,31 |

## HF80

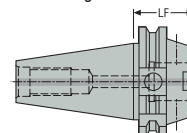
Graflex® szár a Ø 84,5-119,499 mm



Hosszabbító



Dörzsár befogó



Szár

| Megnevezés Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD | Súly |
|----------------------------|----------|--------|--------|----------|----|------|
|                            |          | 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  |

Szárak és hosszabbítók a HF80-080-G6 (részletek a Seco Felszerszámozás katalógusban).

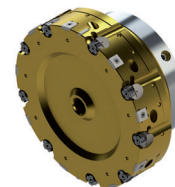
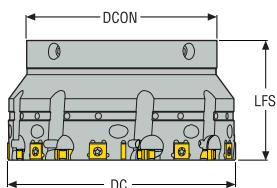
| Megnevezés Szár | Cikkszám | LF  | Kúp       | Graflex méret | Súly |
|-----------------|----------|-----|-----------|---------------|------|
|                 |          | mm  |           |               | kg   |
| EM93044013670   | 00086923 | 70  | HSK-A63   | G6            | 1,21 |
| EM930440136120  | 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 |

Szárak és hosszabbítók a HF32-050-G3 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés Hosszabbító | Cikkszám | LF | Kúp | Graflex méret | Súly |
|------------------------|----------|----|-----|---------------|------|
|                        |          | mm |     |               | kg   |
| M402660                | 00056765 | -  | G6  | G6            | 1,38 |
| M402661                | 00056766 | -  | G6  | G6            | 2,1  |
| M402662                | 00056767 | -  | G6  | G6            | 2,82 |

# HF85

Fejek az RNAX lapkák, átmenő furat  $\varnothing$  119,5-154,499 mm / 4.705-6.083"



- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés                | DCN            | DCX              | LFS           | DCON           | Súly           | Lapka         |
|---------------------------|----------------|------------------|---------------|----------------|----------------|---------------|
|                           | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch     | kg<br>lbs      |               |
| HF85-119.5/124.499-09-100 | 119,5<br>4.705 | 124,499<br>4.902 | 63,0<br>2.480 | 100,0<br>3.937 | 3,89<br>8.580  | 9 RNAX1005... |
| HF85-124.5/129.499-09-100 | 124,5<br>4.902 | 129,499<br>5.098 | 63,0<br>2.480 | 100,0<br>3.937 | 4,15<br>9.150  | 9 RNAX1005... |
| HF85-129.5/134.499-09-100 | 129,5<br>5.098 | 134,499<br>5.295 | 63,0<br>2.480 | 100,0<br>3.937 | 4,42<br>9.740  | 9 RNAX1005... |
| HF85-134.5/139.499-09-100 | 134,5<br>5.295 | 139,499<br>5.492 | 63,0<br>2.480 | 100,0<br>3.937 | 4,7<br>10.360  | 9 RNAX1005... |
| HF85-139.5/144.499-09-100 | 139,5<br>5.492 | 144,499<br>5.689 | 63,0<br>2.480 | 100,0<br>3.937 | 4,99<br>11.000 | 9 RNAX1005... |
| HF85-144.5/149.499-09-100 | 144,5<br>5.689 | 149,499<br>5.886 | 63,0<br>2.480 | 100,0<br>3.937 | 5,29<br>11.660 | 9 RNAX1005... |
| HF85-149.5/154.499-09-100 | 149,5<br>5.886 | 154,499<br>6.083 | 63,0<br>2.480 | 100,0<br>3.937 | 5,6<br>12.350  | 9 RNAX1005... |

## Pótalkatrészek

| Fej         | Állító csavar | Kazetta    | Rögzítő csavar | Lapka csavar | Kulcs (zászló) | Beállító kulcs | Ék rögzítő |
|-------------|---------------|------------|----------------|--------------|----------------|----------------|------------|
|             |               |            |                |              |                |                |            |
| HF85 09-100 | SH4075S       | CARTCYHF20 | LDH4012        | C03010-T09P  | H2.0-2D        | 4SMS795        | B6027      |

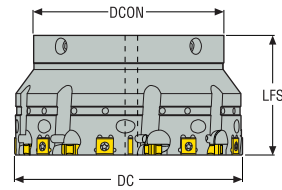
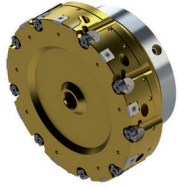
## Kiegészítők

| Fej         | Nyomaték kulcs | Torx kulcs a lapka/befogó csavarhoz |
|-------------|----------------|-------------------------------------|
|             |                |                                     |
| HF85 09-100 | H00-2020       | T00-09P20                           |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF85B



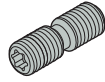





Fejek az RNAX lapkák, zsák furat  $\varnothing$  119,5-154,499 mm / 4.705-6.083"






- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés                 | DCN            | DCX              | LFS           | DCN            | Súly           | Lapka   |
|----------------------------|----------------|------------------|---------------|----------------|----------------|---|
|                            | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch     | kg<br>lbs      |  |
| HF85B-119.5/124.499-09-100 | 119,5<br>4.705 | 124,499<br>4.902 | 63,0<br>2.480 | 100,0<br>3.937 | 3,89<br>8.580  | 9 RNAX1005...   |
| HF85B-124.5/129.499-09-100 | 124,5<br>4.902 | 129,499<br>5.098 | 63,0<br>2.480 | 100,0<br>3.937 | 4,15<br>9.150  | 9 RNAX1005...   |
| HF85B-134.5/139.499-09-100 | 134,5<br>5.295 | 139,499<br>5.492 | 63,0<br>2.480 | 100,0<br>3.937 | 4,7<br>10.360  | 9 RNAX1005...   |
| HF85B-139.5/144.499-09-100 | 139,5<br>5.492 | 144,499<br>5.689 | 63,0<br>2.480 | 100,0<br>3.937 | 4,99<br>11.000 | 9 RNAX1005...   |
| HF85B-144.5/149.499-09-100 | 144,5<br>5.689 | 149,499<br>5.886 | 63,0<br>2.480 | 100,0<br>3.937 | 5,29<br>11.660 | 9 RNAX1005...   |
| HF85B-149.5/154.499-09-100 | 149,5<br>5.886 | 154,499<br>6.083 | 63,0<br>2.480 | 100,0<br>3.937 | 5,6<br>12.350  | 9 RNAX1005...   |

### Pótalkatrészek

| Fej   | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|---|---|---|---|---|---|---|---|
|  |  |  |  |  |  |  |  |
| HF85B 09-100  | SH4075S   | CARTCYHF20B   | LDH4012   | C03010-T09P   | H2.0-2D   | 2SMS795   | B6027   |

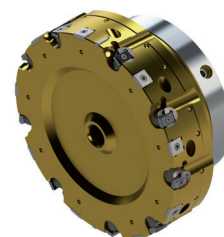
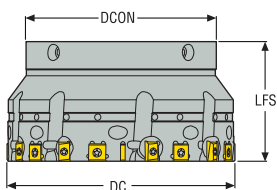
### Kiegészítők

| Fej   | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|---|---|---|
|  |  |  |
| HF85B 09-100  | H00-2020  | T00-09P20   |


Nyomaték érték T00-09P20: 2 Nm.  
Nyomaték érték H00-2020: 2 Nm.

# HF86



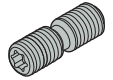




Fejek az LNEG lapkák, átmenő furat  $\varnothing 119,5-154,499 \text{ mm} / 4.705-6.083''$





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés                | DCN            | DCX              | LFS           | DCON           | Súly           | Lapka   |
|---------------------------|----------------|------------------|---------------|----------------|----------------|---|
|                           | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch     | kg<br>lbs      |  |
| HF86-119.5/124.499-09-100 | 119,5<br>4.705 | 124,499<br>4.902 | 63,0<br>2.480 | 100,0<br>3.937 | 3,89<br>8.580  | 9 LNEG1003...   |
| HF86-124.5/129.499-09-100 | 124,5<br>4.902 | 129,499<br>5.098 | 63,0<br>2.480 | 100,0<br>3.937 | 4,15<br>9.150  | 9 LNEG1003...   |
| HF86-129.5/134.499-09-100 | 129,5<br>5.098 | 134,499<br>5.295 | 63,0<br>2.480 | 100,0<br>3.937 | 4,42<br>9.740  | 9 LNEG1003...   |
| HF86-134.5/139.499-09-100 | 134,5<br>5.295 | 139,499<br>5.492 | 63,0<br>2.480 | 100,0<br>3.937 | 4,7<br>10.360  | 9 LNEG1003...   |
| HF86-139.5/144.499-09-100 | 139,5<br>5.492 | 144,499<br>5.689 | 63,0<br>2.480 | 100,0<br>3.937 | 4,99<br>11.000 | 9 LNEG1003...   |
| HF86-144.5/149.499-09-100 | 144,5<br>5.689 | 149,499<br>5.886 | 63,0<br>2.480 | 100,0<br>3.937 | 5,29<br>11.660 | 9 LNEG1003...   |
| HF86-149.5/154.499-09-100 | 149,5<br>5.886 | 154,499<br>6.083 | 63,0<br>2.480 | 100,0<br>3.937 | 5,6<br>12.350  | 9 LNEG1003...   |

## Pótalkatrészek

| Fej         | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|-------------|---|---|---|---|---|---|---|
|             |  |  |  |  |  |  |  |
| HF86 09-100 | SH4075S   | CARTCYHF20  | LDH4010   | C02506-T07P   | H2.0-2D   | 2SMS795   | B6027   |

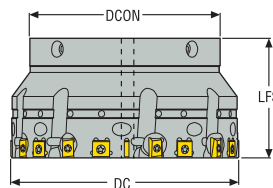
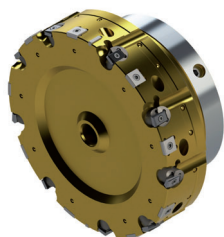
## Kiegészítők

| Fej         | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|-------------|---|---|
|             |  |  |
| HF86 09-100 | H00-2020  | T00-07P09   |


Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF86B



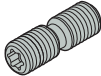




Fejek az LNEG lapkák, zsák furat  $\varnothing$  119,5-154,499 mm / 4.705-6.083"





- Lapkákat, minőségeket és geometriákat lásd a 429-430 old.

| Megnevezés                 | DCN            | DCX              | LFS           | DCN            | Súly           | Lapka   |
|----------------------------|----------------|------------------|---------------|----------------|----------------|---|
|                            | mm<br>Inch     | mm<br>Inch       | mm<br>Inch    | mm<br>Inch     | kg<br>lbs      |  |
| HF86B-119.5/124.499-09-100 | 119,5<br>4.705 | 124,499<br>4.902 | 63,0<br>2.480 | 100,0<br>3.937 | 3,89<br>8.580  | 9 LNEG1003...   |
| HF86B-124.5/129.499-09-100 | 124,5<br>4.902 | 129,499<br>5.098 | 63,0<br>2.480 | 100,0<br>3.937 | 4,15<br>9.150  | 9 LNEG1003...   |
| HF86B-129.5/134.499-09-100 | 129,5<br>5.098 | 134,499<br>5.295 | 63,0<br>2.480 | 100,0<br>3.937 | 4,42<br>9.740  | 9 LNEG1003...   |
| HF86B-134.5/139.499-09-100 | 134,5<br>5.295 | 139,499<br>5.492 | 63,0<br>2.480 | 100,0<br>3.937 | 4,7<br>10.360  | 9 LNEG1003...   |
| HF86B-139.5/144.499-09-100 | 139,5<br>5.492 | 144,499<br>5.689 | 63,0<br>2.480 | 100,0<br>3.937 | 4,99<br>11.000 | 9 LNEG1003...   |
| HF86B-144.5/149.499-09-100 | 144,5<br>5.689 | 149,499<br>5.886 | 63,0<br>2.480 | 100,0<br>3.937 | 5,29<br>11.660 | 9 LNEG1003...   |
| HF86B-149.5/154.499-09-100 | 149,5<br>5.886 | 154,499<br>6.083 | 63,0<br>2.480 | 100,0<br>3.937 | 5,6<br>12.350  | 9 LNEG1003...   |

### Pótalkatrészek

| Fej          | Állító csavar   | Kazetta   | Rögzítő csavar  | Lapka csavar  | Kulcs (zászló)  | Beállító kulcs  | Ék rögzítő  |
|--------------|---|---|---|---|---|---|---|
|              |  |  |  |  |  |  |  |
| HF86B 09-100 | SH4075S   | CARTCYLN20B   | LDH4010   | C02506-T07P   | H2.0-2D   | 2SMS795   | B6027   |

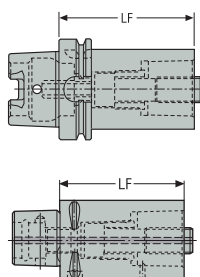
### Kiegészítők

| Fej          | Nyomaték kulcs  | Torx kulcs a lapka/befogó csavarhoz   |
|--------------|---|---|
|              |  |  |
| HF86B 09-100 | H00-2020  | T00-07P09   |

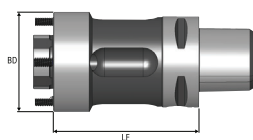
Nyomaték érték T00-07P09: 0,9 Nm.  
Nyomaték érték H00-2020: 2 Nm.

## HF100

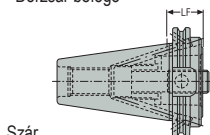
Seco-Capto™ szár a Ø 119,5-154,499 mm



Hosszabbító



Dörzsár befogó



Szár



| Megnevezés Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD  | Súly |
|----------------------------|----------|--------|--------|----------|-----|------|
|                            |          | 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  |

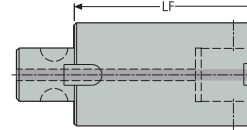
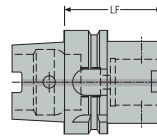
Szárak és hosszabbítók a HF100-100-C8 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés Szár    | Cikkszám | LF  | Kúp       | Seco-Capto méret | Súly |
|--------------------|----------|-----|-----------|------------------|------|
|                    |          | 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  |

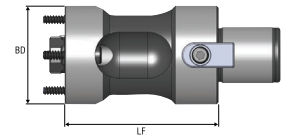
| Megnevezés Hosszabbító | Cikkszám | LF | Kúp | Seco-Capto méret | Súly |
|------------------------|----------|----|-----|------------------|------|
|                        |          | mm |     |                  | kg   |
| C8-391.01-80100A       | 75039888 | –  | C8  | C8               | 3,62 |
| C8-391.01-80125A       | 00004841 | –  | C8  | C8               | 4,54 |

## HF100

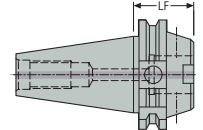
Graflex® szár a Ø 119,5-154,499 mm



Hosszabbító



Dörzsár befogó



Szár

| Megnevezés Dörzsár befogók | Cikkszám | LF min | LF max | Kúp      | BD  | Súly |
|----------------------------|----------|--------|--------|----------|-----|------|
|                            |          | 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  |

Szárak és hosszabbítók a HF100-100-G7 (részletek a Seco Felszerszámozás katalógusban).

| Megnevezés Szár | Cikkszám | LF  | Kúp       | Graflex méret | Súly |
|-----------------|----------|-----|-----------|---------------|------|
|                 |          | 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 |

| Megnevezés Hosszabbító | Cikkszám | LF | Kúp | Graflex méret | Súly |
|------------------------|----------|----|-----|---------------|------|
|                        |          | mm |     |               | kg   |
| M402770                | 00056768 | -  | G7  | G7            | 2,9  |
| M402771                | 00056769 | -  | G7  | G7            | 4,03 |
| M402772                | 00056770 | -  | G7  | G7            | 5,8  |



**Forgácsolási adatok – LNEG...-EB45 metrikus**

| SMG |               | $a_p$ (∅) | f         |           |           |           | $v_c$        |               |               |
|-----|---------------|-----------|-----------|-----------|-----------|-----------|--------------|---------------|---------------|
|     |               |           | z=3       | z=5       | z=7       | z=9       | RX2000       | CF            | RX1500        |
| P1  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 120 (80-200) | 180 (120-250) | 220 (120-300) |
| P2  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 120 (80-200) | 180 (120-250) | 220 (120-300) |
| P3  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 120 (80-200) | 180 (120-250) | 220 (120-300) |
| P4  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 60 (40-120)  | 80 (60-150)   | 100 (80-200)  |
| P5  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 60 (40-120)  | 80 (60-150)   | 100 (80-200)  |
| P6  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 60 (40-120)  | 80 (60-150)   | 100 (80-200)  |
| P7  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 60 (40-120)  | 80 (60-150)   | 100 (80-200)  |
| P8  | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 40 (30-70)   | 60 (50-100)   | 80 (60-120)   |
| P11 | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 40 (30-70)   | 60 (50-100)   | 80 (60-120)   |
| P12 | LNEG1003-EB45 | 0,15-0,25 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 30 (25-55)   | 45 (40-80)    | 65 (45-95)    |
| M1  | LNEG1003-EB45 | 0,10-0,20 | 0,15-0,30 | 0,25-0,50 | 0,35-0,70 | 0,45-0,90 | 35 (25-60)   | -             | -             |
| M2  | LNEG1003-EB45 | 0,10-0,20 | 0,15-0,30 | 0,25-0,50 | 0,35-0,70 | 0,45-0,90 | 35 (25-60)   | -             | -             |
| M3  | LNEG1003-EB45 | 0,10-0,20 | 0,15-0,30 | 0,25-0,50 | 0,35-0,70 | 0,45-0,90 | 35 (25-60)   | -             | -             |
| M4  | LNEG1003-EB45 | 0,10-0,20 | 0,15-0,30 | 0,25-0,50 | 0,35-0,70 | 0,45-0,90 | 25 (20-50)   | -             | -             |
| M5  | LNEG1003-EB45 | 0,10-0,20 | 0,15-0,30 | 0,25-0,50 | 0,35-0,70 | 0,45-0,90 | 25 (20-50)   | -             | -             |
| K1  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | -             | 220 (150-300) |
| K2  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 50 (35-80)   | -             | 70 (50-120)   |
| K3  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | -             | 220 (150-300) |
| K4  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 70 (50-120)  | 100 (60-120)  | 150 (110-200) |
| K5  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 70 (50-120)  | 100 (60-120)  | 150 (110-200) |
| K6  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | -             | 220 (150-300) |
| K7  | LNEG1003-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | -             | 220 (150-300) |
| H3  | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H5  | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H7  | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H8  | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H11 | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H12 | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H21 | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |
| H31 | LNEG1003-EB45 | 0,10-0,20 | 0,1-0,25  | 0,15-0,40 | 0,25-0,5  | 0,30-0,7  | 20 (10-30)   | -             | -             |

SMG = Seco anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Forgácsolási adatok – LNEG...-EB45 inch

| SMG |               | $a_p$ (∅)   | f           |             |             |             | $v_c$         |               |               |
|-----|---------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------|---------------|
|     |               |             | z=3         | z=5         | z=7         | z=9         | RX2000        | CF            | RX1500        |
| P1  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 395 (260-655) | 590 (395-820) | 720 (395-985) |
| P2  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 395 (260-655) | 590 (395-820) | 720 (395-985) |
| P3  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 395 (260-655) | 590 (395-820) | 720 (395-985) |
| P4  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 195 (130-395) | 260 (195-490) | 330 (260-655) |
| P5  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 195 (130-395) | 260 (195-490) | 330 (260-655) |
| P6  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 195 (130-395) | 260 (195-490) | 330 (260-655) |
| P7  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 195 (130-395) | 260 (195-490) | 330 (260-655) |
| P8  | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 130 (100-230) | 195 (165-330) | 260 (195-395) |
| P11 | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 130 (100-230) | 195 (165-330) | 260 (195-395) |
| P12 | LNEG1003-EB45 | 0.006-0.010 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.010-0.053 | 100 (85-185)  | 150 (135-265) | 215 (150-315) |
| M1  | LNEG1003-EB45 | 0.004-0.008 | 0.006-0.012 | 0.010-0.020 | 0.014-0.028 | 0.018-0.035 | 115 (80-195)  | -             | -             |
| M2  | LNEG1003-EB45 | 0.004-0.008 | 0.006-0.012 | 0.010-0.020 | 0.014-0.028 | 0.018-0.035 | 115 (80-195)  | -             | -             |
| M3  | LNEG1003-EB45 | 0.004-0.008 | 0.006-0.012 | 0.010-0.020 | 0.014-0.028 | 0.018-0.035 | 115 (80-195)  | -             | -             |
| M4  | LNEG1003-EB45 | 0.004-0.008 | 0.006-0.012 | 0.010-0.020 | 0.014-0.028 | 0.018-0.035 | 80 (65-165)   | -             | -             |
| M5  | LNEG1003-EB45 | 0.004-0.008 | 0.006-0.012 | 0.010-0.020 | 0.014-0.028 | 0.018-0.035 | 80 (65-165)   | -             | -             |
| K1  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 330 (195-655) | -             | 720 (490-985) |
| K2  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 165 (115-260) | -             | 230 (165-395) |
| K3  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 330 (195-655) | -             | 720 (490-985) |
| K4  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 230 (165-395) | 330 (195-395) | 490 (360-655) |
| K5  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 230 (165-395) | 330 (195-395) | 490 (360-655) |
| K6  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 330 (195-655) | -             | 720 (490-985) |
| K7  | LNEG1003-EB45 | 0.008-0.020 | 0.006-0.018 | 0.010-0.030 | 0.010-0.041 | 0.018-0.053 | 330 (195-655) | -             | 720 (490-985) |
| H3  | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H5  | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H7  | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H8  | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H11 | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H12 | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H21 | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |
| H31 | LNEG1003-EB45 | 0.004-0.008 | 0.004-0.010 | 0.006-0.016 | 0.010-0.020 | 0.012-0.028 | 65 (35-100)   | -             | -             |

SMG = Seco anyagcsoport  
 $a_p$  = inch  
 f = in/ford  
 $v_c$  = sf/perc  
 Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## Forgácsolási adatok – LNEG...-EB845 metrikus

| SMG |                | $a_p (\varnothing)$ | f         |           |           |           | $v_c$<br>RX2000 |
|-----|----------------|---------------------|-----------|-----------|-----------|-----------|-----------------|
|     |                |                     | z=3       | z=5       | z=7       | z=9       |                 |
| 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 anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

Forgácsolási adatok – LNEG...-EB845 inch

| SMG |                | $a_p$ (Ø)   | f           |             |             |             | $v_c$<br>RX2000 |
|-----|----------------|-------------|-------------|-------------|-------------|-------------|-----------------|
|     |                |             | z=3         | z=5         | z=7         | z=9         |                 |
| 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 anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

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## Forgácsolási adatok – LNEG...-EB1570 metrikus

| SMG |                 | $a_p$ (∅) | f         |           |           |           | $v_c$<br>RX2000 |
|-----|-----------------|-----------|-----------|-----------|-----------|-----------|-----------------|
|     |                 |           | z=3       | z=5       | z=7       | z=9       |                 |
| 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 anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

## Forgácsolási adatok – LNEG...-EB1570 inch

| SMG |                 | $a_p$ (∅)   | f           |             |             |             | $v_c$<br>RX2000 |
|-----|-----------------|-------------|-------------|-------------|-------------|-------------|-----------------|
|     |                 |             | z=3         | z=5         | z=7         | z=9         |                 |
| 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 anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

### Forgácsolási adatok – RNAX...-EB45 metrikus

| SMG |               | $a_p$ (∅) | f         |           |           |           | $v_c$        |               |
|-----|---------------|-----------|-----------|-----------|-----------|-----------|--------------|---------------|
|     |               |           | z=3       | z=5       | z=6       | z=9       | RX2000       | RX1500        |
| K1  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |
| K2  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 50 (35-80)   | 70 (50-120)   |
| K3  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |
| K4  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 70 (50-120)  | 150 (110-200) |
| K5  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 70 (50-120)  | 150 (110-200) |
| K6  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |
| K7  | RNAX1005-EB45 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |

SMG = Seco anyagcsoport

$a_p$  = mm

f = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

### Forgácsolási adatok – RNAX...-EB45 inch

| SMG |               | $a_p$ (∅)   | f           |             |             |             | $v_c$         |               |
|-----|---------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------|
|     |               |             | z=3         | z=5         | z=6         | z=9         | RX2000        | RX1500        |
| K1  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |
| K2  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 165 (115-260) | 230 (165-395) |
| K3  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |
| K4  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 230 (165-395) | 490 (360-655) |
| K5  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 230 (165-395) | 490 (360-655) |
| K6  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |
| K7  | RNAX1005-EB45 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |

SMG = Seco anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

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## Forgácsolási adatok – RNAX...-EB845 metrikus

| SMG |                | $a_p$ (∅) | f         |        |          |           | $v_c$        |               |
|-----|----------------|-----------|-----------|--------|----------|-----------|--------------|---------------|
|     |                |           | z=3       | z=5    | z=6      | z=9       | RX2000       | RX1500        |
| K1  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 100 (60-200) | 220 (150-300) |
| K2  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 50 (35-80)   | 70 (50-120)   |
| K3  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 100 (60-200) | 220 (150-300) |
| K4  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 70 (50-120)  | 150 (110-200) |
| K5  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 70 (50-120)  | 150 (110-200) |
| K6  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 100 (60-200) | 220 (150-300) |
| K7  | RNAX1005-EB845 | 0,20-0,50 | 0,15-0,60 | 0,25-1 | 0,35-1,4 | 0,45-1,80 | 100 (60-200) | 220 (150-300) |

SMG = Seco anyagcsoport

 $a_p$  = mm

f = mm/ford

 $v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

## Forgácsolási adatok – RNAX...-EB845 inch

| SMG |                | $a_p$ (∅)   | f           |             |             |             | $v_c$         |               |
|-----|----------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------|
|     |                |             | z=3         | z=5         | z=6         | z=9         | RX2000        | RX1500        |
| K1  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 330 (195-655) | 720 (490-985) |
| K2  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 165 (115-260) | 230 (165-395) |
| K3  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 330 (195-655) | 720 (490-985) |
| K4  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 230 (165-395) | 490 (360-655) |
| K5  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 230 (165-395) | 490 (360-655) |
| K6  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 330 (195-655) | 720 (490-985) |
| K7  | RNAX1005-EB845 | 0.008–0.020 | 0.006–0.024 | 0.010–0.039 | 0.014–0.055 | 0.018–0.071 | 330 (195-655) | 720 (490-985) |

SMG = Seco anyagcsoport

 $a_p$  = inch

f = in/ford

 $v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

### Forgácsolási adatok – RNAX...-EB1570 metrikus

| SMG |                 | $a_p$ (∅) | f         |           |           |           | $v_c$        |               |
|-----|-----------------|-----------|-----------|-----------|-----------|-----------|--------------|---------------|
|     |                 |           | z=3       | z=5       | z=6       | z=9       | RX2000       | RX1500        |
| K1  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |
| K2  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 50 (35-80)   | 70 (50-120)   |
| K3  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |
| K4  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 70 (50-120)  | 150 (110-200) |
| K5  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 70 (50-120)  | 150 (110-200) |
| K6  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |
| K7  | RNAX1005-EB1570 | 0,20-0,50 | 0,15-0,45 | 0,25-0,75 | 0,25-1,05 | 0,45-1,35 | 100 (60-200) | 220 (150-300) |

SMG = Seco anyagcsoport

$a_p$  = mm

f = mm/ford

$v_c$  = m/perc

Minden forgácsolási paraméter kezdeti érték

### Forgácsolási adatok – RNAX...-EB1570 inch

| SMG |                 | $a_p$ (∅)   | f           |             |             |             | $v_c$         |               |
|-----|-----------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------|
|     |                 |             | z=3         | z=5         | z=6         | z=9         | RX2000        | RX1500        |
| K1  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |
| K2  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 165 (115-260) | 230 (165-395) |
| K3  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |
| K4  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 230 (165-395) | 490 (360-655) |
| K5  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 230 (165-395) | 490 (360-655) |
| K6  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |
| K7  | RNAX1005-EB1570 | 0.008–0.020 | 0.006–0.018 | 0.010–0.030 | 0.010–0.041 | 0.018–0.053 | 330 (195-655) | 720 (490-985) |

SMG = Seco anyagcsoport

$a_p$  = inch

f = in/ford

$v_c$  = sf/perc

Minden forgácsolási paraméter kezdeti érték

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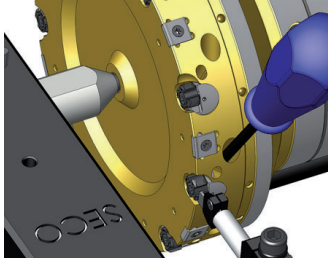

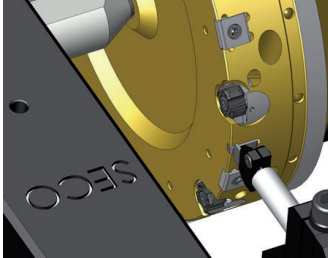
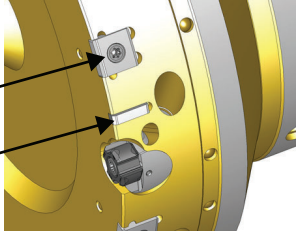
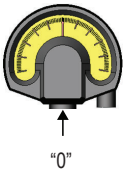
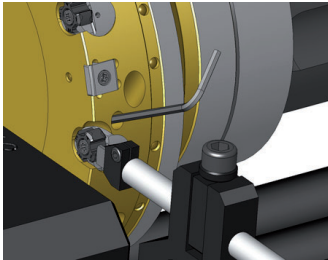

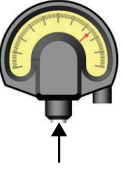


Dörzsárazás

Késztergálás

Melléklet



## Beállítási utasítások

|  |  |              |
|--|--|--------------|
| <p><b>1.</b></p> <ul style="list-style-type: none"> <li>• Lazítsa meg a kazetta leszorító csavart.</li> <li>• Fordítsa át vagy cserélje ki a lapkát.</li> <li>• Hajtsa ki az állítócsavart 1/4 fordulattal, és tolja vissza a kazettát.</li> <li>• Húzza meg finoman ismét a kazetta leszorító csavart kb. 0,5 Nm (4.4 in/lbs). nyomatékkal</li> </ul> |   <p>Kazetta leszorító csavar<br/>Állító csavar</p>  | Bevezetés    |
| <p><b>2.</b></p> <ul style="list-style-type: none"> <li>• Állítsa az órát nullára a referenciatámaszon.</li> <li>• Győződjön meg, hogy a mérőcsúcs a forgácsolási szög mögött van.</li> </ul>  |   <p>Cserélhető vezetőtámasz<br/>Referencia támasz a beállításhoz</p>  <p>"0"</p> | Fűrés        |
| <p><b>3.</b></p> <ul style="list-style-type: none"> <li>• Állítsa a lapkát 0,025 mm-rel (0.001") a referenciatámasz fölé az állítócsavarral.</li> <li>• Ismétlje meg a beállítási eljárást az összes lapkánál.</li> </ul>  |   <p>Állító csavar</p>  <p>+ 0,025 mm (+ 0.001") a referenciatámasz fölött</p> | Dörzsárazás  |
| <p><b>4.</b></p> <ul style="list-style-type: none"> <li>• Végezetül rögzítse a kazetta leszorító csavart 2 Nm (17.7 in/lbs) nyomatékkal.</li> </ul>  |  <p>Kazetta leszorító csavar</p>  | Késztergálás |
| <p>Megjegyzés: Amennyiben az átmérő nagyobb lett állítva a szükségesnél, kezdje előlről a folyamatot a beállítócsavar hibájának elkerüléséért.</p>   |   | Melléklet    |

Megjegyzés: Amennyiben az átmérő nagyobb lett állítva a szükségesnél, kezdje előlről a folyamatot a beállítócsavar hibájának elkerüléséért.

## Beállítási utasítások, adapter

Bevezetés

Fűrés

Dörzsárazás

Késztergálás

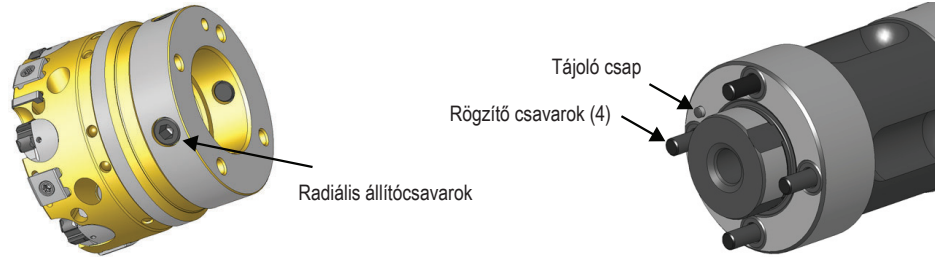
Melléklet

1.

### Összeszerelés

- Tisztítsa meg gondosan az érintkezési felületeket.
- Lazítsa meg a 4 radiális állító csavart, hogy ne akadályozza az összeszerelést.
- Tegye a dörzsárat az adapterre (tájoló csap) és húzza meg a 4 rögzítő csavart.

### Összeszerelés (1. ábra)

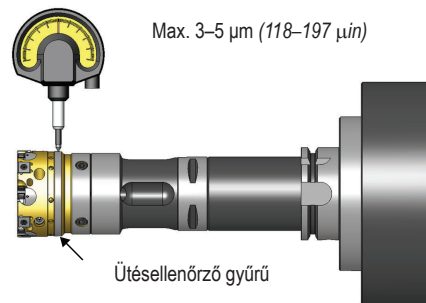


2.

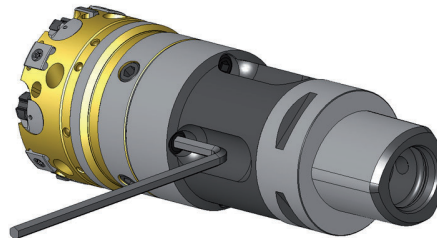
### Beállítás

- Helyezze a szerszámot a főorsóba.
- Helyezze el a mérőórát a 2. ábra szerint.
- Engedje ki a főorsót, hogy kézzel lehessen forgatni.
- Kezdje az ütés beállítását a 4 állítócsavarral (3. ábra).
- Max. ütés 5  $\mu\text{m}$  (197  $\mu\text{in}$ ).
- Ha az ütés értéke kisebb mint 10  $\mu\text{m}$  (394  $\mu\text{in}$ ), rögzítse véglegesen (1. ábra) a táblázatban ajánlott nyomaték értékeket használva.

### Beállítási művelet a főorsón (2. ábra)



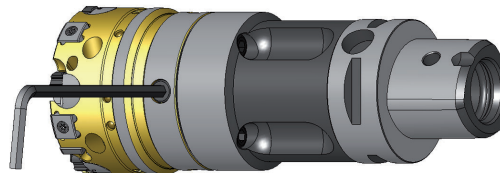
### Rögzítő csavarok (3. ábra)



3.

- Fejezze be az ütésbeállítást, max. 5  $\mu\text{m}$  (max. 197  $\mu\text{in}$ ).

### Radiális állítócsavarok (4. ábra)



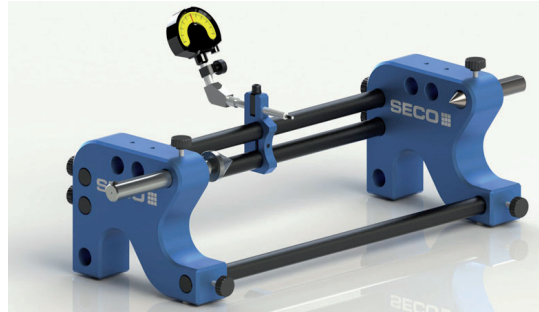
### Befogási nyomaték táblázat

| Átmérő mm     | Átmérő inch | Adapter méret | Leszorító csavar | Rögzítő nyomaték, Nm | Rögzítő nyomaték, 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                      |

## Beállító készülék – Egy mérőórás

### SF-210340-C160: Rendelési és cikkszám: 02885391

- Vízszintes állvány
- Elsődleges választás az Xfix dörzsárazakhoz
- 1 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 340 mm (13.386")
- További Ø 57 mm (2.244") rugós központozító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központozító tartozék



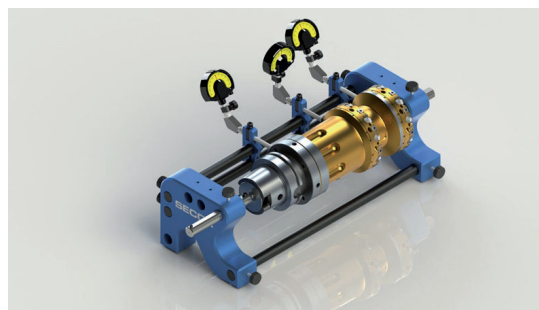
### SF-210290V-C160: Rendelési és cikkszám: 02885392

- Függőleges állvány
- Elsődleges választás az Xfix dörzsárazakhoz
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 290 mm (11.417")
- További Ø 57 mm (2.244") rugós központozító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központozító tartozék



## Beállító készülék – Több mérőórás

A több mérőórás beállítás lehetőségeivel kapcsolatos részletekért olvassa el beállító készülék fejezetet a 485-490. oldalon



## Szerszámozási áttekintés



| Átmérő<br>mm  | Átmérő<br>inch | Max átm./<br>hossz arány |
|---------------|----------------|--------------------------|
| 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                  |

Megjegyzés: > 100 mm (3.937") átmérőnél vagy  $L > 3 \times D$  viszonynál ellenőrizze a gép megengedett max. szerszámtömeg-értéket.

Bevezetés

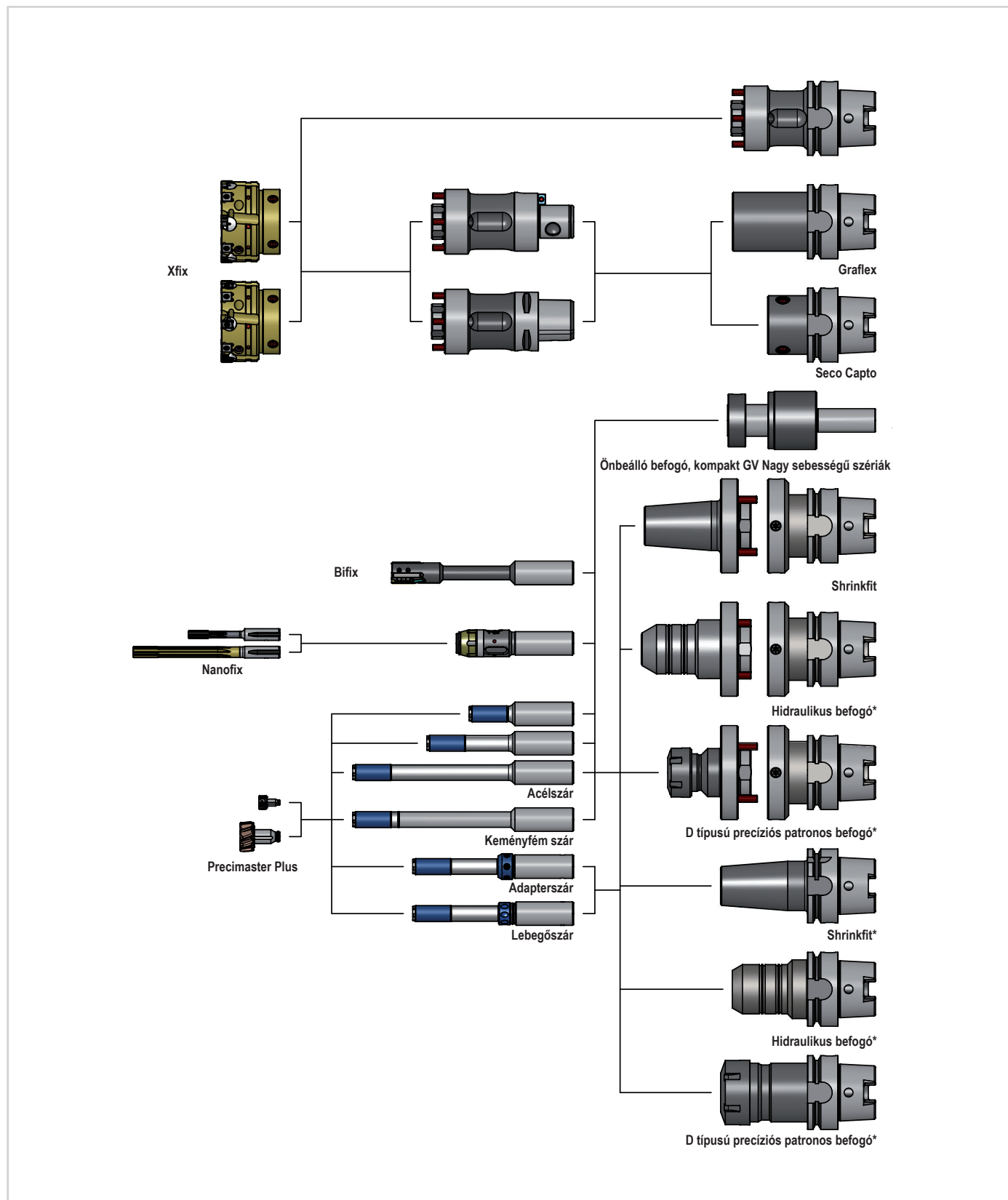
Fúrás

Dörzsárzás

Késztergálás

Melléklet

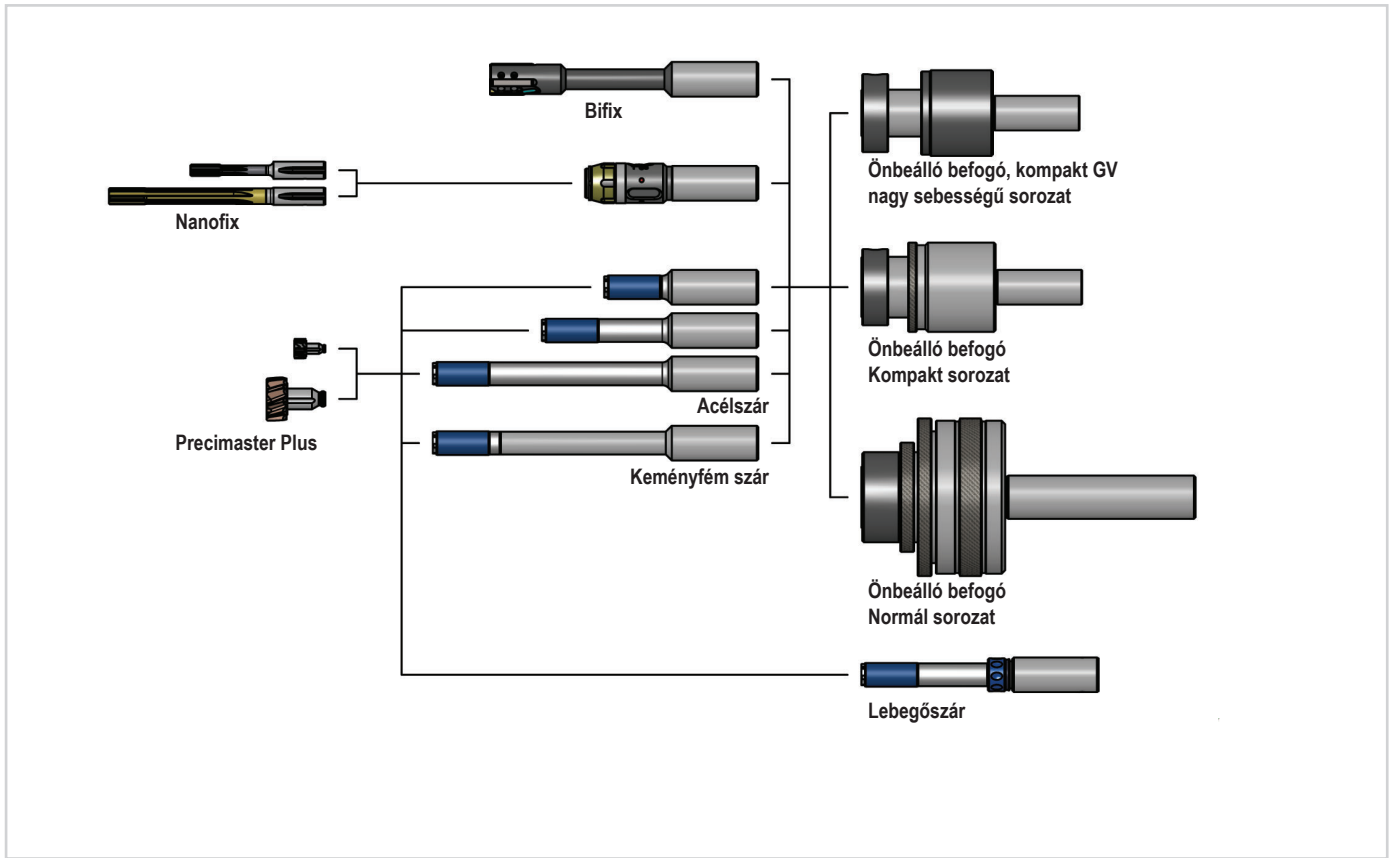
Forgószerszám-alkalmazások



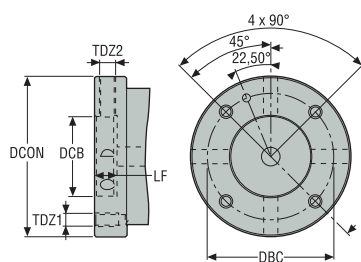
\* Lásd a FELSZERSZÁMOZÁS katalógust

A legjobb eredmény merev szereléssel érhető el (D típusú hidraulikus befogó vagy Shrinkfit)

## Álló alkalmazások

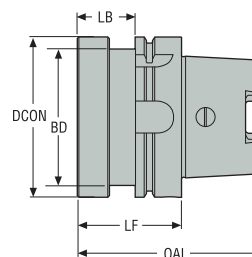


## Karima méret



| 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 |

## Végződés HSK-A

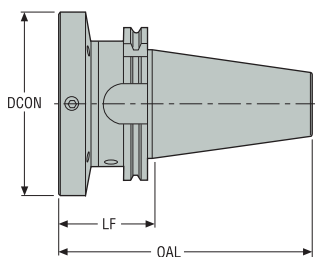


- Megjegyzés: A hűtőfolyadék cső és csavar szállításkor mellékelve.

| Megnevezés      | Cikkszám | Kúp       | DCON           | BD            | LB            | LF            | OAL            | Súly          |
|-----------------|----------|-----------|----------------|---------------|---------------|---------------|----------------|---------------|
|                 |          |           | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | kg<br>lbs     |
| SAH-23405100001 | 02836663 | HSK-A 100 | 60,0<br>2.362  | 60,0<br>2.362 | 26,0<br>1.024 | 55,0<br>2.165 | 105,0<br>4.134 | 2,5<br>5.510  |
| SAH-23405100002 | 02836665 | HSK-A 100 | 80,0<br>3.150  | 80,0<br>3.150 | 26,0<br>1.024 | 55,0<br>2.165 | 105,0<br>4.134 | 2,9<br>6.390  |
| SAH-23405100003 | 02836666 | HSK-A 100 | 100,0<br>3.937 | 85,0<br>3.346 | 36,0<br>1.417 | 65,0<br>2.559 | 115,0<br>4.528 | 3,5<br>7.720  |
| SAH-23405100007 | 02836664 | HSK-A 100 | 70,0<br>2.756  | 70,0<br>2.756 | 26,0<br>1.024 | 55,0<br>2.165 | 105,0<br>4.134 | 2,8<br>6.170  |
| SAH-23405400001 | 02836564 | HSK-A 40  | 60,0<br>2.362  | 34,0<br>1.339 | 35,0<br>1.378 | 55,0<br>2.165 | 75,0<br>2.953  | 0,8<br>1.760  |
| SAH-23405500001 | 02836566 | HSK-A 50  | 60,0<br>2.362  | 42,0<br>1.654 | 34,0<br>1.339 | 60,0<br>2.362 | 85,0<br>3.346  | 0,95<br>2.090 |
| SAH-23405500002 | 02836573 | HSK-A 50  | 80,0<br>3.150  | 42,0<br>1.654 | 34,0<br>1.339 | 60,0<br>2.362 | 85,0<br>3.346  | 1,2<br>2.650  |
| SAH-23405500003 | 02836567 | HSK-A 50  | 70,0<br>2.756  | 42,0<br>1.654 | 34,0<br>1.339 | 60,0<br>2.362 | 85,0<br>3.346  | 1,0<br>2.200  |
| SAH-23405630001 | 02836574 | HSK-A 63  | 60,0<br>2.362  | 53,0<br>2.087 | 34,0<br>1.339 | 60,0<br>2.362 | 92,0<br>3.622  | 1,2<br>2.650  |
| SAH-23405630002 | 02836576 | HSK-A 63  | 80,0<br>3.150  | 53,0<br>2.087 | 34,0<br>1.339 | 60,0<br>2.362 | 92,0<br>3.622  | 1,4<br>3.090  |
| SAH-23405630003 | 02836575 | HSK-A 63  | 70,0<br>2.756  | 53,0<br>2.087 | 34,0<br>1.339 | 60,0<br>2.362 | 92,0<br>3.622  | 1,3<br>2.870  |
| SAH-23405630004 | 02836577 | HSK-A 63  | 100,0<br>3.937 | 53,0<br>2.087 | 39,0<br>1.535 | 65,0<br>2.559 | 97,0<br>3.819  | 1,95<br>4.300 |
| SAH-23405800001 | 02836655 | HSK-A 80  | 60,0<br>2.362  | 60,0<br>2.362 | 24,0<br>0.945 | 50,0<br>1.969 | 90,0<br>3.543  | 1,4<br>3.090  |
| SAH-23405800002 | 02836658 | HSK-A 80  | 80,0<br>3.150  | 67,0<br>2.638 | 34,0<br>1.339 | 60,0<br>2.362 | 100,0<br>3.937 | 1,6<br>3.530  |
| SAH-23405800003 | 02836657 | HSK-A 80  | 70,0<br>2.756  | 67,0<br>2.638 | 34,0<br>1.339 | 60,0<br>2.362 | 100,0<br>3.937 | 1,5<br>3.310  |
| SAH-23405800004 | 02836660 | HSK-A 80  | 100,0<br>3.937 | 67,0<br>2.638 | 39,0<br>1.535 | 65,0<br>2.559 | 105,0<br>4.134 | 2,2<br>4.850  |



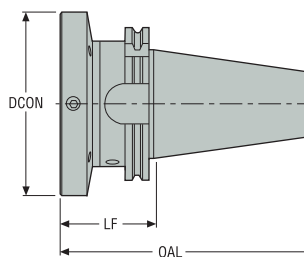
## Végződés DIN 69871



- Megjegyzés: Csavarokat tartalmazza a szállítás

| Megnevezés     | Cikkszám | Kúp       | DCON  |       | LF   |       | OAL   |       | Súly |       |
|----------------|----------|-----------|-------|-------|------|-------|-------|-------|------|-------|
|                |          |           | mm    | Inch  | mm   | Inch  | mm    | Inch  | 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 |

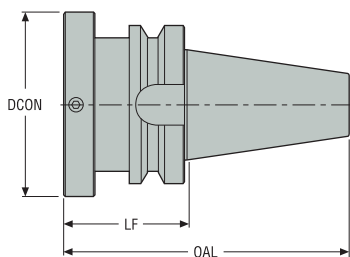
## Végződés CAT



- Megjegyzés: Csavarokat tartalmazza a szállítás
- Behúzó gomba imperial menet

| Megnevezés     | Cikkszám | Kúp    | DCON  |       | LF   |       | OAL   |       | Súly |        |
|----------------|----------|--------|-------|-------|------|-------|-------|-------|------|--------|
|                |          |        | mm    | Inch  | mm   | Inch  | mm    | Inch  | 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  |

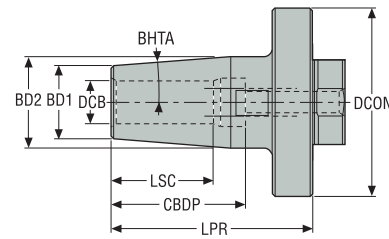
## Végződés BT



- Megjegyzés: Csavarokat tartalmazza a szállítás

| Megnevezés     | Cikkszám | Kúp      | DCON           | LF            | OAL            | Súly          |
|----------------|----------|----------|----------------|---------------|----------------|---------------|
|                |          |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | kg<br>lbs     |
| SAH-2340740001 | 02836717 | BT40 ADB | 60,0<br>2.362  | 55,0<br>2.165 | 120,4<br>4.740 | 1,4<br>3.090  |
| SAH-2340740002 | 02836719 | BT40 ADB | 80,0<br>3.150  | 65,0<br>2.559 | 130,4<br>5.134 | 2,0<br>4.410  |
| SAH-2340740003 | 02836721 | BT40 ADB | 100,0<br>3.937 | 60,0<br>2.362 | 125,4<br>4.937 | 2,7<br>5.950  |
| SAH-2340740004 | 02836718 | BT40 ADB | 70,0<br>2.756  | 55,0<br>2.165 | 120,4<br>4.740 | 1,5<br>3.310  |
| SAH-2340750001 | 02836724 | BT50 ADB | 60,0<br>2.362  | 70,0<br>2.756 | 171,8<br>6.764 | 4,2<br>9.260  |
| SAH-2340750002 | 02836725 | BT50 ADB | 70,0<br>2.756  | 70,0<br>2.756 | 171,8<br>6.764 | 4,4<br>9.700  |
| SAH-2340750003 | 02836726 | BT50 ADB | 80,0<br>3.150  | 70,0<br>2.756 | 171,8<br>6.764 | 4,6<br>10.140 |
| SAH-2340750004 | 02836727 | BT50 ADB | 100,0<br>3.937 | 70,0<br>2.756 | 171,8<br>6.764 | 4,9<br>10.800 |

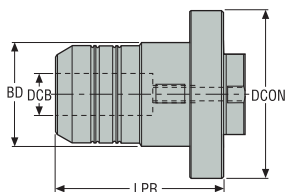
## Megfogás Shrinkfit



- Megjegyzés: Állító csavarokat tartalmazza a szállítás

| Megnevezés     | Cikkszám | DCON           | BD2           | BD1           | DCB           | LSC           | CBDP          | LPR           | Súly          | BHTA° |
|----------------|----------|----------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|-------|
|                |          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |       |
| SAH-2341006235 | 02836735 | 60,0<br>2.362  | 27,0<br>1.063 | 21,0<br>0.827 | 6,0<br>0.236  | 22,0<br>0.866 | 37,5<br>1.476 | 70,0<br>2.756 | 0,5<br>1.100  | 4,5   |
| SAH-2341010237 | 02836736 | 60,0<br>2.362  | 32,0<br>1.260 | 24,0<br>0.945 | 10,0<br>0.394 | 31,0<br>1.220 | 42,5<br>1.673 | 70,0<br>2.756 | 0,5<br>1.100  | 4,5   |
| SAH-2341012238 | 02836737 | 60,0<br>2.362  | 32,0<br>1.260 | 24,0<br>0.945 | 12,0<br>0.472 | 34,0<br>1.339 | 47,5<br>1.870 | 70,0<br>2.756 | 0,52<br>1.150 | 4,5   |
| SAH-2341016241 | 02836741 | 70,0<br>2.756  | 34,0<br>1.339 | 27,0<br>1.063 | 16,0<br>0.630 | 39,0<br>1.535 | 50,5<br>1.988 | 75,0<br>2.953 | 0,7<br>1.540  | 4,5   |
| SAH-2341020251 | 02836742 | 80,0<br>3.150  | 42,0<br>1.654 | 33,0<br>1.299 | 20,0<br>0.787 | 41,0<br>1.614 | 52,5<br>2.067 | 80,0<br>3.150 | 1,0<br>2.200  | 4,5   |
| SAH-2341025260 | 02836743 | 100,0<br>3.937 | 53,0<br>2.087 | 44,0<br>1.732 | 25,0<br>0.984 | 47,0<br>1.850 | 58,5<br>2.303 | 80,0<br>3.150 | 2,2<br>4.850  | 4,5   |
| SAH-2341032261 | 02836744 | 100,0<br>3.937 | 53,0<br>2.087 | 44,0<br>1.732 | 32,0<br>1.260 | 51,0<br>2.008 | 62,5<br>2.461 | 80,0<br>3.150 | 2,5<br>5.510  | 4,5   |

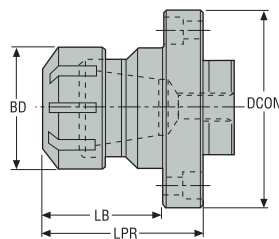
## Megfogás hidraulikus befogó



- Megjegyzés: Állító csavarokat tartalmazza a szállítás

| Megnevezés     | Cikkszám | DCON  |       | BD   |       | DCB  |       | LPR   |       | Súly          |
|----------------|----------|-------|-------|------|-------|------|-------|-------|-------|---------------|
|                |          | mm    | Inch  | mm   | Inch  | mm   | Inch  | mm    | Inch  |               |
| SAH-2341112255 | 02836752 | 80,0  | 3.150 | 32,0 | 1.260 | 12,0 | 0.472 | 77,5  | 3.051 | 1,1<br>2.430  |
| SAH-2341112259 | 02836757 | 100,0 | 3.937 | 32,0 | 1.260 | 12,0 | 0.472 | 90,0  | 3.543 | 1,9<br>4.190  |
| SAH-2341116253 | 02836749 | 70,0  | 2.756 | 38,0 | 1.496 | 16,0 | 0.630 | 50,0  | 1.969 | 0,75<br>1.650 |
| SAH-2341116256 | 02836754 | 80,0  | 3.150 | 38,0 | 1.496 | 16,0 | 0.630 | 82,5  | 3.248 | 1,2<br>2.650  |
| SAH-2341120257 | 02836755 | 80,0  | 3.150 | 42,0 | 1.654 | 20,0 | 0.787 | 82,5  | 3.248 | 1,3<br>2.870  |
| SAH-2341125258 | 02836756 | 80,0  | 3.150 | 50,0 | 1.969 | 25,0 | 0.984 | 90,0  | 3.543 | 1,7<br>3.750  |
| SAH-2341125260 | 02836758 | 100,0 | 3.937 | 50,0 | 1.969 | 25,0 | 0.984 | 100,0 | 3.937 | 2,8<br>6.170  |
| SAH-2341132261 | 02836759 | 100,0 | 3.937 | 60,0 | 2.362 | 32,0 | 1.260 | 103,0 | 4.055 | 2,9<br>6.390  |

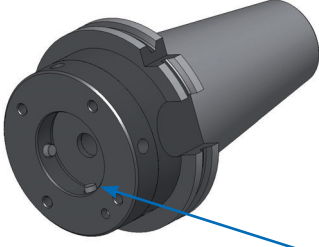
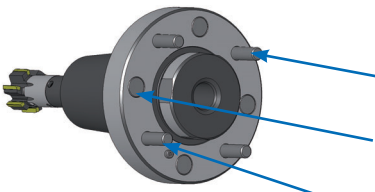
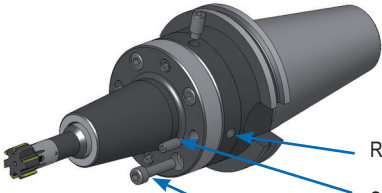
## Megfogás ER patronos befogó



- Megjegyzés: Állító csavarokat tartalmazza a szállítás

| Megnevezés       | Cikkszám | Méret | DCON              | BD                | LB                | LPR               | Súly             |
|------------------|----------|-------|-------------------|-------------------|-------------------|-------------------|------------------|
|                  |          |       | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | mm<br><i>Inch</i> | kg<br><i>lbs</i> |
| SAH-23412ER25254 | 02836762 | ER25  | 80,0<br>3.150     | 42,0<br>1.654     | 45,0<br>1.772     | 60,0<br>2.362     | 1,0<br>2.200     |
| SAH-23412ER32255 | 02836763 | ER32  | 80,0<br>3.150     | 50,0<br>1.969     | 45,0<br>1.772     | 60,0<br>2.362     | 1,2<br>2.650     |
| SAH-23412ER40256 | 02836764 | ER40  | 100,0<br>3.937    | 63,0<br>2.480     | 50,0<br>1.969     | 70,0<br>2.756     | 1,6<br>3.530     |

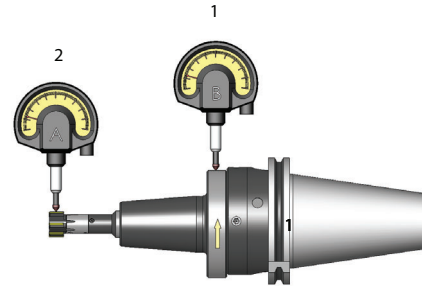
## Összeszerelési utasítások

|  |   |             |
|--|---|-------------|
|  <p>Radiális állító csavarok</p>  | <ul style="list-style-type: none"> <li>• Tisztítsa meg az érintkezési felületet</li> <li>• Győződjön meg róla, hogy a radiális állító csavarok nem érnek hozzá a szerelvényhez</li> </ul> | Bevezetés   |
|  <p>Rögzítő csavarok<br/>Szög állító csavarok<br/>Biztosító csap (választható)</p>                   | <ul style="list-style-type: none"> <li>• Győződjön meg róla, hogy a szög állító csavarok nem érnek hozzá a szerelvényhez</li> </ul>   | Fűrés       |
|  <p>Radiális állító csavarok (4 db)<br/>Szög állító csavarok (4 db)<br/>Rögzítő csavarok (4 db)</p> | <ul style="list-style-type: none"> <li>• Folytassa az összeszerelést és finoman feszítse elő a rögzítő csavarokat (4 db)</li> </ul>   | Dörzsárazás |
| Késztergálás   |   |             |
| Melléklet  |   |             |

## Beállítási utasítások

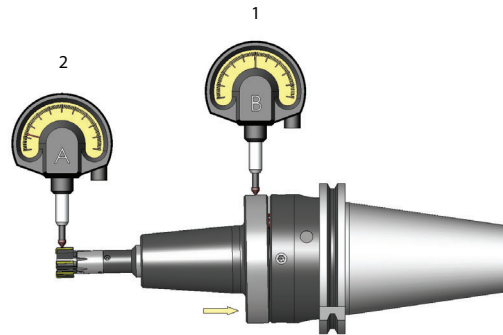
Bevezetés

- Helyezze a szerszámot a főorsóba
- Állítsa be az 1. mérőórát az ábra szerint (itt a 2. mérőórára még nincs szükség)
- Forgassa addig a szerszámot kézzel amíg a legalacsonyabb pontot megtalálja
- Hajtsa végre a radiális ütés kompenzációt, ahogy a nyíl mutatja
- Ellenőrizze és ismétlje meg a kompenzációt ha szükséges



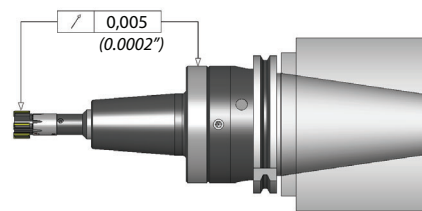
Fúrás

- Állítsa be a 2. mérőórát az ábra szerint
- Forgassa addig a szerszámot kézzel amíg a legalacsonyabb pontot megtalálja
- Hajtsa végre a radiális ütés kompenzációt, ahogy a nyíl mutatja
- Ellenőrizze, és ismétlje meg a kompenzációt ha szükséges



Dörzsárazás

- Ha végzett a beigazítással, az ütés  $<5 \mu\text{m}$  ( $197 \mu\text{in}$ ), véglegesítse a befogást az összeállítás rögzítéséhez
- Az állítható adapter előre beállítható a géptől távol, valamilyen beállító eszközt használva a műhelyben
- A végső beállítás mindig a gép főorsójában legyen elvégezve
- Mikronos órát kell használni.. A két művelethez egy óra használata is elfogadható



Késztergálás

Melléklet



## Választék áttekintése

### A Seco önbeálló befogó használata javasolt

- Ha az ütés meghaladja a 0,02 mm-t (0.0008")
- Álló szerszám esetén

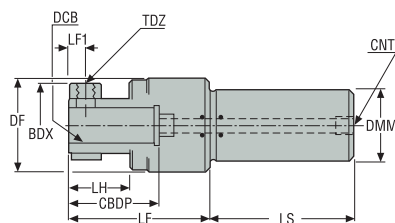
|   |  |
|---|--|
| <p><b>Kompakt GV nagysebességű szériák</b></p> <ul style="list-style-type: none"> <li>• Elsődleges választás forgó szerszámokhoz.</li> <li>• Nincs állításra szükség (gyárilag előre beállítva).</li> <li>• 3000-es fordulatilag alkalmazástól függően.</li> <li>• Álló alkalmazásokban is használható</li> </ul> |    |
| <p><b>Kompakt szériák</b></p> <ul style="list-style-type: none"> <li>• Elsődleges választás álló szerszámokhoz.</li> <li>• Csak radiális állítás.</li> <li>• Forgó alkalmazásokban is használható max. 800 ford/perc-ig</li> </ul>  |  |
| <p><b>Normál szériák</b></p> <ul style="list-style-type: none"> <li>• Amikor követelmény a szögben való és axiális állíthatóság.</li> <li>• Forgó alkalmazásokban is használható max. 800 ford/perc-ig</li> </ul>   |  |

Minden önbeálló befogó belső hűtéshez.  
Kétféle hűtőfolyadék-bevezetés választható.

JJL: oldal bemenet  
JJ: átmenő szár

Használati utasítás mellékelve.

## Kompakt GV nagysebességű szériák

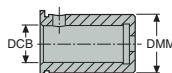


| Cikkszám | Megnevezés     | DCB  | DMM   | LF   | LS   | DF   | BDX  | LH   | CBDP | CNT | LF1  | TDZ | ADJRG | Súly |
|----------|----------------|------|-------|------|------|------|------|------|------|-----|------|-----|-------|------|
|          |                | mm   | mm    | mm   | mm   | 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  |

### Kiegészítők

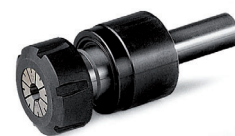
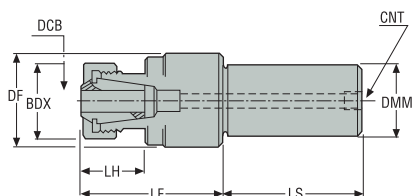
Megnaezés

Szűkítő gyűrű



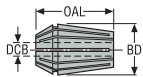

|             | DCB | DMM |
|-------------|-----|-----|
| SRR-BR11016 | 10  | 16  |
| SRR-BR11216 | 12  | 16  |
| SRR-BR11220 | 12  | 20  |
| SRR-BR21620 | 16  | 20  |
| SRR-BR31625 | 16  | 25  |
| SRR-BR32025 | 20  | 25  |
| SRR-GV42532 | 25  | 32  |

## Kompakt GV patronos nagy sebességű szériák



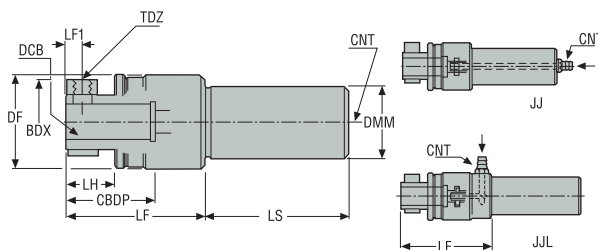
| Cikkszám | Megnevezés     | CZC  | DMM   | LF   | LS   | DF   | BDX  | LH   | CNT | ADJRG | Súly |
|----------|----------------|------|-------|------|------|------|------|------|-----|-------|------|
|          |                |      | mm    | mm   | mm   | mm   | mm   | mm   |     | mm    | kg   |
| 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  |

### Kiegészítők

| Megnevezés | Méret | Patron*   | Méret | Csavar kulcs*   |
|------------|-------|---|-------|---|
|            |       |  |       |  |
|            |       | DCB   | BD    | OAL   |
| 58803210   | ER32  | 10  | 33    | 40  |
| 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  |
| 58804020   | ER40  | 20  | 41    | 46  |
| 58804025   | ER40  | 25  | 41    | 46  |
| 58804026   | ER40  | 26  | 41    | 46  |

\*A patron és a kulcs nem a szállítmány része.

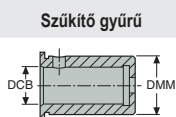
## Kompakt szériák



| Cikkszám | Megnevezés    | DCB  | DMM   | LF    | LS    | DF   | BDX  | LH   | CBDP | CNT | LF1  | TDZ | ADJRG | Súly  |
|----------|---------------|------|-------|-------|-------|------|------|------|------|-----|------|-----|-------|-------|
|          |               | 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-C01019JL  | 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-C21619JL  | 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-C22019JL  | 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-C01020JL  | 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-C21620JL  | 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-C22020JL  | 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-C32525JL  | 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-C32525MJL | 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-C32525MJL | 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  |

### Kiegészítők

| Megnevezés  | 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  |



A hűtőfolyadék adapter szállításkor nincs mellékelve.

Bevezetés

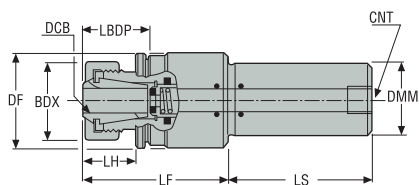
Fűrés

Dörzsárazás

Késztergálás

Melléklet

## Kompakt patronos szériák



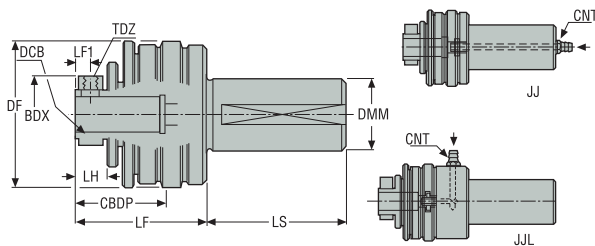
| Cikkszám | Megnevezés      | CZC  | DMM  | LF   | LS   | DF   | BDX  | CBDP | LH   | CNT | ADJRG | Súly |
|----------|-----------------|------|------|------|------|------|------|------|------|-----|-------|------|
|          |                 |      | mm   | mm   | mm   | mm   | mm   | mm   | mm   |     | 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  |

### Kiegészítők

| Megnevezés | Méret | Patron* | Méret | Csavar kulcs* |      |           |
|------------|-------|---------|-------|---------------|------|-----------|
|            |       |         |       |               |      |           |
|            |       | 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            | -    | -         |

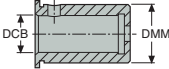
\*A patron és a kulcs nem a szállítmány része.

## Normál szériák



| Cikkszám | Megnevezés    | DCB  | DMM   | LF   | LS    | DF   | BDX  | LH   | CBDP | CNT | LF1  | TDZ | ADJRG | ANADJ | Súly |
|----------|---------------|------|-------|------|-------|------|------|------|------|-----|------|-----|-------|-------|------|
|          |               | 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  |

### Kiegészítők

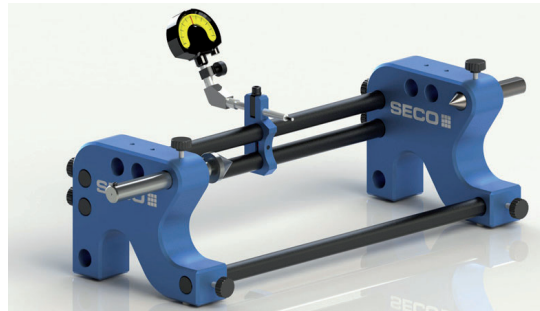
| Megnevezés  | Szűkítő gyűrű   |     |
|-------------|---|-----|
|             |  |     |
|             | DCB   | DMM |
| SRR-BR11016 | 10  | 16  |
| SRR-BR11216 | 12  | 16  |
| SRR-BR11220 | 12  | 20  |
| SRR-BR21620 | 16  | 20  |
| SRR-BR31625 | 16  | 25  |
| SRR-BR32025 | 20  | 25  |

A hűtőfolyadék adapter szállításkor nincs mellékelve.

## Beállító készülék – Egy mérőórás

**SF-210340-C160: Rendelési és cikkszám: 02885391**

- Vízszintes állvány
- Elsődleges választás az Xfix dörzsárazakhoz
- 1 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 340 mm (13.386")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék

**SF-210290V-C160: Rendelési és cikkszám: 02885392**

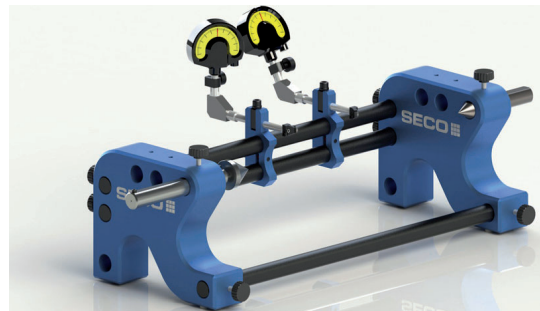
- Függőleges állvány
- Elsődleges választás az Xfix dörzsárazakhoz
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 290 mm (11.417")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék



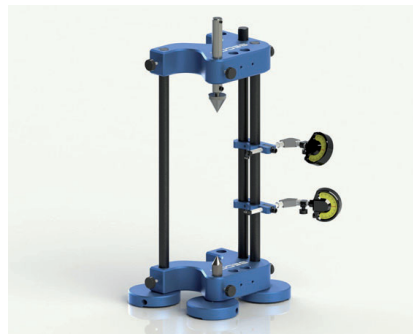
## Beállító készülék – Két mérőórás

**SF-210340-C160C190: Rendelési és cikkszám: 02885393**

- Vízszintes állvány
- Elsődleges választás az Bifix dörzsárazakhoz
- 2 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 340 mm (13.386")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék

**SF-210290V-C160C190: Rendelési és cikkszám: 02885394**

- Függőleges állvány
- Elsődleges választás az Bifix dörzsárazakhoz
- 2 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 290 mm (11.417")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék



Rendelési információkért forduljon a Seco Tools helyi képviselőjéhez.

## Beállító készülék – Egy mérőórás, nagy kapacitású

### SF-210740-C160: Rendelési és cikkszám: 02885385

- Vízszintes állvány
- Elsődleges választás az Xfix dörzsárazakhoz
- 1 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 740 mm (29.134")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék



### SF-210690V-C160: Rendelési és cikkszám: 02885387

- Függőleges állvány
- Elsődleges választás az Xfix dörzsárazakhoz
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 690 mm (27.165")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék



## Beállító készülék – Két mérőórás, nagy kapacitású

### SF-210740-C160C190: Rendelési és cikkszám: 02885388

- Vízszintes állvány
- Elsődleges választás az Bifix dörzsárazakhoz
- 2 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 740 mm (29.134")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék



### SF-210690V-C160C190: Rendelési és cikkszám: 02885390

- Függőleges állvány
- Elsődleges választás az Bifix dörzsárazakhoz
- 2 mérőóra
- Maximális szerszám Ø: 210 mm (8.268")
- Maximális szerszámhossz: 690 mm (27.165")
- További Ø 57 mm (2.244") rugós központosító a HSK 63/80/100 és Capto C8 esetén
- Az SSC5700 központosító tartozék



Rendelési információkért forduljon a Seco Tools helyi képviselőjéhez.



## Beállító készülék – Kompakt

**SF-60200-C160: Rendelési és cikkszám: 02885395**

- Vízszintes állvány
- Elsődleges választás ha az Ø kisebb mint 60 mm (2.362")
- 1 mérőóra
- Maximális szerszám Ø: 60,5 mm (82.382")
- Maximális szerszámhossz: 200 mm (7.874")

**SF-60200-C160C190: Rendelési és cikkszám: 02885396**

- Vízszintes állvány
- Elsődleges választás ha az Ø kisebb mint 60 mm (2362")
- 2 mérőóra
- Maximális szerszám Ø: 60,5 mm (82.382")
- Maximális szerszámhossz: 200 mm (7.874")



Rendelési információkért forduljon a Seco Tools helyi képviselőjéhez.

## További mérőkarok

|   |  |
|---|--|
|    | <p><b>SFB-60: Rendelési és cikkszám: 02208619</b></p> <ul style="list-style-type: none"> <li>• Mérőkar, 60°</li> <li>• A mérőóra tartozék</li> <li>• Tapintót nem tartalmaz, lásd: 489</li> </ul>    |
|    | <p><b>SFB-60 WC: Rendelési és cikkszám: 02885754</b></p> <ul style="list-style-type: none"> <li>• Mérőkar, 60°</li> <li>• A mérőóra tartozék</li> <li>• Tapintót nem tartalmaz, lásd: 489</li> </ul> |
|   | <p><b>SFB-90: Rendelési és cikkszám: 02208622</b></p> <ul style="list-style-type: none"> <li>• Mérőkar, 90°</li> <li>• A mérőóra tartozék</li> <li>• Tapintót nem tartalmaz, lásd: 489</li> </ul>    |
|  | <p><b>SFB-90 WC: Rendelési és cikkszám: 02885755</b></p> <ul style="list-style-type: none"> <li>• Mérőkar, 90°</li> <li>• A mérőóra tartozék</li> <li>• Tapintót nem tartalmaz, lásd: 489</li> </ul> |
|  | <p><b>DG-1: Rendelési és cikkszám: 75079579</b></p> <ul style="list-style-type: none"> <li>• Tárcsás mérőóra, 1 μm (0.00004")</li> </ul>   |

## Példák a több mérőóras beállító készülékekre



## Kiegészítők

|   |  |             |
|---|--|-------------|
|    | <p><b>SMES-406: Rendelési és cikkszám: 02819156</b></p> <ul style="list-style-type: none"> <li>• Mérőcsúcs Xfix dörzsárazáshoz</li> <li>• Ø 4 mm (0.157")</li> <li>• Tömör keményfém fej</li> </ul>  | Bevezetés   |
|    | <p><b>SMES-900: Rendelési és cikkszám: 02208610</b></p> <ul style="list-style-type: none"> <li>• Mérőcsúcs Bifix dörzsárazáshoz</li> <li>• Tömör keményfém fej</li> </ul>  |             |
|   | <p><b>SMES-909: Rendelési és cikkszám: 02980090</b></p> <ul style="list-style-type: none"> <li>• Mérőcsúcs Bifix dörzsárazáshoz</li> <li>• Tömör keményfém fej</li> <li>• 9 mm (0.354") eltolás</li> </ul>                                       | Dörzsárazás |
|  | <p><b>SMES-915: Rendelési és cikkszám: 02208616</b></p> <ul style="list-style-type: none"> <li>• Mérőcsúcs Bifix dörzsárazáshoz</li> <li>• Tömör keményfém fej</li> <li>• 15 mm (0.591") eltolás</li> </ul>                                      |             |
|  | <p><b>SFHS-20: Rendelési és cikkszám: 02884025</b></p> <ul style="list-style-type: none"> <li>• Kézi csavar</li> <li>• A teljes beállító készülék kínálatához használható</li> </ul>   | Melléklet   |
|  | <p><b>SFVST-100: Rendelési és cikkszám: 02884026</b></p> <ul style="list-style-type: none"> <li>• Acél állvány (3 db)</li> <li>• Ø 100 mm (3.937")</li> <li>• Vízszintes beállító készülék függőleges helyzetbe alakításához alkalmas</li> </ul> |             |

## Középpontok

Bevezetés

Fúrás

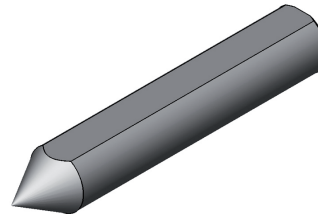
Dörzsárazás

Késztergálás

Melléklet

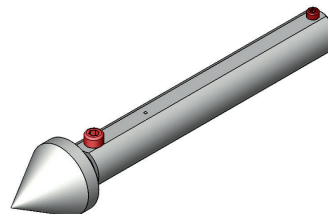
**SFC-2000HM: Rendelési és cikkszám: 02884023**

- Tömör keményfém, rögzített központosító
- Ø 20 mm (0,787")
- Alkalmazható az X.ix és Bifix termékcsalád normál és speciális elemeihez
- A szerszám előoldalán használandó



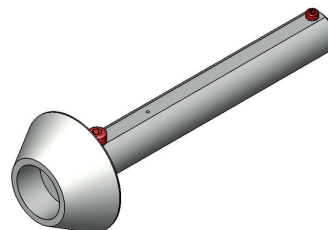
**SSC-3400: Rendelési és cikkszám: 02208617**

- Rugós központosító
- Ø 34 mm (1,339")
- Alkalmazható az Xfix és Bifix termékcsalád normál és speciális elemeihez
- A szerszám hátoldalán használandó
- Nem használható a HSK63/80/100 és capto C8 elemekhez



**SSC5700: Rendelési és cikkszám: 02208620**

- Rugós központosító
- Csonkított Ø 57 mm (2,244")
- Alkalmazható az Xfix és Bifix termékcsalád normál és speciális elemeihez
- A szerszám hátoldalán használandó
- Használható a HSK63/80/100 és Capto C8 elemekhez



# KIESZTERGÁLÓ FEJEK



## NAGYOLÓ ÉS SIMÍTÓ KIESZTERGÁLÓ FEJEK A RUGALMASSÁG ÉS A KIMAGASLÓ EREDMÉNYEK ELÉRÉSÉHEZ

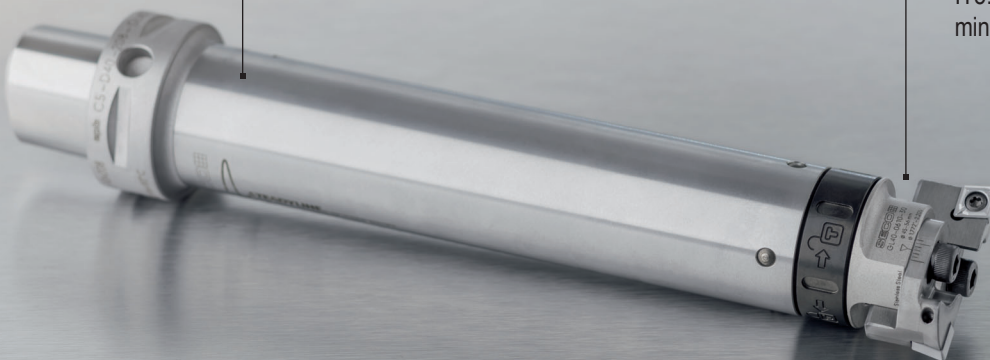
A Seco kiesztergáló fejek széles választékát kínálja Graflex® és Seco-Capto™ gépdali csatlakozással. A nagyoló kiesztergáló fejek erős, merev összeállítást kínálnak nagy anyageltávolítási sebességekhez és geometriai furatpontosságot, az öntött, lángvágott vagy fűrt furatoktól kezdve. A simító kiesztergáló fejekkel akár  $2,5 \mu\text{m}$  ( $98,43 \mu\text{in}$ ) átmérőpontosság is elérhető, kiváló felületi minőséget és nagyon szűk, IT5 tűréseket nyújtva.

### KAPCSOLÓDÓ SZERSZÁMBEFOGÓK

- Graflex® és Seco-Capto™ moduláris rendszerek optimalizált és polivalens összeállításokhoz
- Steadyline® rezgés csillapítási megoldások a mély furat készítési alkalmazásoknál is kimagasló teljesítményhez

### KIESZTERGÁLÓ FEJEK

- Átmérő tartomány  $0,3 \text{ mm}$ -től  $3205 \text{ mm}$ -ig ( $0.0118''$  –  $126.181''$ )
- Nagyoló kiesztergáló fejek nagy anyageltávolítási sebességekkel
- Simító kiesztergáló fejek nagy pontossághoz, akár  $le$  IT5-ig, kiváló felületi minőséggel



## Áttekintés

### Graflex® és Seco-Capto™

Graflex® és Seco-Capto™ befogók, hosszabbítók és csökkentők a kiesztergálók összeszereléséhez

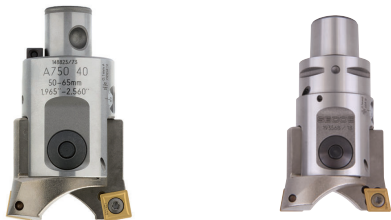


Oldal(ak) 494-553, 554 old.

- A fúrórúd-szerelvények gyorsan összeépíthetők a lehető legrövidebbre a szükséges igények szerint, akár a Graflex, akár a Seco-Capto moduláris rendszer használatával, beleértve a befogókat és közdarabok széles körét.
- Mindkét rendszer merev és precíz csatlakozást kínál nagyoló alkalmazásokhoz vagy furatok simításához.
- A modulok nagyszámú szerszámtartót is fogadhatnak, mint pl patronos befogók, hidraulikus befogók stb. (lásd Szerszámrendszerek katalógusa).

### RB750 kiesztergáló fejek, nagyoló kiesztergálás

Iker fejek, lapkatartó csatlakozó mechanizmussal



Oldal(ak) 560-566 old.

- Magas anyagválasztási arány, pontos furatgeometria és -pozíció
- Szimmetrikus és lépcsőzetes beállítások
- A szimultán beállítás a lapkatartó csatlakozó mechanizmussal végezhető el
- Graflex® vagy Seco-Capto™ csatlakozás

Ø tartomány 18–205 mm  
(0.709 – 8.071")

IT 9/10

### RB 610 kiesztergáló fejek, nagyoló kiesztergálás

Ikerfejek



Oldal(ak) 572-575 old.

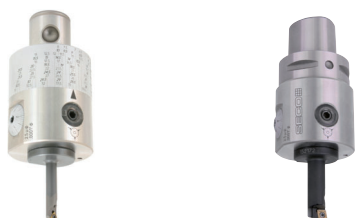
- Magas anyagválasztási arány, pontos furatgeometria és -pozíció
- Szimmetrikus és lépcsőzetes beállítások
- Graflex® csatlakozással Graflex® moduláris rendszerhez
- GL vagy BA csatlakozással Steadyline® rezgéscsilapított rudakhoz

Ø tartomány 28 mm – 116 mm  
(1.102–4.567")

IT 9/10

### FB 760 kiesztergáló fejek, Axiabore™ típus, simító kiesztergálás

Simító kiesztergáló fejek axiális szerszámokkal



Oldal(ak) 583-594 old.

- A furatpontosság mikrométer pontossággal állítható be IT5 tőrésig
- Nagy szerszámmerevség a pontos furatgeometriáért és -pozícióért
- NanoBore™ fej a kisebb átmérőkhöz
- Az AxiaLibraBore™ – és az AxiaLibraBore™ Plus – kiegyensúlyozhatók, HSM-nek megfelelők
- Többfunkciós adapter (MPA) nagyobb furatátmérőkhöz, csap-visszaeszttergáláshoz és beszúráshoz
- Graflex® vagy Seco-Capto™ csatlakozással

Ø tartomány 0,3–108 mm  
(0.012–4.252")

+ csap-visszaeszttergálás és homlokhornnyolás

IT 5/6

## Áttekintés

### FB 620, FB 780 és FB 790 kiesztorgáló fejek, radiális típus

#### Simító kiesztorgáló fejek radiális lapkatartóval



Oldal(ak) 613-621 old.

- A furatpontosság mikrométeres pontossággal állítható be IT5 tűrésig
- Pontos furatgeometria és -pozíció
- Az A790 Libraflex® fejek kiegyensúlyozhatók, HSM-nek megfelelő lapkatartó befogás a legnagyobb megbízhatóságért
- Hosszú furatok készítése a keményfém hosszabbítók (akár 7xD) vagy Steadyline® rudak (akár 10xD) jóvoltából
- Élletöréshez és visszasüllyesztéshez is
- Graflex® vagy Seco-Capto™ csatlakozással moduláris rendszerekhez
- GL vagy BA csatlakozással Steadyline® rezgéscsillapított rudakhoz

Ø tartomány 15–205 mm  
(0.591 – 8.071")

IT 5/6

### Hídrukak és Jumbo fúrófejek

#### Nagyoló és simító kiesztorgáláshoz, nagy átmérőkhöz



Oldal(ak) 623-640 old.

- Kiesztorgáló egységek nagyoló és simító kiesztorgáláshoz, csap-esztorgáláshoz és visszasüllyesztéshez
- Erős kivitel a magas anyagleválasztási arányért nagyoló kiesztorgáláshoz
- Mikrométeres pontosságú beállítás simító kiesztorgáláshoz
- Optimalizált kiesztorgáló blokkok és Jumbo hidak nagy szilárdságú alumíniumból készülnek a nagy sebességekhez
- Betehető a maró alaptartóba „karimás típus

Ø tartomány 204–3205 mm  
(8.031–126.181")

IT 5/6 (simító kiesztorgálás)  
vagy 9/10 (nagyoló kiesztorgálás)  
+ csap-visszaesztorgálás

IT6

### Lapkák kiesztorgáláshoz



Oldal(ak) 642-654 old.

- Furatkészítéshez minden anyagban
- Nagy szívósság nagyoló kiesztorgáláshoz
- Pozitív geometriák simító kiesztorgáláshoz
- Hosszú éltartamú minőségek

### Graflex® vagy Seco-Capto™ moduláris befogó rendszerek



Oldal(ak) 655-657 old.

- A kiesztorgáló fejek Graflex® vagy Seco-Capto™ gépdoldali csatlakozószárral rendelkeznek, így a kiesztorgálási mélységek és átmérők teljes választéka elérhető
- Válassza ki a kívánt Graflex® vagy Seco-Capto™ tűskéket és toldatokat a FELSZERSZÁMOZÁS katalógusból (HSK, DIN, BT, ANSI-CAT, Seco-Capto™)
- Graflex® csatlakozó pótalkatrészek kiesztorgáló fejekhez a fejezetben



## Graflex®

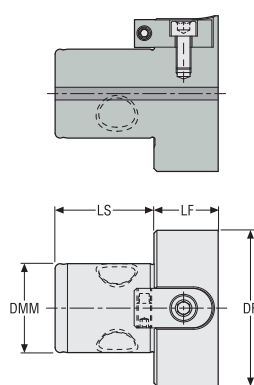
A Graflex® összeállításokban megtalálhatók a tuskék, a közbetétek, a befogók és a kiesztergáló fejek is, melyek szükség esetén gyorsan összeépíthetők. A marásra, fúrásra, menetfúrásra, dörzsárazásra és kiesztergálásra használható Graflex® modulok különféle hosszúságú és átmérőjű szerszámokat kínálnak, és egyszerűen felszerelhetők mindenféle típusú gépre, kiváltva a Graflex® alaptuskét.

- Kiváló csatlakozási merevség
- A modulok széles választéka nagy rugalmasságot nyújt
- Belső hűtés lehetősége

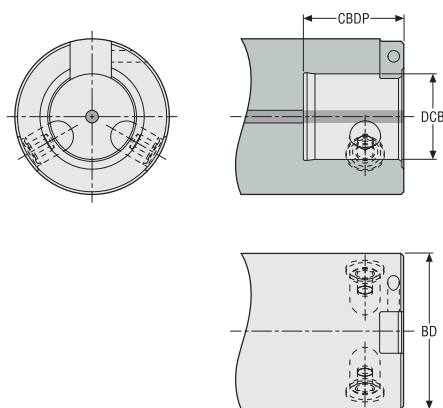


## Graflex®, szabvány méretek

Gép oldal



Munkadarab oldal

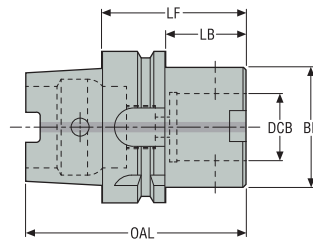


| Géppoldali megnevezés | Furat az RFID számára* | DF          | DMM         | LS          | LF           |
|-----------------------|------------------------|-------------|-------------|-------------|--------------|
|                       |                        | mm<br>Inch  | mm<br>Inch  | mm<br>Inch  | mm<br>Inch   |
| G0                    | Nem                    | 16<br>0.630 | 8<br>0.315  | 12<br>0.472 | 8<br>0.315   |
| G1                    | Nem                    | 20<br>0.787 | 11<br>0.433 | 13<br>0.512 | 9,5<br>0.374 |
| G2                    | Nem                    | 25<br>0.984 | 14<br>0.551 | 16<br>0.630 | 11<br>0.433  |
| G3                    | Nem                    | 32<br>1.260 | 18<br>0.709 | 20<br>0.787 | 14<br>0.551  |
| G4                    | Nem                    | 40<br>1.575 | 22<br>0.866 | 24<br>0.945 | 17<br>0.669  |
| G5                    | Nem                    | 50<br>1.969 | 28<br>1.102 | 30<br>1.181 | 20<br>0.787  |
| G6                    | Nem                    | 63<br>2.480 | 36<br>1.417 | 40<br>1.575 | 26<br>1.024  |
| G7                    | Nem                    | 90<br>3.543 | 46<br>1.811 | 50<br>1.969 | 26<br>1.024  |

| Munkadarab oldali megnevezés | Furat az RFID számára* | CBDP        | DCB         | BD          |
|------------------------------|------------------------|-------------|-------------|-------------|
|                              |                        | mm<br>Inch  | mm<br>Inch  | mm<br>Inch  |
| G0                           | Nem                    | 16<br>0.630 | 8<br>0.315  | 12<br>0.472 |
| G1                           | Nem                    | 20<br>0.787 | 11<br>0.433 | 13<br>0.512 |
| G2                           | Nem                    | 25<br>0.984 | 14<br>0.551 | 16<br>0.630 |
| G3                           | Nem                    | 32<br>1.260 | 18<br>0.709 | 20<br>0.787 |
| G4                           | Nem                    | 40<br>1.575 | 22<br>0.866 | 24<br>0.945 |
| G5                           | Nem                    | 50<br>1.969 | 28<br>1.102 | 30<br>1.181 |
| G6                           | Nem                    | 63<br>2.480 | 36<br>1.417 | 40<br>1.575 |
| G7                           | Nem                    | 90<br>3.543 | 46<br>1.811 | 50<br>1.969 |

## G 401 – Graflex® befogók

HSK-A/ ISO12164-1-HSK-A




- A HSK tömítő dugók, hűtőcsövek és cső rögzítők a 523 old.

| Megnevezés     | Cikkszám | CTMS     | CTWS | DCB           | LF             | LB             | BD            | OAL            | RFID<br>furat | Egys.<br>faktor | Súly           |
|----------------|----------|----------|------|---------------|----------------|----------------|---------------|----------------|---------------|-----------------|----------------|
|                |          |          |      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     |               |                 | kg<br>lbs      |
| EM93034012870  | 00086917 | HSK-A50  | G5   | 28,0<br>1.102 | 70,0<br>2.756  | 44,0<br>1.732  | 50,0<br>1.969 | 95,0<br>3.740  | 1             | PB              | 0,79<br>1.740  |
| EM93044011445  | 02469722 | HSK-A63  | G2   | 14,0<br>0.551 | 45,0<br>1.772  | 19,0<br>0.748  | 25,0<br>0.984 | 77,0<br>3.031  | 1             | G6.3            | 0,69<br>1.520  |
| EM93044011850  | 00086918 | HSK-A63  | G3   | 18,0<br>0.709 | 50,0<br>1.969  | 24,0<br>0.945  | 32,0<br>1.260 | 82,0<br>3.228  | 1             | G6.3            | 0,73<br>1.610  |
| EM93044012255  | 00088217 | HSK-A63  | G4   | 22,0<br>0.866 | 55,0<br>2.165  | 29,0<br>1.142  | 40,0<br>1.575 | 87,0<br>3.425  | 1             | G6.3            | 0,83<br>1.830  |
| EM93044012860  | 00086920 | HSK-A63  | G5   | 28,0<br>1.102 | 60,0<br>2.362  | 34,0<br>1.339  | 50,0<br>1.969 | 92,0<br>3.622  | 1             | PB              | 0,98<br>2.160  |
| EM930440128100 | 00086921 | HSK-A63  | G5   | 28,0<br>1.102 | 100,0<br>3.937 | 74,0<br>2.913  | 50,0<br>1.969 | 132,0<br>5.197 | 1             | PB              | 1,58<br>3.480  |
| EM930440128140 | 00086922 | HSK-A63  | G5   | 28,0<br>1.102 | 140,0<br>5.512 | 114,0<br>4.488 | 50,0<br>1.969 | 172,0<br>6.772 | 1             | PB              | 2,18<br>4.810  |
| EM93044013670  | 00086923 | HSK-A63  | G6   | 36,0<br>1.417 | 70,0<br>2.756  | 44,0<br>1.732  | 63,0<br>2.480 | 102,0<br>4.016 | 1             | PB              | 1,21<br>2.670  |
| EM930440136120 | 00086924 | HSK-A63  | G6   | 36,0<br>1.417 | 120,0<br>4.724 | 94,0<br>3.701  | 63,0<br>2.480 | 152,0<br>5.984 | 1             | PB              | 2,38<br>5.250  |
| EM93064011855  | 00086925 | HSK-A100 | G3   | 18,0<br>0.709 | 55,0<br>2.165  | 26,0<br>1.024  | 32,0<br>1.260 | 105,0<br>4.134 | 1             | G6.3            | 2,1<br>4.630   |
| EM93064012260  | 00086926 | HSK-A100 | G4   | 22,0<br>0.866 | 60,0<br>2.362  | 31,0<br>1.220  | 40,0<br>1.575 | 110,0<br>4.331 | 1             | G6.3            | 2,19<br>4.830  |
| EM93064012865  | 00086927 | HSK-A100 | G5   | 28,0<br>1.102 | 65,0<br>2.559  | 36,0<br>1.417  | 50,0<br>1.969 | 115,0<br>4.528 | 1             | PB              | 2,37<br>5.220  |
| EM930640128110 | 00086928 | HSK-A100 | G5   | 28,0<br>1.102 | 110,0<br>4.331 | 81,0<br>3.189  | 50,0<br>1.969 | 160,0<br>6.299 | 1             | PB              | 3,02<br>6.660  |
| EM930640128150 | 00086929 | HSK-A100 | G5   | 28,0<br>1.102 | 150,0<br>5.906 | 121,0<br>4.764 | 50,0<br>1.969 | 200,0<br>7.874 | 1             | PB              | 3,7<br>8.160   |
| EM93064013675  | 00083432 | HSK-A100 | G6   | 36,0<br>1.417 | 75,0<br>2.953  | 46,0<br>1.811  | 63,0<br>2.480 | 125,0<br>4.921 | 1             | PB              | 2,6<br>5.730   |
| EM930640136120 | 00086931 | HSK-A100 | G6   | 36,0<br>1.417 | 120,0<br>4.724 | 91,0<br>3.583  | 63,0<br>2.480 | 170,0<br>6.693 | 1             | PB              | 3,82<br>8.420  |
| EM930640136160 | 00086932 | HSK-A100 | G6   | 36,0<br>1.417 | 160,0<br>6.299 | 131,0<br>5.157 | 63,0<br>2.480 | 210,0<br>8.268 | 1             | PB              | 4,72<br>10.410 |
| EM93064014685  | 00074385 | HSK-A100 | G7   | 46,0<br>1.811 | 85,0<br>3.346  | 56,0<br>2.205  | 90,0<br>3.543 | 135,0<br>5.315 | 1             | PB              | 3,99<br>8.800  |
| EM930640146160 | 00086933 | HSK-A100 | G7   | 46,0<br>1.811 | 160,0<br>6.299 | 131,0<br>5.157 | 90,0<br>3.543 | 210,0<br>8.268 | 1             | PB              | 7,67<br>16.910 |
| HSKA125-G6-120 | 03229653 | HSK-A125 | G6   | 36,0<br>1.417 | 120,0<br>4.724 | 91,0<br>3.583  | 63,0<br>2.480 | 183,0<br>7.205 | 1             | PB              | 5,1<br>11.240  |
| HSKA125-G7-120 | 03229654 | HSK-A125 | G7   | 46,0<br>1.811 | 120,0<br>4.724 | 91,0<br>3.583  | 90,0<br>3.543 | 183,0<br>7.205 | 1             | PB              | 7,1<br>15.650  |

## Pótalkatrészek

| Méret | Összeszerelő csavar   |
|-------|---|
|       |  |
| G2    | 90F2  |
| G3    | 90F3  |
| G4    | 90F4  |
| G5    | 90F5  |
| G6    | 90F6  |
| G7    | 90F7  |

## Kiegészítők

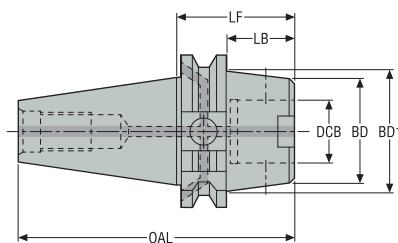
| Méret | Rögzítő kulcs   |
|-------|---|
|       |  |
| G2    | 03H025  |
| G3    | 03H03   |
| G4    | 03H04   |
| G5    | 03H05   |
| G6    | 03H06   |
| G7    | 03H10   |

## G 401 – Graflex® befogók

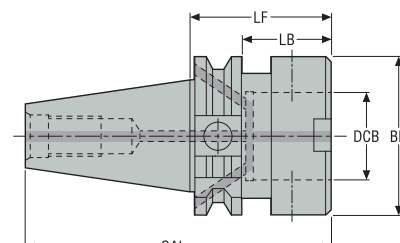
DIN 69871-ADB



Diseño 1




Diseño 2



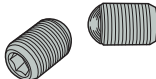

| Megnevezés     | Cikkszám | CTMS      | CTWS | DCB           | LF             | LB             | BD1           | BD            | OAL            | Kivitel | RFID furat | Egys. faktor | Súly           |
|----------------|----------|-----------|------|---------------|----------------|----------------|---------------|---------------|----------------|---------|------------|--------------|----------------|
|                |          |           |      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |         |            |              | kg<br>lbs      |
| EM34694011190  | 02503292 | DIN40 ADB | G1   | 11,0<br>0.433 | 90,0<br>3.543  | 70,9<br>2.791  | -             | 20,0<br>0.787 | 158,4<br>6.236 | 2       | 1          | G6.3         | 0,94<br>2.070  |
| EM34694011435  | 02469729 | DIN40 ADB | G2   | 14,0<br>0.551 | 35,0<br>1.378  | 15,9<br>0.626  | -             | 25,0<br>0.984 | 103,4<br>4.071 | 2       | 1          | G6.3         | 0,83<br>1.830  |
| EM34694011490  | 02503293 | DIN40 ADB | G2   | 14,0<br>0.551 | 90,0<br>3.543  | 70,9<br>2.791  | -             | 25,0<br>0.984 | 158,4<br>6.236 | 2       | 1          | G6.3         | 1,02<br>2.250  |
| EM34694011835  | 02420097 | DIN40 ADB | G3   | 18,0<br>0.709 | 35,0<br>1.378  | 15,9<br>0.626  | 50,0<br>1.969 | 32,0<br>1.260 | 103,4<br>4.071 | 1       | 1          | G6.3         | 0,91<br>2.010  |
| EM346940118100 | 02503298 | DIN40 ADB | G3   | 18,0<br>0.709 | 100,0<br>3.937 | 80,9<br>3.185  | -             | 32,0<br>1.260 | 168,4<br>6.630 | 2       | 1          | G6.3         | 1,22<br>2.690  |
| EM34694012235  | 02503299 | DIN40 ADB | G4   | 22,0<br>0.866 | 35,0<br>1.378  | 15,9<br>0.626  | 50,0<br>1.969 | 40,0<br>1.575 | 103,4<br>4.071 | 1       | 1          | G6.3         | 0,92<br>2.030  |
| EM346940122100 | 02503300 | DIN40 ADB | G4   | 22,0<br>0.866 | 100,0<br>3.937 | 80,9<br>3.185  | -             | 40,0<br>1.575 | 168,4<br>6.630 | 2       | 1          | G6.3         | 1,44<br>3.170  |
| EM34694012840  | 02458421 | DIN40 ADB | G5   | 28,0<br>1.102 | 40,0<br>1.575  | 20,9<br>0.823  | -             | 50,0<br>1.969 | 108,4<br>4.268 | 2       | 1          | PB           | 0,93<br>2.050  |
| EM34694012880  | 02503301 | DIN40 ADB | G5   | 28,0<br>1.102 | 80,0<br>3.150  | 60,9<br>2.398  | -             | 50,0<br>1.969 | 148,4<br>5.843 | 2       | 1          | PB           | 1,5<br>3.310   |
| EM346940128120 | 02503302 | DIN40 ADB | G5   | 28,0<br>1.102 | 120,0<br>4.724 | 100,9<br>3.972 | -             | 50,0<br>1.969 | 188,4<br>7.417 | 2       | 1          | PB           | 2,08<br>4.590  |
| EM34694013660  | 02503303 | DIN40 ADB | G6   | 36,0<br>1.417 | 60,0<br>2.362  | 40,9<br>1.610  | -             | 63,0<br>2.480 | 128,4<br>5.055 | 2       | 1          | PB           | 1,24<br>2.730  |
| EM346940136120 | 02503304 | DIN40 ADB | G6   | 36,0<br>1.417 | 120,0<br>4.724 | 100,9<br>3.972 | -             | 63,0<br>2.480 | 188,4<br>7.417 | 2       | 1          | PB           | 2,65<br>5.840  |
| EM347140114100 | 02503306 | DIN50 ADB | G2   | 14,0<br>0.551 | 100,0<br>3.937 | 80,9<br>3.185  | -             | 25,0<br>0.984 | 201,7<br>7.941 | 2       | 1          | G6.3         | 2,8<br>6.170   |
| EM34714011835  | 02503307 | DIN50 ADB | G3   | 18,0<br>0.709 | 35,0<br>1.378  | 15,9<br>0.626  | -             | 32,0<br>1.260 | 136,7<br>5.382 | 2       | 1          | G6.3         | 2,67<br>5.890  |
| EM347140118110 | 02503308 | DIN50 ADB | G3   | 18,0<br>0.709 | 110,0<br>4.331 | 90,9<br>3.579  | -             | 32,0<br>1.260 | 211,7<br>8.335 | 2       | 1          | G6.3         | 3,0<br>6.610   |
| EM34714012235  | 02503309 | DIN50 ADB | G4   | 22,0<br>0.866 | 35,0<br>1.378  | 15,9<br>0.626  | 80,0<br>3.150 | 40,0<br>1.575 | 136,7<br>5.382 | 1       | 1          | G6.3         | 2,88<br>6.350  |
| EM347140122120 | 02503311 | DIN50 ADB | G4   | 22,0<br>0.866 | 120,0<br>4.724 | 100,9<br>3.972 | -             | 40,0<br>1.575 | 221,7<br>8.728 | 2       | 1          | G6.3         | 3,5<br>7.720   |
| EM34714012840  | 02503312 | DIN50 ADB | G5   | 28,0<br>1.102 | 40,0<br>1.575  | 20,9<br>0.823  | -             | 50,0<br>1.969 | 141,7<br>5.579 | 2       | 1          | PB           | 2,75<br>6.060  |
| EM347140128100 | 02503315 | DIN50 ADB | G5   | 28,0<br>1.102 | 100,0<br>3.937 | 80,9<br>3.185  | -             | 50,0<br>1.969 | 201,7<br>7.941 | 2       | 1          | PB           | 3,56<br>7.850  |
| EM347140128140 | 02503316 | DIN50 ADB | G5   | 28,0<br>1.102 | 140,0<br>5.512 | 120,9<br>4.760 | -             | 50,0<br>1.969 | 241,7<br>9.516 | 2       | 1          | PB           | 4,08<br>8.990  |
| EM34714013645  | 02503317 | DIN50 ADB | G6   | 36,0<br>1.417 | 45,0<br>1.772  | 25,9<br>1.020  | -             | 63,0<br>2.480 | 146,7<br>5.776 | 2       | 1          | PB           | 2,88<br>6.350  |
| EM347140136100 | 02503318 | DIN50 ADB | G6   | 36,0<br>1.417 | 100,0<br>3.937 | 80,9<br>3.185  | -             | 63,0<br>2.480 | 201,7<br>7.941 | 2       | 1          | PB           | 4,1<br>9.040   |
| EM347140136140 | 02503319 | DIN50 ADB | G6   | 36,0<br>1.417 | 140,0<br>5.512 | 120,9<br>4.760 | -             | 63,0<br>2.480 | 241,7<br>9.516 | 2       | 1          | PB           | 4,99<br>11.000 |

| Megnevezés     | Cikkszám | CTMS      | CTWS | DCB           | LF             | LB             | BD1 | BD            | OAL             | Kivétel | RFID furat | Egys. faktor | Súly           |
|----------------|----------|-----------|------|---------------|----------------|----------------|-----|---------------|-----------------|---------|------------|--------------|----------------|
|                |          |           |      |               |                |                |     |               |                 |         |            |              | kg<br>lbs      |
| EM34714014650  | 02503320 | DIN50 ADB | G7   | 46,0<br>1.811 | 50,0<br>1.969  | 30,9<br>1.217  | –   | 90,0<br>3.543 | 151,7<br>5.972  | 2       | 1          | PB           | 3,23<br>7.120  |
| EM347140146120 | 02503321 | DIN50 ADB | G7   | 46,0<br>1.811 | 120,0<br>4.724 | 100,9<br>3.972 | –   | 90,0<br>3.543 | 221,7<br>8.728  | 2       | 1          | PB           | 6,48<br>14.290 |
| EM347140146200 | 02503324 | DIN50 ADB | G7   | 46,0<br>1.811 | 200,0<br>7.874 | 180,9<br>7.122 | –   | 90,0<br>3.543 | 301,7<br>11.878 | 2       | 1          | PB           | 10,4<br>22.930 |

## Kiegészítők

| Méret         | Rögzítő kulcs   |
|---------------|---|
|               |  |
| 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   |

## Pótalkatrészek

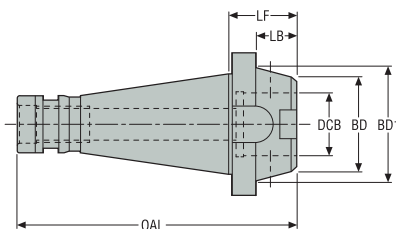
| Méret         | Összeszerelő csavar   | Tömítő csavar   |
|---------------|---|---|
|               |  |  |
| DIN40/ G1     | 90F1  | 950A0406  |
| DIN40/ G2     | 90F2  | 950A0406  |
| DIN40/ G3     | 90F3  | 950A0406  |
| DIN40/ G4     | 90F4  | 950A0406  |
| DIN40/ G5     | 90F5  | 950A0406  |
| 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® befogók

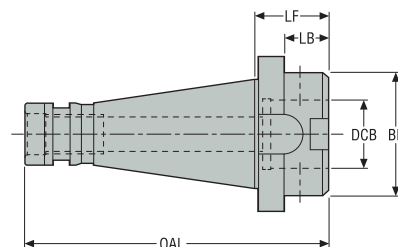
DIN 2080



Diseño 1



Diseño 2



| Megnevezés    | Cikkszám | CTMS        | CTWS | DCB           | LF            | LB            | BD1           | BD            | OAL            | Kivitel | RFID furat | Egys. faktor | Súly          |
|---------------|----------|-------------|------|---------------|---------------|---------------|---------------|---------------|----------------|---------|------------|--------------|---------------|
|               |          |             |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |         |            |              | kg<br>lbs     |
| EM00404013650 | 00076707 | DIN(2080)40 | G6   | 36,0<br>1.417 | 50,0<br>1.969 | 0,0<br>0.0    | –             | 63,0<br>2.480 | 143,4<br>5.646 | 2       | 0          | PB           | 1,27<br>2.800 |
| EM00504012835 | 00076710 | DIN(2080)50 | G5   | 28,0<br>1.102 | 35,0<br>1.378 | 19,8<br>0.780 | 78,0<br>3.071 | 50,0<br>1.969 | 161,8<br>6.370 | 1       | 0          | PB           | 2,94<br>6.480 |
| EM00504013640 | 00076714 | DIN(2080)50 | G6   | 36,0<br>1.417 | 40,0<br>1.575 | 24,8<br>0.976 | –             | 63,0<br>2.480 | 166,8<br>6.567 | 2       | 0          | PB           | 2,82<br>6.220 |
| EM00504014645 | 00076718 | DIN(2080)50 | G7   | 46,0<br>1.811 | 45,0<br>1.772 | 29,8<br>1.173 | –             | 90,0<br>3.543 | 171,8<br>6.764 | 2       | 0          | PB           | 3,34<br>7.360 |

### Kiegészítők

| Méret | Rögzítő kulcs |
|-------|---------------|
| G5    | 03H05         |
| G6    | 03H06         |
| G7    | 03H10         |

### Pótalkatrészek

| Méret | Összeszerelő csavar |
|-------|---------------------|
| G5    | 90F5                |
| G6    | 90F6                |
| G7    | 90F7                |

Bevezetés

Fúrás

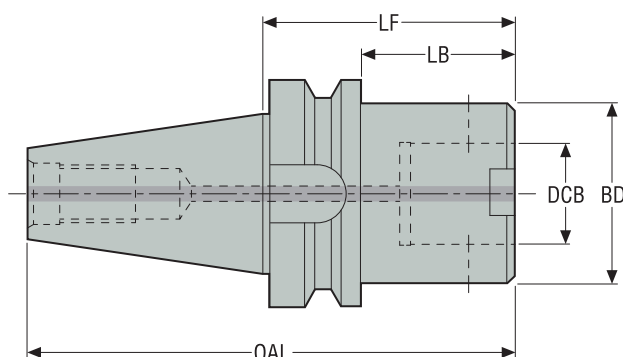
Dörzsárazás

Kiesztergálás

Melléklet

## G 401 – Graflex® befogók

BT JIS B 6339-AD



| Megnevezés    | Cikkszám | CTMS    | CTWS | DCB           | LF            | LB            | BD            | OAL           | RFID furat | Egys. faktor | Súly          |
|---------------|----------|---------|------|---------------|---------------|---------------|---------------|---------------|------------|--------------|---------------|
|               |          |         |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    |            |              | kg<br>lbs     |
| EM40404011835 | 00056699 | BT30 AD | G3   | 18,0<br>0.709 | 35,0<br>1.378 | 13,0<br>0.512 | 32,0<br>1.260 | 83,4<br>3.283 | 0          | G6.3         | 0,41<br>0.900 |
| EM40404012850 | 00056705 | BT30 AD | G5   | 28,0<br>1.102 | 50,0<br>1.969 | 25,0<br>0.984 | 50,0<br>1.969 | 98,4<br>3.874 | 0          | PB           | 0,62<br>1.370 |

### Kiegészítők

| Megnevezés    | Rögzítő kulcs |
|---------------|---------------|
| EM40404011835 | 03H03         |
| EM40404012850 | 03H05         |

### Pótalkatrészek

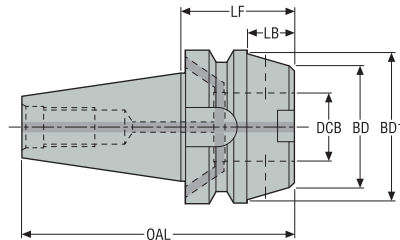
| Megnevezés    | Összeszerelő csavar |
|---------------|---------------------|
| EM40404011835 | 90F3                |
| EM40404012850 | 90F5                |

## G 401 – Graflex® befogók

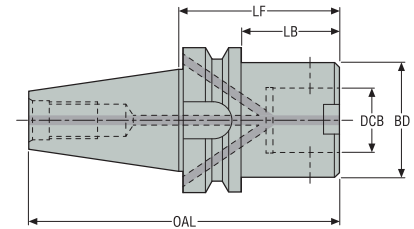
BT JIS B 6339-ADB



Diseño 1



Diseño 2



| Megnevezés     | Cikkszám | CTMS     | CTWS | DCB           | LF             | LB             | BD1           | BD            | OAL            | Kivitel | RFID<br>furat | Egys.<br>faktor | Súly           |
|----------------|----------|----------|------|---------------|----------------|----------------|---------------|---------------|----------------|---------|---------------|-----------------|----------------|
|                |          |          |      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |         |               |                 | kg<br>lbs      |
| EM34144011190  | 02503364 | BT40 ADB | G1   | 11,0<br>0.433 | 90,0<br>3.543  | 63,0<br>2.480  | -             | 20,0<br>0.787 | 155,4<br>6.118 | 2       | 1             | G6.3            | 1,06<br>2.340  |
| EM34144011440  | 02469725 | BT40 ADB | G2   | 14,0<br>0.551 | 40,0<br>1.575  | 13,0<br>0.512  | -             | 25,0<br>0.984 | 105,4<br>4.150 | 2       | 1             | G6.3            | 0,98<br>2.160  |
| EM34144011490  | 02503365 | BT40 ADB | G2   | 14,0<br>0.551 | 90,0<br>3.543  | 63,0<br>2.480  | -             | 25,0<br>0.984 | 155,4<br>6.118 | 2       | 1             | G6.3            | 1,15<br>2.540  |
| EM34144011840  | 02503366 | BT40 ADB | G3   | 18,0<br>0.709 | 40,0<br>1.575  | 13,0<br>0.512  | 62,0<br>2.441 | 32,0<br>1.260 | 105,4<br>4.150 | 1       | 1             | G6.3            | 1,07<br>2.360  |
| EM341440118100 | 02503367 | BT40 ADB | G3   | 18,0<br>0.709 | 100,0<br>3.937 | 73,0<br>2.874  | -             | 32,0<br>1.260 | 165,4<br>6.512 | 2       | 1             | G6.3            | 1,31<br>2.890  |
| EM34144012245  | 02503368 | BT40 ADB | G4   | 22,0<br>0.866 | 45,0<br>1.772  | 18,0<br>0.709  | 62,0<br>2.441 | 40,0<br>1.575 | 110,4<br>4.346 | 1       | 1             | G6.3            | 1,14<br>2.510  |
| EM341440122100 | 02503370 | BT40 ADB | G4   | 22,0<br>0.866 | 100,0<br>3.937 | 73,0<br>2.874  | -             | 40,0<br>1.575 | 165,4<br>6.512 | 2       | 1             | G6.3            | 1,54<br>3.400  |
| EM34144012845  | 02457989 | BT40 ADB | G5   | 28,0<br>1.102 | 45,0<br>1.772  | 18,0<br>0.709  | 62,0<br>2.441 | 50,0<br>1.969 | 110,4<br>4.346 | 1       | 1             | PB              | 1,12<br>2.470  |
| EM34144012880  | 02503371 | BT40 ADB | G5   | 28,0<br>1.102 | 80,0<br>3.150  | 53,0<br>2.087  | -             | 50,0<br>1.969 | 145,4<br>5.724 | 2       | 1             | PB              | 1,54<br>3.400  |
| EM341440128120 | 02503372 | BT40 ADB | G5   | 28,0<br>1.102 | 120,0<br>4.724 | 93,0<br>3.661  | -             | 50,0<br>1.969 | 185,4<br>7.299 | 2       | 1             | PB              | 2,12<br>4.670  |
| EM34144013650  | 02503373 | BT40 ADB | G6   | 36,0<br>1.417 | 50,0<br>1.969  | 0,0<br>-       | -             | 63,0<br>2.480 | 115,4<br>4.543 | 2       | 0             | PB              | 1,13<br>2.490  |
| EM341440136120 | 02503374 | BT40 ADB | G6   | 36,0<br>1.417 | 120,0<br>4.724 | 0,0<br>-       | -             | 63,0<br>2.480 | 185,4<br>7.299 | 2       | 1             | PB              | 2,78<br>6.130  |
| EM341640114110 | 02503375 | BT50 ADB | G2   | 14,0<br>0.551 | 110,0<br>4.331 | 72,0<br>2.835  | -             | 25,0<br>0.984 | 211,8<br>8.339 | 2       | 1             | G6.3            | 3,7<br>8.160   |
| EM34164011845  | 02503376 | BT50 ADB | G3   | 18,0<br>0.709 | 45,0<br>1.772  | 7,0<br>0.276   | 70,0<br>2.756 | 32,0<br>1.260 | 146,8<br>5.780 | 1       | 1             | G6.3            | 3,58<br>7.890  |
| EM341640118120 | 02503377 | BT50 ADB | G3   | 18,0<br>0.709 | 120,0<br>4.724 | 82,0<br>3.228  | -             | 32,0<br>1.260 | 221,8<br>8.732 | 2       | 1             | G6.3            | 3,9<br>8.600   |
| EM34164012250  | 02503378 | BT50 ADB | G4   | 22,0<br>0.866 | 50,0<br>1.969  | 12,0<br>0.472  | 70,0<br>2.756 | 40,0<br>1.575 | 151,8<br>5.976 | 1       | 1             | G6.3            | 3,66<br>8.070  |
| EM341640122140 | 02503379 | BT50 ADB | G4   | 22,0<br>0.866 | 140,0<br>5.512 | 102,0<br>4.016 | -             | 40,0<br>1.575 | 241,8<br>9.520 | 2       | 1             | G6.3            | 4,5<br>9.920   |
| EM34164012855  | 02503380 | BT50 ADB | G5   | 28,0<br>1.102 | 55,0<br>2.165  | 17,0<br>0.669  | 98,0<br>3.858 | 50,0<br>1.969 | 156,8<br>6.173 | 1       | 1             | PB              | 4,0<br>8.820   |
| EM341640128100 | 02503381 | BT50 ADB | G5   | 28,0<br>1.102 | 100,0<br>3.937 | 62,0<br>2.441  | -             | 50,0<br>1.969 | 201,8<br>7.945 | 2       | 1             | PB              | 4,22<br>9.300  |
| EM341640128140 | 02503382 | BT50 ADB | G5   | 28,0<br>1.102 | 140,0<br>5.512 | 102,0<br>4.016 | -             | 50,0<br>1.969 | 241,8<br>9.520 | 2       | 1             | PB              | 4,8<br>10.580  |
| EM34164013663  | 02503383 | BT50 ADB | G6   | 36,0<br>1.417 | 63,0<br>2.480  | 25,0<br>0.984  | 98,0<br>3.858 | 63,0<br>2.480 | 164,8<br>6.488 | 1       | 1             | PB              | 4,2<br>9.260   |
| EM341640136100 | 02503384 | BT50 ADB | G6   | 36,0<br>1.417 | 100,0<br>3.937 | 62,0<br>2.441  | -             | 63,0<br>2.480 | 201,8<br>7.945 | 2       | 1             | PB              | 4,6<br>10.140  |
| EM341640136140 | 02503385 | BT50 ADB | G6   | 36,0<br>1.417 | 140,0<br>5.512 | 102,0<br>4.016 | -             | 63,0<br>2.480 | 241,8<br>9.520 | 2       | 1             | PB              | 5,54<br>12.210 |



| Megnevezés     | Cikkszám | CTMS     | CTWS | DCB           | LF             | LB             | BD1           | BD            | OAL             | Kivitel | RFID<br>furat | Egys.<br>faktor | Súly           |
|----------------|----------|----------|------|---------------|----------------|----------------|---------------|---------------|-----------------|---------|---------------|-----------------|----------------|
|                |          |          |      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch      |         |               |                 | kg<br>lbs      |
| EM34164014665  | 02503386 | BT50 ADB | G7   | 46,0<br>1.811 | 65,0<br>2.559  | 27,0<br>1.063  | 98,0<br>3.858 | 90,0<br>3.543 | 166,8<br>6.567  | 1       | 1             | PB              | 4,4<br>9.700   |
| EM341640146120 | 02503387 | BT50 ADB | G7   | 46,0<br>1.811 | 120,0<br>4.724 | 82,0<br>3.228  | –             | 90,0<br>3.543 | 221,8<br>8.732  | 2       | 1             | PB              | 6,8<br>14.990  |
| EM341640146200 | 02503388 | BT50 ADB | G7   | 46,0<br>1.811 | 200,0<br>7.874 | 162,0<br>6.378 | –             | 90,0<br>3.543 | 301,8<br>11.882 | 2       | 1             | PB              | 10,7<br>23.590 |

## Kiegészítők

| Kúp/méret | Rögzítő kulcs |
|-----------|---------------|
|           |               |
| 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         |

## Pótalkatrészek

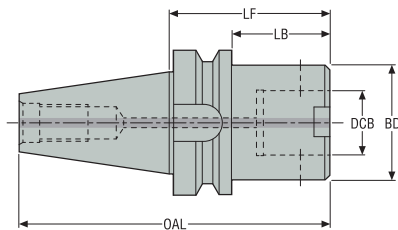
| Kúp/méret | Összeszerelő csavar | Tömítő csavar |
|-----------|---------------------|---------------|
|           |                     |               |
| BT40/ G1  | 90F1                | 950A0406      |
| BT40/ G2  | 90F2                | 950A0406      |
| BT40/ G3  | 90F3                | 950A0406      |
| 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® befogók

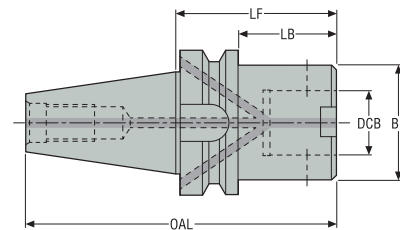
BT Taper-Face-AD/ADB



Diseño 1



Diseño 2



| Megnevezés     | Cikkszám | CTMS        | CTWS | DCB           | LF             | LB             | BD            | OAL             | Kivitel | RFID furat | Egys. faktor | Súly           |
|----------------|----------|-------------|------|---------------|----------------|----------------|---------------|-----------------|---------|------------|--------------|----------------|
|                |          |             |      | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch      |         |            |              | kg<br>lbs      |
| EM40024011850  | 02998757 | BT30 TF AD  | G3   | 18,0<br>0.709 | 50,0<br>1.969  | 28,0<br>1.102  | 32,0<br>1.260 | 98,4<br>3.874   | 1       | 0          | G6.3         | 0,5<br>1.100   |
| EM40024012250  | 02998758 | BT30 TF AD  | G4   | 22,0<br>0.866 | 50,0<br>1.969  | 28,0<br>1.102  | 40,0<br>1.575 | 98,4<br>3.874   | 1       | 0          | G6.3         | 0,6<br>1.320   |
| EM321440122100 | 02998754 | BT40 TF ADB | G4   | 22,0<br>0.866 | 100,0<br>3.937 | 73,0<br>2.874  | 40,0<br>1.575 | 165,4<br>6.512  | 2       | 1          | G6.3         | 1,6<br>3.530   |
| EM321440128120 | 02926006 | BT40 TF ADB | G5   | 28,0<br>1.102 | 120,0<br>4.724 | 93,0<br>3.661  | 50,0<br>1.969 | 185,4<br>7.299  | 2       | 1          | PB           | 2,1<br>4.630   |
| EM321440136120 | 02998755 | BT40 TF ADB | G6   | 36,0<br>1.417 | 120,0<br>4.724 | 93,0<br>3.661  | 63,0<br>2.480 | 185,4<br>7.299  | 2       | 1          | PB           | 2,8<br>6.170   |
| EM321640128140 | 02998756 | BT50 TF ADB | G5   | 28,0<br>1.102 | 140,0<br>5.512 | 102,0<br>4.016 | 50,0<br>1.969 | 241,8<br>9.520  | 2       | 1          | PB           | 4,9<br>10.800  |
| EM321640136140 | 02926009 | BT50 TF ADB | G6   | 36,0<br>1.417 | 140,0<br>5.512 | 102,0<br>4.016 | 63,0<br>2.480 | 241,8<br>9.520  | 2       | 1          | PB           | 5,6<br>12.350  |
| EM321640146200 | 02926010 | BT50 TF ADB | G7   | 46,0<br>1.811 | 200,0<br>7.874 | 162,0<br>6.378 | 90,0<br>3.543 | 301,8<br>11.882 | 2       | 1          | PB           | 10,7<br>23.590 |

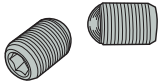

### Kiegészítők

| Megnevezés     | Rögzítő kulcs |
|----------------|---------------|
| EM40024011850  | 03H03         |
| EM40024012250  | 03H04         |
| EM321440122100 | 03H04         |
| EM321440128120 | 03H05         |
| EM321440136120 | 03H06         |
| EM321640128140 | 03H05         |
| EM321640136140 | 03H06         |
| EM321640146200 | 03H10         |

Rögzítő kulcs



## Pótalkatrészek

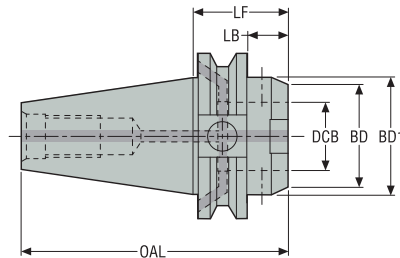
| Megnevezés     | Összeszerelő csavar   | Tömítő csavar   |
|----------------|---|---|
|                |  |  |
| EM40024011850  | 90F3  | -   |
| EM40024012250  | 90F4  | -   |
| EM321440122100 | 90F4  | 950A0406  |
| EM321440128120 | 90F5  | 950A0406  |
| EM321440136120 | 90F6  | 950A0406  |
| EM321640128140 | 90F5  | 950A0606  |
| EM321640136140 | 90F6  | 950A0606  |
| EM321640146200 | 90F7  | 950A0606  |

## G 401 – Graflex® befogók

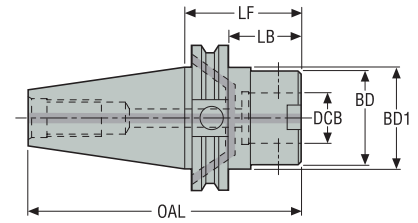
CAT / ASME B5.50-1994-ADB



Diseño 1



Diseño 2



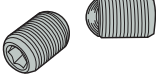

| Megnevezés     | Cikkszám | CTMS      | CTWS | DCB         | LF          | LB          | BD1         | BD          | OAL         | Kivitel | RFID furat | Egys. faktor | Súly       |
|----------------|----------|-----------|------|-------------|-------------|-------------|-------------|-------------|-------------|---------|------------|--------------|------------|
|                |          |           |      | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> |         |            |              | <i>lbs</i> |
| 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     |

### Kiegészítők

| Kúp/méret | Rögzítő kulcs |
|-----------|---------------|
| 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         |

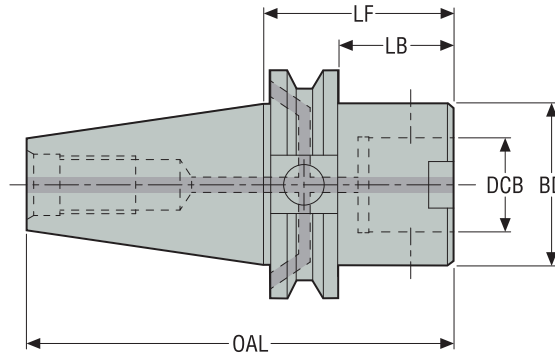


## Pótalkatrészek

| Kúp/méret | Összeszerelő csavar   | Tömítő csavar   |
|-----------|---|---|
|           |  |  |
| 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® befogók

CAT TF / ASME B5.50-2009-ADB

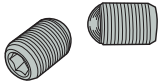



| Megnevezés     | Cikkszám | CTMS         | CTWS | DCB   | LF    | LB    | BD    | OAL    | Kívitel | RFID furat | Egys. faktor | Súly   |
|----------------|----------|--------------|------|-------|-------|-------|-------|--------|---------|------------|--------------|--------|
|                |          |              |      | Inch  | Inch  | Inch  | Inch  | Inch   |         |            |              | 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 |

### Kiegészítők

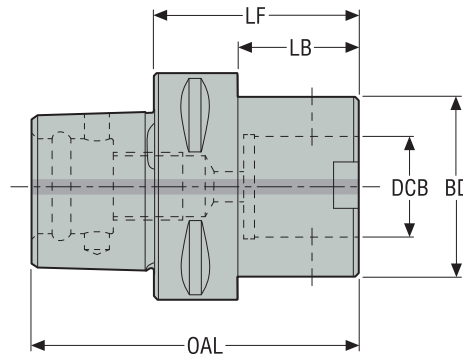
| Megnevezés     | Rögzítő kulcs   |
|----------------|---|
|                |  |
| EM26424011880  | 03H03   |
| EM26424012280  | 03H04   |
| EM264240128100 | 03H05   |
| EM264240136100 | 03H06   |
| EM264440122100 | 03H04   |
| EM264440128100 | 03H05   |
| EM264440136120 | 03H06   |
| EM264440146200 | 03H10   |

## Pótalkatrészek

| Megnevezés     | Összeszerelő csavar   | Tömítő csavar   |
|----------------|---|---|
|                |  |  |
| 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® adapterek


Seco-Capto™



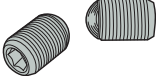
| Megnevezés        | Cikkszám | CTMS | CTWS | DCB           | LF            | LB            | BD            | OAL            | RFID<br>furat | Egys.<br>faktor | Súly          |
|-------------------|----------|------|------|---------------|---------------|---------------|---------------|----------------|---------------|-----------------|---------------|
|                   |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |               |                 | kg<br>lbs     |
| C3-391.0401-08025 | 02532939 | C3   | G0   | 8,0<br>0.315  | 25,0<br>0.984 | 7,0<br>0.276  | 16,0<br>0.630 | 44,0<br>1.732  | 0             | G6.3            | 0,14<br>0.310 |
| C3-391.0401-11025 | 02532940 | C3   | G1   | 11,0<br>0.433 | 25,0<br>0.984 | 7,0<br>0.276  | 20,0<br>0.787 | 44,0<br>1.732  | 0             | G6.3            | 0,14<br>0.310 |
| C3-391.0401-14025 | 02532941 | C3   | G2   | 14,0<br>0.551 | 25,0<br>0.984 | 7,0<br>0.276  | 25,0<br>0.984 | 44,0<br>1.732  | 0             | G6.3            | 0,15<br>0.330 |
| C3-391.0401-18030 | 02532942 | C3   | G3   | 18,0<br>0.709 | 30,0<br>1.181 | 0,0<br>-      | 32,0<br>1.260 | 49,0<br>1.929  | 0             | G6.3            | 0,16<br>0.350 |
| C4-391.0401-18035 | 02532943 | C4   | G3   | 18,0<br>0.709 | 35,0<br>1.378 | 12,0<br>0.472 | 32,0<br>1.260 | 59,0<br>2.323  | 0             | G6.3            | 0,31<br>0.680 |
| C4-391.0401-22035 | 02532944 | C4   | G4   | 22,0<br>0.866 | 35,0<br>1.378 | 0,0<br>-      | 40,0<br>1.575 | 59,0<br>2.323  | 0             | G6.3            | 0,31<br>0.680 |
| C5-391.0401-14030 | 02532945 | C5   | G2   | 14,0<br>0.551 | 30,0<br>1.181 | 7,0<br>0.276  | 25,0<br>0.984 | 60,0<br>2.362  | 1             | G6.3            | 0,47<br>1.040 |
| C5-391.0401-18035 | 02532947 | C5   | G3   | 18,0<br>0.709 | 35,0<br>1.378 | 12,0<br>0.472 | 32,0<br>1.260 | 65,0<br>2.559  | 1             | G6.3            | 0,47<br>1.040 |
| C5-391.0401-22035 | 02532948 | C5   | G4   | 22,0<br>0.866 | 35,0<br>1.378 | 12,0<br>0.472 | 40,0<br>1.575 | 65,0<br>2.559  | 1             | G6.3            | 0,51<br>1.120 |
| C5-391.0401-28045 | 02532949 | C5   | G5   | 28,0<br>1.102 | 45,0<br>1.772 | 22,0<br>0.866 | 50,0<br>1.969 | 75,0<br>2.953  | 1             | PB              | 0,64<br>1.410 |
| C6-391.0401-18035 | 02532950 | C6   | G3   | 18,0<br>0.709 | 35,0<br>1.378 | 10,0<br>0.394 | 32,0<br>1.260 | 73,0<br>2.874  | 1             | G6.3            | 0,84<br>1.850 |
| C6-391.0401-22040 | 02532951 | C6   | G4   | 22,0<br>0.866 | 40,0<br>1.575 | 15,0<br>0.591 | 40,0<br>1.575 | 78,0<br>3.071  | 1             | G6.3            | 0,89<br>1.960 |
| C6-391.0401-28050 | 02532952 | C6   | G5   | 28,0<br>1.102 | 50,0<br>1.969 | 25,0<br>0.984 | 50,0<br>1.969 | 88,0<br>3.465  | 1             | PB              | 1,04<br>2.290 |
| C6-391.0401-36055 | 02532953 | C6   | G6   | 36,0<br>1.417 | 55,0<br>2.165 | 0,0<br>-      | 63,0<br>2.480 | 93,0<br>3.661  | 1             | PB              | 1,19<br>2.620 |
| C8-391.0401-28050 | 02532954 | C8   | G5   | 28,0<br>1.102 | 50,0<br>1.969 | 17,0<br>0.669 | 50,0<br>1.969 | 98,0<br>3.858  | 1             | PB              | 1,92<br>4.230 |
| C8-391.0401-36055 | 02532955 | C8   | G6   | 36,0<br>1.417 | 55,0<br>2.165 | 22,0<br>0.866 | 63,0<br>2.480 | 103,0<br>4.055 | 1             | PB              | 2,02<br>4.450 |
| C8-391.0401-46065 | 02532956 | C8   | G7   | 46,0<br>1.811 | 65,0<br>2.559 | 35,0<br>1.378 | 90,0<br>3.543 | 113,0<br>4.449 | 1             | PB              | 2,71<br>5.970 |



## Kiegészítők

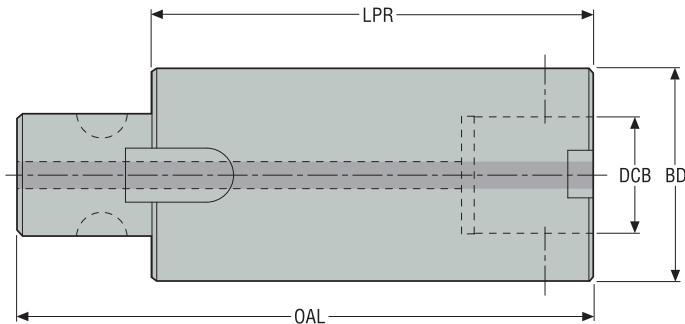
| Méret | Rögzítő kulcs   |
|-------|---|
|       |  |
| G0    | 03H02   |
| G1    | 03H02   |
| G2    | 03H025  |
| G3    | 03H03   |
| G4    | 03H04   |
| G5    | 03H05   |
| G6    | 03H06   |
| G7    | 03H10   |

## Pótalkatrészek

| Méret | Összeszerelő csavar   |
|-------|---|
|       |  |
| G0    | 90F0  |
| G1    | 90F1  |
| G2    | 90F2  |
| G3    | 90F3  |
| G4    | 90F4  |
| G5    | 90F5  |
| G6    | 90F6  |
| G7    | 90F7  |

## G 402 – Graflex® hosszabbítók


Graflex®



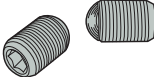

| Megnevezés | Cikkszám | CTMS | CTWS | LPR             | DCB           | BD            | OAL             | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|-----------------|---------------|---------------|-----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch      |            |              | kg<br>lbs     |
| M402000    | 00056752 | G0   | G0   | 30,0<br>1.181   | 8,0<br>0.315  | 16,0<br>0.630 | 42,0<br>1.654   | 0          | PB           | 0,05<br>0.110 |
| M402001    | 00056753 | G0   | G0   | 50,0<br>1.969   | 8,0<br>0.315  | 16,0<br>0.630 | 62,0<br>2.441   | 0          | PB           | 0,08<br>0.180 |
| M402110    | 00056754 | G1   | G1   | 30,0<br>1.181   | 11,0<br>0.433 | 20,0<br>0.787 | 43,0<br>1.693   | 0          | PB           | 0,07<br>0.150 |
| M402111    | 00056755 | G1   | G1   | 50,0<br>1.969   | 11,0<br>0.433 | 20,0<br>0.787 | 63,0<br>2.480   | 0          | PB           | 0,12<br>0.260 |
| M402220    | 00056756 | G2   | G2   | 30,0<br>1.181   | 14,0<br>0.551 | 25,0<br>0.984 | 46,0<br>1.811   | 0          | PB           | 0,11<br>0.240 |
| M402221    | 00056757 | G2   | G2   | 50,0<br>1.969   | 14,0<br>0.551 | 25,0<br>0.984 | 66,0<br>2.598   | 0          | PB           | 0,18<br>0.400 |
| M402330    | 00056758 | G3   | G3   | 40,0<br>1.575   | 18,0<br>0.709 | 32,0<br>1.260 | 60,0<br>2.362   | 0          | PB           | 0,24<br>0.530 |
| M402331    | 75056759 | G3   | G3   | 60,0<br>2.362   | 18,0<br>0.709 | 32,0<br>1.260 | 80,0<br>3.150   | 0          | PB           | 0,36<br>0.790 |
| M402440    | 00056760 | G4   | G4   | 40,0<br>1.575   | 22,0<br>0.866 | 40,0<br>1.575 | 64,0<br>2.520   | 0          | PB           | 0,37<br>0.820 |
| M402441    | 00056761 | G4   | G4   | 60,0<br>2.362   | 22,0<br>0.866 | 40,0<br>1.575 | 84,0<br>3.307   | 0          | PB           | 0,57<br>1.260 |
| M402444    | 02786252 | G4   | G4   | 200,0<br>7.874  | 22,0<br>0.866 | 40,0<br>1.575 | 224,0<br>8.819  | 0          | PB           | 1,95<br>4.300 |
| M402550    | 00056762 | G5   | G5   | 50,0<br>1.969   | 28,0<br>1.102 | 50,0<br>1.969 | 80,0<br>3.150   | 0          | PB           | 0,72<br>1.590 |
| M402551    | 00056763 | G5   | G5   | 75,0<br>2.953   | 28,0<br>1.102 | 50,0<br>1.969 | 105,0<br>4.134  | 0          | PB           | 1,12<br>2.470 |
| M402552    | 00056764 | G5   | G5   | 100,0<br>3.937  | 28,0<br>1.102 | 50,0<br>1.969 | 130,0<br>5.118  | 0          | PB           | 1,48<br>3.260 |
| M402554    | 02786254 | G5   | G5   | 250,0<br>9.843  | 28,0<br>1.102 | 50,0<br>1.969 | 280,0<br>11.024 | 0          | PB           | 3,9<br>8.600  |
| M402660    | 00056765 | G6   | G6   | 60,0<br>2.362   | 36,0<br>1.417 | 63,0<br>2.480 | 100,0<br>3.937  | 0          | PB           | 1,38<br>3.040 |
| M402661    | 00056766 | G6   | G6   | 90,0<br>3.543   | 36,0<br>1.417 | 63,0<br>2.480 | 130,0<br>5.118  | 0          | PB           | 2,1<br>4.630  |
| M402662    | 00056767 | G6   | G6   | 120,0<br>4.724  | 36,0<br>1.417 | 63,0<br>2.480 | 160,0<br>6.299  | 0          | PB           | 2,82<br>6.220 |
| M402664    | 02786255 | G6   | G6   | 300,0<br>11.811 | 36,0<br>1.417 | 63,0<br>2.480 | 340,0<br>13.386 | 0          | PB           | 7,2<br>15.870 |
| M402770    | 00056768 | G7   | G7   | 60,0<br>2.362   | 46,0<br>1.811 | 90,0<br>3.543 | 110,0<br>4.331  | 0          | -            | 2,9<br>6.390  |
| M402771    | 00056769 | G7   | G7   | 90,0<br>3.543   | 46,0<br>1.811 | 90,0<br>3.543 | 140,0<br>5.512  | 0          | -            | 4,03<br>8.880 |

| Megnevezés | Cikkszám | CTMS | CTWS | LPR             | DCB           | BD            | OAL             | RFID furat | Egys. faktor | Súly           |
|------------|----------|------|------|-----------------|---------------|---------------|-----------------|------------|--------------|----------------|
|            |          |      |      | mm<br>Inch      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch      |            |              | kg<br>lbs      |
| M402772    | 00056770 | G7   | G7   | 120,0<br>4.724  | 46,0<br>1.811 | 90,0<br>3.543 | 170,0<br>6.693  | 0          | -            | 5,8<br>12.790  |
| M402774    | 02786257 | G7   | G7   | 300,0<br>11.811 | 46,0<br>1.811 | 90,0<br>3.543 | 350,0<br>13.780 | 0          | -            | 14,6<br>32.190 |

## Kiegészítők

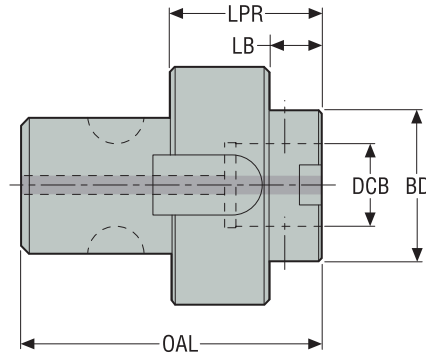
| Méret | Rögzítő kulcs   |
|-------|---|
|       |  |
| G0    | 03H02   |
| G1    | 03H02   |
| G2    | 03H025  |
| G3    | 03H03   |
| G4    | 03H04   |
| G5    | 03H05   |
| G6    | 03H06   |
| G7    | 03H10   |

## Pótalkatrészek

| Méret | Összeszerelő csavar   | Retesz  |
|-------|---|---|
|       |  |  |
| 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® csökkentők

Graflex®




| Megnevezés | Cikkszám | CTMS | CTWS | LPR           | LB            | DCB           | BD            | OAL            | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|---------------|---------------|---------------|---------------|----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs     |
| M40310     | 00056771 | G1   | G0   | 30,0<br>1.181 | 22,0<br>0.866 | 8,0<br>0.315  | 16,0<br>0.630 | 43,0<br>1.693  | 0          | PB           | 0,06<br>0.130 |
| M40320     | 00056772 | G2   | G0   | 30,0<br>1.181 | 19,0<br>0.748 | 8,0<br>0.315  | 16,0<br>0.630 | 46,0<br>1.811  | 0          | PB           | 0,08<br>0.180 |
| M40321     | 00056773 | G2   | G1   | 30,0<br>1.181 | 19,0<br>0.748 | 11,0<br>0.433 | 20,0<br>0.787 | 46,0<br>1.811  | 0          | PB           | 0,1<br>0.220  |
| M40330     | 00056774 | G3   | G0   | 30,0<br>1.181 | 16,0<br>0.630 | 8,0<br>0.315  | 16,0<br>0.630 | 50,0<br>1.969  | 0          | PB           | 0,15<br>0.330 |
| M40331     | 00056775 | G3   | G1   | 30,0<br>1.181 | 16,0<br>0.630 | 11,0<br>0.433 | 20,0<br>0.787 | 50,0<br>1.969  | 0          | PB           | 0,15<br>0.330 |
| M40332     | 00056776 | G3   | G2   | 30,0<br>1.181 | 16,0<br>0.630 | 14,0<br>0.551 | 25,0<br>0.984 | 50,0<br>1.969  | 0          | PB           | 0,16<br>0.350 |
| M40341     | 00056778 | G4   | G1   | 30,0<br>1.181 | 13,0<br>0.512 | 11,0<br>0.433 | 20,0<br>0.787 | 54,0<br>2.126  | 0          | PB           | 0,25<br>0.550 |
| M40342     | 00056779 | G4   | G2   | 30,0<br>1.181 | 13,0<br>0.512 | 14,0<br>0.551 | 25,0<br>0.984 | 54,0<br>2.126  | 0          | PB           | 0,27<br>0.600 |
| M40343     | 00056780 | G4   | G3   | 30,0<br>1.181 | 13,0<br>0.512 | 18,0<br>0.709 | 32,0<br>1.260 | 54,0<br>2.126  | 0          | PB           | 0,27<br>0.600 |
| M40350     | 00056781 | G5   | G0   | 40,0<br>1.575 | 20,0<br>0.787 | 8,0<br>0.315  | 16,0<br>0.630 | 70,0<br>2.756  | 0          | PB           | 0,47<br>1.040 |
| M40351     | 00056783 | G5   | G1   | 40,0<br>1.575 | 20,0<br>0.787 | 11,0<br>0.433 | 20,0<br>0.787 | 70,0<br>2.756  | 0          | PB           | 0,49<br>1.080 |
| M40352     | 00056785 | G5   | G2   | 40,0<br>1.575 | 20,0<br>0.787 | 14,0<br>0.551 | 25,0<br>0.984 | 70,0<br>2.756  | 0          | PB           | 0,49<br>1.080 |
| M40353     | 00056787 | G5   | G3   | 40,0<br>1.575 | 20,0<br>0.787 | 18,0<br>0.709 | 32,0<br>1.260 | 70,0<br>2.756  | 0          | PB           | 0,52<br>1.150 |
| M40354     | 00056789 | G5   | G4   | 40,0<br>1.575 | 20,0<br>0.787 | 22,0<br>0.866 | 40,0<br>1.575 | 70,0<br>2.756  | 0          | PB           | 0,55<br>1.210 |
| M40363     | 00056797 | G6   | G3   | 40,0<br>1.575 | 14,0<br>0.551 | 18,0<br>0.709 | 32,0<br>1.260 | 80,0<br>3.150  | 0          | PB           | 0,98<br>2.160 |
| M40364     | 00056799 | G6   | G4   | 40,0<br>1.575 | 14,0<br>0.551 | 22,0<br>0.866 | 40,0<br>1.575 | 80,0<br>3.150  | 0          | PB           | 0,97<br>2.140 |
| M40365     | 00056807 | G6   | G5   | 45,0<br>1.772 | 19,0<br>0.748 | 28,0<br>1.102 | 50,0<br>1.969 | 85,0<br>3.346  | 0          | PB           | 1,04<br>2.290 |
| M40375     | 00056811 | G7   | G5   | 50,0<br>1.969 | 24,0<br>0.945 | 28,0<br>1.102 | 50,0<br>1.969 | 100,0<br>3.937 | 0          | -            | 2,08<br>4.590 |
| M40376     | 00056812 | G7   | G6   | 55,0<br>2.165 | 29,0<br>1.142 | 36,0<br>1.417 | 63,0<br>2.480 | 105,0<br>4.134 | 0          | -            | 2,23<br>4.920 |

## Kiegészítők

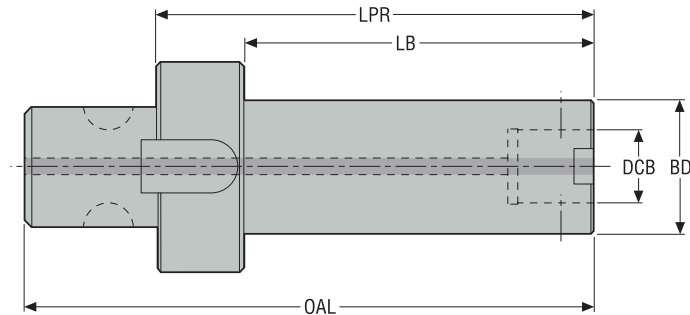
| Méret  | Rögzítő kulcs   |
|--------|---|
|        |  |
| M40310 | 03H02   |
| M40320 | 03H02   |
| M40321 | 03H02   |
| M40330 | 03H02   |
| M40331 | 03H02   |
| M40332 | 03H025  |
| M40341 | 03H02   |
| M40342 | 03H025  |
| M40343 | 03H03   |
| M40350 | 03H02   |
| M40351 | 03H02   |
| M40352 | 03H025  |
| M40353 | 03H03   |
| M40354 | 03H04   |
| M40363 | 03H03   |
| M40364 | 03H04   |
| M40365 | 03H05   |
| M40375 | 03H05   |
| M40376 | 03H06   |

## Pótalkatrészek

| Méret  | Összeszerelő csavar   | Retesz  |
|--------|---|---|
|        |  |  |
| 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® hosszú csökkentők

Graflex®



| Megnevezés | Cikkszám | CTMS | CTWS | LPR            | LB             | DCB           | BD            | OAL            | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|----------------|----------------|---------------|---------------|----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs     |
| M40350070  | 00056782 | G5   | G0   | 70,0<br>2.756  | 50,0<br>1.969  | 8,0<br>0.315  | 16,0<br>0.630 | 100,0<br>3.937 | 0          | PB           | 0,51<br>1.120 |
| M40351080  | 00056784 | G5   | G1   | 80,0<br>3.150  | 60,0<br>2.362  | 11,0<br>0.433 | 20,0<br>0.787 | 110,0<br>4.331 | 0          | PB           | 0,57<br>1.260 |
| M40352100  | 00056786 | G5   | G2   | 100,0<br>3.937 | 80,0<br>3.150  | 14,0<br>0.551 | 25,0<br>0.984 | 130,0<br>5.118 | 0          | PB           | 0,71<br>1.570 |
| M40353120  | 00056788 | G5   | G3   | 120,0<br>4.724 | 100,0<br>3.937 | 18,0<br>0.709 | 32,0<br>1.260 | 150,0<br>5.906 | 0          | PB           | 1,02<br>2.250 |
| M40354150  | 00056790 | G5   | G4   | 150,0<br>5.906 | 130,0<br>5.118 | 22,0<br>0.866 | 40,0<br>1.575 | 180,0<br>7.087 | 0          | PB           | 1,62<br>3.570 |
| M40361090  | 00056794 | G6   | G1   | 90,0<br>3.543  | 64,0<br>2.520  | 11,0<br>0.433 | 20,0<br>0.787 | 130,0<br>5.118 | 0          | PB           | 1,08<br>2.380 |
| M40362110  | 00056796 | G6   | G2   | 110,0<br>4.331 | 84,0<br>3.307  | 14,0<br>0.551 | 25,0<br>0.984 | 150,0<br>5.906 | 0          | PB           | 1,23<br>2.710 |
| M40363120  | 00056798 | G6   | G3   | 120,0<br>4.724 | 94,0<br>3.701  | 18,0<br>0.709 | 32,0<br>1.260 | 160,0<br>6.299 | 0          | PB           | 1,46<br>3.220 |
| M40364150  | 00056800 | G6   | G4   | 150,0<br>5.906 | 124,0<br>4.882 | 22,0<br>0.866 | 40,0<br>1.575 | 190,0<br>7.480 | 0          | PB           | 2,07<br>4.560 |
| M40365190  | 00056808 | G6   | G5   | 190,0<br>7.480 | 164,0<br>6.457 | 28,0<br>1.102 | 50,0<br>1.969 | 230,0<br>9.055 | 0          | PB           | 3,2<br>7.050  |

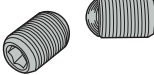

### Kiegészítők

| Megnevezés | Rögzítő kulcs |
|------------|---------------|
| M40350070  | 03H02         |
| M40351080  | 03H02         |
| M40352100  | 03H025        |
| M40353120  | 03H03         |
| M40354150  | 03H04         |
| M40361090  | 03H02         |
| M40362110  | 03H025        |
| M40363120  | 03H03         |
| M40364150  | 03H04         |
| M40365190  | 03H05         |

Rögzítő kulcs



Pótalkatrészek

| Megnevezés | Összeszerelő csavar   | Retesz  |
|------------|---|---|
|            |  |  |
| 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  |

Bevezetés

Fűrés

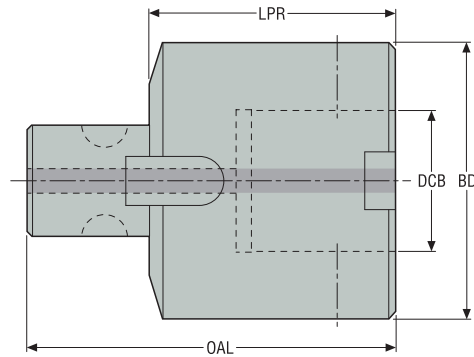
Dörzsárazás

Kiesztergálás

Melléklet

## G 403 – Graflex® nagyobbítók

Graflex®



| Megnevezés | Cikkszám | CTMS | CTWS | LPR           | DCB           | BD            | OAL            | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|---------------|---------------|---------------|----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs     |
| M40356     | 00056791 | G5   | G6   | 55,0<br>2.165 | 36,0<br>1.417 | 63,0<br>2.480 | 85,0<br>3.346  | 0          | PB           | 1,08<br>2.380 |
| M40367     | 00056810 | G6   | G7   | 80,0<br>3.150 | 46,0<br>1.811 | 90,0<br>3.543 | 120,0<br>4.724 | 0          | PB           | 3,46<br>7.630 |

### Kiegészítők

| Megnevezés | Rögzítő kulcs |
|------------|---------------|
| M40356     | 03H06         |
| M40367     | 03H10         |

### Pótalkatrészek

| Megnevezés | Összeszerelő csavar | Retesz |
|------------|---------------------|--------|
| M40356     | 90F6                | 90M5   |
| M40367     | 90F7                | 90M6   |

Bevezetés

Fúrás

Dörzsárazás

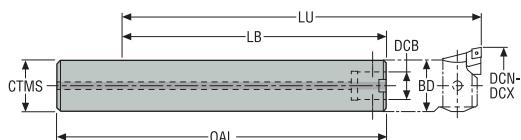
Kiesztergálás

Melléklet



## G 401 – Graflex® befogók, acél

Hengeres



- Alkalmos simító kiesztergáláshoz egészen LU kiesztergálási mélységig a bevelő A780 vagy A790 típusú kiesztergáló fejekkel
- Hengeres szár, CTMS h5-ös tőrésel, kompatibilis a Shrinkfit-hez

| Megnevezés | Cikkszám | CTMS | CTWS | DCB           | DCN           | DCX           | OAL            | BD            | LU             | LB             | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|---------------|---------------|---------------|----------------|---------------|----------------|----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     |            |              | kg<br>lbs     |
| M4011408   | 00086938 | 14   | G0   | 8,0<br>0.315  | 15,0<br>0.591 | 18,5<br>0.728 | 120,0<br>4.724 | 14,0<br>0.551 | 110,0<br>4.331 | 75,0<br>2.953  | 0          | G6.3         | 0,12<br>0.260 |
| M4011608   | 00086935 | 16   | G0   | 8,0<br>0.315  | 18,0<br>0.709 | 23,5<br>0.925 | 150,0<br>5.906 | 16,0<br>0.630 | 137,0<br>5.394 | 102,0<br>4.016 | 0          | G6.3         | 0,2<br>0.440  |
| M4012011   | 00086936 | 20   | G1   | 11,0<br>0.433 | 23,0<br>0.906 | 31,0<br>1.220 | 150,0<br>5.906 | 20,0<br>0.787 | 140,0<br>5.512 | 100,0<br>3.937 | 0          | G6.3         | 0,33<br>0.730 |
| M4012514   | 00086937 | 25   | G2   | 14,0<br>0.551 | 30,0<br>1.181 | 40,0<br>1.575 | 150,0<br>5.906 | 25,0<br>0.984 | 139,0<br>5.472 | 93,0<br>3.661  | 0          | G6.3         | 0,53<br>1.170 |
| M4013218   | 00086939 | 32   | G3   | 18,0<br>0.709 | 39,0<br>1.535 | 51,0<br>2.008 | 150,0<br>5.906 | 32,0<br>1.260 | 155,0<br>6.102 | 90,0<br>3.543  | 0          | G6.3         | 0,87<br>1.920 |

### Pótalkatrészek

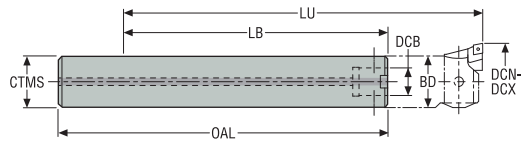
| Megnevezés | Összeszerelő csavar |
|------------|---------------------|
| M4011408   | 90F01               |
| M4011608   | 90F0                |
| M4012011   | 90F1                |
| M4012514   | 90F2                |
| M4013218   | 90F3                |

### Kiegészítők

| Megnevezés | Rögzítő kulcs |
|------------|---------------|
| M4011408   | 03H025        |
| M4011608   | 03H02         |
| M4012011   | 03H02         |
| M4012514   | 03H025        |
| M4013218   | 03H03         |

## G 401 – Graflex® befogók, acél

Hengeres



- Alkalmos simító kiesztergáláshoz egészen LU kiesztergálási mélységig a bevaló A780 vagy A790 típusú kiesztergáló fejekkel
- Hengeres szár, CTMS h5-ös tőrésel, kompatibilis a Shrinkfit-hez

| Megnevezés | Cikkszám | CTMS        | CTWS | DCB         | DCN         | DCX         | OAL         | BD          | LU          | LB          | RFID furat | Egys. faktor | Súly       |
|------------|----------|-------------|------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|------------|--------------|------------|
|            |          | <i>Inch</i> |      | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> |            |              | <i>lbs</i> |
| M40107511  | 00056741 | 0.750       | G1   | 0.433       | 0.906       | 1.220       | 5.906       | 0.827       | 5.510       | 3.906       | 0          | G6.3         | 0.640      |

### Pótalkatrészek

| Megnevezés | Összeszerelő csavar | Rögzítő kulcs |
|------------|---------------------|---------------|
| M40107511  | <br>90F1            | <br>03H02     |

Bevezetés

Fűrés

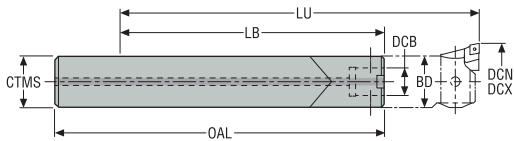
Dörzsárazás

Kiesztergálás

Melléklet

## G 401 – Graflex® befogók, keményfém

Hengeres



- Alkalmos simító kiesztergáláshoz egészen LU kiesztergálási mélységig a beleváló A780 vagy A790 típusú kiesztergáló fejekkel
- CTMS tűrés h5

| Megnevezés | Cikkszám | CTMS | CTWS | DCB           | DCN           | DCX           | OAL             | BD            | LU              | LB              | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|---------------|---------------|---------------|-----------------|---------------|-----------------|-----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch      | mm<br>Inch    | mm<br>Inch      | mm<br>Inch      |            |              |               |
| M4011408C  | 00073004 | 14   | G0   | 8,0<br>0.315  | 15,0<br>0.591 | 18,5<br>0.728 | 152,0<br>5.984  | 14,0<br>0.551 | 140,0<br>5.512  | 105,0<br>4.134  | 0          | G6.3         | 0,31<br>0.680 |
| M4011608C  | 00056747 | 16   | G0   | 8,0<br>0.315  | 18,0<br>0.709 | 23,5<br>0.925 | 175,0<br>6.890  | 16,0<br>0.630 | 160,0<br>6.299  | 125,0<br>4.921  | 0          | G6.3         | 0,47<br>1.040 |
| M4012011C  | 00056749 | 20   | G1   | 11,0<br>0.433 | 23,0<br>0.906 | 31,0<br>1.220 | 212,0<br>8.346  | 20,0<br>0.787 | 200,0<br>7.874  | 160,0<br>6.299  | 0          | G6.3         | 0,89<br>1.960 |
| M4012514C  | 00056750 | 25   | G2   | 14,0<br>0.551 | 30,0<br>1.181 | 40,0<br>1.575 | 262,0<br>10.315 | 25,0<br>0.984 | 250,0<br>9.843  | 204,0<br>8.031  | 0          | G6.3         | 1,71<br>3.770 |
| M4013218C  | 00056751 | 32   | G3   | 18,0<br>0.709 | 39,0<br>1.535 | 51,0<br>2.008 | 317,0<br>12.480 | 32,0<br>1.260 | 320,0<br>12.598 | 255,0<br>10.039 | 0          | G6.3         | 3,44<br>7.580 |

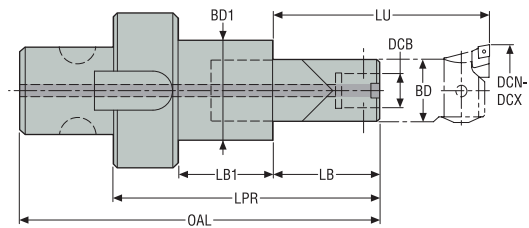
### Pótalkatrészek

| Megnevezés | Összeszerelő csavar |
|------------|---------------------|
|            |                     |
| M4011408C  | 90F01               |
| M4011608C  | 90F0                |
| M4012011C  | 90F1                |
| M4012514C  | 90F2                |
| M4013218C  | 90F3                |

### Kiegészítők

| Megnevezés | Rögzítő kulcs |
|------------|---------------|
|            |               |
| M4011408C  | 03H025        |
| M4011608C  | 03H02         |
| M4012011C  | 03H02         |
| M4012514C  | 03H025        |
| M4013218C  | 03H03         |

## G 403 – Graflex® extra hosszú csökkentők, keményfém



- A hosszabbító keményfémből gyártott
- Alkalmas simító kiesztergáláshoz egészen LU kiesztergálási mélységig a beleváló A780 vagy A790 típusú kiesztergáló fejekkel

| Megnevezés | Cikkszám | CTMS | CTWS | DCB           | DCN           | DCX           | LPR            | LU             | BD            | BD1           | LB1           | LB             | OAL            | RFID furat | Egys. faktor | Súly          |
|------------|----------|------|------|---------------|---------------|---------------|----------------|----------------|---------------|---------------|---------------|----------------|----------------|------------|--------------|---------------|
|            |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     |            |              | kg<br>lbs     |
| M40350C150 | 00057604 | G5   | G0   | 8,0<br>0.315  | 18,0<br>0.709 | 23,5<br>0.925 | 150,0<br>5.906 | 130,0<br>5.118 | 16,0<br>0.630 | 32,0<br>1.260 | 35,0<br>1.378 | 95,0<br>3.740  | 180,0<br>7.087 | 0          | PB           | 1,0<br>2.200  |
| M40351C180 | 00056943 | G5   | G1   | 11,0<br>0.433 | 23,0<br>0.906 | 31,0<br>1.220 | 180,0<br>7.087 | 160,0<br>6.299 | 20,0<br>0.787 | 36,0<br>1.417 | 40,0<br>1.575 | 120,0<br>4.724 | 210,0<br>8.268 | 0          | PB           | 1,33<br>2.930 |
| M40352C220 | 00057605 | G5   | G2   | 14,0<br>0.551 | 30,0<br>1.181 | 40,0<br>1.575 | 220,0<br>8.661 | 200,0<br>7.874 | 25,0<br>0.984 | 41,0<br>1.614 | 45,0<br>1.772 | 155,0<br>6.102 | 250,0<br>9.843 | 0          | PB           | 2,01<br>4.430 |

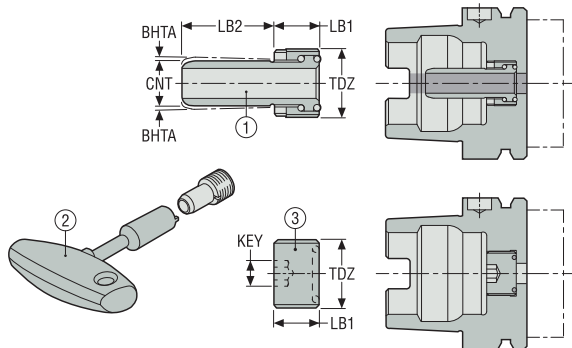
### Pótalkatrészek

| Megnevezés | Összeszerelő csavar | Retes |
|------------|---------------------|-------|
| M40350C150 | 90F0                | 90M5  |
| M40351C180 | 90F1                | 90M5  |
| M40352C220 | 90F2                | 90M5  |

### Kiegészítők

| Megnevezés | Rögzítő kulcs |
|------------|---------------|
| M40350C150 | 03H02         |
| M40351C180 | 03H02         |
| M40352C220 | 03H025        |

## HSK hűtőfolyadék-csövek, csőkulcsok és tömítődugók



- A HSK-A – Seco-Capto befogók cserealkatrészként elérhető speciális hűtőfolyadékcsövekkel vannak ellátva, és speciális hűtőfolyadék-csőkulcsot igényelnek, lásd az oldal(aka)t 530, 531-532, 533 old.

| Megnevezés             | Megnevezés                | Cikkszám | Befogók<br>HSK Form A és E | LB1               | LB2           | KEY           | CNT | TDZ     | BHTA° |
|------------------------|---------------------------|----------|----------------------------|-------------------|---------------|---------------|-----|---------|-------|
|                        |                           |          |                            | mm<br>Inch        | mm<br>Inch    | mm<br>Inch    | mm  |         |       |
| Hűtőfolyadék cső (1) * | 20E9301                   | 00088814 | HSK-A32 & HSK-E32          | 5,5<br>0.217      | 20,5<br>0.807 | -             | 6   | M10x1   | 1,0   |
|                        | 20E9302                   | 00088815 | HSK-A40 & HSK-E40          | 7,5<br>0.295      | 22,0<br>0.866 | -             | 8   | M12x1   | 1,0   |
|                        | 20E9303                   | 00086740 | HSK-A50 & HSK-E50          | 9,5<br>0.374      | 23,5<br>0.925 | -             | 6   | M16x1   | 1,0   |
|                        | 20E9304                   | 00086741 | HSK-A63 & HSK-E63          | 11,5<br>0.453     | 25,0<br>0.984 | -             | 8   | M18x1   | 1,0   |
|                        | 20E9306                   | 00086742 | HSK-A100 & HSK-E100        | 15,5<br>0.610     | 28,5<br>1.122 | -             | 6   | M24x1,5 | 1,0   |
|                        | 20E9307                   | 00088816 | HSK-A125                   | 17,5<br>0.689     | 30,5<br>1.201 | -             | 18  | M30x1,5 | 1,0   |
|                        | Hűtőfolyadék csőkulcs (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                   | -                 | -             | -             | -   | -       | -     |
| Tömítő dugó (3)        | 02E9301                   | 00031588 | HSK-A32 & HSK-E32          | 5,0<br>0.197      | -             | 3,0<br>0.118  | -   | M10x1   | -     |
|                        | 02E9302                   | 00031593 | HSK-A40 & HSK-E40          | 7,0<br>0.276      | -             | 4,0<br>0.157  | -   | M12x1   | -     |
|                        | 02E9303                   | 00001002 | HSK-A50 & HSK-E50          | 9,0<br>0.354      | -             | 5,0<br>0.197  | -   | M16x1   | -     |
|                        | 02E9304                   | 00010101 | HSK-A63 & HSK-E63          | 11,0<br>0.433     | -             | 6,0<br>0.236  | -   | M18x1   | -     |
|                        | 02E9306                   | 00014002 | HSK-A100 & HSK-E100        | 15,0<br>0.591     | -             | 10,0<br>0.394 | -   | M24x1,5 | -     |
|                        | 02E9307                   | 00033649 | HSK-A125                   | 17,0<br>0.669     | -             | 12,0<br>0.472 | -   | M30x1,5 | -     |



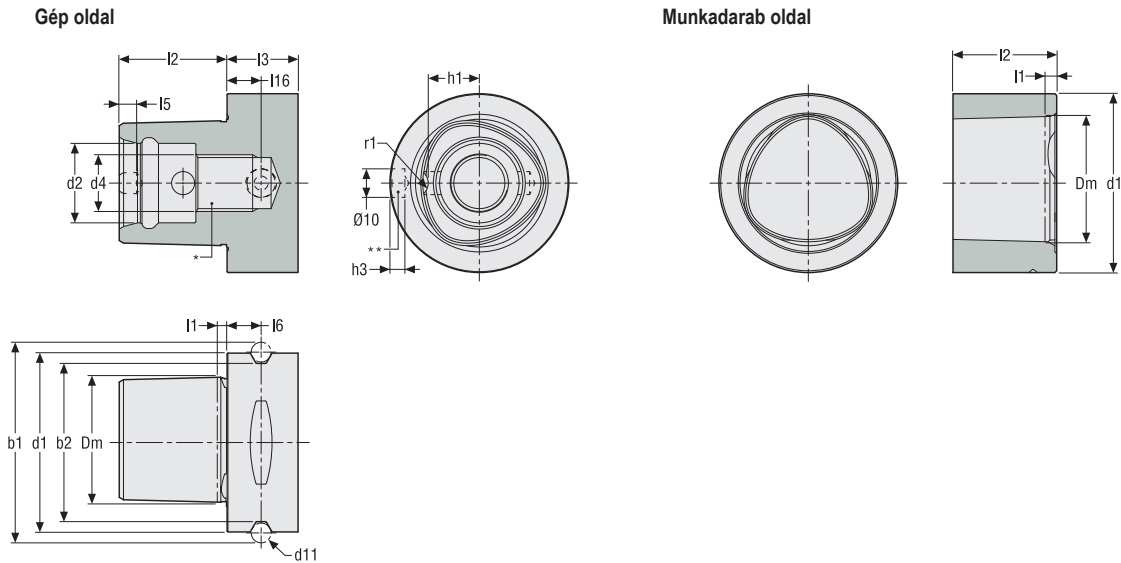
## Seco-Capto™

A Seco-Capto™ egy vezető, gyorsan cserélhető moduláris szerszámrendszer a vágóélbefogók gyors beállításához és cseréjéhez. A Seco-Capto™ moduláris szerszámrendszer ISO 26623 szerinti sokszög illesztőfelületet (Polygonal Shank Coupling – PSC) használ és önzáró kúpos csatlakozással rendelkezik.

- Szerszám befogók kínálata, például Shrinkfit, patronos befogó és marófej befogó
- Seco-Capto™ alaptüskék HSK, DIN, BT csatlakozással
- Seco-Capto™ kazetta a nagyobb megbízhatóság és lapka leszorítás érdekében

# Seco-Capto™, szabvány méretek

ISO 26623-1-PSC/ ISO 26623-2-PSC



| Géppoldali megnevezés | Furat az RFID számára** | d <sub>1</sub> | d <sub>2</sub> | d <sub>4</sub> | d <sub>11</sub> | Dm          | b <sub>1</sub> | b <sub>2</sub> | l <sub>1</sub> | l <sub>2</sub> | l <sub>3 min</sub> | l <sub>5</sub> | l <sub>6</sub> | l <sub>16</sub> | h <sub>1</sub> | h <sub>3</sub> | r <sub>1</sub> |
|-----------------------|-------------------------|----------------|----------------|----------------|-----------------|-------------|----------------|----------------|----------------|----------------|--------------------|----------------|----------------|-----------------|----------------|----------------|----------------|
|                       |                         | mm<br>Inch     | mm<br>Inch     |                | mm<br>Inch      | mm<br>Inch  | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch         | mm<br>Inch     | mm<br>Inch     | mm<br>Inch      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     |
| C3                    | Nem**                   | 32<br>1.260    | 15<br>0.591    | M12            | 5<br>0.197      | 22<br>0.866 | 39<br>1.535    | 28,3<br>1.114  | 2,5<br>0.098   | 19<br>0.748    | 15<br>0.591        | 3,2<br>0.126   | 6<br>0.236     | 9<br>0.354      | 9<br>0.354     | 5,4<br>0.213   | 3<br>0.118     |
| C4                    | Nem**                   | 40<br>1.575    | 18<br>0.709    | M14            | 5<br>0.197      | 28<br>1.102 | 46<br>1.811    | 35,3<br>1.390  | 2,5<br>0.098   | 24<br>0.945    | 20<br>0.787        | 4<br>0.157     | 8<br>0.315     | 12<br>0.472     | 11<br>0.433    | 5,2<br>0.205   | 3<br>0.118     |
| C5                    | **                      | 50<br>1.969    | 21<br>0.827    | M16            | 7<br>0.276      | 35<br>1.378 | 59,3<br>2.335  | 44,4<br>1.748  | 3<br>0.118     | 30<br>1.181    | 20<br>0.787        | 5,3<br>0.209   | 10<br>0.394    | 12<br>0.472     | 14<br>0.551    | 5,1<br>0.201   | 4<br>0.157     |
| C6                    | **                      | 63<br>2.480    | 28<br>1.102    | M20            | 7<br>0.276      | 44<br>1.732 | 70,7<br>2.783  | 55,8<br>2.197  | 3<br>0.118     | 38<br>1.496    | 22<br>0.866        | 6,2<br>0.244   | 12<br>0.472    | 12<br>0.472     | 18<br>0.709    | 5<br>0.197     | 5<br>0.197     |
| C8                    | **                      | 80<br>3.150    | 32<br>1.260    | M20            | 7<br>0.276      | 55<br>2.165 | 86<br>3.386    | 71,1<br>2.799  | 3<br>0.118     | 48<br>1.890    | 30<br>1.181        | 8<br>0.315     | 12<br>0.472    | 12<br>0.472     | 22,2<br>0.874  | 4,9<br>0.193   | 6<br>0.236     |

| Munkadarab oldali megnevezés | Furat az RFID számára** | d <sub>1 min</sub> | d <sub>3</sub> | Dm          | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> | l <sub>4</sub> |
|------------------------------|-------------------------|--------------------|----------------|-------------|----------------|----------------|----------------|----------------|
|                              |                         | mm<br>Inch         | mm<br>Inch     | mm<br>Inch  | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     | mm<br>Inch     |
| C3                           | Nem                     | 32<br>1.260        | 2<br>0.079     | 22<br>0.866 | 2,3<br>0.091   | 18,4<br>0.724  | 16,5<br>0.650  | 9,4<br>0.370   |
| C4                           | Nem                     | 40<br>1.575        | 2,5<br>0.098   | 28<br>1.102 | 2,3<br>0.091   | 23,4<br>0.921  | 21<br>0.827    | 11,5<br>0.453  |
| C5                           | Nem                     | 50<br>1.969        | 3<br>0.118     | 35<br>1.378 | 2,8<br>0.110   | 29,4<br>1.157  | 26<br>1.024    | 14,5<br>0.571  |
| C6                           | **                      | 63<br>2.480        | 4<br>0.157     | 44<br>1.732 | 2,8<br>0.110   | 37,4<br>1.472  | 33,5<br>1.319  | 18,5<br>0.728  |
| C8                           | **                      | 80<br>3.150        | 5<br>0.197     | 55<br>2.165 | 2,8<br>0.110   | 47,4<br>1.866  | 43<br>1.693    | 22,8<br>0.898  |

Bevezetés

Fúrás

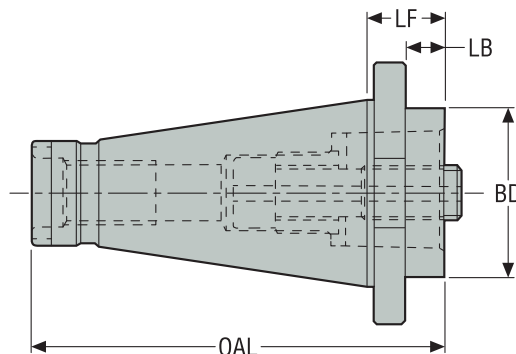
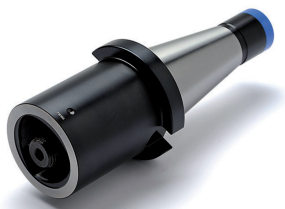
Dörzsálás

Kiesztorgálás

Melléklet

## C 00 – DIN 2080 a Seco-Capto™ befogókhhoz – ISO 26623-2

DIN 2080



| Megnevezés      | Cikkszám | CTMS        | CTWS | LF             | LB             | BD            | OAL            | RFID furat | Egys. faktor | Súly          |
|-----------------|----------|-------------|------|----------------|----------------|---------------|----------------|------------|--------------|---------------|
|                 |          |             |      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs     |
| C3-390.00-40030 | 75039844 | DIN(2080)40 | C3   | 30,0<br>1.181  | 18,4<br>0.724  | 32,0<br>1.260 | 123,4<br>4.858 | 0          | -            | 0,8<br>1.760  |
| C4-390.00-40030 | 75039848 | DIN(2080)40 | C4   | 30,0<br>1.181  | 18,4<br>0.724  | 40,0<br>1.575 | 123,4<br>4.858 | 0          | -            | 0,82<br>1.810 |
| C4-390.00-40060 | 75039849 | DIN(2080)40 | C4   | 60,0<br>2.362  | 48,4<br>1.906  | 40,0<br>1.575 | 153,4<br>6.039 | 0          | -            | 1,08<br>2.380 |
| C5-390.00-40030 | 75039852 | DIN(2080)40 | C5   | 30,0<br>1.181  | 18,4<br>0.724  | 50,0<br>1.969 | 123,4<br>4.858 | 0          | -            | 0,81<br>1.790 |
| C6-390.00-40075 | 00048158 | DIN(2080)40 | C6   | 75,0<br>2.953  | 0,0<br>-       | 63,0<br>2.480 | 168,4<br>6.630 | 0          | -            | 1,82<br>4.010 |
| C3-390.00-50030 | 75039846 | DIN(2080)50 | C3   | 30,0<br>1.181  | 14,8<br>0.583  | 32,0<br>1.260 | 156,8<br>6.173 | 0          | -            | 2,5<br>5.510  |
| C3-390.00-50060 | 75039847 | DIN(2080)50 | C3   | 60,0<br>2.362  | 44,8<br>1.764  | 32,0<br>1.260 | 186,8<br>7.354 | 0          | -            | 2,5<br>5.510  |
| C4-390.00-50030 | 75039850 | DIN(2080)50 | C4   | 30,0<br>1.181  | 14,8<br>0.583  | 40,0<br>1.575 | 156,8<br>6.173 | 0          | -            | 2,5<br>5.510  |
| C4-390.00-50060 | 75039851 | DIN(2080)50 | C4   | 60,0<br>2.362  | 44,8<br>1.764  | 40,0<br>1.575 | 186,8<br>7.354 | 0          | -            | 2,5<br>5.510  |
| C5-390.00-50030 | 75039854 | DIN(2080)50 | C5   | 30,0<br>1.181  | 14,8<br>0.583  | 50,0<br>1.969 | 156,8<br>6.173 | 0          | -            | 2,62<br>5.780 |
| C5-390.00-50070 | 75039855 | DIN(2080)50 | C5   | 70,0<br>2.756  | 54,8<br>2.157  | 50,0<br>1.969 | 196,8<br>7.748 | 0          | -            | 3,29<br>7.250 |
| C6-390.00-50030 | 75039856 | DIN(2080)50 | C6   | 30,0<br>1.181  | 14,8<br>0.583  | 63,0<br>2.480 | 156,8<br>6.173 | 0          | -            | 2,56<br>5.640 |
| C6-390.00-50080 | 75039857 | DIN(2080)50 | C6   | 80,0<br>3.150  | 64,8<br>2.551  | 63,0<br>2.480 | 206,8<br>8.142 | 0          | -            | 3,27<br>7.210 |
| C8-390.00-50070 | 75039858 | DIN(2080)50 | C8   | 70,0<br>2.756  | 54,8<br>2.157  | 80,0<br>3.150 | 196,8<br>7.748 | 0          | -            | 3,8<br>8.380  |
| C8-390.00-50120 | 75039859 | DIN(2080)50 | C8   | 120,0<br>4.724 | 104,8<br>4.126 | 80,0<br>3.150 | 246,8<br>9.717 | 0          | -            | 5,6<br>12.350 |

### Kiegészítők

| Megnevezés | Nyitó kulcs | Csavar kulcs |
|------------|-------------|--------------|
| 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   |

Bevezetés

Fúrás

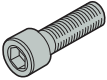

Dörzsárazás

Kiesztergálás

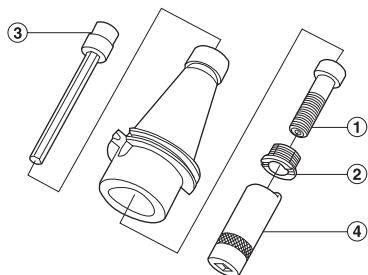
Melléklet



## Pótalkatrészek

| Megnevezés | Központi csavar   | Rögzítő anya  |
|------------|---|---|
|            |  |  |
| 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  |

## Kiegészítők / Pótalkatrészek

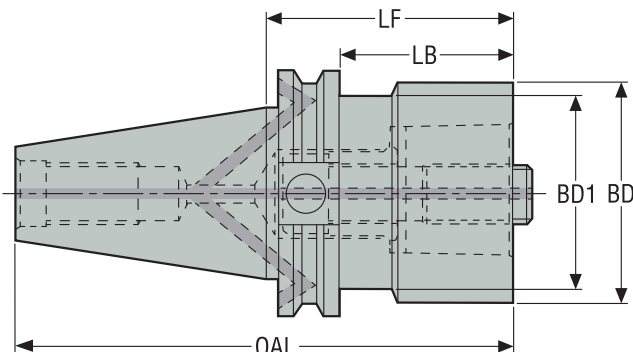


Kiegészítők:  
3 = Nyitó kulcs  
4 = Csavarkulcs

Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya

## C 55/58 – CAT a Seco-Capto™ befogókhhoz

CAT / ASME B5.50-2009-ADB



| Megnevezés        | Cikkszám | CTMS      | CTWS | LF          | LB          | BD          | BD1         | OAL         | Kivitel | RFID furat | Egys. faktor | Súly       |
|-------------------|----------|-----------|------|-------------|-------------|-------------|-------------|-------------|---------|------------|--------------|------------|
|                   |          |           |      | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> |         |            |              | <i>lbs</i> |
| 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     |

### Kiegészítők

| Méret           | Nyitó kulcs | Csavarkulcs |
|-----------------|-------------|-------------|
| 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  |

Bevezetés

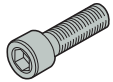


Fűrés

Dörzsárazás

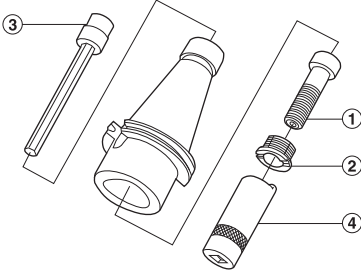
Kiesztergálás

Melléklet

Pótalkatrészek

| Méret           | Központi csavar   | Dugó  | Rögzítő anya  |
|-----------------|---|---|---|
|                 |  |  |  |
| 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  |

Kiegészítők / Pótalkatrészek



Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavarkulcs

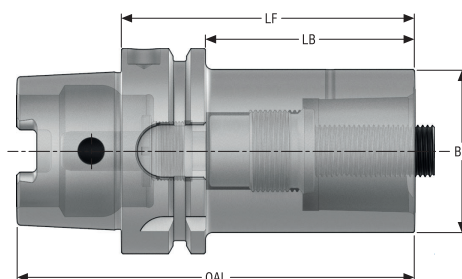
Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
3 = Tömítő dugó

## C 410 – HSK-A a Seco-Capto™ befogókhhoz – ISO 26623-2

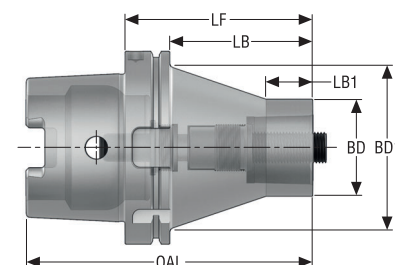
HSK-A/ ISO12164-1-HSK-A



Diseño 1



Diseño 2



| Megnevezés         | Cikkszám | CTMS     | CTWS | LF             | LB             | LB1           | BD            | BD1            | OAL            | Kivitel | RFID furat | Egys. faktor | Súly           |
|--------------------|----------|----------|------|----------------|----------------|---------------|---------------|----------------|----------------|---------|------------|--------------|----------------|
|                    |          |          |      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch     |         |            |              | kg<br>lbs      |
| C3-390.410-63075C  | 75039871 | HSK-A63  | C3   | 75,0<br>2.953  | 49,0<br>1.929  | -             | 32,0<br>1.260 | -              | 107,0<br>4.213 | 1       | 0          | PB           | 0,9<br>1.980   |
| C4-390.410-63080C  | 02425047 | HSK-A63  | C4   | 80,0<br>3.150  | 54,0<br>2.126  | -             | 40,0<br>1.575 | -              | 112,0<br>4.409 | 1       | 0          | PB           | 1,06<br>2.340  |
| C5-390.410-63090C  | 75039878 | HSK-A63  | C5   | 90,0<br>3.543  | 64,0<br>2.520  | -             | 50,0<br>1.969 | -              | 122,0<br>4.803 | 1       | 0          | PB           | 1,41<br>3.110  |
| C3-390.410-100080A | 75039873 | HSK-A100 | C3   | 80,0<br>3.150  | 51,0<br>2.008  | -             | 32,0<br>1.260 | -              | 130,0<br>5.118 | 1       | 0          | -            | 2,3<br>5.070   |
| C4-390.410-100090A | 75039877 | HSK-A100 | C4   | 90,0<br>3.543  | 61,0<br>2.402  | -             | 40,0<br>1.575 | -              | 140,0<br>5.512 | 1       | 0          | -            | 2,5<br>5.510   |
| C5-390.410-100100A | 75039880 | HSK-A100 | C5   | 100,0<br>3.937 | 71,0<br>2.795  | -             | 50,0<br>1.969 | -              | 150,0<br>5.906 | 1       | 0          | -            | 2,9<br>6.390   |
| C6-390.410-100110A | 75039882 | HSK-A100 | C6   | 110,0<br>4.331 | 81,0<br>3.189  | -             | 63,0<br>2.480 | -              | 160,0<br>6.299 | 1       | 0          | -            | 3,56<br>7.850  |
| C8-390.410-100120A | 75039883 | HSK-A100 | C8   | 120,0<br>4.724 | 91,0<br>3.583  | -             | 80,0<br>3.150 | -              | 170,0<br>6.693 | 1       | 0          | -            | 4,72<br>10.410 |
| HSKA125-C6-120     | 03229625 | HSK-A125 | C6   | 120,0<br>4.724 | 91,0<br>3.583  | -             | 63,0<br>2.480 | -              | 183,0<br>7.205 | 1       | 1          | PB           | 5,3<br>11.680  |
| HSKA125-C6-120-V   | 03229626 | HSK-A125 | C6   | 120,0<br>4.724 | 91,0<br>3.583  | 30,0<br>1.181 | 63,0<br>2.480 | 108,0<br>4.252 | 183,0<br>7.205 | 2       | 1          | PB           | 6,4<br>14.110  |
| HSKA125-C8-130     | 03229627 | HSK-A125 | C8   | 130,0<br>5.118 | 101,0<br>3.976 | -             | 80,0<br>3.150 | -              | 193,0<br>7.598 | 1       | 1          | PB           | 6,5<br>14.330  |
| HSKA125-C8-130-V   | 03229628 | HSK-A125 | C8   | 130,0<br>5.118 | 101,0<br>3.976 | 30,0<br>1.181 | 80,0<br>3.150 | 105,0<br>4.134 | 193,0<br>7.598 | 2       | 1          | PB           | 7,8<br>17.200  |

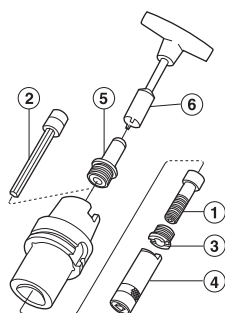
## Kiegészítők

| Megnevezés         | Nyitó kulcs | Kulcs      | Csavarkulcs |
|--------------------|-------------|------------|-------------|
| 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  |

## Pótalkatrészek

| Megnevezés         | Központi csavar | Hűtőfolyadék cső | Rögzítő anyá |
|--------------------|-----------------|------------------|--------------|
| 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   |

## Kiegészítők / Pótalkatrészek



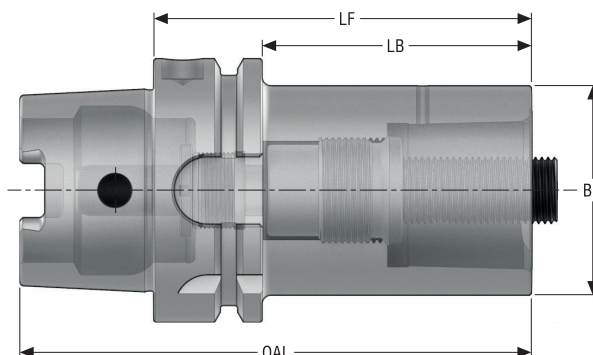
Kiegészítők:  
2 = Nyitó kulcs  
4 = Csavarkulcs  
6 = Kulcs a hűtőcsőhöz

Pótalkatrészek:  
1 = Központi csavar  
3 = Rögzítő anyá  
5 = Hűtőcső\*

\*Minden HSK-A - Seco-Capto befogóhoz mellékelve van egy speciális hűtőfolyadékcső

## C 411 – HSK-T a Seco-Capto™ befogókhhoz – ISO 26623-2

HSK-T/ ISO12164-3-HSK-T



| Megnevezés        | Cikkszám | CTMS     | CTWS | LF             | LB            | BD            | OAL            | RFID furat | Egys. faktor | Súly         |
|-------------------|----------|----------|------|----------------|---------------|---------------|----------------|------------|--------------|--------------|
|                   |          |          |      | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs    |
| C4-390.411-63080  | 02786511 | HSK-T63  | C4   | 80,0<br>3.150  | 54,0<br>2.126 | 40,0<br>1.575 | 112,0<br>4.409 | 1          | -            | 1,0<br>2.200 |
| C5-390.411-63090  | 02786520 | HSK-T63  | C5   | 90,0<br>3.543  | 64,0<br>2.520 | 50,0<br>1.969 | 122,0<br>4.803 | 1          | -            | 1,3<br>2.870 |
| C4-390.411-100090 | 02786519 | HSK-T100 | C4   | 90,0<br>3.543  | 61,0<br>2.402 | 40,0<br>1.575 | 140,0<br>5.512 | 1          | -            | 2,4<br>5.290 |
| C5-390.411-100100 | 02786521 | HSK-T100 | C5   | 100,0<br>3.937 | 71,0<br>2.795 | 50,0<br>1.969 | 150,0<br>5.906 | 1          | -            | 2,7<br>5.950 |
| C6-390.411-100110 | 02786522 | HSK-T100 | C6   | 110,0<br>4.331 | 81,0<br>3.189 | 63,0<br>2.480 | 160,0<br>6.299 | 1          | -            | 3,3<br>7.280 |
| C8-390.411-100120 | 02786523 | HSK-T100 | C8   | 120,0<br>4.724 | 91,0<br>3.583 | 80,0<br>3.150 | 170,0<br>6.693 | 1          | -            | 4,5<br>9.920 |

### Kiegészítők

| Megnevezés        | Nyitó kulcs | Kulcs      | Csavarkulcs |
|-------------------|-------------|------------|-------------|
| 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  |

### Pótalkatrészek

| Megnevezés        | Központi csavar | Hűtőfolyadék cső | Rögzítő anya |
|-------------------|-----------------|------------------|--------------|
| 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   |

Bevezetés

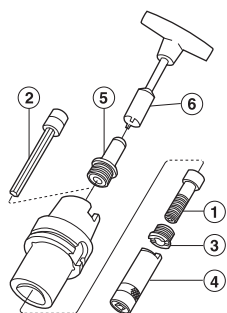
Fúrás

Dörzsárazás

Kiesztergálás

Melléklet

## Kiegészítők / Pótalkatrészek



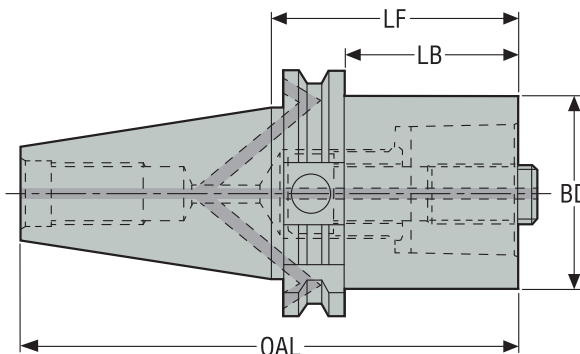
Kiegészítők:  
2 = Nyitó kulcs  
4 = Csavarkulcs  
6 = Kulcs a hűtőcsőhöz

Pótalkatrészek:  
1 = Központi csavar  
3 = Rögzítő anya  
5 = Hűtőcső\*

\*Minden HSK-A - Seco-Capto befogóhoz mellékelve van egy speciális hűtőfolyadékcső

## C 140 – DIN a Seco-Capto™ befogókhhoz – ISO 26623-2

DIN 69871-ADB



| Megnevezés        | Cikkszám | CTMS      | CTWS | LF             | LB             | BD            | OAL            | RFID furat | Egys. faktor | Súly          |
|-------------------|----------|-----------|------|----------------|----------------|---------------|----------------|------------|--------------|---------------|
|                   |          |           |      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs     |
| C3-390B.140-40030 | 02924104 | DIN40 ADB | C3   | 30,0<br>1.181  | 10,9<br>0.429  | 32,0<br>1.260 | 98,4<br>3.874  | 0          | PB           | 0,8<br>1.760  |
| C3-390B.140-40060 | 02924105 | DIN40 ADB | C3   | 60,0<br>2.362  | 40,9<br>1.610  | 32,0<br>1.260 | 128,4<br>5.055 | 0          | PB           | 0,9<br>1.980  |
| C4-390B.140-40030 | 02924108 | DIN40 ADB | C4   | 30,0<br>1.181  | 10,9<br>0.429  | 40,0<br>1.575 | 98,4<br>3.874  | 0          | PB           | 0,8<br>1.760  |
| C4-390B.140-40060 | 02924109 | DIN40 ADB | C4   | 60,0<br>2.362  | 40,9<br>1.610  | 40,0<br>1.575 | 128,4<br>5.055 | 0          | PB           | 1,1<br>2.430  |
| C5-390B.140-40040 | 02924112 | DIN40 ADB | C5   | 40,0<br>1.575  | 20,9<br>0.823  | 50,0<br>1.969 | 108,4<br>4.268 | 0          | PB           | 0,9<br>1.980  |
| C5-390B.140-40080 | 02924113 | DIN40 ADB | C5   | 80,0<br>3.150  | 60,9<br>2.398  | 50,0<br>1.969 | 148,4<br>5.843 | 0          | PB           | 1,5<br>3.310  |
| C6-390B.140-40085 | 02924116 | DIN40 ADB | C6   | 85,0<br>3.346  | 65,9<br>2.594  | 63,0<br>2.480 | 153,4<br>6.039 | 0          | PB           | 1,8<br>3.970  |
| C3-390B.140-50030 | 02924106 | DIN50 ADB | C3   | 30,0<br>1.181  | 10,9<br>0.429  | 32,0<br>1.260 | 131,7<br>5.185 | 0          | PB           | 2,6<br>5.730  |
| C3-390B.140-50060 | 02924107 | DIN50 ADB | C3   | 60,0<br>2.362  | 40,9<br>1.610  | 32,0<br>1.260 | 161,7<br>6.366 | 0          | PB           | 2,7<br>5.950  |
| C4-390B.140-50030 | 02924110 | DIN50 ADB | C4   | 30,0<br>1.181  | 10,9<br>0.429  | 40,0<br>1.575 | 131,7<br>5.185 | 0          | PB           | 2,6<br>5.730  |
| C4-390B.140-50060 | 02924111 | DIN50 ADB | C4   | 60,0<br>2.362  | 40,9<br>1.610  | 40,0<br>1.575 | 161,7<br>6.366 | 0          | PB           | 2,8<br>6.170  |
| C5-390B.140-50030 | 02924114 | DIN50 ADB | C5   | 30,0<br>1.181  | 10,9<br>0.429  | 50,0<br>1.969 | 131,7<br>5.185 | 0          | PB           | 2,6<br>5.730  |
| C5-390B.140-50070 | 02924115 | DIN50 ADB | C5   | 70,0<br>2.756  | 50,9<br>2.004  | 50,0<br>1.969 | 171,7<br>6.760 | 0          | PB           | 3,1<br>6.830  |
| C6-390B.140-50030 | 02924117 | DIN50 ADB | C6   | 30,0<br>1.181  | 10,9<br>0.429  | 63,0<br>2.480 | 131,7<br>5.185 | 0          | PB           | 2,5<br>5.510  |
| C6-390B.140-50080 | 02924118 | DIN50 ADB | C6   | 80,0<br>3.150  | 60,9<br>2.398  | 63,0<br>2.480 | 181,7<br>7.154 | 0          | PB           | 3,6<br>7.940  |
| C8-390B.140-50070 | 02924119 | DIN50 ADB | C8   | 70,0<br>2.756  | 50,9<br>2.004  | 80,0<br>3.150 | 171,7<br>6.760 | 0          | PB           | 3,7<br>8.160  |
| C8-390B.140-50120 | 02924120 | DIN50 ADB | C8   | 120,0<br>4.724 | 100,9<br>3.972 | 80,0<br>3.150 | 221,7<br>8.728 | 0          | PB           | 5,6<br>12.350 |

Bevezetés

Fűrés

Dörzsárazás

Kiesztorgálás

Melléklet



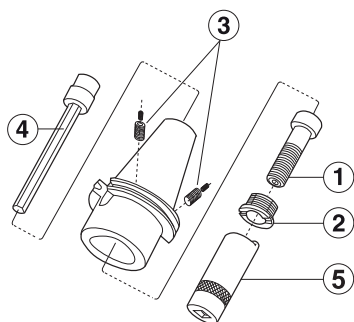
## Kiegészítők

| Megnevezés | Nyitó kulcs | Csavar kulcs |
|------------|-------------|--------------|
| 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   |

## Pótalkatrészek

| Megnevezés | Központi csavar | Dugó      | Rögzítő anya |
|------------|-----------------|-----------|--------------|
| 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   |

## Kiegészítők / Pótalkatrészek



Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavar kulcs

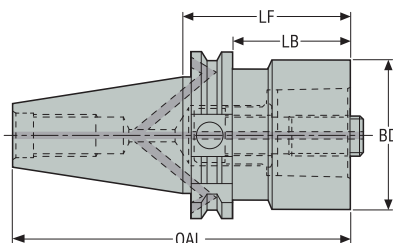
Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
3 = Tömítő dugó

## C 5191 – Seco-Capto™ alaptartókhhoz – ISO 26623-2

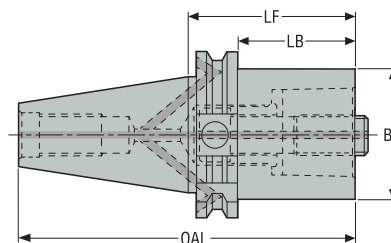
DIN Taper-Face-ADB



Diseño 1



Diseño 2

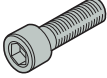




| Megnevezés     | Cikkszám | CTMS         | CTWS | LF             | LB             | BD            | OAL            | Kivitel | RFID furat | Egys. faktor | Súly           |
|----------------|----------|--------------|------|----------------|----------------|---------------|----------------|---------|------------|--------------|----------------|
|                |          |              |      | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     |         |            |              | kg<br>lbs      |
| E316951915050  | 03030258 | DIN40 TF ADB | C5   | 50,0<br>1.969  | 30,9<br>1.217  | 50,0<br>1.969 | 118,4<br>4.661 | 2       | 0          | PB           | 1,1<br>2.430   |
| E316951916385  | 03030259 | DIN40 TF ADB | C6   | 85,0<br>3.346  | 65,9<br>2.594  | 63,0<br>2.480 | 153,4<br>6.039 | 1       | 0          | PB           | 1,9<br>4.190   |
| E317151914030  | 03030260 | DIN50 TF ADB | C4   | 30,0<br>1.181  | 10,9<br>0.429  | 40,0<br>1.575 | 131,7<br>5.185 | 2       | 0          | -            | 2,7<br>5.950   |
| E317151915030  | 03030261 | DIN50 TF ADB | C5   | 30,0<br>1.181  | 10,9<br>0.429  | 50,0<br>1.969 | 131,7<br>5.185 | 2       | 0          | -            | 2,8<br>6.170   |
| E317151915070  | 03030264 | DIN50 TF ADB | C5   | 70,0<br>2.756  | 50,9<br>2.004  | 50,0<br>1.969 | 171,7<br>6.760 | 2       | 0          | -            | 3,15<br>6.940  |
| E317151916350  | 03030262 | DIN50 TF ADB | C6   | 50,0<br>1.969  | 30,9<br>1.217  | 63,0<br>2.480 | 151,7<br>5.972 | 2       | 0          | -            | 2,4<br>5.290   |
| E3171519163100 | 03030265 | DIN50 TF ADB | C6   | 100,0<br>3.937 | 80,9<br>3.185  | 63,0<br>2.480 | 201,7<br>7.941 | 2       | 0          | -            | 4,08<br>8.990  |
| E317151918070  | 03030263 | DIN50 TF ADB | C8   | 70,0<br>2.756  | 50,9<br>2.004  | 80,0<br>3.150 | 171,7<br>6.760 | 2       | 0          | -            | 3,9<br>8.600   |
| E3171519180120 | 03030266 | DIN50 TF ADB | C8   | 120,0<br>4.724 | 100,9<br>3.972 | 80,0<br>3.150 | 221,7<br>8.728 | 2       | 0          | -            | 5,62<br>12.390 |

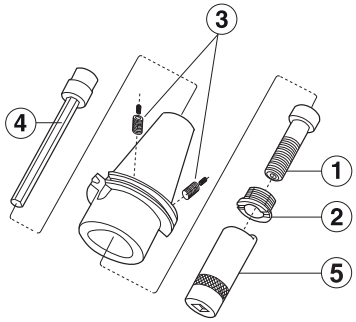
### Kiegészítők

| Megnevezés      | Nyitó kulcs | Csavarkulcs |
|-----------------|-------------|-------------|
| 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  |

Pótalkatrészek

| Megnevezés      | Központi csavar   | Dugó  | Rögzítő anya  |
|-----------------|---|---|---|
|                 |  |  |  |
| 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  |

Kiegészítők / Pótalkatrészek



Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavarkulcs

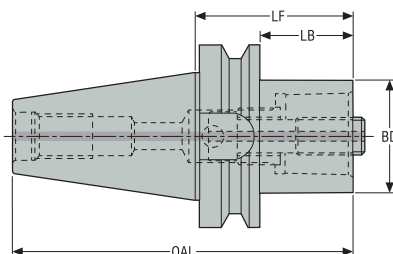
Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
3 = Tömítő dugó

## C 55/58 – BT a Seco-Capto™ befogókhhoz – ISO 26623-2

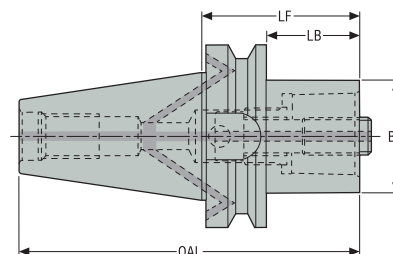
BT



Diseño 1



Diseño 2



| Megnevezés       | Cikkszám | CTMS     | CTWS | LF             | LB            | BD            | OAL            | Kivitel | RFID furat | Egys. faktor | Súly          |
|------------------|----------|----------|------|----------------|---------------|---------------|----------------|---------|------------|--------------|---------------|
|                  |          |          |      | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |         |            |              | kg<br>lbs     |
| C3-390.55-30030  | 75039807 | BT30 AD  | C3   | 30,0<br>1.181  | 8,0<br>0.315  | 32,0<br>1.260 | 78,4<br>3.087  | 1       | 0          | PB           | 0,53<br>1.170 |
| C3-390.55-30060  | 75039808 | BT30 AD  | C3   | 60,0<br>2.362  | 38,0<br>1.496 | 32,0<br>1.260 | 108,4<br>4.268 | 1       | 0          | PB           | 0,73<br>1.610 |
| C3-390B.55-40030 | 02925959 | BT40 ADB | C3   | 30,0<br>1.181  | 3,0<br>0.118  | 32,0<br>1.260 | 95,4<br>3.756  | 2       | 0          | PB           | 0,9<br>1.980  |
| C3-390B.55-40060 | 02925960 | BT40 ADB | C3   | 60,0<br>2.362  | 33,0<br>1.299 | 32,0<br>1.260 | 125,4<br>4.937 | 2       | 0          | PB           | 1,1<br>2.430  |
| C4-390B.55-40030 | 02925963 | BT40 ADB | C4   | 30,0<br>1.181  | 3,0<br>0.118  | 40,0<br>1.575 | 95,4<br>3.756  | 2       | 0          | PB           | 0,9<br>1.980  |
| C4-390B.55-40060 | 02925964 | BT40 ADB | C4   | 60,0<br>2.362  | 33,0<br>1.299 | 40,0<br>1.575 | 125,4<br>4.937 | 2       | 0          | PB           | 1,2<br>2.650  |
| C5-390B.55-40050 | 02925967 | BT40 ADB | C5   | 50,0<br>1.969  | 23,0<br>0.906 | 50,0<br>1.969 | 115,4<br>4.543 | 2       | 0          | PB           | 1,1<br>2.430  |
| C5-390B.55-40090 | 02925968 | BT40 ADB | C5   | 90,0<br>3.543  | 63,0<br>2.480 | 50,0<br>1.969 | 155,4<br>6.118 | 2       | 0          | PB           | 1,7<br>3.750  |
| C6-390B.55-40075 | 02925971 | BT40 ADB | C6   | 75,0<br>2.953  | 54,6<br>2.150 | 63,0<br>2.480 | 140,4<br>5.528 | 2       | 0          | PB           | 1,7<br>3.750  |
| C3-390B.58-50040 | 02925961 | BT50 ADB | C3   | 40,0<br>1.575  | 2,0<br>0.079  | 32,0<br>1.260 | 141,8<br>5.583 | 2       | 0          | PB           | 3,5<br>7.720  |
| C3-390B.58-50070 | 02925962 | BT50 ADB | C3   | 70,0<br>2.756  | 32,0<br>1.260 | 32,0<br>1.260 | 171,8<br>6.764 | 2       | 0          | PB           | 3,7<br>8.160  |
| C4-390B.58-50040 | 02925965 | BT50 ADB | C4   | 40,0<br>1.575  | 2,0<br>0.079  | 40,0<br>1.575 | 141,8<br>5.583 | 2       | 0          | PB           | 3,5<br>7.720  |
| C4-390B.58-50070 | 02925966 | BT50 ADB | C4   | 70,0<br>2.756  | 32,0<br>1.260 | 40,0<br>1.575 | 171,8<br>6.764 | 2       | 0          | PB           | 3,8<br>8.380  |
| C5-390B.58-50040 | 02925969 | BT50 ADB | C5   | 40,0<br>1.575  | 2,0<br>0.079  | 50,0<br>1.969 | 141,8<br>5.583 | 2       | 0          | PB           | 3,4<br>7.500  |
| C5-390B.58-50080 | 02925970 | BT50 ADB | C5   | 80,0<br>3.150  | 42,0<br>1.654 | 50,0<br>1.969 | 181,8<br>7.157 | 2       | 0          | PB           | 4,0<br>8.820  |
| C6-390B.58-50050 | 02925972 | BT50 ADB | C6   | 50,0<br>1.969  | 12,0<br>0.472 | 63,0<br>2.480 | 151,8<br>5.976 | 2       | 0          | PB           | 3,5<br>7.720  |
| C6-390B.58-50100 | 02925973 | BT50 ADB | C6   | 100,0<br>3.937 | 62,0<br>2.441 | 63,0<br>2.480 | 201,8<br>7.945 | 2       | 0          | PB           | 4,6<br>10.140 |
| C8-390B.58-50070 | 02925974 | BT50 ADB | C8   | 70,0<br>2.756  | 32,0<br>1.260 | 80,0<br>3.150 | 171,8<br>6.764 | 2       | 0          | PB           | 4,0<br>8.820  |
| C8-390B.58-50120 | 02925975 | BT50 ADB | C8   | 120,0<br>4.724 | 82,0<br>3.228 | 80,0<br>3.150 | 221,8<br>8.732 | 2       | 0          | PB           | 5,9<br>13.010 |

Bevezetés

Fúrás

Dörzsárazás

Kiesztergálás

Melléklet

Kiegészítők

| Megnevezés | Nyitó kulcs | Csavarkulcs |
|------------|-------------|-------------|
| 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  |

Pótalkatrészek

| Megnevezés | Központi csavar | Dugó      | Rögzítő anya |
|------------|-----------------|-----------|--------------|
| 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   |

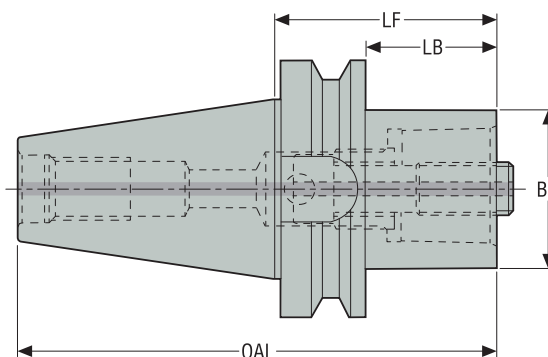
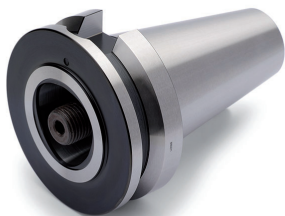
Kiegészítők / Pótalkatrészek

Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavarkulcs

Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
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## C 605 – BT Mazak a Seco-Capto™ befogókhhoz – ISO 26623-2

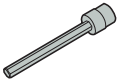
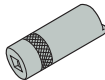
BT Mazak



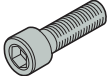

- Mazak kivétel 90°-al elforgatott Seco-Capto™ polygont jelent a klasszikus BT alaptartóhoz képest
- Mazak e-gépekhez

| Megnevezés       | Cikkszám | CTMS          | CTWS | LF            | LB            | BD            | OAL            | RFID furat | Egys. faktor | Súly         |
|------------------|----------|---------------|------|---------------|---------------|---------------|----------------|------------|--------------|--------------|
|                  |          |               |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs    |
| C5-390.605-40030 | 02606358 | BT40 AD Mazak | C5   | 30,0<br>1.181 | 3,0<br>0.118  | 50,0<br>1.969 | 95,4<br>3.756  | 0          | -            | 1,1<br>2.430 |
| C6-390.605-50040 | 02606354 | BT50 AD Mazak | C6   | 40,0<br>1.575 | 2,0<br>0.079  | 63,0<br>2.480 | 141,8<br>5.583 | 0          | -            | 3,3<br>7.280 |
| C8-390.605-50070 | 02646032 | BT50 AD Mazak | C8   | 70,0<br>2.756 | 70,0<br>2.756 | 80,0<br>3.150 | 171,8<br>6.764 | 0          | -            | 4,1<br>9.040 |

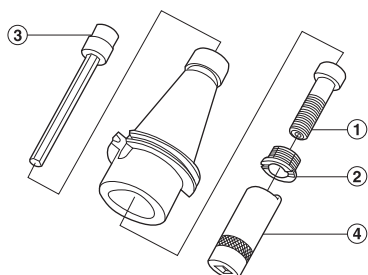
### Kiegészítők

| Méret | Nyitó kulcs   | Csavarkulcs   |
|-------|---|---|
| C5    | <br>5680015-01 | <br>5680065-11 |
| C6    | 5680015-02  | 5680065-12  |
| C8    | 5680015-02  | 5680065-12  |

### Pótalkatrészek

| Méret | Központi csavar   | Rögzítő anya  |
|-------|---|---|
| C5    | <br>5512063-08 | <br>5512091-01 |
| C6    | 5512063-09  | 5512091-02  |
| C8    | 5512063-09  | 5512091-02  |

## Kiegészítők / Pótalkatrészek



Kiegészítők:  
3 = Nyitó kulcs  
4 = Csavarkulcs

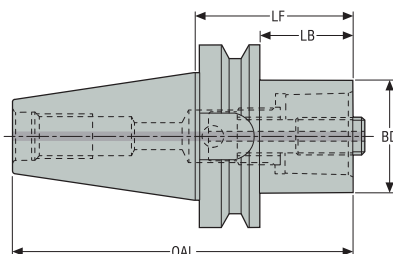
Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya

## C 5191 – Seco-Capto™ alaptartókhhoz – ISO 26623-2

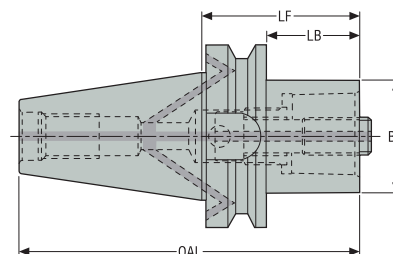
BT Taper-Face-AD/ADB



Diseño 1



Diseño 2



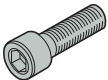


| Megnevezés     | Cikkszám | CTMS        | CTWS | LF             | LB            | BD            | OAL            | Kivitel | RFID furat | Egys. faktor | Súly           |
|----------------|----------|-------------|------|----------------|---------------|---------------|----------------|---------|------------|--------------|----------------|
|                |          |             |      | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |         |            |              | kg<br>lbs      |
| E400251913240  | 03030234 | BT30 TF AD  | C3   | 40,0<br>1.575  | 22,0<br>0.866 | 32,0<br>1.260 | 88,4<br>3.480  | 1       | 0          | PB           | 0,454<br>1.000 |
| E400251914060  | 03030235 | BT30 TF AD  | C4   | 60,0<br>2.362  | 22,0<br>0.866 | 40,0<br>1.575 | 108,4<br>4.268 | 1       | 0          | PB           | 0,651<br>1.440 |
| E311451914040  | 03030236 | BT40 TF ADB | C4   | 40,0<br>1.575  | 13,0<br>0.512 | 40,0<br>1.575 | 105,4<br>4.150 | 2       | 0          | PB           | 1,1<br>2.430   |
| E311451915050  | 03030237 | BT40 TF ADB | C5   | 50,0<br>1.969  | 23,0<br>0.906 | 50,0<br>1.969 | 115,4<br>4.543 | 2       | 0          | PB           | 1,2<br>2.650   |
| E311451916375  | 03030238 | BT40 TF ADB | C6   | 75,0<br>2.953  | 48,0<br>1.890 | 63,0<br>2.480 | 140,4<br>5.528 | 2       | 0          | PB           | 1,7<br>3.750   |
| E311651914040  | 03030239 | BT50 TF ADB | C4   | 40,0<br>1.575  | 2,0<br>0.079  | 50,0<br>1.969 | 141,8<br>5.583 | 2       | 0          | PB           | 3,6<br>7.940   |
| E311651915040  | 03030240 | BT50 TF ADB | C5   | 40,0<br>1.575  | 2,0<br>0.079  | 50,0<br>1.969 | 141,8<br>5.583 | 2       | 0          | PB           | 3,5<br>7.720   |
| E311651916350  | 03030241 | BT50 TF ADB | C6   | 50,0<br>1.969  | 12,0<br>0.472 | 63,0<br>2.480 | 151,8<br>5.976 | 2       | 0          | PB           | 3,6<br>7.940   |
| E3116519163100 | 03030242 | BT50 TF ADB | C6   | 100,0<br>3.937 | 62,0<br>2.441 | 63,0<br>2.480 | 201,8<br>7.945 | 2       | 0          | PB           | 4,63<br>10.210 |
| E311651918070  | 03030243 | BT50 TF ADB | C8   | 70,0<br>2.756  | 32,0<br>1.260 | 80,0<br>3.150 | 171,8<br>6.764 | 2       | 0          | PB           | 4,2<br>9.260   |
| E3116519180120 | 03030244 | BT50 TF ADB | C8   | 120,0<br>4.724 | 82,0<br>3.228 | 80,0<br>3.150 | 121,8<br>4.795 | 2       | 0          | PB           | 5,91<br>13.030 |

### Kiegészítők

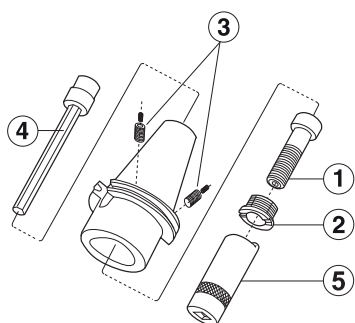
| Kúp/méret      | Nyitó kulcs | Csavarkulcs |
|----------------|-------------|-------------|
| BT30 TF/ C3    | 5680015-05  | 5680065-13  |
| BT30 TF/ C4    | 5680015-05  | 5680065-10  |
| BT40 TF/ C4    | 5680015-05  | 5680065-10  |
| BT40 TF/ C5    | 5680015-01  | 5680065-11  |
| BT40 TF/ C6    | 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  |



Pótalkatrészek

| Kúp/méret      | Központi csavar   | Dugó   | Rögzítő anya  |
|----------------|---|--|---|
|                |  |  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  |

Kiegészítők / Pótalkatrészek



Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavarkulcs

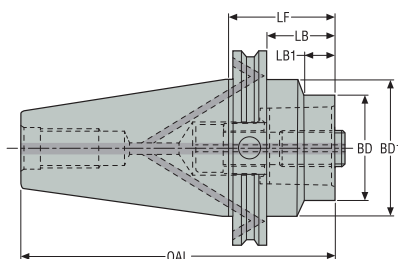
Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
3 = Tömítő dugó

## C 5191 – Seco-Capto™ alaptartókhhoz

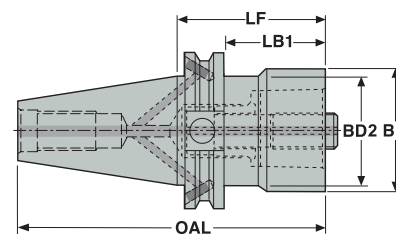
CAT TF / ASME B5.50-1994-ADB



Diseño 1



Diseño 2



| Megnevezés     | Cikkszám | CTMS         | CTWS | LF          | LB          | LB1         | BD          | BD1         | OAL         | Kivitel | RFID furat | Egys. faktor | Súly   |
|----------------|----------|--------------|------|-------------|-------------|-------------|-------------|-------------|-------------|---------|------------|--------------|--------|
|                |          |              |      | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> | <i>Inch</i> |         |            |              |        |
| 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 |

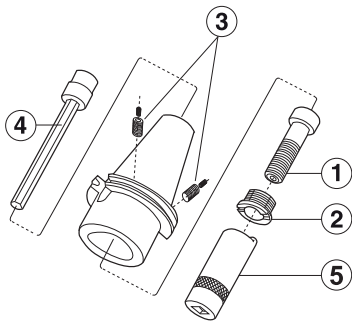
### Kiegészítők

| Méret     | Nyitó kulcs | Csavar kulcs |
|-----------|-------------|--------------|
| 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   |

### Pótalkatrészek

| Méret     | Központi csavar | Dugó      | Rögzítő any |
|-----------|-----------------|-----------|-------------|
| 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  |

## Kiegészítők / Pótalkatrészek



Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavarkulcs

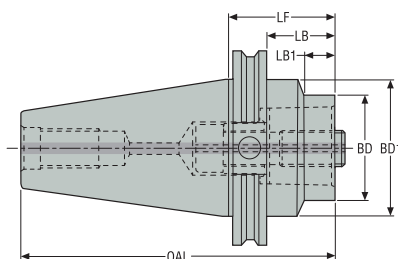
Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
3 = Tömítő dugó

## C 5191 – Seco-Capto™ alaptartókhhoz

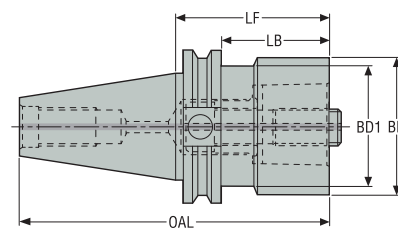
CAT TF Mazak™ e-machine és Mori Seiki NT™ -sorozat



Diseño 1



Diseño 2



- 90°-kal elfordított sokszög a szerszámhegy precíziós vezérlése érdekében

| Megnevezés    | Cikkszám | CTMS              | CTWS | LF    | LB    | LB1   | BD    | BD1   | OAL   | Kivitel | RFID furat | Egys. faktor | Súly  |
|---------------|----------|-------------------|------|-------|-------|-------|-------|-------|-------|---------|------------|--------------|-------|
|               |          |                   |      | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  |         |            |              | 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 |

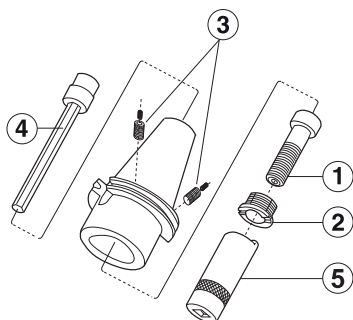
### Kiegészítők

| Méret         | Nyitó kulcs | Csavarkulcs |
|---------------|-------------|-------------|
| E947451916350 | 5680015-02  | 5680065-12  |
| E947451918070 | 5680015-02  | 5680065-12  |
| E945451918070 | 5680015-02  | 5680065-12  |

### Pótalkatrészek

| Méret         | Központi csavar | Rögzítő anya |
|---------------|-----------------|--------------|
| E945451918070 | 5512067-04      | 5512091-02   |
| E947451916350 | 5512063-09      | 5512091-02   |
| E947451918070 | 5512063-09      | 5512091-02   |

### Kiegészítők / Pótalkatrészek

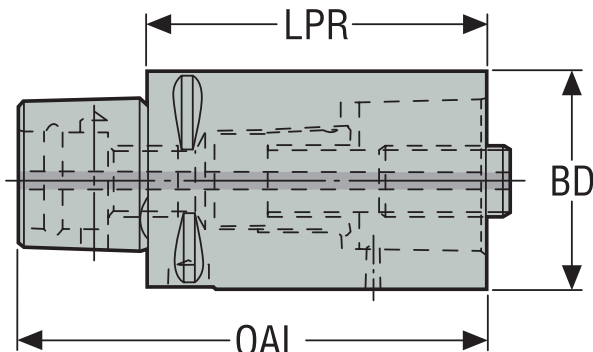


Kiegészítők:  
4 = Nyitó kulcs  
5 = Csavarkulcs

Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya  
3 = Tömítő dugó

## C 01 – Seco-Capto™ hosszabbítók

ISO 26623-1



| Megnevezés       | Cikkszám | CTMS | CTWS | LPR            | BD            | OAL            | RFID furat | Egys. faktor | Súly           |
|------------------|----------|------|------|----------------|---------------|----------------|------------|--------------|----------------|
|                  |          |      |      | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     |            |              | kg<br>lbs      |
| C3-391.01-32060A | 75039884 | C3   | C3   | 60,0<br>2.362  | 32,0<br>1.260 | 79,0<br>3.110  | 0          | -            | 0,34<br>0.750  |
| C3-391.01-32080A | 00090847 | C3   | C3   | 80,0<br>3.150  | 32,0<br>1.260 | 99,0<br>3.898  | 0          | -            | 0,45<br>0.990  |
| C4-391.01-40060A | 75039885 | C4   | C4   | 60,0<br>2.362  | 40,0<br>1.575 | 84,0<br>3.307  | 0          | -            | 0,54<br>1.190  |
| C4-391.01-40080A | 02207391 | C4   | C4   | 80,0<br>3.150  | 40,0<br>1.575 | 104,0<br>4.094 | 0          | -            | 0,71<br>1.570  |
| C5-391.01-50080A | 75039886 | C5   | C5   | 80,0<br>3.150  | 50,0<br>1.969 | 110,0<br>4.331 | 0          | -            | 1,12<br>2.470  |
| C5-391.01-50100A | 00004773 | C5   | C5   | 100,0<br>3.937 | 50,0<br>1.969 | 130,0<br>5.118 | 0          | -            | 1,39<br>3.060  |
| C6-391.01-63100A | 75039887 | C6   | C6   | 100,0<br>3.937 | 63,0<br>2.480 | 138,0<br>5.433 | 0          | -            | 2,2<br>4.850   |
| C6-391.01-63140A | 00004840 | C6   | C6   | 140,0<br>5.512 | 63,0<br>2.480 | 178,0<br>7.008 | 0          | -            | 3,1<br>6.830   |
| C8-391.01-80100A | 75039888 | C8   | C8   | 100,0<br>3.937 | 80,0<br>3.150 | 148,0<br>5.827 | 0          | -            | 3,62<br>7.980  |
| C8-391.01-80125A | 00004841 | C8   | C8   | 125,0<br>4.921 | 80,0<br>3.150 | 173,0<br>6.811 | 0          | -            | 4,54<br>10.010 |

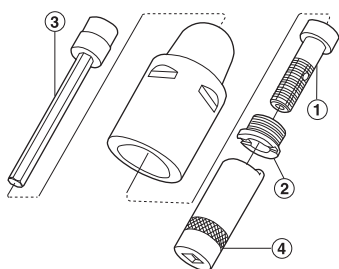
### Kiegészítők

| Méret | Nyitó kulcs | Csavar kulcs |
|-------|-------------|--------------|
| 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   |

Pótalkatrészek

| Méret | Központi csavar | Rögzőítő anya |
|-------|-----------------|---------------|
| 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    |

Kiegészítők / Pótalkatrészek



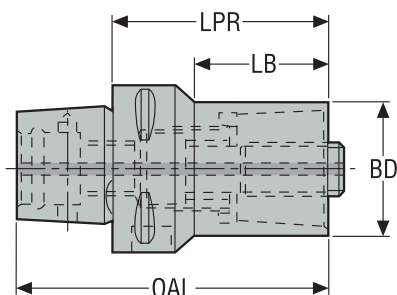
Kiegészítők:  
3 = Nyitó kulcs  
4 = Rögzőítő anya fesztő

Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzőítő anya

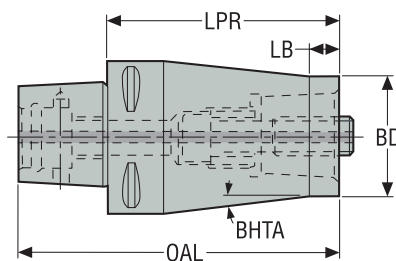
## C 02 – Seco-Capto™ csökkentők

ISO 26623-1

Diseño 1



Diseño 2



| Megnevezés       | Cikkszám | CTMS | CTWS | LPR            | LB            | BD            | OAL            | Kivitel | BHTA° | RFID furat | Egys. faktor | Súly          |
|------------------|----------|------|------|----------------|---------------|---------------|----------------|---------|-------|------------|--------------|---------------|
|                  |          |      |      | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |         |       |            |              | kg<br>lbs     |
| C4-391.02-32055A | 75039889 | C4   | C3   | 55,0<br>2.165  | 31,0<br>1.220 | 32,0<br>1.260 | 79,0<br>3.110  | 1       | -     | 0          | -            | 0,42<br>0.930 |
| C4-391.02-32070A | 02535687 | C4   | C3   | 70,0<br>2.756  | 12,0<br>0.472 | 32,0<br>1.260 | 94,0<br>3.701  | 2       | 6,0   | 0          | -            | 0,56<br>1.230 |
| C5-391.02-32060A | 75039890 | C5   | C3   | 60,0<br>2.362  | 34,8<br>1.370 | 32,0<br>1.260 | 90,0<br>3.543  | 1       | -     | 0          | -            | 0,64<br>1.410 |
| C5-391.02-40065A | 75039891 | C5   | C4   | 65,0<br>2.559  | 40,0<br>1.575 | 40,0<br>1.575 | 95,0<br>3.740  | 1       | -     | 0          | -            | 0,77<br>1.700 |
| C6-391.02-32070A | 75039892 | C6   | C3   | 70,0<br>2.756  | 39,0<br>1.535 | 32,0<br>1.260 | 108,0<br>4.252 | 1       | -     | 0          | -            | 1,06<br>2.340 |
| C6-391.02-40080A | 75039893 | C6   | C4   | 80,0<br>3.150  | 51,4<br>2.024 | 40,0<br>1.575 | 118,0<br>4.646 | 1       | -     | 0          | -            | 1,24<br>2.730 |
| C6-391.02-50080A | 75039894 | C6   | C5   | 80,0<br>3.150  | 51,5<br>2.028 | 50,0<br>1.969 | 118,0<br>4.646 | 1       | -     | 0          | -            | 1,45<br>3.200 |
| C6-391.02-50110A | 02207400 | C6   | C5   | 110,0<br>4.331 | 12,0<br>0.472 | 50,0<br>1.969 | 148,0<br>5.827 | 2       | 4,5   | 0          | -            | 2,15<br>4.740 |
| C8-391.02-32060B | 03080008 | C8   | C3   | 60,0<br>2.362  | 20,7<br>0.815 | 32,0<br>1.260 | 108,0<br>4.252 | 1       | -     | 0          | -            | 2,0<br>4.410  |
| C8-391.02-40070B | 03080009 | C8   | C4   | 70,0<br>2.756  | 31,4<br>1.236 | 40,0<br>1.575 | 118,0<br>4.646 | 1       | -     | 0          | -            | 2,1<br>4.630  |
| C8-391.02-50080B | 03080011 | C8   | C5   | 80,0<br>3.150  | 42,8<br>1.685 | 50,0<br>1.969 | 128,0<br>5.039 | 1       | -     | 0          | -            | 2,4<br>5.290  |
| C8-391.02-63080B | 02527212 | C8   | C6   | 80,0<br>3.150  | 44,5<br>1.752 | 63,0<br>2.480 | 128,0<br>5.039 | 1       | -     | 0          | -            | 2,6<br>5.730  |
| C8-391.02-63120A | 02207176 | C8   | C6   | 120,0<br>4.724 | 12,0<br>0.472 | 63,0<br>2.480 | 168,0<br>6.614 | 2       | 6,0   | 0          | -            | 3,96<br>8.730 |

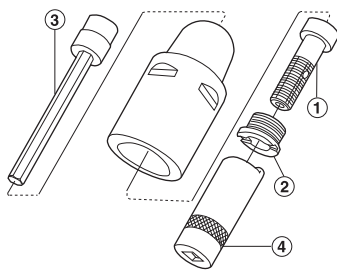
### Kiegészítők

| Méret   | Nyitó kulcs | Csavar kulcs |
|---------|-------------|--------------|
| C...-32 | 5680015-05  | 5680065-13   |
| C...-40 | 5680015-05  | 5680065-10   |
| C...-50 | 5680015-01  | 5680065-11   |
| C...-63 | 5680015-02  | 5680065-12   |

Pótalkatrészek

| Méret  | Központi csavar | Rögzítő anya |
|--------|-----------------|--------------|
| C...32 | 5512067-01      | 5512091-04   |
| C...40 | 5512067-02      | 5512091-03   |
| C...50 | 5512067-03      | 5512091-01   |
| C...63 | 5512067-04      | 5512091-02   |

Kiegészítők / Pótalkatrészek



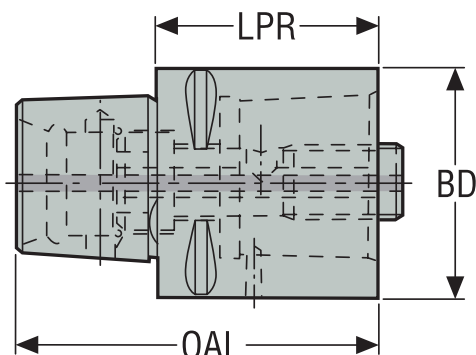
Kiegészítők:  
3 = Nyitó kulcs  
4 = Rögzítő anya fesztő

Pótalkatrészek:  
1 = Központi csavar  
2 = Rögzítő anya



## C 01 – Seco-Capto™ hosszabbítók, rövid verzió, szegmens rögzítésre csak

ISO 26623-1



- A Seco-Capto™ rövid befogók gépi oldalán csak a főorsóhoz rögzíthetők (nincs központi csap rögzítés)

| Megnevezés      | Cikkszám | CTMS | CTWS | LPR           | BD            | OAL            | RFID furat | Egys. faktor | Súly          |
|-----------------|----------|------|------|---------------|---------------|----------------|------------|--------------|---------------|
|                 |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |            |              |               |
| C3-391.01-32035 | 02535685 | C3   | C3   | 35,0<br>1.378 | 32,0<br>1.260 | 54,0<br>2.126  | 0          | -            | 0,21<br>0.460 |
| C4-391.01-40040 | 02535686 | C4   | C4   | 40,0<br>1.575 | 40,0<br>1.575 | 64,0<br>2.520  | 0          | -            | 0,37<br>0.820 |
| C5-391.01-50050 | 02484934 | C5   | C5   | 50,0<br>1.969 | 50,0<br>1.969 | 80,0<br>3.150  | 0          | -            | 0,7<br>1.540  |
| C6-391.01-63060 | 02300834 | C6   | C6   | 60,0<br>2.362 | 63,0<br>2.480 | 98,0<br>3.858  | 0          | -            | 1,31<br>2.890 |
| C8-391.01-80065 | 02417041 | C8   | C8   | 65,0<br>2.559 | 80,0<br>3.150 | 113,0<br>4.449 | 0          | -            | 2,3<br>5.070  |

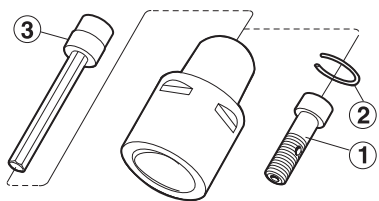
## Kiegészítők

| Megnevezés      | Nyitó kulcs |
|-----------------|-------------|
| 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  |

## Pótalkatrészek

| Megnevezés      | Központi csavar | Seeger-gyűrű |
|-----------------|-----------------|--------------|
| 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   |

Kiegészítők / Pótalkatrészek

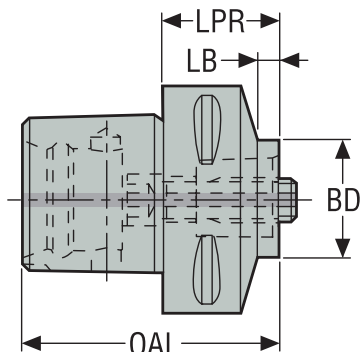


Kiegészítők:  
3 = Nyitó kulcs

Pótalkatrészek:  
1 = Központi csavar  
2 = Seeger alátét

## C 02 – Seco-Capto™ csökkentők, rövid verzió, csak szegmens rögzítésre

ISO 26623-1

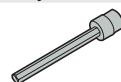


- A Seco-Capto™ rövid csökkentők gépi oldalán csak a főrsóhoz rögzíthető (nincs központi csap rögzítés)
- \* 180°-os gépoldali állás a munkadarab oldallal szemben

| Megnevezés        | Cikkszám | CTMS | CTWS | LPR           | LB            | BD            | OAL            | * | RFID furat | Egys. faktor | Súly          |
|-------------------|----------|------|------|---------------|---------------|---------------|----------------|---|------------|--------------|---------------|
|                   |          |      |      | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     |   |            |              | kg<br>lbs     |
| C5-391.02-32033A  | 03080025 | C5   | C3   | 33,0<br>1.299 | 5,0<br>0.197  | 32,0<br>1.260 | 63,0<br>2.480  |   | 0          | PB           | 0,5<br>1.100  |
| C5-391.02-40040A  | 03079983 | C5   | C4   | 40,0<br>1.575 | 15,0<br>0.591 | 40,0<br>1.575 | 70,0<br>2.756  |   | 0          | -            | 0,6<br>1.320  |
| C6-391.02-32032   | 02535690 | C6   | C3   | 32,0<br>1.260 | 6,0<br>0.236  | 32,0<br>1.260 | 70,0<br>2.756  |   | 0          | -            | 0,85<br>1.870 |
| C6-391.02-40040   | 02459467 | C6   | C4   | 40,0<br>1.575 | 11,0<br>0.433 | 40,0<br>1.575 | 78,0<br>3.071  |   | 0          | -            | 0,93<br>2.050 |
| C6-391.02-50050A  | 03080019 | C6   | C5   | 50,0<br>1.969 | 20,0<br>0.787 | 50,0<br>1.969 | 88,0<br>3.465  |   | 0          | -            | 1,0<br>2.200  |
| C8-391.02-50045A  | 03080010 | C8   | C5   | 45,0<br>1.772 | 5,0<br>0.197  | 50,0<br>1.969 | 93,0<br>3.661  |   | 0          | -            | 1,9<br>4.190  |
| C8-391.02-63055A  | 03080012 | C8   | C6   | 55,0<br>2.165 | 15,0<br>0.591 | 63,0<br>2.480 | 103,0<br>4.055 |   | 0          | -            | 2,1<br>4.630  |
| C8-391.02R-63055A | 03080030 | C8   | C6   | 55,0<br>2.165 | 15,0<br>0.591 | 63,0<br>2.480 | 103,0<br>4.055 | * | 0          | -            | 1,9<br>4.190  |

## Kiegészítők

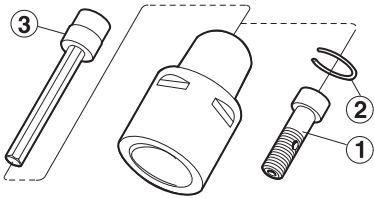
| Megnevezés        | Nyitó kulcs |
|-------------------|-------------|
| C5-391.02-32033A  | 5680015-05  |
| C5-391.02-40040A  | 5680015-05  |
| C6-391.02-32032   | 5680015-05  |
| C6-391.02-40040   | 5680015-05  |
| C6-391.02-50050A  | 5680015-01  |
| C8-391.02-50045A  | 5680015-01  |
| C8-391.02-63055A  | 5680015-02  |
| C8-391.02R-63055A | 5680015-02  |



Pótalkatrészek

| Megnevezés        | Központi csavar | Seeger-gyűrű |
|-------------------|-----------------|--------------|
| 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   |

Kiegészítők / Pótalkatrészek



Kiegészítők:  
3 = Nyitó kulcs

Pótalkatrészek:  
1 = Központi csavar  
2 = Seeger alátét

Bevezetés

Fúrás

Dörzsárazás

Kiesztergálás

Melléklet



## Nagyoló kiesztorgálás

A Seco nagyoló kiesztorgálási termékei a szilárdságuk és nagy merevségük révén maximalizálják az anyagleválasztási arányt és pontosságot. Szimmetrikus és lépcsőzetes kivitelben kapható. A Steadyline™ rezgéscsillapító megoldások kiegészítik a választékot, hogy még nagyobb stabilitást biztosítsanak a mély üregek kimunkálásához, ahol hosszú szerszámtúlnyúlásokra van szükség.

- Az RB 750 nagyoló kiesztorgáló fejek a lehető legnagyobb nagyoló kiesztorgálási teljesítményt nyújtják
- Az RB 610 nagyoló kiesztorgáló fejek nagyoló műveletekhez való rövid, egyszerű, robusztus kiesztorgáló fejek

## Nagyoló kiesztergáló fejek áttekintése

### 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")

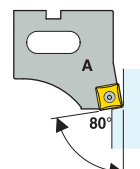
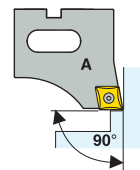
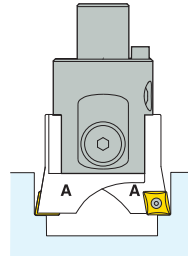


Ø 85-144 (Ø 3.346"-5.669")

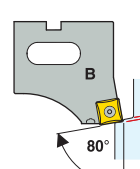
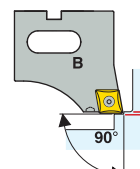
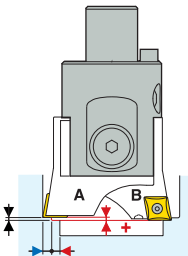


Ø 114-205 (Ø 4.488"-8.071")

Szimmetrikus kiesztergálás:  
2 szabványos A típusú lapkatartó



Lépcsőzetes kiesztergálás:  
1 meghosszabbított B típusú és 1 szabványos A típusú lapkatartó



Bevezetés

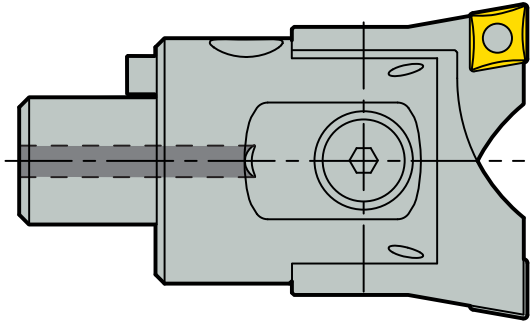
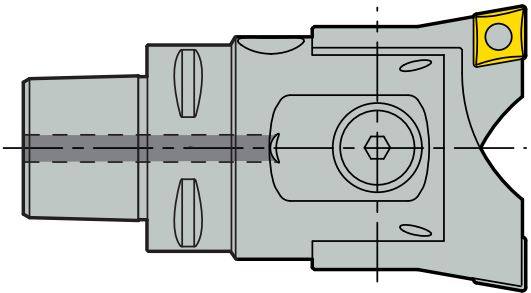
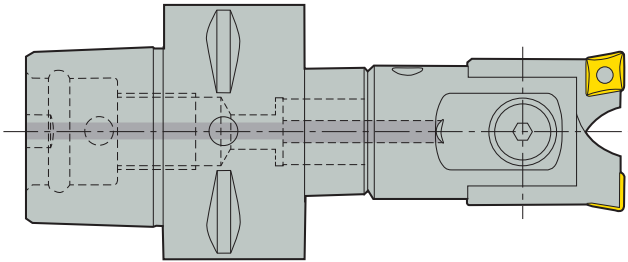
Fúrás

Dörzsárazás

Kiesztergálás

Melléklet

## Jellemzők

|   |  |             |
|---|--|-------------|
| <p><b>Graflex® nagyoló kiesztgáló fejek</b></p> <ul style="list-style-type: none"> <li>• Ø 18–205 mm (0.709–8.071")</li> <li>• 8 nagyoló kiesztgáló fej, RB 750, Graflex® csatlakozóval Ø 18–205 mm (0.709–8.071") furatokhoz</li> </ul>  |    | Bevezetés   |
| <p><b>Seco-Capto™ nagyoló kiesztgáló fejek</b></p> <ul style="list-style-type: none"> <li>• <b>Megjegyzés:</b> A legkisebb Capto™ nagyoló kiesztgáló fejekkel készíthető legkisebb furatméret Ø 39 mm (1.535"), a kapható legkisebb Capto™ C3 csatlakozóval.</li> <li>• Ø 18–40 mm (0.709–1.575") furathoz használja a G0–G2 csatlakozóméretű Graflex® kiesztgáló fejeket a megfelelő Capto™/Graflex® adapterrel.</li> </ul>  |   | Fúrás       |
| <p><b>Seco-Capto™ nagyoló kiesztgáló fejek</b></p> <ul style="list-style-type: none"> <li>• <b>Megjegyzés:</b> A jellemzők, előírások (lapkátartó beszerelés, átmérő beállítás, visszaesztgálási utasítások, hibaelhárítás, ajánlott megmunkálási feltételek, maximális sebességek), alkalmazható lapkátartók és lapkák ugyanazok mindkét RB 750 simító kiesztgáló fejek egyazon méreteihez, függetlenül a csatlakozás típusától.</li> <li>• Moduláris egységek és forgácsolási körülmények, Seco-Capto™ és Graflex® adapterek és moduláris hosszabbítók: lásd a Felszerszámozás katalógust.</li> </ul> |  | Dörzsárazás |
|   |  | Kiesztgálás |
|   |  | Melléklet   |

## Jellemzők

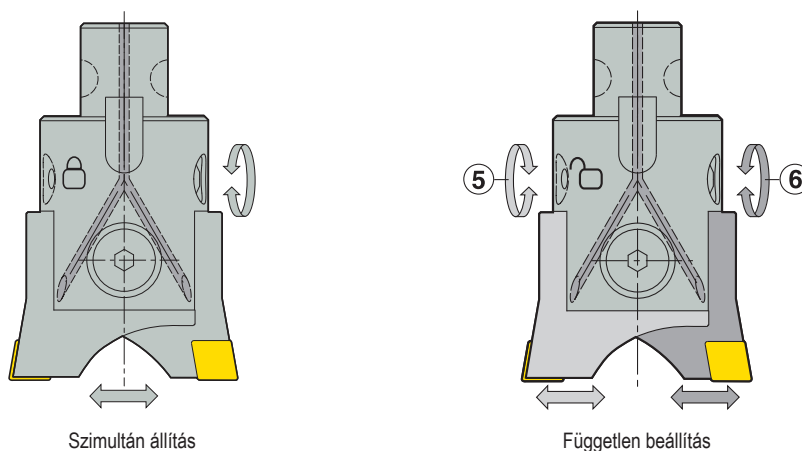
A nagyoló kiesztergáló szerszám 1 test (fej) és 2 lapkatartó kombinációja.

### A lapkatartók szimultán vagy függetlenül állíthatók be:

A szimultán beállítás a lapkatartó csatlakozó mechanizmusával végezhető el (a legkisebb fej, Ø 18–24 mm (0.709–0.9445") esetén nincs csatlakozó mechanizmus).

Minden állítócsavar egyszerre mozgatja mindkét lapkatartót (fogaskerékkel összekapcsolva).

Az átmérő előbeállítás nélkül (1 osztás = 0,1 mm (0,004") átmérőt jelent) beállítható. Független beállítás is lehetséges: oldja fel a rögzítést, hogy mindkét állító csavar külön lapkatartót mozgasson.



### Szimmetrikus kiesztergálás:

A szimmetrikus kiesztergálás azt jelenti, hogy mindkét vágóél ugyanarra az átmérőre van beállítva: Ehhez két, egyforma, A típusú, szabványos lapkatartó szükséges (azonos forgácsolási szöggel).

### Lépcsőzetes kiesztergálás:

A lépcsőzetes kiesztergálás azt jelenti, hogy az egyik vágóél vezető forgácsoló élként el van tolvá, és kisebb átmérőn halad, mint a másik él, amely a kívánt átmérőre van beállítva: ehhez egy A típusú, szabványos lapkatartó, illetve egy B típusú, meghosszabbított lapkatartó szükséges, mellyel elérhető a kívánt (+) axiális eltolás.

### 90° vagy 80° forgácsolási szögű lapkatartók

Az A75...CC... és A75...CP... lapkatartók 90°-os forgácsolási szögűek a rombusz alakú lapkákhöz: ez a legmegfelelőbb a zsákfuratokhoz, és kisebb orsónyomatékok igényelnek.

Az A75...SC... lapkatartók 80°-os forgácsolási szögűek a szögletes lapkákhöz: ezek a legmegfelelőbbek az átmenő furatokhoz és nagy igénybevételekhez. A forgácsoló él szögállása ISO szerinti.



## Jellemzők

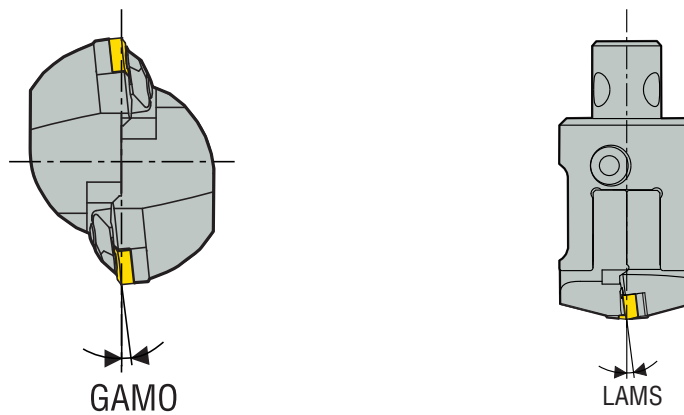
### CC, CP, SC vagy CN típusú lapkatartók

Az A750,..CC..., A750,..CP... és A750,..SC... lapkatartók  $0^\circ$  élszöggel (GAMO) és  $0^\circ$  kiegyenlítő szöggel (LAMS) rendelkeznek.

A750,..CN..... lapkatartók  $-6^\circ$  élszöggel (GAMO) és  $-6^\circ$  kiegyenlítő szöggel (LAMS), használhatók a „negatív” CNMM lapkával és a többélű CNMG lapkával 4 vágóéllel.

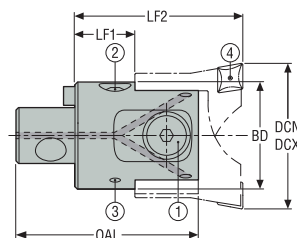
Ebben az esetben különösen fontos, hogy jól válasszunk az ajánlott CN lapkákból és használjuk az ajánlott forgácsolási adatokat (lásd a következő oldalt: 646).

Egyéb lapkák használata, pl. kisebb élszög, vagy/és nem megfelelő paraméterek nagy forgácsolási igénybevételt és a gép/munkadarab sérülését is okozhatják.



## RB750

Graflex®



- Szimmetrikus és lépcsős kiesztergálásra is alkalmas.
- Szimultán beállítás lapkatarató csatlakozó mechanizmussal.

1. Szerszám rögzítő csavar
2. Állító csavar
3. Csatlakozó mechanizmus rögzítő csavar
4. Lapka csavar

| Megnevezés | Cikkszám | Gép oldal<br>Graflex méret | Munkadarab oldal |                | Átmérő<br>DCN-DCX Ø | OAL           | LF1            | LF2           | BD            | Súly | Szimultán<br>beállítási mód |     | Független<br>beállítási mód |     | Max. ford. |
|------------|----------|----------------------------|------------------|----------------|---------------------|---------------|----------------|---------------|---------------|------|-----------------------------|-----|-----------------------------|-----|------------|
|            |          |                            | mm<br>Inch       | mm<br>Inch     |                     |               |                |               |               |      | Igen                        | Nem | Igen                        | Nem |            |
| A75000     | 00026687 | G0                         | 18,0<br>0.709    | 24,0<br>0.945  | 38,0<br>1.496       | 12,5<br>0.492 | 35,0<br>1.378  | 16,5<br>0.650 | 0,03<br>0.070 |      | ■                           | ■   |                             |     | 15000      |
| A75010     | 00026688 | G1                         | 23,0<br>0.906    | 31,0<br>1.220  | 42,5<br>1.673       | 13,5<br>0.531 | 40,0<br>1.575  | 21,5<br>0.846 | 0,1<br>0.220  | ■    |                             | ■   |                             |     | 12000      |
| A75020     | 00026689 | G2                         | 30,0<br>1.181    | 40,0<br>1.575  | 51,0<br>2.008       | 16,0<br>0.630 | 46,0<br>1.811  | 27,0<br>1.063 | 0,11<br>0.240 | ■    |                             | ■   |                             |     | 9500       |
| A75030     | 00026690 | G3                         | 39,0<br>1.535    | 51,0<br>2.008  | 69,0<br>2.717       | 24,0<br>0.945 | 65,0<br>2.559  | 35,0<br>1.378 | 0,5<br>1.100  | ■    |                             | ■   |                             |     | 7500       |
| A75040     | 00026691 | G4                         | 50,0<br>1.969    | 65,0<br>2.559  | 78,0<br>3.071       | 27,0<br>1.063 | 72,0<br>2.835  | 43,0<br>1.693 | 0,46<br>1.010 | ■    |                             | ■   |                             |     | 5700       |
| A75050     | 00026692 | G5                         | 64,0<br>2.520    | 86,0<br>3.386  | 92,0<br>3.622       | 30,0<br>1.181 | 82,0<br>3.228  | 54,0<br>2.126 | 0,8<br>1.760  | ■    |                             | ■   |                             |     | 4500       |
| A75060     | 00026693 | G6                         | 85,0<br>3.346    | 144,0<br>5.669 | 119,0<br>4.685      | 37,0<br>1.457 | 105,0<br>4.134 | 70,0<br>2.756 | 1,69<br>3.730 | ■    |                             | ■   |                             |     | 3500       |
| A75070     | 00026694 | G7                         | 114,0<br>4.488   | 205,0<br>8.071 | 143,0<br>5.630      | 39,0<br>1.535 | 120,0<br>4.724 | 95,0<br>3.740 | 3,7<br>8.160  | ■    |                             | ■   |                             |     | 2500       |

A lapkataratókat külön kell rendelni, lásd a 562-566 old.  
Megj.: súly a lapkatarató nélkül

### Pótalkatrészek

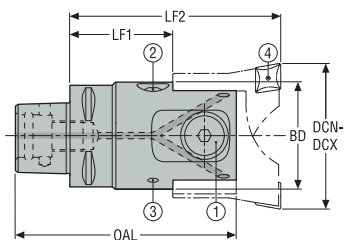
### Kiegészítők

| Fej    | Összeszerelő<br>csavar | Rögzítő kulcs | Vezető kulcs | Lapka kulcs | Kulcs (T-típus) | Beállító kulcs | Retes | Ék       |
|--------|------------------------|---------------|--------------|-------------|-----------------|----------------|-------|----------|
| A75000 | 90A75000               | 03HL03        | -            | H4B-T07P    | DOUBLE-T        | H1.5-2D        | 90M0  | -        |
| A75010 | 90A75010               | 03HL03        | H4B-T06P     | H4B-T07P    | DOUBLE-T        | H1.5-2D        | 90M11 | CAA75010 |
| A75020 | 90A75020               | 03HL04        | H4B-T07P     | -           | DOUBLE-T        | H2.0-2D        | 90M21 | CAA75020 |
| A75030 | 90A75030               | 03HL05        | H4B-T08P     | -           | DOUBLE-T        | H2.0-2D        | 90M31 | CAA75030 |
| A75040 | 90A75040               | 03HL05        | H4B-T09P     | -           | DOUBLE-T        | H2.5-2D        | 90M41 | CAA75040 |
| A75050 | 90A75050               | 03HL06        | -            | -           | DOUBLE-T        | 03M03C         | 90M51 | CAA75050 |
| A75060 | 90A75060               | 03HL08        | -            | -           | DOUBLE-T        | H04-4          | 90M61 | CAA75060 |
| A75070 | 90A75070               | 03HL10        | H4B-T15P     | H4B-T15PL   | DOUBLE-T        | H04-4          | 90M71 | CAA75070 |

Kiegészítők, külön rendelendő

RB750

Seco-Capto™



1. Szerszám rögzítő csavar
2. Állító csavar
3. Csatlakozó mechanizmus rögzítő csavar
4. Lapka csavar



- Szimmetrikus és lépcsős kiesztergálásra is alkalmas.
- Szimultán beállítás lapkatartó csatlakozó mechanizmussal.

| Megnevezés     | Cikkszám | Gép oldal | Munkadarab oldal Átmérő |                | OAL            | LF1           | LF2            | BD            | Súly          | Szimultán beállítási mód |     | Független beállítási mód |     | Max. ford. |
|----------------|----------|-----------|-------------------------|----------------|----------------|---------------|----------------|---------------|---------------|--------------------------|-----|--------------------------|-----|------------|
|                |          |           | mm                      | Inch           |                |               |                |               |               | Igen                     | Nem | Igen                     | Nem |            |
| C3-391.0750-30 | 02809726 | C3        | 39,0<br>1.535           | 51,0<br>2.008  | 73,0<br>2.874  | 29,0<br>1.142 | 70,0<br>2.756  | 35,0<br>1.378 | 0,28<br>0.620 | ■                        |     | ■                        |     | 7500       |
| C4-391.0750-40 | 02809728 | C4        | 50,0<br>1.969           | 65,0<br>2.559  | 88,0<br>3.465  | 37,0<br>1.457 | 82,0<br>3.228  | 43,0<br>1.693 | 0,52<br>1.150 | ■                        |     | ■                        |     | 5700       |
| C5-391.0750-50 | 02809733 | C5        | 64,0<br>2.520           | 86,0<br>3.386  | 102,0<br>4.016 | 40,0<br>1.575 | 92,0<br>3.622  | 54,0<br>2.126 | 0,94<br>2.070 | ■                        |     | ■                        |     | 4500       |
| C6-391.0750-60 | 02809735 | C6        | 85,0<br>3.346           | 144,0<br>5.669 | 129,0<br>5.079 | 49,0<br>1.929 | 117,0<br>4.606 | 70,0<br>2.756 | 1,88<br>4.140 | ■                        |     | ■                        |     | 3500       |
| C8-391.0750-70 | 02809736 | C8        | 114,0<br>4.488          | 205,0<br>8.071 | 159,0<br>6.260 | 57,0<br>2.244 | 138,0<br>5.433 | 95,0<br>3.740 | 4,14<br>9.130 | ■                        |     | ■                        |     | 2500       |

A lapkatartókat külön kell rendelni, lásd a 562-566 old.  
Megj.: súly a lapkatartó nélkül

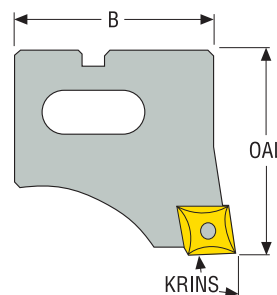
Pótalkatrészek

Kiegészítők

| Fej       | Összeszerelő csavar | Rögzítő kulcs | Vezető kulcs | Kulcs (T-típus) | Beállító kulcs | Ék       |
|-----------|---------------------|---------------|--------------|-----------------|----------------|----------|
| C3-...-30 | 90A75030            | 03HL05        | H4B-T08P     | DOUBLE-T        | H2.0-2D        | CAA75030 |
| C4-...-40 | 90A75040            | 03HL05        | H4B-T09P     | DOUBLE-T        | H2.5-2D        | CAA75040 |
| C5-...-50 | 90A75050            | 03HL06        | -            | DOUBLE-T        | 03M03C         | CAA75050 |
| C6-...-60 | 90A75060            | 03HL08        | -            | DOUBLE-T        | H04-4          | CAA75060 |
| C8-...-70 | 90A75070            | 03HL10        | -            | DOUBLE-T        | H04-4          | CAA75070 |

Kiegészítők, külön rendelendő

## Lapkatartók 90° a CC.. és CP.. lapkákhoz



- Az RB A750 típusú fejekhez
- A szimmetrikus kiesztergáláshoz kettő, szabványos, A típusú lapkatartó szükséges.
- A lépcsőzetes kiesztergáláshoz egy, szabványos, A típusú és egy meghosszabbított, B típusú lapkatartó szükséges.

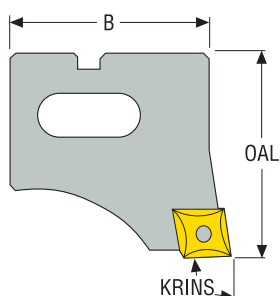
| Megnevezés   | Cikkszám | Lapkatartó típus   | Fej      | Átmérő DCN-DCX Ø |                | OAL           | B              | Súly          | KRINS° | Használható lapka méret |
|--------------|----------|--------------------|----------|------------------|----------------|---------------|----------------|---------------|--------|-------------------------|
|              |          |                    |          | mm               | mm             |               |                |               |        |                         |
| A75000CP0590 | 00026695 | Szabványos A típus | RB 75000 | 18,0<br>0.709    | 24,0<br>0.945  | 22,5<br>0.886 | 16,5<br>0.650  | 0,01<br>0.020 | 90     | CP...0502...            |
| A75010CC0690 | 00026696 | Szabványos A típus | RB 75010 | 23,0<br>0.906    | 31,0<br>1.220  | 26,5<br>1.043 | 21,5<br>0.846  | 0,02<br>0.040 | 90     | CC...0602...            |
| A75020CC0690 | 00026697 | Szabványos A típus | RB 75020 | 30,0<br>1.181    | 40,0<br>1.575  | 30,0<br>1.181 | 27,0<br>1.063  | 0,04<br>0.090 | 90     | CC...0602...            |
| A75030CC0990 | 00026698 | Szabványos A típus | RB 75030 | 39,0<br>1.535    | 51,0<br>2.008  | 41,0<br>1.614 | 35,0<br>1.378  | 0,08<br>0.180 | 90     | CC...09T3...            |
| A75040CC1290 | 00026699 | Szabványos A típus | RB 75040 | 50,0<br>1.969    | 65,0<br>2.559  | 45,0<br>1.772 | 43,0<br>1.693  | 0,14<br>0.310 | 90     | CC...1204...            |
| A75050CC1290 | 00026700 | Szabványos A típus | RB 75050 | 64,0<br>2.520    | 86,0<br>3.386  | 52,0<br>2.047 | 54,0<br>2.126  | 0,25<br>0.550 | 90     | CC...1204...            |
| A75060CC1290 | 00026701 | Szabványos A típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,0<br>2.677 | 70,0<br>2.756  | 0,55<br>1.210 | 90     | CC...1204...            |
| A75060CC1690 | 00030763 | Szabványos A típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,0<br>2.677 | 70,0<br>2.756  | 0,55<br>1.210 | 90     | CC...1605...            |
| A75065CC1290 | 00026702 | Szabványos A típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,0<br>2.677 | 100,0<br>3.937 | 0,89<br>1.960 | 90     | CC...1204...            |
| A75065CC1690 | 00030765 | Szabványos A típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,0<br>2.677 | 100,0<br>3.937 | 0,9<br>1.980  | 90     | CC...1605...            |
| A75070CC1290 | 00026703 | Szabványos A típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 81,0<br>3.189 | 95,0<br>3.740  | 1,18<br>2.600 | 90     | CC...1204...            |
| A75070CC1690 | 00030766 | Szabványos A típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 81,0<br>3.189 | 95,0<br>3.740  | 1,18<br>2.600 | 90     | CC...1605...            |
| A75075CC1290 | 00026704 | Szabványos A típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 81,0<br>3.189 | 141,0<br>5.551 | 2,0<br>4.410  | 90     | CC...1204...            |
| A75075CC1690 | 00030771 | Szabványos A típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 81,0<br>3.189 | 141,0<br>5.551 | 2,0<br>4.410  | 90     | CC...1605...            |

### Pótalkatrészek

| Lapka méret  | Lapka kulcs | Kulcs (T-típus) | Csavar      |
|--------------|-------------|-----------------|-------------|
| 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 |

Nagyoló kiesztergáláshoz lapkák a 646 old.

## Lapkatartók 90° a CC.. és CP.. lapkákhoz



- Az RB A750 típusú fejekhez
- A szimmetrikus kiesztorgáláshoz kettő, szabványos, A típusú lapkatartó szükséges.
- A lépcsőzetes kiesztorgáláshoz egy, szabványos, A típusú és egy meghosszabbított, B típusú lapkatartó szükséges.

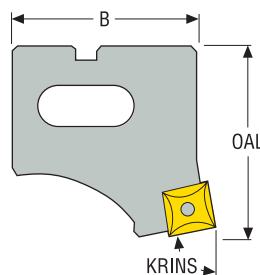
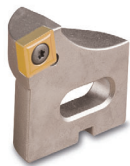
| Megnevezés   | Cikkszám | Lapkatartó típus  | Fej      | Átmérő DCN-DCX Ø |                | OAL            | B              | Súly          | KRINS° | Használható lapka méret |
|--------------|----------|-------------------|----------|------------------|----------------|----------------|----------------|---------------|--------|-------------------------|
|              |          |                   |          | mm<br>Inch       | mm<br>Inch     |                |                |               |        |                         |
| A75001CP0590 | 00026705 | Erősített B típus | RB 75000 | 18,0<br>0.709    | 24,0<br>0.945  | 22,8<br>0.898  | 16,5<br>0.650  | 0,01<br>0.020 | 90     | CP...0502...            |
| A75011CC0690 | 00026706 | Erősített B típus | RB 75010 | 23,0<br>0.906    | 31,0<br>1.220  | 26,85<br>1.057 | 21,5<br>0.846  | 0,02<br>0.040 | 90     | CC...0602...            |
| A75021CC0690 | 00026707 | Erősített B típus | RB 75020 | 30,0<br>1.181    | 40,0<br>1.575  | 30,35<br>1.195 | 27,0<br>1.063  | 0,04<br>0.090 | 90     | CC...0602...            |
| A75031CC0990 | 00026708 | Erősített B típus | RB 75030 | 39,0<br>1.535    | 51,0<br>2.008  | 41,4<br>1.630  | 35,0<br>1.378  | 0,08<br>0.180 | 90     | CC...09T3...            |
| A75041CC1290 | 00026709 | Erősített B típus | RB 75040 | 50,0<br>1.969    | 65,0<br>2.559  | 46,5<br>1.831  | 43,0<br>1.693  | 0,13<br>0.290 | 90     | CC...1204...            |
| A75051CC1290 | 00026710 | Erősített B típus | RB 75050 | 64,0<br>2.520    | 86,0<br>3.386  | 52,6<br>2.071  | 54,0<br>2.126  | 0,25<br>0.550 | 90     | CC...1204...            |
| A75061CC1290 | 00026711 | Erősített B típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,6<br>2.701  | 70,0<br>2.756  | 0,55<br>1.210 | 90     | CC...1204...            |
| A75061CC1690 | 00030774 | Erősített B típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,6<br>2.701  | 70,0<br>2.756  | 0,55<br>1.210 | 90     | CC...1605...            |
| A75066CC1290 | 00026712 | Erősített B típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,6<br>2.701  | 100,0<br>3.937 | 0,91<br>2.010 | 90     | CC...1204...            |
| A75066CC1690 | 00030775 | Erősített B típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,6<br>2.701  | 100,0<br>3.937 | 0,91<br>2.010 | 90     | CC...1605...            |
| A75071CC1290 | 00026713 | Erősített B típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 81,6<br>3.213  | 95,0<br>3.740  | 1,16<br>2.560 | 90     | CC...1204...            |
| A75071CC1690 | 00030776 | Erősített B típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 81,6<br>3.213  | 95,0<br>3.740  | 1,16<br>2.560 | 90     | CC...1605...            |
| A75076CC1290 | 00026714 | Erősített B típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 81,6<br>3.213  | 141,0<br>5.551 | 2,0<br>4.410  | 90     | CC...1204...            |
| A75076CC1690 | 00030778 | Erősített B típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 81,6<br>3.213  | 141,0<br>5.551 | 2,01<br>4.430 | 90     | CC...1605...            |

## Pótalkatrészek

| Lapka méret  | Kulcs (T-típus) | Kulcs    | Csavar      |
|--------------|-----------------|----------|-------------|
| 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 |

Nagyoló kiesztorgáláshoz lapkák a 646 old.

## Lapkatartók 80° az SC.. lapkákhoz






- Az RB A750 típusú fejekhez
- A szimmetrikus kiesztergáláshoz kettő, szabványos, A típusú lapkatartó szükséges.
- A lépcsőzetes kiesztergáláshoz egy, szabványos, A típusú és egy meghosszabbított, B típusú lapkatartó szükséges.

| Megnevezés   | Cikkszám | Lapkatartó típus   | Fej      | Átmérő DCN-DCX Ø |                | OAL           | B              | Súly          | KRINS° | Használható lapka méret |
|--------------|----------|--------------------|----------|------------------|----------------|---------------|----------------|---------------|--------|-------------------------|
|              |          |                    |          | mm               | mm             |               |                |               |        |                         |
|              |          |                    |          | Inch             | Inch           | Inch          | Inch           | kg            |        |                         |
|              |          |                    |          |                  |                | Inch          | Inch           | lbs           |        |                         |
| A75000SC0580 | 00026715 | Szabványos A típus | RB 75000 | 18,0<br>0.709    | 24,0<br>0.945  | 22,5<br>0.886 | 16,5<br>0.650  | 0,01<br>0.020 | 80     | SC...0502...            |
| A75010SC0680 | 00026716 | Szabványos A típus | RB 75010 | 23,0<br>0.906    | 31,0<br>1.220  | 26,5<br>1.043 | 21,5<br>0.846  | 0,02<br>0.040 | 80     | SC...0602...            |
| A75020SC0680 | 00026717 | Szabványos A típus | RB 75020 | 30,0<br>1.181    | 40,0<br>1.575  | 30,0<br>1.181 | 27,0<br>1.063  | 0,04<br>0.090 | 80     | SC...0602...            |
| A75030SC0980 | 00026718 | Szabványos A típus | RB 75030 | 39,0<br>1.535    | 51,0<br>2.008  | 41,0<br>1.614 | 35,0<br>1.378  | 0,08<br>0.180 | 80     | SC...09T3...            |
| A75040SC1280 | 00026719 | Szabványos A típus | RB 75040 | 50,0<br>1.969    | 65,0<br>2.559  | 45,0<br>1.772 | 43,0<br>1.693  | 0,03<br>0.070 | 80     | SC...1204...            |
| A75050SC1280 | 00051986 | Szabványos A típus | RB 75050 | 64,0<br>2.520    | 86,0<br>3.386  | 52,0<br>2.047 | 54,0<br>2.126  | 0,25<br>0.550 | 80     | SC...1204...            |
| A75060SC1280 | 00052207 | Szabványos A típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,0<br>2.677 | 70,0<br>2.756  | 0,56<br>1.230 | 80     | SC...1204...            |
| A75060SC1580 | 00039863 | Szabványos A típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,0<br>2.677 | 70,0<br>2.756  | 0,56<br>1.230 | 80     | SC...1505...            |
| A75065SC1280 | 00051989 | Szabványos A típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,0<br>2.677 | 100,0<br>3.937 | 0,94<br>2.070 | 80     | SC...1204...            |
| A75065SC1580 | 00039865 | Szabványos A típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,0<br>2.677 | 100,0<br>3.937 | 1,0<br>2.200  | 80     | SC...1505...            |
| A75070SC1280 | 00026723 | Szabványos A típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 81,4<br>3.205 | 95,0<br>3.740  | 1,2<br>2.650  | 80     | SC...1204...            |
| A75070SC1580 | 00039867 | Szabványos A típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 81,4<br>3.205 | 95,0<br>3.740  | 1,18<br>2.600 | 80     | SC...1505...            |
| A75075SC1280 | 00026724 | Szabványos A típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 81,4<br>3.205 | 141,0<br>5.551 | 2,09<br>4.610 | 80     | SC...1204...            |
| A75075SC1580 | 00039869 | Szabványos A típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 81,4<br>3.205 | 141,0<br>5.551 | 2,1<br>4.630  | 80     | SC...1505...            |
| A75001SC0580 | 00092946 | Erősített B típus  | RB 75000 | 18,0<br>0.709    | 24,0<br>0.945  | 23,2<br>0.913 | 16,5<br>0.650  | 0,01<br>0.020 | 80     | SC...0502...            |
| A75011SC0680 | 00092947 | Erősített B típus  | RB 75010 | 23,0<br>0.906    | 31,0<br>1.220  | 27,3<br>1.075 | 21,5<br>0.846  | 0,02<br>0.040 | 80     | SC...0602...            |
| A75021SC0680 | 00092948 | Erősített B típus  | RB 75020 | 30,0<br>1.181    | 40,0<br>1.575  | 30,9<br>1.217 | 27,0<br>1.063  | 0,04<br>0.090 | 80     | SC...0602...            |
| A75031SC0980 | 00092949 | Erősített B típus  | RB 75030 | 39,0<br>1.535    | 51,0<br>2.008  | 42,2<br>1.661 | 35,0<br>1.378  | 0,08<br>0.180 | 80     | SC...09T3...            |
| A75041SC1280 | 00092961 | Erősített B típus  | RB 75040 | 50,0<br>1.969    | 65,0<br>2.559  | 46,4<br>1.827 | 43,0<br>1.693  | 0,14<br>0.310 | 80     | SC...1204...            |
| A75051SC1280 | 00092962 | Erősített B típus  | RB 75050 | 64,0<br>2.520    | 86,0<br>3.386  | 53,7<br>2.114 | 54,0<br>2.126  | 0,26<br>0.570 | 80     | SC...1204...            |
| A75061SC1580 | 00039864 | Erősített B típus  | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 70,3<br>2.768 | 70,0<br>2.756  | 0,57<br>1.260 | 80     | SC...1505...            |
| A75061SC1280 | 00092963 | Erősített B típus  | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 69,8<br>2.748 | 70,0<br>2.756  | 0,57<br>1.260 | 80     | SC...1204...            |

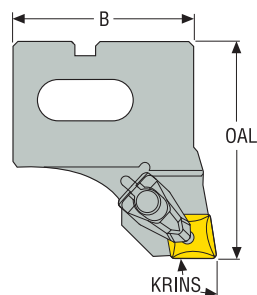
| Megnevezés   | Cikkszám | Lapkatartó típus  | Fej      | Átmérő DCN-DCX Ø |                | OAL           | B              | Súly          | KRINS° | Használható lapka méret |
|--------------|----------|-------------------|----------|------------------|----------------|---------------|----------------|---------------|--------|-------------------------|
|              |          |                   |          | mm<br>Inch       | mm<br>Inch     |               |                |               |        |                         |
| A75066SC1280 | 00092964 | Erősített B típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 69,8<br>2.748 | 100,0<br>3.937 | 0,96<br>2.120 | 80     | SC...1204...            |
| A75066SC1580 | 00039866 | Erősített B típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 70,3<br>2.768 | 100,0<br>3.937 | 0,96<br>2.120 | 80     | SC...1505...            |
| A75071SC1280 | 00092965 | Erősített B típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 82,8<br>3.260 | 95,0<br>3.740  | 1,21<br>2.670 | 80     | SC...1204...            |
| A75071SC1580 | 00039868 | Erősített B típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 83,3<br>3.280 | 95,0<br>3.740  | 1,21<br>2.670 | 80     | SC...1505...            |
| A75076SC1280 | 00092968 | Erősített B típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 82,8<br>3.260 | 141,0<br>5.551 | 2,16<br>4.760 | 80     | SC...1204...            |
| A75076SC1580 | 00039870 | Erősített B típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 83,3<br>3.280 | 141,0<br>5.551 | 2,14<br>4.720 | 80     | SC...1505...            |

## Pótalkatrészek

| Lapka méret  | Kulcs (T-típus)   | Kulcs   | Csavar  |
|--------------|---|---|---|
|              |  |  |  |
| 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   |

Nagyoló kiesztorgáláshoz lapkák a 646 old.

## Lapkatartók 80° az SC.. lapkákhoz



- Az RB A750 típusú fejekhez
- Szimmetrikus kiesztergáláshoz szükséges 2 szabványos A típusú lapkatartó (B típusú lapkatartó a CN.. lapkákhoz nincs).
- GAMO = forgácsolási szög = - 6°
- LAMS = kiegyenlítő szög = - 6°

| Megnevezés   | Cikkszám | Lapkatartó típus   | Fej      | Átmérő DCN-DCX Ø |                | OAL           | B              | Súly          | KRINS° | Használható lapka méret |
|--------------|----------|--------------------|----------|------------------|----------------|---------------|----------------|---------------|--------|-------------------------|
|              |          |                    |          | mm               | mm             |               |                |               |        |                         |
| A75050CN1290 | 02786307 | Szabványos A típus | RB 75050 | 64,0<br>2.520    | 86,0<br>3.386  | 63,0<br>2.480 | 55,0<br>2.165  | 0,28<br>0.620 | 90     | CN...1204...            |
| A75060CN1290 | 02786308 | Szabványos A típus | RB 75060 | 85,0<br>3.346    | 115,0<br>4.528 | 68,0<br>2.677 | 69,5<br>2.736  | 0,58<br>1.280 | 90     | CN...1204...            |
| A75065CN1290 | 02786309 | Szabványos A típus | RB 75060 | 114,0<br>4.488   | 144,0<br>5.669 | 68,0<br>2.677 | 99,5<br>3.917  | 0,98<br>2.160 | 90     | CN...1204...            |
| A75070CN1290 | 02786310 | Szabványos A típus | RB 75070 | 114,0<br>4.488   | 160,0<br>6.299 | 85,0<br>3.346 | 95,0<br>3.740  | 1,25<br>2.760 | 90     | CN...1204...            |
| A75075CN1290 | 02786311 | Szabványos A típus | RB 75070 | 159,0<br>6.260   | 205,0<br>8.071 | 85,0<br>3.346 | 140,0<br>5.512 | 2,03<br>4.480 | 90     | CN...1204...            |

### Pótalkatrészek

| Lapka méret  | Alátét csavar   | Rögzítő készlet   | Alátét lapka  | Kulcs (T-típus)   |
|--------------|---|---|---|---|
| CN...1204... | <br>CSC6312-T15P | <br>CD12-S12 | <br>UCN120612 | <br>DOUBLE-T |

Nagyoló kiesztergáláshoz lapkák a 646 old.



## Előírások Ajánlott megmunkálási feltételek

### Főrsó teljesítmény:

Mivel a nagyoló kiesztorgáláshoz nagy gépteljesítmény szükséges, először ellenőrizze, hogy a gép megfelelő-e. A lépcsőzetes kiesztorgálás megoldást jelent a teljesítményigények csökkentésére, mivel az előtolást a szimmetrikus beállításához képest kétszer el kell osztani ugyanahhoz a teljes fogásmélységhez.

A legjobb teljesítményt átmenő hűtőfolyadékkal lehet elérni (nagyobb forgácsolási paraméterek, jobb felületi minőség, jobb forgácskihordás, hosszabb lapkaéltartam).

Részletes utasításokért olvassa el a kiesztorgáló fejekkel és a Steadyline® rudakkal szállított mellékelt használati utasítást. A használati utasítás a [www.secotools.com](http://www.secotools.com) webhelyről is letölthető.

### Maximális sebességek a nagyoló kiesztorgáló fejekhez

| Fej   | Tartomány Ø mm | Tartomány Ø inch | Max. ford. | Adódó max. vágósebesség<br>$v_c$ min. átm. méret m/perc (sf/<br>min) | Adódó max. vágósebesség $v_c$<br>max. átm. méret m/perc (sf/<br>min) |
|---|----------------|------------------|------------|--|--|
| Nagyoló kiesztorgáló fejek (két ugyanolyan lapkatartóval szimmetrikusan állítva), Graflex® csatlakozóval    |                |                  |            |  |  |
| 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)  |
| Nagyoló kiesztorgáló fejek (két ugyanolyan lapkatartóval szimmetrikusan állítva), Seco-Capto™ csatlakozóval |                |                  |            |  |  |
| 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)  |

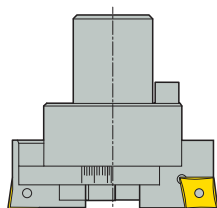
**Megjegyzés:** A maximum fordulatszámok függnek a kiesztorgáló fej mechanikus kivitelétől és kiegyensúlyozási minőségétől. Az ezeken a korlátokon belül lévő fordulatszámokat a többi forgácsolási feltétel alapján kell kiválasztani, pl. munkadarab anyaga, vágóél (lapka), szerszám hossza, gépporsó. kb. 8000 és magasabb fordulatszámnál finom-kiegyensúlyozni kell a tartóüskéket és a köztes elemeket.

## Hibaelhárítási utasítások

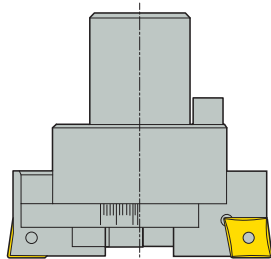
| Probléma                              | Lehetséges ok  | Megoldás   |   |
|---------------------------------------|--|--|---|
| Rossz forgácsrányítás                 | Túl alacsony előtolási sebesség<br>Túl nagy fogásmélység | Növelje az előtolási sebességet<br>Használja a lépcsőzetes módszert  |   |
| Kopogás és vibráció                   | Túl nagy sebesség  | A vágósebességet csökkentse, az előtolást ne<br>Rövidítse a szerszámot a merevség növeléséhez  |   |
|                                       | Extrém L/D arány   | Növelje a tartótüske és a köztes elemek külső átmérőjét<br>Steadyline rúd használata<br>Használjon keményfém vagy nehézfém hosszabbítókat  |   |
|                                       |  | Túl nagy rádiusz   | Használjon kisebb rádiuszú lapkát   |
|                                       |  | Nem stabil munkadarab  | Javítson a készülékhez történő befogáson és rögzítésen                      |
|                                       | A forgácsolási szög $\kappa = 80^\circ$                  | Cserélje $\kappa = 90^\circ$ értékre, CC típusú lapka  |   |
|                                       | Lapka sérülése vagy törése                               | Nem megfelelő lapka  | Válasszon szívósabb lapkaminőséget<br>Használjon nagyobb rádiuszt, ha lehet |
| Erősen megszakított forgácsolás       |  | Csökkentse a sebességet és az előtolást  |   |
| Forgács felrakódás és újraforgácsolás |  | Ellenőrizze a kiesztergáló rúd/furatátmérő játékát<br>Javítsa a forgácsszabályozást, növelje az előtolást  |   |
| Rövid szerszám élettartam             | Nem megfelelő lapka                                      | Válasszon kopásállóbb minőséget  |   |
|                                       | Túl nagy vágósebesség                                    | Csökkentse a sebességet  |   |
|                                       | Lapka élettöredezése                                     | Ellenőrizze a forgácsolási mélységet és az előtolási sebességet  |   |
|                                       | Túl alacsony hűtési nyomás                               | Növelje a hűtési nyomást   |   |
| A forgács nem távozik                 | Túl nagy a kiesztergáló szerszám                         | Váltson kisebb fejre hosszabbított lapkatartóval, ha lehetséges  |   |
|                                       | Túl nagy fogásmélység                                    | Használjon lépcsőzetes beállítást; lehetőleg CC.. lapkát a CN.. helyett (különösen kis furatok kiesztergálásánál).   |   |
|                                       | Nincs elég hely a furat alatt                            | Állítsa a munkadarabot magasabbra az asztalon  |   |
|                                       | Rossz forgácsrányítás                                    | Lásd fent  |   |
| Nem megfelelő gépteljesítmény         | Túl nagy előtolás  | Csökkentse az előtolást (ne legyen kevesebb, mint a lapka rádiuszának 25%-a)   |   |
|                                       | Túl nagy fogásmélység                                    | Használja a lépcsőzetes módszert   |   |
|                                       | Kis gépteljesítmény                                      | Fordulatszám alacsony orsónyomatékkal: növelje a fordulatszámot<br>Fordulatszám áttétel átkapcsolásakor: állítson a fordulatszámra<br>Váltson nagyobb dőlésszögű lapkára (különleges esetekben HSS-re) |   |
|                                       |  | Csökkentse a forgácsolási mélységet  |   |
|                                       |  | Csökkentse az előtolást  |   |
| Túl sok sorja a furat kimeneténél     | Túl nagy előtolás  | Csökkentse az előtolást  |   |
|                                       | CC típusú lapkatartók $90^\circ$                         | Használjon $80^\circ$ -os, négyszög lapkás lapkatartót   |   |
|                                       | A forgácsolóerők túl nagyok                              | Csökkentse a forgácsolási mélységet<br>Csökkentse a lapka rádiuszt   |   |

## RB 610 Nagyoló kiesztergáló fejek – Áttekintés

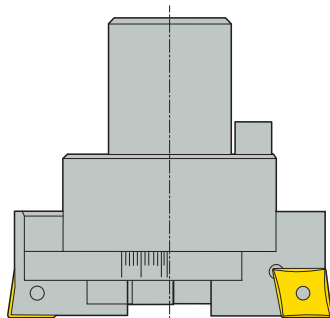
Graflex® csatlakozás



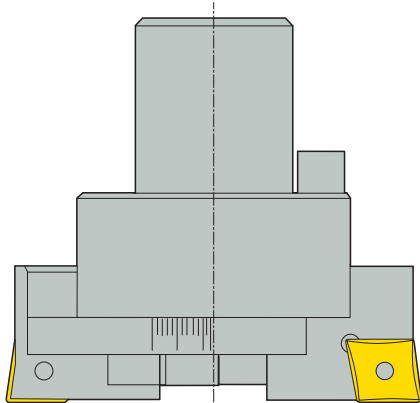
Ø 39–51 mm (Ø 1.535–2.008")



Ø 50–65 mm (Ø 1.969–2.559")

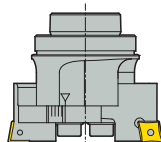


Ø 64–86 mm (Ø 2.520–3.386")

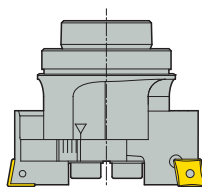


Ø 85–115 mm (Ø 3.346–4.528")

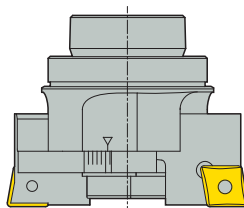
GL csatlakozás



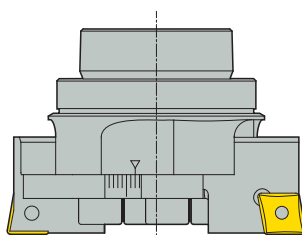
Ø 28–37 mm (Ø 1.102–1.457")



Ø 36–46 mm (Ø 1.417–1.811")

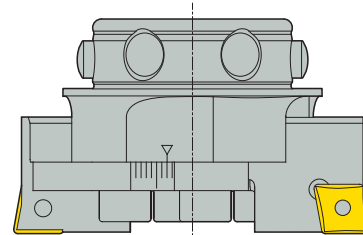


Ø 45–56 mm (Ø 1.772–2.205")

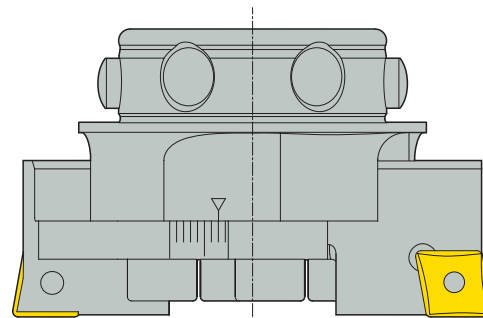


Ø 55–69 mm (Ø 2.165–2.717")

BA csatlakozás



Ø 66–88 mm (Ø 2.598–3.465")



Ø 86–116 mm (Ø 3.386–4.567")

## RB 610 típus Nagyoló kiesztérgáló fejek – Útmutató

### Jellemzők

- A nagyoló kiesztérgáló szerszám 1 test (fej) és 2 lapkatarató kombinációja
- Geometriai furatpontosság öntött, lángvágott vagy fűrt furatok esetén
- Minimalizált kiegyensúlyozatlanság a szimmetrikus kivitelnek köszönhetően

### Kompakt

- Rövid test a fűrészerkezet merevségének maximalizálása érdekében, és a legjobb csillapítási teljesítmény biztosítása a Steadyline® esztérgáló- és fűrórudaknál
- Csökkentett tömeg a gyors szerszámcserehez és az orsó gyorsításához

### Intuitív és gyors beállítás

- Mindegyik lapkatarató jellemzője a nyomó és húzó mechanizmus, amely biztosítja az egyszerű és gyors átmérő beállítását, szerszámberőrt használva
- Az átmérő skála nagyjából láthatóvá teszi a lapkataratók helyzetét

### Lapkataratók

- A610...CC... lapkataratók biztosítják a 90°-os forgácsolási szöget a rombusz alakú lapkákkal, 0°-os élszöggel és 0°-os kiegyenlítő szöggel
- A lapkataratók használhatók az RB 610 Graflex® és RB 610 GL fejekhez

### Termelékenység

- A nagy merevség a fejbe feszesen illesztett lapkataratóknak és a nagy rögzítő csavaroknak köszönhető
- Lehetséges a forgácsolási mélység, ap növelése a lapka vastagsága feléig, maximalizálva a forgácsolási arányt, lehetővé téve a lapka teljes kihasználását
- Lépcsőzetes beállításnál használja az alátétet (része a szállítmánynak) az egyik lapkatarató eltolásához, hogy megnövelje a radiális forgácsolási mélységet
- Az átáramló hűtőfolyadék a vágóélekre van irányítva

### Termékválaszték

- Az RB 610 nagyoló kiesztérgáló fejek Graflex® géppoldali csatlakozással rendelkeznek, a kényelmes kiesztérgálási műveletek érdekében akár 6xD túlnyúlásig,
- A GL és BA géppoldali csatlakozással rendelkező RB 610 nagyoló kiesztérgáló fejek nagyobb túlnyúlásokra készültek rezgécscillapító Steadyline® szerelvényekkel.

### RB 610 Graflex®



- Graflex®: 4 kompakt nagyoló kiesztérgáló fej  $\varnothing$  39–115 mm ( $\varnothing$  1.535–4.528") furatokhoz
- A flexibilis Graflex® moduláris rendszer lehetővé teszi az optimális kiesztérgáló összeszerelést a Graflex® adapterekkel, közbetétekkel és kiesztérgáló fejekkel

### RB 610 GL és BA, a Steadyline® rezgécscillapított rudakhoz



GL



BA

- GL: 4 rövid és kompakt nagyoló kiesztérgáló fej,  $\varnothing$  28–69 mm ( $\varnothing$  1.102–2.717") furatokhoz
- BA: 2 rövid és kompakt nagyoló kiesztérgáló fej,  $\varnothing$  66–116 mm ( $\varnothing$  1.417–2.717") furatokhoz
- Kifejezetten a Steadyline® esztérgáló- és fűrórudakhoz készült. A hosszú Steadyline® rudak használatakor a kiesztérgálás teljesítménye hasonló a rövid nem csillapított összeállításéhoz (<6xD).

## RB 610 típus Nagyoló kiesztorgáló fejek – Útmutató

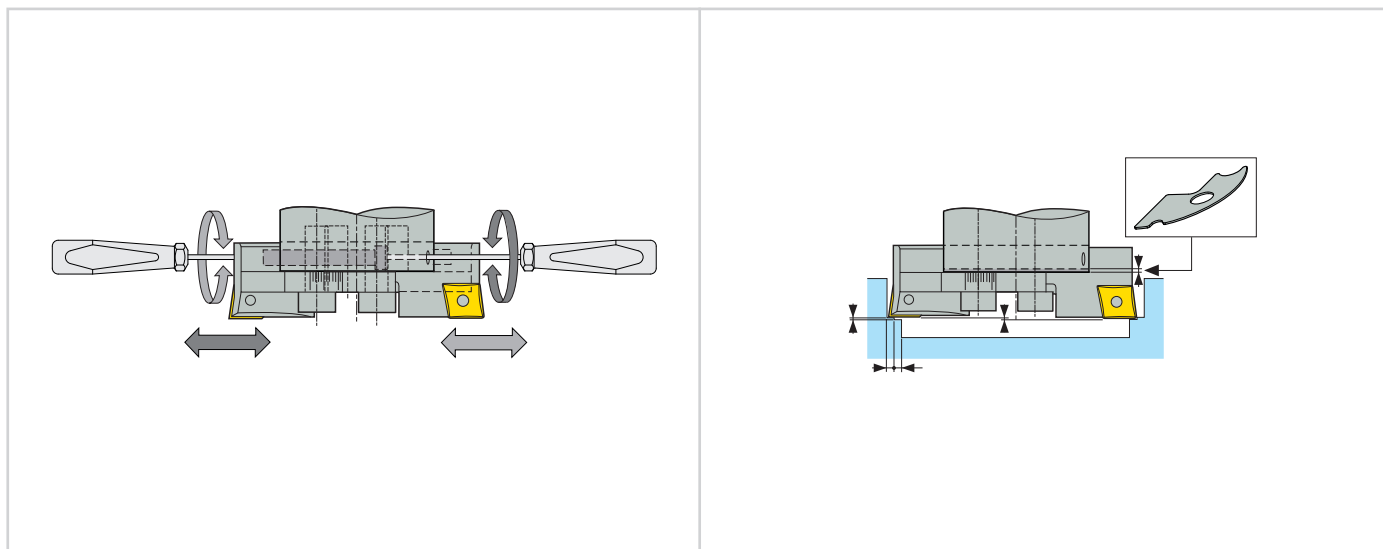
### Szimmetrikus kiesztorgálás beállítása:

A szimmetrikus kiesztorgálás azt jelenti, hogy mindkét vágóél ugyanarra az átmérőre és magasságra van beállítva:

### Lépcsőzetes kiesztorgálás beállítása:

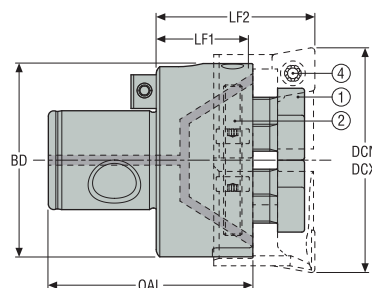
A lépcsőzetes kiesztorgálás azt jelenti, hogy az egyik vágóél el van tolvva mint (a furatba először belépő) vezető forgácsoló él, és kisebb átmérőn halad, mint a másik él, amely a kívánt átmérőre van beállítva: A kiesztorgáló fej teste és az egyik lapkatarató közé történő felszereléshez (a fejhez szállított) alátétet igényel a (+) axiális eltolás eléréséhez, lásd az alábbi táblázatot.

| alátétlapka megnevezés | Vastagság (mm) | Vastagság (inch) |
|------------------------|----------------|------------------|
| 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®



- Szimmetrikus és lépcsőzetes kiesztergálási módok lehetőségek
- Egyedi lapkatartók állító mechanizmus
- Belső hűtés a lapkákra

1. Rögzítő csavar és rögzítő kulcs
- 2 & 4. Lapka kulcs az átmérő beállításához és lapka rögzítéshez

| Megnevezés | Cikkszám | Gép oldal<br>Graflex méret | Munkadarab oldal Átmérő<br>DCN-DCX Ø |                | OAL           | LF1           | LF2           | BD            | Súly          | Max. ford.* |
|------------|----------|----------------------------|--------------------------------------|----------------|---------------|---------------|---------------|---------------|---------------|-------------|
|            |          |                            | mm<br>Inch                           | mm<br>Inch     |               |               |               |               |               |             |
| A61030     | 02904453 | G3                         | 39,0<br>1.535                        | 51,0<br>2.008  | 43,5<br>1.713 | 23,5<br>0.925 | 36,4<br>1.433 | 34,0<br>1.339 | 0,18<br>0.400 | 7500        |
| A61040     | 02904454 | G4                         | 50,0<br>1.969                        | 65,0<br>2.559  | 45,5<br>1.791 | 21,5<br>0.846 | 35,3<br>1.390 | 43,0<br>1.693 | 0,27<br>0.600 | 5700        |
| A61050     | 02904455 | G5                         | 64,0<br>2.520                        | 86,0<br>3.386  | 55,0<br>2.165 | 25,0<br>0.984 | 42,3<br>1.665 | 54,0<br>2.126 | 0,54<br>1.190 | 4500        |
| A61060     | 02904457 | G6                         | 85,0<br>3.346                        | 115,0<br>4.528 | 69,0<br>2.717 | 29,0<br>1.142 | 47,8<br>1.882 | 63,0<br>2.480 | 0,93<br>2.050 | 3500        |

A lapkatartókat külön kell rendelni, lásd a 575 old.

\* Megjegyzések a max fordulatszámokról, lásd az Utasítás oldalakat.

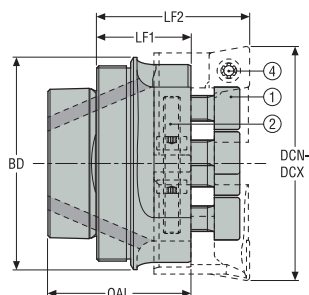
Megj.: súly a lapkatartó nélkül

## Pótalkatrészek

| Fej    | Összeszerelő csavar | Rögzítő kulcs | Kulcs (T-típus) | Alátétlapka, lépcsős<br>kiesztergálás | Retes |
|--------|---------------------|---------------|-----------------|---------------------------------------|-------|
| 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. Rögzítő csavar és rögzítő kulcs  
2 & 4. Lapka kulcs az átmérő beállításához és lapka rögzítéshez

- GL25, GL32, GL40 és GL50 Steadyline® esztorgáló és kiesztorgáló rudakhoz tervezve
- Szimmetrikus és lépcsőzetes kiesztorgálási módok lehetségesek
- Egyedi lapkatartók állító mechanizmus
- Belső hűtés a lapkákra






| Megnevezés    | Cikkszám | Gép oldal<br>GL méret | Munkadarab oldal Átmérő |               | OAL           | LF1           | LF2           | BD            | Súly         | Max. ford.* |
|---------------|----------|-----------------------|-------------------------|---------------|---------------|---------------|---------------|---------------|--------------|-------------|
|               |          |                       | DCN                     | DCX Ø         |               |               |               |               |              |             |
|               |          |                       | mm<br>Inch              | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs    |             |
| GL25-RB610-10 | 03307854 | GL25                  | 28,0<br>1.102           | 37,0<br>1.457 | 21,7<br>0.854 | 16,2<br>0.638 | 25,0<br>0.984 | 25,0<br>0.984 | 0,1<br>0.220 | 9500        |
| GL32-0610-20  | 02904458 | GL32                  | 36,0<br>1.417           | 46,0<br>1.811 | 27,6<br>1.087 | 21,1<br>0.831 | 32,0<br>1.260 | 32,0<br>1.260 | 0,1<br>0.220 | 7500        |
| GL40-0610-30  | 02904459 | GL40                  | 45,0<br>1.772           | 56,0<br>2.205 | 31,6<br>1.244 | 22,1<br>0.870 | 35,0<br>1.378 | 40,0<br>1.575 | 0,2<br>0.440 | 5700        |
| GL50-0610-40  | 02904460 | GL50                  | 55,0<br>2.165           | 69,0<br>2.717 | 33,7<br>1.327 | 22,2<br>0.874 | 36,0<br>1.417 | 50,0<br>1.969 | 0,3<br>0.660 | 4500        |

A lapkatartókat külön kell rendelni, lásd a 575 old.

\* Megjegyzések a max fordulatszámokról, lásd az Utasítás oldalakat.

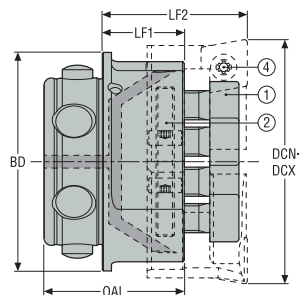
Megj.: súly a lapkatartó nélkül

### Pótalkatrészek

| Fej          | Összeszerelő csavar   | Rögzítő kulcs   | Lapka kulcs   | Kulcs (T-típus)   | Alátétlapka, lépcsős kiesztorgálás  |
|--------------|---|---|---|---|---|
|              |  |  |  |  |  |
| 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



- BA60 és BA80 Steadyline® esztergáló és kiesztergáló rudakhoz tervezve
- Szimmetrikus és lépcsőzetes kiesztergálási módok lehetségesek
- Egyedi lapkatarók állító mechanizmus
- Belső hűtés a lapkákra

1. Rögzítő csavar és rögzítő kulcs  
2 & 4. Lapka kulcs az átmérő beállításához és lapka rögzítéshez

| Megnevezés     | Cikkszám | Gép oldal<br>BA méret | Munkadarab oldal    |                | OAL           | LF1           | LF2           | BD            | Súly         | Max. ford.* |
|----------------|----------|-----------------------|---------------------|----------------|---------------|---------------|---------------|---------------|--------------|-------------|
|                |          |                       | Átmérő<br>DCN-DCX Ø | Átmérő         |               |               |               |               |              |             |
|                |          |                       | mm<br>Inch          | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs    |             |
| BA060-RB610-50 | 03204092 | BA060                 | 66,0<br>2.598       | 88,0<br>3.465  | 38,5<br>1.516 | 22,5<br>0.886 | 39,8<br>1.567 | 60,0<br>2.362 | 0,8<br>1.760 | 4000        |
| BA080-RB610-60 | 03204093 | BA080                 | 86,0<br>3.386       | 116,0<br>4.567 | 44,5<br>1.752 | 22,5<br>0.886 | 39,8<br>1.567 | 80,0<br>3.150 | 1,1<br>2.430 | 3000        |

A lapkatarókat külön kell rendelni, lásd a 575 old.

\* Megjegyzések a max fordulatszámokról, lásd az Utasítás oldalakat.

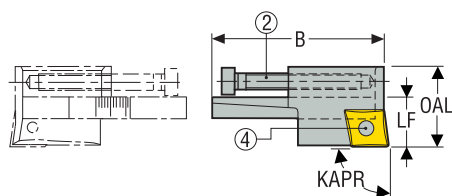
Megj.: súly a lapkataró nélkül

### Pótalkatrészek

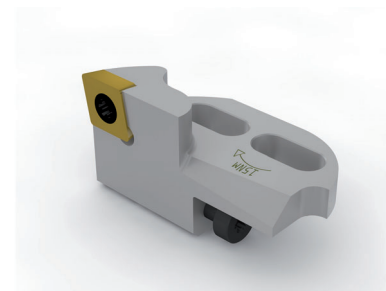
| Fej            | Rögzítő kulcs | Rögzítő csavar | Kulcs (T-típus) | Alátétlapka, lépcsős kiesztergálás |
|----------------|---------------|----------------|-----------------|------------------------------------|
| BA060-RB610-50 | 03HL06        | 950D0820       | DOUBLE-T        | AU6105003                          |
| BA080-RB610-60 | 03HL06        | 950D0822       | DOUBLE-T        | AU6106003                          |



## Insert holders




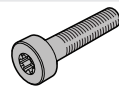
- 2. Beállító csavar
- 4. Lapka csavar



- Használható RB 610 kiesztorgáló fejekhez Graflex®, BA- vagy GL csatlakozással

| Megnevezés   | Cikkszám | Fej      | Munkadarab oldal Átmérő DCN-DCX Ø |                   | OAL           | LF            | B              | Súly         |
|--------------|----------|----------|-----------------------------------|-------------------|---------------|---------------|----------------|--------------|
|              |          |          | mm<br><i>Inch</i>                 | mm<br><i>Inch</i> |               |               |                |              |
| A61010CC0690 | 03307856 | RB 61010 | 28,0<br>1.102                     | 37,0<br>1.457     | 15,1<br>0.594 | 15,1<br>0.594 | 21,75<br>0.856 | 0,1<br>0.220 |
| A61020CC0690 | 02971268 | RB 61020 | 36,0<br>1.417                     | 46,0<br>1.811     | 17,6<br>0.693 | 10,9<br>0.429 | 26,0<br>1.024  | 0,1<br>0.220 |
| A61030CC0990 | 02904461 | RB 61030 | 39,0<br>1.535                     | 56,0<br>2.205     | 17,6<br>0.693 | 12,9<br>0.508 | 33,0<br>1.299  | 0,1<br>0.220 |
| A61040CC0990 | 02904462 | RB 61040 | 50,0<br>1.969                     | 69,0<br>2.717     | 22,5<br>0.886 | 13,8<br>0.543 | 43,8<br>1.724  | 0,1<br>0.220 |
| A61050CC1290 | 02904463 | RB 61050 | 64,0<br>2.520                     | 86,0<br>3.386     | 22,5<br>0.886 | 17,3<br>0.681 | 57,4<br>2.260  | 0,2<br>0.440 |
| A61060CC1290 | 02904464 | RB 61060 | 85,0<br>3.346                     | 115,0<br>4.528    | 27,5<br>1.083 | 18,8<br>0.740 | 75,0<br>2.953  | 0,3<br>0.660 |

### Pótalkatrészek

| Lapka tartó  | Lapka csavar  | Beállító csavar   |
|--------------|---|---|
|              |  |  |
| A61010CC0690 | C02504-T07P   | -   |
| A61020CC0690 | C02504-T07P   | 19A61020  |
| A61030CC0990 | C04008-T15P   | 19A61030  |
| A61040CC0990 | C04008-T15P   | 19A61040  |
| A61050CC1290 | C05012-T15P   | 19A61050  |
| A61060CC1290 | C05012-T15P   | 19A61060  |

Nagyoló kiesztorgáláshoz lapkák a 646 old.

Megjegyzés: Egy kulcs az állító csavarokhoz része az RB 610 fej szállításának

## RB 610 nagyoló kiesztergáló fejek – Utasítások

Javasolt meghúzási nyomatékok. Fordulatonkénti maximális előtolás lépcsőzetes kiesztergálás esetén.

| RB 610 nagyoló kiesztergáló fejek mérete                                     | 30             | 40             | 50             | 60             |
|--|----------------|----------------|----------------|----------------|
| A lapkatartó-rögzítés rögzítőcsavarjainak meghúzási nyomatéka (Nm)           | 2 x 25         | 4 x 25         | 4 x 40         | 4 x 40         |
| f Max. előtolási sebesség lépcsőzetes kiesztergálás esetén, mm/ford (in/rev) | 0,4<br>(0.016) | 0,5<br>(0.020) | 0,6<br>(0.024) | 0,6<br>(0.024) |

### Ajánlott megmunkálási feltételek Főorsó teljesítmény:

Mivel a nagyoló kiesztergáláshoz nagy gépteljesítmény szükséges, először ellenőrizze, hogy a gép megfelelő-e. A lépcsőzetes kiesztergálás megoldást jelent a teljesítményigények csökkentésére, mivel az előtolást a szimmetrikus beállításhoz képest kettővel el kell osztani ugyanahhoz a teljes fogásmélységhez. A legjobb teljesítményt átmenő hűtőfolyadékkal lehet elérni (nagyobb forgácsolási paraméterek, jobb felületi minőség, jobb forgácskihordás, hosszabb lapkaéltartam).

A részletes felhasználói tudnivalóért olvassa el a kiesztergáló fejekhez és a Steadyline® rudakhoz mellékelt használati utasítást. A használati utasítás a [www.secotools.com](http://www.secotools.com) webhelyről is letölthető.

### Maximális sebességek RB 610 nagyoló kiesztergáló fejekhez

**Figyelem!** A kiesztergáló fejek Termékoldalain látható maximum fordulatszámok a kiesztergáló fej mechanikus kivitelétől és kiegyensúlyozási minőségétől függenek.

Az ezeken a korlátokon belül lévő fordulatszámokat a többi forgácsolási feltétel alapján kell kiválasztani, pl. munkadarab anyaga, vágóél (lapka), szerszám hossza, géporsó.

A Steadyline® rudakkal végzett kiesztergálás esetén ügyeljen arra, hogy ne lépje túl a rudak maximális fordulatszámát: Olvassa el a Steadyline® esztergáló és kiesztergáló rudakhoz mellékelt használati utasítást.



## Simító kiesztorgálás

A Seco furatméretek és munkadarab anyagok széles körét lefedő simító kiesztorgáló termékcsoportja mikronos nagyságrendű precíziós beállításokra képes, akár  $Ra < 1$  (RMS 44 micro/inch) felületminőséget és IT6 túréson belüli furatokat nyújtva. Ezek a pontosságot és merevséget szem előtt tartó termékek a legszigorúbb alkatrész-előírások betartását is megkönnyítik. A Steadyline™ rezgéscsillapító megoldások kiegészítik a választékot, hogy még nagyobb stabilitást biztosítsanak a mély üregek kimunkálásához, ahol hosszú szerszámtúlnyúlásokra van szükség.

- Az FB 760 Axiabore típusú simító kiesztorgáló fejek precizitásra és kiváló felületi minőség kialakítására készültek kis átmérőknél
- Az FB 620/780/790 radiális simító kiesztorgáló fejek nagyobb (max. 205 mm) átmérőknél nyújtják a legjobb furatgeometriákat

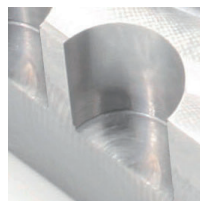
## Áttekintés



Csap felül esztergálás



Horony

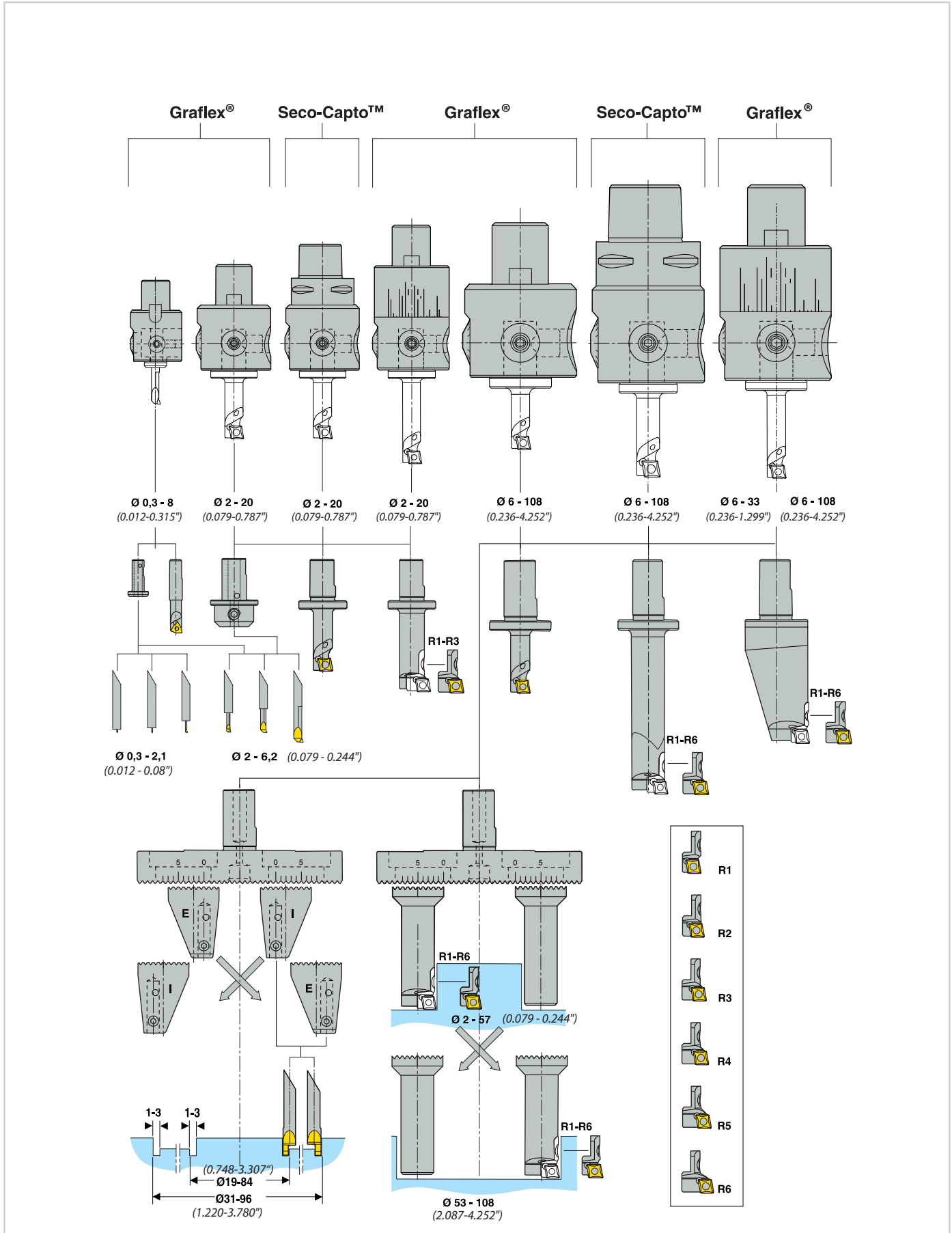


Megszakított kiesztergálás



Kiesztergálás

Áttekintés

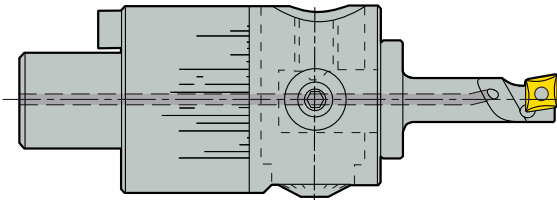


## Axiabore™ típusú simító kiesztérgáló fej $\varnothing$ 0,3–108 mm (0.012–4.252") méretekhez

Axiabore™ típusú fej, melynek része a test (fej) és a szerszám.

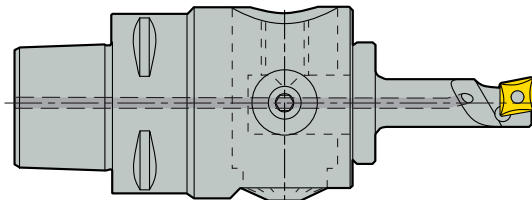
| Axiabore™ típusú fej kiválasztása | Tartomány $\varnothing$ mm | Tartomány $\varnothing$ inch | HSM/Max. sebességek        | Furat geometria | Költség hatékony | Többcélú |
|-----------------------------------|----------------------------|------------------------------|----------------------------|-----------------|------------------|----------|
| Nanobore™ A760 01                 | 0,3-8                      | 0.012–0.315"                 | 30000 RPM                  | ■ ■             | ■ ■              |          |
| Axiabore™ A760 02                 | 2-20                       | 0.079–0.787"                 | 12000 RPM                  | ■               | ■ ■              |          |
| Axiabore™ Plus - A760 03          | 6-108                      | 0.236–4.252"                 | 8000* RPM vagy 1000 m/perc | ■               | ■ ■ ■            | ■ ■ ■    |
| Axiabore™ Plus C5-391.0760-03     | 6-108                      | 0.236–4.252"                 | 8000* RPM                  | ■               | ■ ■ ■            | ■ ■ ■    |
| Axialibrabore™ Plus - A760 13     | 6-33                       | 0.236–1.299"                 | 20000 RPM vagy 1500 m/perc | ■ ■             | ■                |          |

Axiabore™ típusú fejek elérhetőek Graflex® vagy Seco-Capto™ csatlakozással: 5 Axiabore™ FB 760 simító kiesztérgáló fej Graflex® csatlakozással  $\varnothing$  0,3–108 mm (0.012–4.252") méretekhez:



Nanobore™ A760 01  
Axiabore™ A760 02  
Axialibrabore™ A760 12  
Axiabore™ Plus - A760 03  
Axialibrabore™ Plus - A760 13

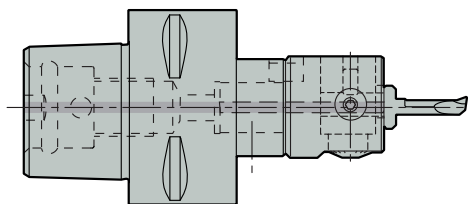
2 Axiabore™ simító kiesztérgáló fej FB 760 Seco-Capto™ csatlakozással az alábbi méretekhez:  $\varnothing$  2–108 mm (0.079–4.252")



Axiabore™ C3-391.0760-02  
Axiabore™ Plus- C5-391.0760-03

**Figyelem!** A legkisebb Capto™ simító kiesztérgáló fejekkel készíthető legkisebb furatméret  $\varnothing$  2 mm (0.079"), a kapható legkisebb Capto™ C3 csatlakozóval.  $\varnothing$  0,3–8 mm (0.012–0.315") méretekhez használjon G2 csatlakozójú Nanobore™ fejet a megfelelő Seco-Capto™/Graflex® adapterrel.

Seco-Capto™ adapter és Graflex® fej:  $\varnothing$  0,3–8 mm (0.012–0.315")



Graflex® és Seco-Capto™ adapterek és moduláris hosszabbítók: lásd a Felszerszámozás katalógust.

**Figyelem!** A jellemzők, utasítások (szerszám szerelés, átmérő beállítás, MPA szerelés, hibaelhárítás, ajánlott megmunkálási feltételek, maximális sebességek), alkalmazható lapkatartók és lapkák ugyanazok mindkét 760-as simító kiesztérgáló fej egyazon méreteihez, függetlenül a csatlakozás típusától.

## Kiesztorgáló szerszámok

**Figyelem!** A termékoldalakon egyértelműen szerepel, hogy mely szerszámok mely fejekhez tartoznak.

**Kiesztorgáló szerszámok**, Ø 4 mm (Ø 0.1574") keményfém szárral a legkisebb, Ø 0,3–6,2 mm (Ø 0.012–0.244") átmérőkhöz, forgácsolási szög 98°. A Nanobore™ és Axia(libra)bore™ fejekhez történő illesztéshez szűkítő perselyek szükségesek. A szerszámok gépoldali része ferde lapolással készül, az ISO szerinti vágóél-pozicionálás érdekében.

**Kiesztorgáló rudak, beilleszthető száruk**, Ø 6, 12 vagy 16 mm (Ø 0.236, 0.472, 0.630") Ø 6–13 mm (Ø 0.236–0.512") furatokhoz, rövid szerszámokhoz acélból, hosszúakhoz keményfémről. WB..0301.. vagy CC..0602.. lapkákhoz és 90° forgácsolási szöghöz. Közvetlen illesztés a fejekre. A rögzítő sikkal elérhető az ISO szerinti vágóél pozicionálás.

## Többfunkciós adapter (MPA)

MPA kiesztorgáláshoz és külső átmérő/csap esztorgáláshoz, vagy akár homlok-hornyoláshoz az – Axiabore™ Plus – fejjel. Az MPA és a szerszámok barázdált csatlakozó felületekkel rendelkeznek a precíz beállítási és pozicionálási fokozatok érdekében 2,5 mm (0.098") osztásközzel Irányított hűtőfolyadék kiömlő mellékelve.

Válassza ki az MPA típusú szerszám felépítéséhez szükséges alkatrészeket az MPA szerszám kiválasztó táblázatokkal. A tartozékok részleteit lásd az Útmutató fejezetben.

### Kiesztorgáló és csapesztorgáló egység beállítása.

A kiesztorgáló és külső átmérő/csap esztorgáló szerszámok ugyanazt a lapkatartóval felszerelt szárat és ellensúlyt használják. Kiesztorgáló egység: Válassza ki a megfelelő lapkatartót, amelyet az MPA adapter szárra szerel fel, a „kiesztorgáló” lapkatartó kiválasztó táblázat (a következő termékoldalak része) segítségével.

**Kiesztorgáló rudak**, moduláris kivitelű, a szárból és a lapkatartóból áll, Ø 13–63 mm (Ø 0.512–2.480") méretekhez. Ø 12 vagy 16 mm (Ø 0.472, 0.630") méretű rövid száruk acélból, hosszú száruk keményfémről, valamint könnyűalumínium kivitelek a legnagyobb átmérőkhöz. Közvetlen illesztés a fejekre.

Hat lapkatartó a CC..0602... lapkákhoz és 90° beállási szöghöz, minden szárral kompatibilis, így széles kiesztorgálási választékot biztosít egyetlen szárra.

Csapesztorgáló egység: Válassza ki a megfelelő lapkatartót, amelyet az MPA adapter szárra szerel fel, a „külső átmérő/csap kiesztorgáló” lapkatartó kiválasztó táblázat (a következő termékoldalak része) segítségével. A tartozékok részleteit lásd az Útmutató fejezetben.

### Beszűrő szerszám összeállítása

A beszűrő szerszám összeállításához szükséges:

- Egy pár beszűrő szerszám tartó (egy E=„Külső” External és egy I=„Belső” Internal),
- Egy beszűrő szerszám „csap mellett” vagy „fal mellett”. Ha a beszűrő szerszám nincs csap mellett vagy fal mellett, mindkét szerszámtípus használható. Lásd a kiválasztási táblázat „Beszűrő szerszám MPA beszűrőshöz” részét

## Jellemzők

### Nanobore™ fej, cikksz. A76001



**Ultra kicsi fej simító kiesztergáláshoz, Ø 0,3–8 mm (Ø 0.012–0.315"):**

Külső átmérő 25 mm (0.984"), hossz 25 mm (0.984"), Graflex® G2 méretű csatlakozó, Ø 6 mm (Ø 0.236") szerszám fogadása. Az akár 30 000 f/p fordulatszámmal nagyon kicsi átmérők is termelékenyen megmunkálhatók.

A 6–4 mm-es (0.236–0.157") szűkítő persely pozicionáló sikkal, és a csap a tömör kiesztergáló szerszámok illesztéséhez a fej tartozéka.

### Axiabore™ fej, cikksz. A76002



**Kicsi fej simító kiesztergáláshoz, Ø 2–20 mm (Ø 0.079–0.787"):**

Külső átmérő 36,5 mm (1.401"), hossz 32 mm (1.260"), Graflex® G3-ös csatlakozómérettel és Seco-Capto™ C3-ös csatlakozómérettel, Ø 12 mm (Ø 0.472") méretű szerszámhoz. Ezek a fejek nehezen hozzáférhető furatokhoz lettek optimalizálva.

A 12–4 mm-es (0.472–0.157") szűkítő persely pozicionáló sikkal, és a csap a tömör kiesztergáló szerszámok illesztéséhez a fej tartozéka.

**Figyelem!** Nanobore® kisebb szerszámok 0,3–2,1 mm (0.012–0.083") szintén alkalmazhatók, de a maximális megmunkálási fordulatszám 12 000 f/p: a Nanobore® fejet kell előnyben részesíteni.

### Axiabore™ Plus - fej, cikksz. A76003 és C5-391.0760-03



**Többfunkciós fej simító kiesztergáláshoz, Ø 6–108 mm (Ø 0.236–4.252"), csap-visszaesztéráláshoz, Ø 2–57 mm (Ø 0.079–2.244") és beszúráshoz, Ø 19–96 mm (Ø 0.748–3.780"):**

Külső átmérő 54 mm (Ø 2.126"), hossz 45 mm (Ø 1.772"), Graflex® 5-ös csatlakozómérettel és Seco-Capto™ 5-ös csatlakozómérettel, Ø 16 mm (Ø 0.630") méretű szerszámhoz.

Megfelelő szerszámok: minden Ø 16 mm (Ø 0.630") szárméretű szerszám, közvetlenül a fejekbe szerelve.

Ez a fej úgy lett tervezve, hogy MPA-val (multi-purpose adapter) is fel lehessen szerelni, így nagy átmérőjű simító kiesztergálás, külső átmérő/csap esztérálás és homlokbeszúrás elvégzésére is alkalmas.

### Axialibrabore™ Plus – fej, cikksz. A76013



**Kiegyensúlyozható fej simító kiesztergáláshoz, Ø 6–33 mm (Ø 0.236–1.299"):**

Ugyanazok a tulajdonságai, mint az - Axiabore™ Plus - fejnek, azonban finom-kiegyensúlyozás is végezhető, a test hossza 65 mm (2.559").

Graflex® G5 csatlakozó méret.

A finom-kiegyensúlyozható fejek nagyobb fordulatszámokat tesznek lehetővé, akár 20 000 fordulat/perc vagy 1 500 m/perc (amelyiket először eléri, miközben a másik értéket nem haladja meg), javítják a furatgeometriát, és csökkentik a főrsó terhelését.

A 'LibraOne' kiegyensúlyozása a kiegyensúlyozó gyűrű beállításával történik (a használt kiegyensúlyozó eszköznek és a furatátmérőnek megfelelően) a kiesztergáló fej jelölése szerint. Nincs szükség táblázatra.

A finom-kiegyensúlyozás csak a legkisebb, Ø 6–33 mm (Ø 0.236–1.299") kiesztergáló szerszámokhoz érhető el.

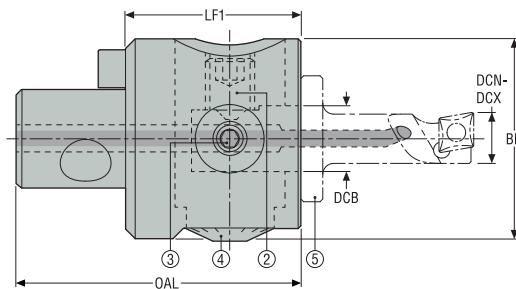
**Figyelem!** Ha nagyobb „Alu” vagy „MPA” szerszámot használ az - Axiaore™ Plus - sorozatból - Axialibrabore™ Plus - fejjel, a finom-kiegyensúlyozás nem valósítható meg, és a kiegyensúlyozó gyűrűt a fej előkiegyensúlyozási helyzetébe kell beállítani (a végrehajtandó művelettől függően, lásd az Útmutató fejezetet).

A maximális sebesség ugyanaz, mint az - Axiabore® Plus esetén.



## FB 760 – Axiabore™ típusú fejek, nem kiegyensúlyozható

Graflex®



2. Szerszám rögzítő csavar
3. Rögzítő csavar
4. Mikrométeres állító csavar
5. Szerszám



- Mikrométeres pontosságú állítással (0,01 mm-es léptékekkel és átmérőben 2,5 µm).
- Axiabore™ Plus - kiesztergálás, külső átmérő/csap esztergálás és homlokbeszúrás.

| Megnevezés | Cikkszám | Gép oldal<br>Graflex<br>méret | Munkadarab oldal    |                | * | OAL           | LF1           | BD            | DCB           | Súly          | Max. megmunkálási<br>sebesség** |                 | *** |
|------------|----------|-------------------------------|---------------------|----------------|---|---------------|---------------|---------------|---------------|---------------|---------------------------------|-----------------|-----|
|            |          |                               | Átmérő<br>DCN-DCX Ø | Átmérő         |   |               |               |               |               |               | Max. ford.**                    | Max.<br>m/min** |     |
|            |          |                               | mm<br>Inch          | mm<br>Inch     |   | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |                                 |                 |     |
| A76001     | 02462575 | G2                            | 0,3<br>0.012        | 8,0<br>0.315   | - | 41,0<br>1.614 | 25,0<br>0.984 | 25,0<br>0.984 | 6,0<br>0.236  | 0,1<br>0.220  | 30000                           | 1500,0          | -   |
| A76002     | 02594930 | G3                            | 2,0<br>0.079        | 20,0<br>0.787  | - | 52,0<br>2.047 | 32,0<br>1.260 | 36,5<br>1.437 | 12,0<br>0.472 | 0,29<br>0.640 | 12000                           | 1500,0          | -   |
| A76003     | 02594935 | G5                            | 6,0<br>0.236        | 108,0<br>4.252 | * | 75,0<br>2.953 | 45,0<br>1.772 | 54,0<br>2.126 | 16,0<br>0.630 | 0,82<br>1.810 | 8000                            | 1000,0          | *** |

Megj.: súly a lapkataró nélkül

Szerszámokhoz lásd a 586-588 old.

\*Átmérők - Axiabore™ Plus fej 6-108 mm-es kiesztergálás, csap esztergálás 2-57 mm, homlokbeszúrás 19-96 mm (0.748-3.780).

\*\*Maximális sebesség, amelyeket előbb eléri, egyiket sem túllépve.

\*\*\*Max 5000 ford/perc MPA használatánál.

### Pótalkatrészek

| Fej    | Összeszerelő csavar | Kulcs (T-típus) | Kulcs     | Rögzítő csavar | Csökkentő persely | Tömítő csavar | Retes |
|--------|---------------------|-----------------|-----------|----------------|-------------------|---------------|-------|
| 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 |

### Kiegészítők

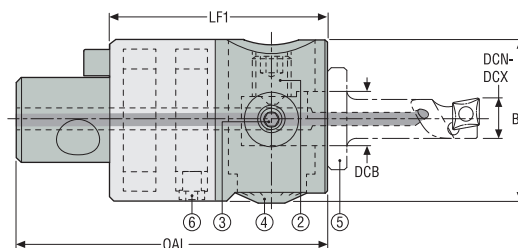
| Fej    | Nagyító üveg | Tároló | Nyomaték kulcs 1 | Nyomaték kulcs 2              |
|--------|--------------|--------|------------------|-------------------------------|
| A76001 | 935L01       | -      | -                | H00-2009                      |
| A76002 | -            | 42M06  | -                | H00-3030                      |
| A76003 | -            | 42M07  | H00T-4060        | Kiegészítők, külön rendelendő |

Nyomatékkulcs 1 = kiegyensúlyozó rögzítő csavarokhoz

Nyomatékkulcs 2 = rögzítő és összeszerelő csavarokhoz

## FB 760 – Axiabore™ típusú fejek, kiegyensúlyozható

Graflex®



- LibraOne beépített kiegyensúlyozó rendszer, egy kiegyensúlyozást beállító gyűrűvel.
- Mikrométeres pontosságú állítással (0,01 mm-es léptékkel és átmérőben 2,5 µm).

2. Szerszám rögzítő csavar
3. Rögzítő csavar 1
4. Mikrométeres állító csavar
5. Szerszám
6. Rögzítő csavar 2

| Megnevezés | Cikkszám | Gép oldal<br>Graflex<br>méret | Munkadarab oldal    |               | * | OAL           | LF1           | BD            | DCB           | Súly          | Max. megmunkálási<br>sebesség** |                 |
|------------|----------|-------------------------------|---------------------|---------------|---|---------------|---------------|---------------|---------------|---------------|---------------------------------|-----------------|
|            |          |                               | Átmérő<br>DCN-DCX Ø | Átmérő        |   |               |               |               |               |               | Max. ford.**                    | Max.<br>m/min** |
|            |          |                               | mm<br>Inch          | mm<br>Inch    |   | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |                                 |                 |
| A76013     | 02594943 | G5                            | 6,0<br>0.236        | 33,0<br>1.299 | * | 95,0<br>3.740 | 65,0<br>2.559 | 54,0<br>2.126 | 16,0<br>0.630 | 1,16<br>2.560 | 20000                           | 1500,0          |

Megj.: súly a lapkatarató nélkül  
Szerszámokhoz lásd a 586-588 old.

\*Átmérők - Axialibrabore™ Plus -fej, kiegyensúlyozással.

\*\*Maximális sebesség, amelyiket előbb eléri, egyiket sem túllépve.

## Pótalkatrészek

| Fej    | Összeszerelő csavar | Kulcs (T-típus) | Kulcs     | Rögzítő csavar 1 | Rögzítő csavar 2 | Retesz |
|--------|---------------------|-----------------|-----------|------------------|------------------|--------|
| A76013 | AU7601312           | DOUBLE-T        | H6B-H4.0L | 19A71008125      | AU7601318        | 90M5A1 |

## Kiegészítők

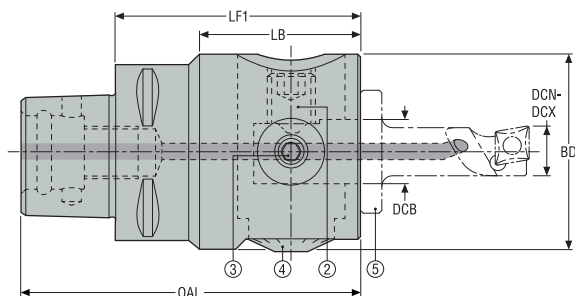
| Fej    | Tároló | Nyomaték kulcs 1 | Nyomaték kulcs 2 |
|--------|--------|------------------|------------------|
| A76013 | 42M07  | H00-4020-60      | H00T-4060        |

Nyomatékkulcs 1 = kiegyensúlyozó rögzítő csavarokhoz  
Nyomatékkulcs 2 = rögzítő és összeszerelő csavarokhoz

Kiegészítők, külön rendelendő

## FB 760 – Axiabore™ típusú fejek

Seco-Capto™



- 2. Szerszám rögzítő csavar
- 3. Rögzítés
- 4. Mikrométeres állító csavar
- 5. Szerszám



- Mikrométeres pontosságú állítással (0,01 mm-es léptékkel és átmérőben 2,5 µm).
- Axiabore™ Plus - kiesztergálás, külső átmérő/csap esztergálás és homlokbeszúrás.

| Megnevezés     | Cikkszám | Gép oldal | Munkadarab oldal |                | Átmérő DCN-DCX Ø * | OAL           | LF1           | LB            | BD            | DCB           | Súly          | Max. megmunkálási sebesség** |              |
|----------------|----------|-----------|------------------|----------------|--------------------|---------------|---------------|---------------|---------------|---------------|---------------|------------------------------|--------------|
|                |          |           | mm               | mm             |                    |               |               |               |               |               |               | Max. ford.**                 | Max. m/min** |
| C5-391.0760-03 | 02822777 | C5        | 6,0<br>0.236     | 108,0<br>4.252 | *                  | 95,0<br>3.740 | 65,0<br>2.559 | 44,0<br>1.732 | 54,0<br>2.126 | 16,0<br>0.630 | 1,12<br>2.470 | 8000                         | 1500,0       |

Megj.: súly a lapkatartó nélkül

Szerszámokhoz lásd a 586-588 old.

\*Max 5000 ford/perc MPA használatánál.

\*\*Átmérők - Axiabore™ Plus fej 6-108 mm-es kiesztergálás, csap esztergálás 2-57 mm, homlokbeszúrás 19-96 mm (0.748-3.780").

### Pótalkatrészek

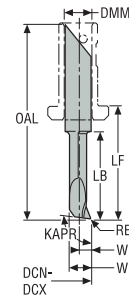
### Kiegészítők

| Fej       | Összeszerelő csavar | Kulcs (T-típus) | Kulcs     | Rögzítő csavar | Nyomaték kulcs 2 |
|-----------|---------------------|-----------------|-----------|----------------|------------------|
| C5-...-03 | AU7601312           | DOUBLE-T        | H6B-H4.0L | 19A71008125    | H00-3030         |

Nyomatékkulcs 2 = rögzítő és összeszerelő csavarokhoz

Kiegészítők, külön rendelendő

## Kiesztorgáló szerszámok, keményfém, az FB 760 fejekhez



- KRINS 98°
- ISO szerinti vágóél pozícionálás.
- Belső hűtés

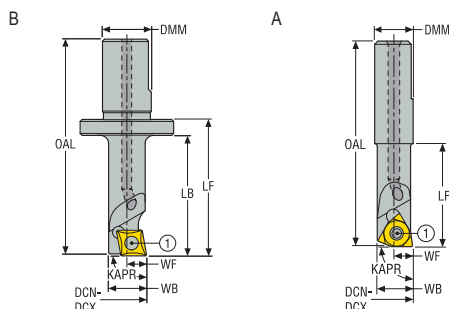
| Megnevezés | Cikkszám | Szerszám anyag* | Fej         | Átmérő DCN-DCX*** |              | OAL           | LB            | LF            | DMM          | WB            | WF            | RE            | Ajánlott forgácsolási adatok** a <sub>p</sub> | Ajánlott forgácsolási adatok** f | Súly          | Kiegyensúlyozás |
|------------|----------|-----------------|-------------|-------------------|--------------|---------------|---------------|---------------|--------------|---------------|---------------|---------------|---|----------------------------------|---------------|-----------------|
|            |          |                 |             | mm<br>Inch        | mm<br>Inch   |               |               |               |              |               |               |               | mm<br>Inch                                    | mm<br>Inch                       |               |                 |
| A761402    | 02462579 | Tömör-keményfém | FB 76001    | 0,3<br>0.012      | 0,6<br>0.024 | 30,7<br>1.209 | 1,2<br>0.047  | 15,5<br>0.610 | 4,0<br>0.157 | 0,25<br>0.010 | 0,1<br>0.004  | 0,0<br>-      | 0,02<br>0.001                                 | 0,01<br>0                        | 0,01<br>0.020 | -               |
| A761412    | 02462581 | Tömör-keményfém | FB 76001    | 0,5<br>0.020      | 1,1<br>0.043 | 30,7<br>1.209 | 2,0<br>0.079  | 15,5<br>0.610 | 4,0<br>0.157 | 0,45<br>0.018 | 0,2<br>0.008  | 0,0<br>-      | 0,02<br>0.001                                 | 0,01<br>0                        | 0,01<br>0.020 | -               |
| A761422    | 02462583 | Tömör-keményfém | FB 76001    | 1,0<br>0.039      | 2,1<br>0.083 | 30,7<br>1.209 | 5,0<br>0.197  | 15,5<br>0.610 | 4,0<br>0.157 | 0,95<br>0.037 | 0,45<br>0.018 | 0,1<br>0.004  | 0,03<br>0.001                                 | 0,02<br>0.001                    | 0,01<br>0.020 | -               |
| A761432    | 02462584 | Tömör-keményfém | 76001/02/12 | 2,0<br>0.079      | 3,2<br>0.126 | 30,7<br>1.209 | 8,0<br>0.315  | 15,5<br>0.610 | 4,0<br>0.157 | 1,8<br>0.071  | 0,88<br>0.035 | 0,1<br>0.004  | 0,05<br>0.002                                 | 0,02<br>0.001                    | 0,01<br>0.020 | E13             |
| A761442    | 02462586 | Tömör-keményfém | 76001/02/12 | 3,0<br>0.118      | 4,7<br>0.185 | 30,7<br>1.209 | 10,0<br>0.394 | 15,5<br>0.610 | 4,0<br>0.157 | 2,75<br>0.108 | 1,35<br>0.053 | 0,15<br>0.006 | 0,06<br>0.002                                 | 0,03<br>0.001                    | 0,01<br>0.020 | E14             |
| A761452    | 02462587 | Tömör-keményfém | 76001/02/12 | 4,5<br>0.177      | 6,2<br>0.244 | 35,7<br>1.406 | 15,0<br>0.591 | 20,5<br>0.807 | 4,0<br>0.157 | 3,95<br>0.156 | 1,95<br>0.077 | 0,15<br>0.006 | 0,08<br>0.003                                 | 0,03<br>0.001                    | 0,01<br>0.020 | E15             |

\*Ezek a 4 mm-es átmérőjű szárú szerszámok csökkentő persely használatát követelik meg, amelyet a megfelelő fejekkel és szettekkel szállítunk.

\*\* A vágósebességeket lásd a 650-653 old.

\*\*\*+0,1 mm kiegészítő átmérő is elérhető.

## Kiesztérgáló fejek, lapka típus az FB 760 fejekhez



1 = Lapka csavar



- ISO szerinti vágóél pozícionálás.
- Belső hűtés
- Mindössze két lapkaméret minden szerszámhoz.
- Tool material + = Steel, indexable insert type
- Tool material \*\* = Carbide, indexable insert type
- KRINS 90°

| Megnevezés | Cikkszám | Szerszám anyaga | Fej         | ** Átmérő DCN-DCX Ø |               | OAL           | LB            | LF            | DMM           | WB            | WF           | Súly          | Kivitel | Használható lapka méret | Kiegyensúlyozás |
|------------|----------|-----------------|-------------|---------------------|---------------|---------------|---------------|---------------|---------------|---------------|--------------|---------------|---------|-------------------------|-----------------|
|            |          |                 |             | mm<br>Inch          | mm<br>Inch    |               |               |               |               |               |              |               |         |                         |                 |
| A762001    | 02462590 | *               | FB 76001    | 6,0<br>0.236        | 8,0<br>0.315  | 31,7<br>1.248 | 0,0<br>0.000  | 16,0<br>0.630 | 6,0<br>0.236  | 5,5<br>0.217  | 2,9<br>0.114 | 0,01<br>0.020 | A       | WB..0301..              | -               |
| A762002    | 02594947 | *               | FB 76002/12 | 6,0<br>0.236        | 8,0<br>0.315  | 39,7<br>1.563 | 16,0<br>0.630 | 20,0<br>0.787 | 12,0<br>0.472 | 5,5<br>0.217  | 2,9<br>0.114 | 0,03<br>0.070 | B       | WB..0301..              | S21             |
| A762003    | 02594967 | *               | FB 76003/13 | 6,0<br>0.236        | 8,0<br>0.315  | 50,2<br>1.976 | 16,0<br>0.630 | 21,0<br>0.827 | 16,0<br>0.630 | 5,5<br>0.217  | 2,9<br>0.114 | 0,07<br>0.150 | B       | WB..0301..              | S31             |
| A763002    | 02594948 | *               | FB 76002/12 | 8,0<br>0.315        | 10,0<br>0.394 | 45,7<br>1.799 | 22,0<br>0.866 | 26,0<br>1.024 | 12,0<br>0.472 | 7,4<br>0.291  | 3,9<br>0.154 | 0,04<br>0.090 | B       | WB..0301..              | S22             |
| A763003    | 02594968 | *               | FB 76003/13 | 8,0<br>0.315        | 10,0<br>0.394 | 56,2<br>2.213 | 22,0<br>0.866 | 27,0<br>1.063 | 16,0<br>0.630 | 7,4<br>0.291  | 3,9<br>0.154 | 0,08<br>0.180 | B       | WB..0301..              | S32             |
| A765002    | 02594957 | *               | FB 76002/12 | 10,0<br>0.394       | 13,0<br>0.512 | 53,5<br>2.106 | 30,0<br>1.181 | 34,0<br>1.339 | 12,0<br>0.472 | 9,35<br>0.368 | 4,8<br>0.189 | 0,04<br>0.090 | B       | CC..0602..              | S23             |
| A765003    | 02594969 | *               | FB 76003/13 | 10,0<br>0.394       | 13,0<br>0.512 | 64,0<br>2.520 | 30,0<br>1.181 | 35,0<br>1.378 | 16,0<br>0.630 | 9,35<br>0.368 | 4,8<br>0.189 | 0,08<br>0.180 | B       | CC..0602..              | S33             |
| A762201    | 02462591 | **              | FB 76001    | 6,0<br>0.236        | 8,0<br>0.315  | 41,7<br>1.642 | 0,0<br>0.000  | 26,0<br>1.024 | 6,0<br>0.236  | 5,5<br>0.217  | 2,9<br>0.114 | 0,02<br>0.040 | A       | WB..0301..              | -               |
| A762202    | 02594958 | **              | FB 76002/12 | 6,0<br>0.236        | 8,0<br>0.315  | 50,7<br>1.996 | 27,0<br>1.063 | 31,0<br>1.220 | 12,0<br>0.472 | 5,5<br>0.217  | 2,9<br>0.114 | 0,06<br>0.130 | B       | WB..0301..              | E21             |
| A762203    | 02594970 | **              | FB 76003/13 | 6,0<br>0.236        | 8,0<br>0.315  | 61,2<br>2.409 | 27,0<br>1.063 | 32,0<br>1.260 | 16,0<br>0.630 | 5,5<br>0.217  | 2,9<br>0.114 | 0,13<br>0.290 | B       | WB..0301..              | E31             |
| A763202    | 02594961 | **              | FB 76002/12 | 8,0<br>0.315        | 10,0<br>0.394 | 60,7<br>2.390 | 37,0<br>1.457 | 41,0<br>1.614 | 12,0<br>0.472 | 7,4<br>0.291  | 3,9<br>0.154 | 0,07<br>0.150 | B       | WB..0301..              | E22             |
| A763203    | 02594971 | **              | FB 76003/13 | 8,0<br>0.315        | 10,0<br>0.394 | 71,2<br>2.803 | 37,0<br>1.457 | 42,0<br>1.654 | 16,0<br>0.630 | 7,4<br>0.291  | 3,9<br>0.154 | 0,14<br>0.310 | B       | WB..0301..              | E32             |
| A765202    | 02594962 | **              | FB 76002/12 | 10,0<br>0.394       | 13,0<br>0.512 | 78,5<br>3.091 | 55,0<br>2.165 | 59,0<br>2.323 | 12,0<br>0.472 | 9,35<br>0.368 | 4,8<br>0.189 | 0,09<br>0.200 | B       | CC..0602..              | E23             |
| A765203    | 02594972 | **              | FB 76003/13 | 10,0<br>0.394       | 13,0<br>0.512 | 89,0<br>3.504 | 55,0<br>2.165 | 60,0<br>2.362 | 16,0<br>0.630 | 9,35<br>0.368 | 4,8<br>0.189 | 0,17<br>0.370 | B       | CC..0602..              | E33             |

### Pótalkatrészek

| Lapka méret | Lapka csavar |
|-------------|--------------|
| WB...0301.. | C02035-T06P  |
| CC...0602.. | C02504-T07P  |

### Kiegészítők

| Lapka kulcs | Kulcs (T-típus) |
|-------------|-----------------|
| H4B-T06P    | DOUBLE-T        |
| H4B-T07P    | DOUBLE-T        |

\*\*+0,2 mm kiegészítő átmérő is elérhető.

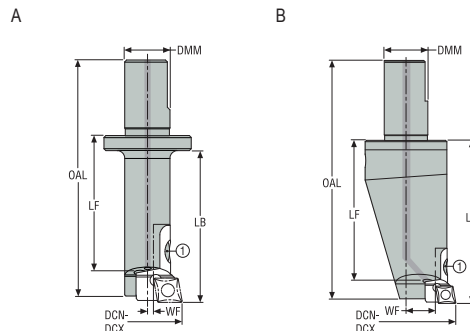
Kiegészítők, külön rendelendő

## Kiesztergáló szárok, a moduláris simító kiesztergáló rudakhoz, az FB 760 fejekhez

Bevezetés



- Többféle átmérőben érhető el, a cserélhető lapkatartókkal.
- 'Acél' típusú szár kis kinyúláshoz, 'keményfém' hosszú kinyúláshoz, 'alumínium' nagy átmérőkhöz.
- Belső hűtés



1 = Rögzítő csavar

Fűrés

| Megnevezés | Cikkszám | Moduláris kiesztergáló szár típus | Fej         | ** Átmérő DCN-DCX $\varnothing$ |               | OAL            | LB            | LF            | DMM           | WF            | Súly          | Kivitel | *** |
|------------|----------|-----------------------------------|-------------|---------------------------------|---------------|----------------|---------------|---------------|---------------|---------------|---------------|---------|-----|
|            |          |                                   |             | mm                              | mm            |                |               |               |               |               |               |         |     |
| A760S20    | 02594963 | Acél                              | FB 76002/12 | 13,0<br>0.512                   | 20,0<br>0.787 | 62,5<br>2.461  | 40,0<br>1.575 | 34,0<br>1.339 | 12,0<br>0.472 | 1,4<br>0.055  | 0,06<br>0.130 | A       |     |
| A760S30    | 02594973 | Acél                              | FB 76003/13 | 13,0<br>0.512                   | 18,0<br>0.709 | 73,0<br>2.874  | 40,0<br>1.575 | 35,0<br>1.378 | 16,0<br>0.630 | 1,4<br>0.055  | 0,1<br>0.220  | A       |     |
| A760S31    | 02594974 | Acél                              | FB 76003/13 | 18,0<br>0.709                   | 33,0<br>1.299 | 83,0<br>3.268  | 50,0<br>1.969 | 45,0<br>1.772 | 16,0<br>0.630 | 3,9<br>0.154  | 0,13<br>0.290 | A       |     |
| A760E20    | 02594964 | Keményfém                         | FB 76002/12 | 13,0<br>0.512                   | 20,0<br>0.787 | 82,5<br>3.248  | 60,0<br>2.362 | 54,0<br>2.126 | 12,0<br>0.472 | 1,4<br>0.055  | 0,2<br>0.440  | A       |     |
| A760E30    | 02594965 | Keményfém                         | FB 76003/13 | 13,0<br>0.512                   | 18,0<br>0.709 | 103,0<br>4.055 | 70,0<br>2.756 | 65,0<br>2.559 | 16,0<br>0.630 | 1,4<br>0.055  | 0,21<br>0.460 | A       |     |
| A760E31    | 02594966 | Keményfém                         | FB 76003/13 | 18,0<br>0.709                   | 33,0<br>1.299 | 113,0<br>4.449 | 80,0<br>3.150 | 75,0<br>2.953 | 16,0<br>0.630 | 3,9<br>0.154  | 0,3<br>0.660  | A       |     |
| A760A32    | 02594977 | Alumínium                         | FB 76003/13 | 33,0<br>1.299                   | 48,0<br>1.890 | 88,0<br>3.465  | 60,0<br>2.362 | 50,0<br>1.969 | 16,0<br>0.630 | 11,5<br>0.453 | 0,14<br>0.310 | B       | *** |
| A760A33    | 02594978 | Alumínium                         | FB 76003/13 | 48,0<br>1.890                   | 63,0<br>2.480 | 108,0<br>4.252 | 80,0<br>3.150 | 70,0<br>2.756 | 16,0<br>0.630 | 19,0<br>0.748 | 0,34<br>0.750 | B       | *** |

Dörzsárazás

### Pótalkatrészek

### Kiegészítők

| Fej       | Rögzítő csavar | Kulcs (T-típus) |
|-----------|----------------|-----------------|
| A76002/12 | C04008-T15P    | DOUBLE-T        |
| A76003/13 | C04008-T15P    | DOUBLE-T        |
| A76003    | C04008-T15P    | DOUBLE-T        |

\*\*+0,2 mm kiegészítő átmérő is elérhető.

\*\*\* A760 13-on használva nem lehet finom-kiegyensúlyozni.

Válassza ki a kívánt szár és lapkatartó(k) kombinációját/kombinációit a kiválasztási táblázat segítségével a 590 old.

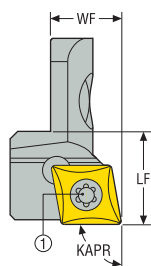
Megj.: súly a lapkatartó nélkül.

**Kiegészítők**, külön rendelendő

Kiesztergálás

Melléklet

## Lapkatartók, moduláris simító kiesztergáló fejekhez, FB 760 fejekhez



1 = Lapka csavar

- Egyetlen méret minden kiesztergáló (és külső átmérő/csap esztergáló) szárhoz.
- Egy lapkaméret minden lapkatartóhoz.

| Megnevezés | Cikkszám | LF   |       | WF*  |       | Súly          | Használható lapka méret | KRINS° |
|------------|----------|------|-------|------|-------|---------------|-------------------------|--------|
|            |          | mm   | Inch  | mm   | Inch  |               |                         |        |
| A765R1     | 02594979 | 10,0 | 0.394 | 4,95 | 0.195 | 0,01<br>0.020 | CC..0602..              | 90     |
| A765R2     | 02594983 | 10,0 | 0.394 | 6,2  | 0.244 | 0,01<br>0.020 | CC..0602..              | 90     |
| A765R3     | 02594984 | 10,0 | 0.394 | 7,45 | 0.293 | 0,01<br>0.020 | CC..0602..              | 90     |
| A765R4     | 02594987 | 10,0 | 0.394 | 8,7  | 0.343 | 0,01<br>0.020 | CC..0602..              | 90     |
| A765R5     | 02594989 | 10,0 | 0.394 | 9,97 | 0.393 | 0,01<br>0.020 | CC..0602..              | 90     |
| A765R6     | 02594990 | 10,0 | 0.394 | 11,2 | 0.441 | 0,01<br>0.020 | CC..0602..              | 90     |

### Pótalkatrészek

| Lapka méret  | Lapka csavar |
|--------------|--------------|
| CC...0602... | C02504-T07P  |

### Kiegészítők

| Lapka kulcs | Kulcs (T-típus) |
|-------------|-----------------|
| H4B-T07P    | DOUBLE-T        |

\*WF ha a CC..060204 típusú lapka van felszerelve.

Válassza ki a szükséges szár és lapkatartó kombinációt, használva a táblázatot 590 old..

Kiegészítők, külön rendelendő

## Kiválasztó táblázat:

## Kiesztorgáló szerszámok és lapka tartók az FB 760 fejekhez

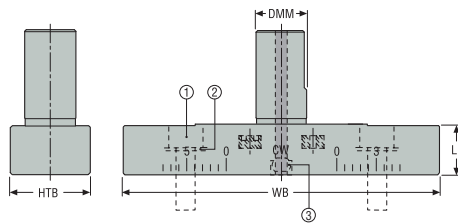
| Fej              | Furat átmérő<br>DCN-DCX<br>Ø mm inch |                | Furat hossz<br>LB mm inch |         | Megnevezés |         | DMM<br>mm inch |            | Használható<br>lapka méret   | Szerszám típus               |
|------------------|--------------------------------------|----------------|---------------------------|---------|------------|---------|----------------|------------|------------------------------|------------------------------|
|                  | Kiesztorgálás<br>szerszám            | Lapka<br>tartó |                           |         |            |         |                |            |                              |                              |
| A760 01          | 0,3-0,6                              | 0.012-0.024    | 1,2                       | 0.047   | A761402    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 0,5-1,1                              | 0.020-0.043    | 2                         | 0.078   | A761412    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 1-2,1                                | 0.039-0.083    | -                         | -       | A761422    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 2-3,2                                | 0.079-0.126    | 8                         | 0.315   | A761432    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 3-4,7                                | 0.118-0.185    | 10                        | 0.394   | A761442    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 4,5-6,2                              | 0.177-0.244    | 15                        | 0.591   | A761452    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 6-8                                  | 0.236-0.315    | 16                        | 0.630   | A762001    | -       | 6              | 0.236      | WB..0301..                   | Acél, lapkás típus           |
|                  | 6-8                                  | 0.236-0.315    | 26                        | 1.024   | A762201    | -       | 6              | 0.236      | WB..0301..                   | Keményfém, lapkás típus      |
| A760 02/ A760 12 | 2-3,2                                | 0.079-0.126    | 8                         | 0.315   | A761432    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 3-4,7                                | 0.118-0.185    | 10                        | 0.394   | A761442    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 4,5-6,2                              | 0.177-0.244    | 15                        | 0.591   | A761452    | -       | 4              | 0.157      | -                            | Tömör keményfém              |
|                  | 6-8                                  | 0.236-0.315    | 16                        | 0.630   | A762002    | -       | 12             | 0.472      | WB..0301..                   | Acél, lapkás típus           |
|                  | 6-8                                  | 0.236-0.315    | 27                        | 1.063   | A762202    | -       | 12             | 0.472      | WB..0301..                   | Keményfém, lapkás típus      |
|                  | 8-10                                 | 0.315-0.394    | 22                        | 0.866   | A763002    | -       | 12             | 0.472      | WB..0301..                   | Acél, lapkás típus           |
|                  | 8-10                                 | 0.315-0.394    | 37                        | 1.457   | A763202    | -       | 12             | 0.472      | WB..0301..                   | Keményfém, lapkás típus      |
|                  | 10-13                                | 0.394-0.512    | 30                        | 1.181   | A765002    | -       | 12             | 0.472      | CC..0602..                   | Acél, lapkás típus           |
|                  | 10-13                                | 0.394-0.512    | 55                        | 2.165   | A765202    | -       | 12             | 0.472      | CC..0602..                   | Keményfém, lapkás típus      |
|                  | 13-15,5                              | 0.512-0.610    | 40                        | 1.575   | A760S20    | A765R1  | 12             | 0.472      | CC..0602..                   | Acél szár lapkatartóval      |
|                  | 13-15,5                              | 0.512-0.610    | 60                        | 2.362   | A760E20    | A765R1  | 12             | 0.472      | CC..0602..                   | Keményfém szár lapkatartóval |
|                  | 15,5-18                              | 0.610-0.709    | 40                        | 1.575   | A760S20    | A765R2  | 12             | 0.472      | CC..0602..                   | Acél szár lapkatartóval      |
|                  | 15,5-18                              | 0.610-0.709    | 60                        | 2.362   | A760E20    | A765R2  | 12             | 0.472      | CC..0602..                   | Keményfém szár lapkatartóval |
|                  | 18-20                                | 0.709-0.787    | 40                        | 1.575   | A760S20    | A765R3  | 12             | 0.472      | CC..0602..                   | Acél szár lapkatartóval      |
|                  | 18-20                                | 0.709-0.787    | 60                        | 2.362   | A760E20    | A765R3  | 12             | 0.472      | CC..0602..                   | Keményfém szár lapkatartóval |
|                  | A760 03/ A760 13                     | 6-8            | 0.236-0.315               | 16      | 0.630      | A762003 | -              | 16         | 0.630                        | WB..0301..                   |
| 6-8              |                                      | 0.236-0.315    | 32                        | 1.260   | A762203    | -       | 16             | 0.630      | WB..0301..                   | Keményfém, lapkás típus      |
| 8-10             |                                      | 0.315-0.394    | 22                        | 0.866   | A763003    | -       | 16             | 0.630      | WB..0301..                   | Acél, lapkás típus           |
| 8-10             |                                      | 0.315-0.394    | 37                        | 1.457   | A763203    | -       | 16             | 0.630      | WB..0301..                   | Keményfém, lapkás típus      |
| 10-13            |                                      | 0.394-0.512    | 30                        | 1.181   | A765003    | -       | 16             | 0.630      | CC..0602..                   | Acél, lapkás típus           |
| 10-13            |                                      | 0.394-0.512    | 55                        | 2.165   | A765203    | -       | 16             | 0.630      | CC..0602..                   | Keményfém, lapkás típus      |
| 13-15,5          |                                      | 0.512-0.610    | 40                        | 1.575   | A760S30    | A765R1  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 13-15,5          |                                      | 0.512-0.610    | 70                        | 2.756   | A760E30    | A765R1  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 15,5-18          |                                      | 0.610-0.709    | 40                        | 1.575   | A760S30    | A765R2  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 15,5-18          |                                      | 0.610-0.709    | 70                        | 2.756   | A760E30    | A765R2  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 18-20,5          |                                      | 0.709-0.807    | 50                        | 1.969   | A760S31    | A765R1  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 18-20,5          |                                      | 0.709-0.807    | 80                        | 3.150   | A760E31    | A765R1  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 20,5-23          |                                      | 0.807-0.906    | 50                        | 1.969   | A760S31    | A765R2  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 20,5-23          |                                      | 0.807-0.906    | 80                        | 3.150   | A760E31    | A765R2  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 23-25,5          |                                      | 0.906-1.00     | 50                        | 1.969   | A760S31    | A765R3  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 23-25,5          |                                      | 0.906-1.00     | 80                        | 3.150   | A760E31    | A765R3  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 25,5-28          |                                      | 1.004-1.102    | 50                        | 1.969   | A760S31    | A765R4  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 25,5-28          |                                      | 1.004-1.102    | 80                        | 3.150   | A760E31    | A765R4  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 28-30,5          |                                      | 1.102-1.201    | 50                        | 1.969   | A760S31    | A765R5  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 28-30,5          |                                      | 1.102-1.201    | 80                        | 3.150   | A760E31    | A765R5  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 30,5-33          |                                      | 1.201-1.299    | 50                        | 1.969   | A760S31    | A765R6  | 16             | 0.630      | CC..0602..                   | Acél szár lapkatartóval      |
| 30,5-33          |                                      | 1.201-1.299    | 80                        | 3.150   | A760E31    | A765R6  | 16             | 0.630      | CC..0602..                   | Keményfém szár lapkatartóval |
| 33-35,5*         |                                      | 1.299-1.398*   | 60                        | 2.362   | A760A32    | A765R1  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 35,5-38*         |                                      | 1.299-1.496*   | 60                        | 2.362   | A760A32    | A765R2  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 38-40,5*         |                                      | 1.496-1.594*   | 60                        | 2.362   | A760A32    | A765R3  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 40,5-43*         |                                      | 1.594-1.693*   | 60                        | 2.362   | A760A32    | A765R4  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 43-45,5*         |                                      | 1.693-1.791*   | 60                        | 2.362   | A760A32    | A765R5  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 45,5-48*         |                                      | 1.791-1.890*   | 60                        | 2.362   | A760A32    | A765R6  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 48-50,5*         |                                      | 1.890-1.988*   | 80                        | 3.150   | A760A33    | A765R1  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 50,5-53*         |                                      | 1.988-2.087*   | 80                        | 3.150   | A760A33    | A765R2  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 53-55,5*         |                                      | 2.087-2.185*   | 80                        | 3.150   | A760A33    | A765R3  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 55,5-58*         |                                      | 2.185-2.283*   | 80                        | 3.150   | A760A33    | A765R4  | 16             | 0.630      | CC..0602..                   | Alumínium szár lapkatartóval |
| 58-60,5*         | 2.283-2.382*                         | 80             | 3.150                     | A760A33 | A765R5     | 16      | 0.630          | CC..0602.. | Alumínium szár lapkatartóval |                              |
| 60,5-63*         | 2.382-2.480*                         | 80             | 3.150                     | A760A33 | A765R6     | 16      | 0.630          | CC..0602.. | Alumínium szár lapkatartóval |                              |

Nagyobb átmérőkhöz, keresse a több funkciós adapter (MPA) részt.

\* A760 13-on használva nem lehet finom-kiegyensúlyozni.



## Többcélú adatter (MPA), az FB 760 fejekhez



1. Szerszám rögzítő csavar
2. Alátét
3. Állítható fúvóka



- Csak - Axiabore™ Plus - A760 03 fejhez megfelelő\*.
- Egy szárhoz és egy ellensúlyhoz (kiesztorgálás vagy külső átmérő/csapesztorgálás) vagy két beszűrő szerszám befogóhoz (homlokbeszúrás) tervezve.
- Belső hűtés állítható fúvókával (3).

| Cikkszám | Megnevezés   | Átmérő DCN-DCX Ø |       |                        |       |       |       | HTB   | LF    | DMM   | WB    | Súly  |
|----------|--------------|------------------|-------|------------------------|-------|-------|-------|-------|-------|-------|-------|-------|
|          |              | Furat            |       | Csap kiesztorgálásához |       |       |       |       |       |       |       |       |
|          |              | mm               | mm    | mm                     | mm    | mm    | mm    | mm    | mm    | mm    | mm    | kg    |
|          |              | Inch             | Inch  | Inch                   | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | lbs   |
| 02595014 | BDA16BS25100 | 53,0             | 108,0 | 2,0                    | 57,0  | 31,0  | 96,0  | 25,0  | 16,0  | 16,0  | 100,0 | 0,28  |
|          |              | 2.087            | 4.252 | 0.079                  | 2.244 | 1.220 | 3.780 | 0.984 | 0.630 | 0.630 | 3.937 | 0.620 |

### Pótalkatrészek

| Megnevezés   | Összeszerelő csavar | Alátét  |
|--------------|---------------------|---------|
| BDA16BS25100 | 950D0618            | 940ZC06 |

### Kiegészítők

| Rögzítő kulcs |
|---------------|
| 03HL05        |

\*Axiabore™ Plus - A760 13 fején használva nem végezhető finom-kiegyensúlyozás, lásd a 582 old.

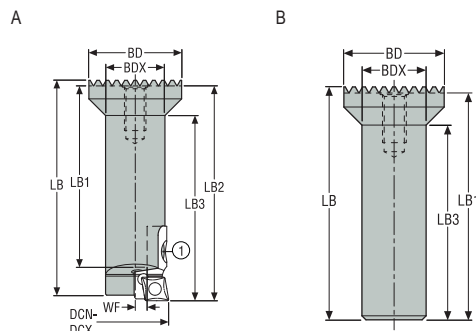
Válassza ki a szükséges alkatrészeket a kiesztorgáló, külső átmérő/csap esztorgáló vagy homlokbeszűrő szerszámokhoz, kövesd a 595-606 old.

**Kiegészítők, külön rendelendő**

Szár és ellensúly kiesztergáláshoz vagy csap-esztergáláshoz MPA-n, FB 760 fejekhez



- MPA-ra való illesztéshez.
- Használható kiesztergáláshoz és csap-esztergáláshoz
- Ugyanazok a lapkatarók valók bele, mint a moduláris kiesztergáló szárakba.



1. Szerszám rögzítő csavar

| Cikkszám | Megnevezés  | Kivitel   | ** Átmérő DCN-DCX Ø   |       |       |       | LB    | LB1   | LB2   | LB3   | WF    | BDX   | BD    | Súly  | Kivitel |
|----------|-------------|-----------|-----------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|---------|
|          |             |           | Csap kiesztergáláshoz |       |       |       |       |       |       |       |       |       |       |       |         |
|          |             |           | Furat                 |       |       |       |       |       |       |       |       |       |       |       |         |
|          |             |           | mm                    | mm    | mm    | mm    | mm    | mm    | mm    | mm    | mm    | mm    | mm    | kg    |         |
|          |             |           | Inch                  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | lbs   |         |
| 02595019 | BAS25MH1660 | Szár*     | 53,0                  | 108,0 | 2,0   | 57,0  | 58,5  | 48,5  | 58,5  | 50,0  | 4,0   | 16,0  | 25,0  | 0,1   | A       |
|          |             |           | 2.087                 | 4.252 | 0.079 | 2.244 | 2.303 | 1.909 | 2.303 | 1.969 | 0.157 | 0.630 | 0.984 | 0.220 |         |
| 02595016 | BAS25CW1660 | Ellensúly | 53,0                  | 108,0 | 2,0   | 57,0  | 58,0  | 56,6  | -     | 48,5  | -     | 16,0  | 25,0  | 0,11  | B       |
|          |             |           | 2.087                 | 4.252 | 0.079 | 2.244 | 2.283 | 2.228 | -     | 1.909 | -     | 0.630 | 0.984 | 0.240 |         |

Pótalkatrészek

| Megnevezés  | Összeszerelő csavar |
|-------------|---------------------|
| BAS25MH1660 | C04008-T15P         |
| BAS25CW1660 | -                   |

Kiegészítők

| Megnevezés  | Kulcs (T-típus) |
|-------------|-----------------|
| BAS25MH1660 | DOUBLE-T        |
| BAS25CW1660 | -               |

\*A lapkatarókat külön kell rendelni lásd a 589 old.

\*\*Az átmérők kiesztergálásban és csap-esztergálásban meg van határozva a kiválasztott lapkataró és a szár beállítási pozíció alapján, használja a 'Lapka tartók kiesztergáláshoz és csap-esztergáláshoz kiválasztási táblázatot' a 595-606 old.

**Kiegészítők**, külön rendelendő

Bevezetés

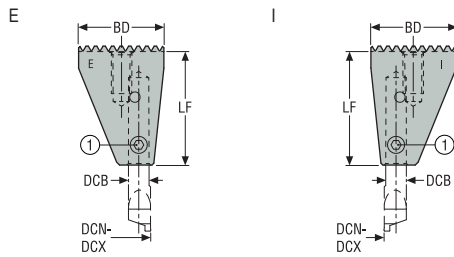
Fűrés

Dörzsárazás

Kiesztergálás

Melléklet

## Beszúró szerszám tartók, homlok beszúráshoz az MPA-n az FB 760 fejekhez



1. Rögzítő csavar



- MPA-ra való illesztéshez.
- A beszúró szerszám befogó homlokbeszúró szerszám befogására vagy ellensúlyként használatos.

| Cikkszám | Megnevezés | Kivitel                          | * Átmérő DCN-DCX Ø |               | DCB          | LF            | BD            | Súly         | Kivitel   |
|----------|------------|----------------------------------|--------------------|---------------|--------------|---------------|---------------|--------------|-----------|
|          |            |                                  | mm                 | mm            |              |               |               |              |           |
| 02595021 | BAS25FGI35 | Beszúró szerszámtartó I (furat)* | 19,0<br>0.748      | 76,0<br>2.992 | 6,0<br>0.236 | 35,0<br>1.378 | 25,0<br>0.984 | 0,1<br>0.220 | I (Furat) |
| 02595020 | BAS25FGE35 | Beszúró szerszámtartó E (külső)* | 39,0<br>1.535      | 96,0<br>3.780 | 6,0<br>0.236 | 35,0<br>1.378 | 25,0<br>0.984 | 0,1<br>0.220 | E (Külső) |

### Pótalkatrészek

| Megnevezés | [Locking screw] Rögzítő csavar |
|------------|--------------------------------|
| BAS25FGI35 | 950L0607T15P                   |
| BAS25FGE35 | 950L0607T15P                   |



### Kiegészítők

| Kiegészítő      |
|-----------------|
| Kulcs (T-típus) |
| DOUBLE-T        |
| DOUBLE-T        |



\*A beszúró szerszámokat külön kell rendelni, lásd a 594 old.

\* A beszúrási méretei a kiválasztott homlokbeszúró szerszámtól, a homlokbeszúró helyzete pedig a kiválasztott szerszám befogótól függ. 595-606 old.

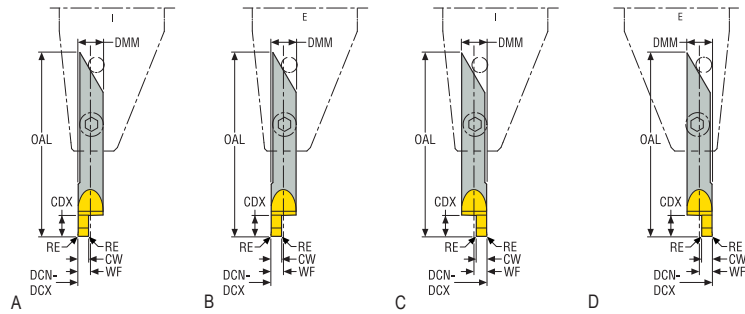
**Kiegészítők**, külön rendelendő

## Beszűrő szerszámok

FB 760 fejekhez



- Használhatók 'külső' vagy 'belső' beszűrő szerszámbefogókhoz, feladattól függően.



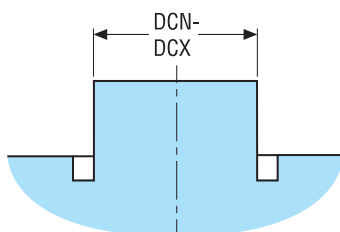
| * Átmérő DCN-DCX Ø |               |         |           |       |           |       |           |       |           |       |       |       |       |       |       |                |       |
|--------------------|---------------|---------|-----------|-------|-----------|-------|-----------|-------|-----------|-------|-------|-------|-------|-------|-------|----------------|-------|
| Cikkszám           | Megnevezés    | Kivitel | Kivitel A |       | Kivitel B |       | Kivitel C |       | Kivitel D |       | OAL   | CW    | RE    | DMM   | WF    | Horony max. ** | Súly  |
|                    |               |         | mm        | mm    | mm        | mm    | mm        | mm    | mm        | mm    | mm    | mm    | mm    | mm    | mm    | mm             | kg    |
|                    |               |         | Inch      | Inch  | Inch      | Inch  | Inch      | Inch  | Inch      | Inch  | Inch  | Inch  | Inch  | Inch  | Inch  | Inch           | lbs   |
| 02595028           | AFG0629101582 | Csap    | 19,0      | 64,0  | 39,0      | 84,0  | -         | -     | -         | -     | 42,0  | 1,0   | 0,15  | 6,0   | 2,95  | 2,0            | 0,07  |
|                    |               |         | 0.748     | 2.520 | 1.535     | 3.307 |           |       |           |       | 1.654 | 0.039 | 0.006 | 0.236 | 0.116 | 0.079          | 0.150 |
| 02595029           | AFG0629151582 | Csap    | 19,0      | 64,0  | 39,0      | 84,0  | -         | -     | -         | -     | 42,0  | 1,5   | 0,15  | 6,0   | 2,95  | 3,0            | 0,07  |
|                    |               |         | 0.748     | 2.520 | 1.535     | 3.307 |           |       |           |       | 1.654 | 0.059 | 0.006 | 0.236 | 0.116 | 0.118          | 0.150 |
| 02595031           | AFG0629201582 | Csap    | 19,0      | 64,0  | 39,0      | 84,0  | -         | -     | -         | -     | 42,0  | 2,0   | 0,15  | 6,0   | 2,95  | 5,0            | 0,07  |
|                    |               |         | 0.748     | 2.520 | 1.535     | 3.307 |           |       |           |       | 1.654 | 0.079 | 0.006 | 0.236 | 0.116 | 0.197          | 0.150 |
| 02595032           | AFG0629251582 | Csap    | 19,0      | 64,0  | 39,0      | 84,0  | -         | -     | -         | -     | 42,0  | 2,5   | 0,15  | 6,0   | 2,95  | 5,0            | 0,07  |
|                    |               |         | 0.748     | 2.520 | 1.535     | 3.307 |           |       |           |       | 1.654 | 0.098 | 0.006 | 0.236 | 0.116 | 0.197          | 0.150 |
| 02595033           | AFG0629301582 | Csap    | 19,0      | 64,0  | 39,0      | 84,0  | -         | -     | -         | -     | 42,0  | 3,0   | 0,15  | 6,0   | 2,95  | 6,0            | 0,07  |
|                    |               |         | 0.748     | 2.520 | 1.535     | 3.307 |           |       |           |       | 1.654 | 0.118 | 0.006 | 0.236 | 0.116 | 0.236          | 0.150 |
| 02595022           | AFG0629101581 | Furat   | -         | -     | -         | -     | 31,0      | 76,0  | 51,0      | 96,0  | 42,0  | 1,0   | 0,15  | 6,0   | 2,95  | 2,0            | 0,02  |
|                    |               |         |           |       |           |       | 1.220     | 2.992 | 2.008     | 3.780 | 1.654 | 0.039 | 0.006 | 0.236 | 0.116 | 0.079          | 0.040 |
| 02595023           | AFG0629151581 | Furat   | -         | -     | -         | -     | 31,0      | 76,0  | 51,0      | 96,0  | 42,0  | 1,5   | 0,15  | 6,0   | 2,95  | 3,0            | 0,07  |
|                    |               |         |           |       |           |       | 1.220     | 2.992 | 2.008     | 3.780 | 1.654 | 0.059 | 0.006 | 0.236 | 0.116 | 0.118          | 0.150 |
| 02595024           | AFG0629201581 | Furat   | -         | -     | -         | -     | 31,0      | 76,0  | 51,0      | 96,0  | 42,0  | 2,0   | 0,15  | 6,0   | 2,95  | 4,0            | 0,07  |
|                    |               |         |           |       |           |       | 1.220     | 2.992 | 2.008     | 3.780 | 1.654 | 0.079 | 0.006 | 0.236 | 0.116 | 0.157          | 0.150 |
| 02595026           | AFG0629251581 | Furat   | -         | -     | -         | -     | 31,0      | 76,0  | 51,0      | 96,0  | 42,0  | 2,5   | 0,15  | 6,0   | 2,95  | 5,0            | 0,07  |
|                    |               |         |           |       |           |       | 1.220     | 2.992 | 2.008     | 3.780 | 1.654 | 0.098 | 0.006 | 0.236 | 0.116 | 0.197          | 0.150 |
| 02595027           | AFG0629301581 | Furat   | -         | -     | -         | -     | 31,0      | 76,0  | 51,0      | 96,0  | 42,0  | 3,0   | 0,15  | 6,0   | 2,95  | 6,0            | 0,07  |
|                    |               |         |           |       |           |       | 1.220     | 2.992 | 2.008     | 3.780 | 1.654 | 0.118 | 0.006 | 0.236 | 0.116 | 0.236          | 0.150 |

\* A beszűrés méretei a kiválasztott homlokbeszűrő szerszámtól, a homlokbeszűrő helyzete pedig a kiválasztott szerszámbefogótól függ. 595-606 old.

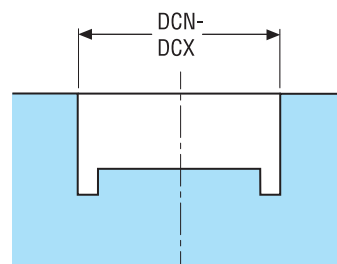
\*\* Horony max. mélység CDX

### Pótalkatrészek

Beszűrő szerszám csap mellett



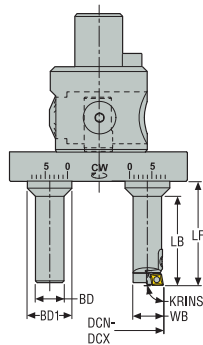
Beszűrő szerszám furatban



**Kiválasztó táblázat:  
Kiesztergáló szerszámok és lapka tartók az FB 760 fejekhez, Metrikus**

|  | Átmérő<br>DCN-DCX* | Lapka tartó<br>Megnevezés | Szár<br>pozíció | Méretek mm-ben |     |      |    |      | Elhe-<br>lyezési<br>szög<br>KRINS° | Használható<br>lapka méret |
|--|--------------------|---------------------------|-----------------|----------------|-----|------|----|------|------------------------------------|----------------------------|
|  |                    |                           |                 | 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..                 |
|  | 65,5-68            | A765 R5                   | 0               | 16             | 25  | 58,5 | 50 | 22   | 90°                                | CC..0602..                 |
|  |                    | A765 R2                   | 2               | 16             | 25  | 58,5 | 50 | 18,2 | 90°                                | CC..0602..                 |
|  | 68-70,5            | 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..                 |
|  | 70,5-73            | 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..                 |
|  | 73-75,5            | A765 R5                   | 1               | 16             | 25  | 58,5 | 50 | 22   | 90°                                | CC..0602..                 |
|  |                    | A765 R2                   | 3               | 16             | 25  | 58,5 | 50 | 18,2 | 90°                                | CC..0602..                 |
|  | 75,5-78            | 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..                 |
|  | 78-80,5            | 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..                 |
|  | 80,5-83            | A765 R5                   | 2               | 16             | 25  | 58,5 | 50 | 22   | 90°                                | CC..0602..                 |
|  |                    | A765 R2                   | 4               | 16             | 25  | 58,5 | 50 | 18,2 | 90°                                | CC..0602..                 |
|  | 83-85,5            | 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..                 |
|  | 85,5-88            | 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..                 |
|  | 88-90,5            | A765 R5                   | 3               | 16             | 25  | 58,5 | 50 | 22   | 90°                                | CC..0602..                 |
|  |                    | A765 R2                   | 5               | 16             | 25  | 58,5 | 50 | 18,2 | 90°                                | CC..0602..                 |
|  | 90,5-93            | 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..                 |
|  | 93-95,5            | 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..                 |
|  | 95,5-98            | A765 R5                   | 4               | 16             | 25  | 58,5 | 50 | 22   | 90°                                | CC..0602..                 |
|  |                    | A765 R2                   | 6               | 16             | 25  | 58,5 | 50 | 18,2 | 90°                                | CC..0602..                 |
|  | 98-100,5           | A765 R4                   | 7               | 16             | 25  | 58,5 | 50 | 20,7 | 90°                                | CC..0602..                 |
|  |                    | A765 R6                   | 5               | 16             | 25  | 58,5 | 50 | 23,2 | 90°                                | CC..0602..                 |
|  | 100,5-103          | 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..                 |
|  | 103-105,5          | A765 R5                   | 6               | 16             | 25  | 58,5 | 50 | 22   | 90°                                | CC..0602..                 |
|  |                    | A765 R2                   | 8               | 16             | 25  | 58,5 | 50 | 18,2 | 90°                                | CC..0602..                 |
|  | 105,5-108          | 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..                 |

Válasszon egy megfelelő lapkatartót, és jegyezze meg a szár helyzetét az MPA-n, hogy megkapja a kívánt kiesztergálási átmérőt.  
Megjegyzés: A kiesztergáló szerszámhoz az következők szükségesek:  
- Axiabore™ Plus  
- fej (A760 03)  
- MPA (BDA16BS25100)  
- szár (BAS25MH1660)  
- ellensúly (BAS25CW1660).  
- lapkatartó (A765R.), melyet a táblázatból kell kiválasztani  
- lapka

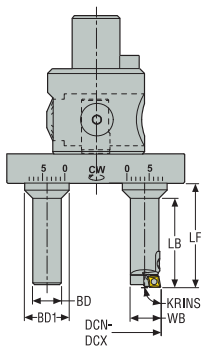


\* +0,2 mm (0.008") kiegészítő átmérő is elérhető.  
A lapkatartók részletes leírását lásd a 589 old.

## Kiválasztó táblázat:

## Kiesztorgáló szerszámok és lapka tartók az FB 760 fejekhez, inch

|  | Tartomány<br>DCN-DCX<br>inch* | Lapka tartó<br>Megnevezés | Szár<br>pozíció | Méretek inch-ben |       |       |       |       | Elhe-<br>lyezési<br>szög<br>KRINS° | Használható<br>lapka méret |
|--|-------------------------------|---------------------------|-----------------|------------------|-------|-------|-------|-------|------------------------------------|----------------------------|
|  |                               |                           |                 | 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..                 |
|  | 2.579-2.677                   | A765 R5                   | 0               | 0.630            | 0.984 | 2.303 | 1.969 | 0.866 | 90°                                | CC..0602..                 |
|  |                               | A765 R2                   | 2               | 0.630            | 0.984 | 2.303 | 1.969 | 0.717 | 90°                                | CC..0602..                 |
|  | 2.677-2.776                   | 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..                 |
|  | 2.776-2.874                   | 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..                 |
|  | 2.874-2.972                   | A765 R5                   | 1               | 0.630            | 0.984 | 2.303 | 1.969 | 0.866 | 90°                                | CC..0602..                 |
|  |                               | A765 R2                   | 3               | 0.630            | 0.984 | 2.303 | 1.969 | 0.717 | 90°                                | CC..0602..                 |
|  | 2.972-3.071                   | 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..                 |
|  | 3.169-3.268                   | A765 R5                   | 3               | 0.630            | 0.984 | 2.303 | 1.969 | 0.866 | 90°                                | CC..0602..                 |
|  |                               | A765 R2                   | 5               | 0.630            | 0.984 | 2.303 | 1.969 | 0.717 | 90°                                | CC..0602..                 |
|  | 3.268-3.366                   | 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..                 |
|  | 3.366-3.465                   | 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..                 |
|  | 3.465-3.563                   | A765 R5                   | 4               | 0.630            | 0.984 | 2.303 | 1.969 | 0.866 | 90°                                | CC..0602..                 |
|  |                               | A765 R2                   | 6               | 0.630            | 0.984 | 2.303 | 1.969 | 0.717 | 90°                                | CC..0602..                 |
|  | 3.563-3.661                   | 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..                 |
|  | 3.661-3.760                   | 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..                 |
|  | 3.760-3.858                   | A765 R5                   | 5               | 0.630            | 0.984 | 2.303 | 1.969 | 0.866 | 90°                                | CC..0602..                 |
|  |                               | A765 R2                   | 7               | 0.630            | 0.984 | 2.303 | 1.969 | 0.717 | 90°                                | CC..0602..                 |
|  | 3.858-3.957                   | 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..                 |
|  | 3.957-4.055                   | 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..                 |
|  | 4.055-4.154                   | A765 R5                   | 6               | 0.630            | 0.984 | 2.303 | 1.969 | 0.866 | 90°                                | CC..0602..                 |
|  |                               | A765 R2                   | 8               | 0.630            | 0.984 | 2.303 | 1.969 | 0.717 | 90°                                | CC..0602..                 |
|  | 4.154-4.252                   | 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..                 |

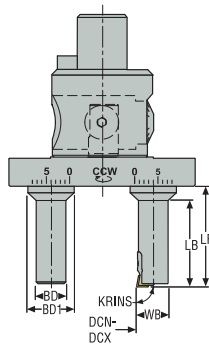


\* +0,2 mm (0.008") kiegészítő átmérő is elérhető.  
A lapkatartók részletes leírását lásd a 589 old.

Kiválasztó táblázat:  
Lapkatartók csap esztergáláshoz MPA-val , FB 760 fejekhez, Metrikus

|  | Átmérő DCN-DCX* | Lapka tartó Megnevezés | Szár pozíció | Méretek mm-ben |     |      |    |      | Elhelyezési szög KRINS° | Használható lapka méret |
|--|-----------------|------------------------|--------------|----------------|-----|------|----|------|-------------------------|-------------------------|
|  |                 |                        |              | 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..              |
|  |                 | A765 R6                | 2            | 16             | 25  | 58,5 | 50 | 23,2 | 90°                     | CC..0602..              |
|  | 12-14,5         | 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..              |

Válasszon egy megfelelő lapkatartót, és jegyezze meg a szár helyzetét az MPA-n, hogy megkapja a kívánt kiesztergálási átmérőt.  
Megjegyzés: A kiesztergáló szerszámhoz következők szükségesek :  
- Axiabore™ Plus  
- fej (A760 03)  
- MPA (BDA16BS25100)  
- szár (BAS25MH1660)  
- ellensúly (BAS25CW1660).  
- lapkatartó (A765R.), melyet a táblázatból kell kiválasztani  
- lapka



\* +0,2 mm (0.008") kiegészítő átmérő is elérhető.  
A lapkatartók részletes leírását lásd a 589 old.

Bevezetés

Fúrás

Dörzsöraszás

Kiesztergálás

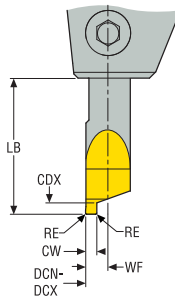
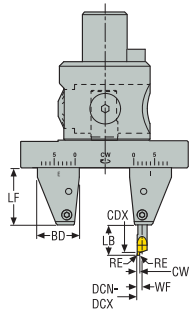
Melléklet



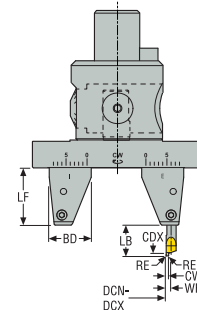


**Kiválasztó táblázat:  
Beszúró szerszám - csap melletti - MPA-val történő beszúráshoz, FB 760 fejekhez,  
Metrikus**

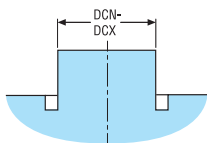
Kivitel 1



Kivitel 2



|   | Átmérő<br>DCN-DCX* | Csap melletti<br>beszúró szerszám<br>Megnevezés | Beszúró<br>szerszámtartó<br>pozíció** | Kivitel | Méretek mm-ben |     |      |      |      |      | Horony<br>max.<br>mélység<br>CDX |
|---|--------------------|---|---------------------------------------|---------|----------------|-----|------|------|------|------|----------------------------------|
|   |                    |   |                                       |         | BD             | CW  | LF   | LB   | WF   | RE   |                                  |
| Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt. | 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              |   | 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   | 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  |      |                                  |



Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek:

- Axiabore™ Plus fej (A760 03)
- MPA (BDA16BS25100)
- I (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)
- furat homlokbeszúró szerszám (AFG...82), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.

\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve. A beszúró szerszámok részletes leírását lásd a 594 old.

**Kiválasztó táblázat:**  
**Beszúró szerszám - csap melletti - MPA-val történő beszúráshoz, FB 760 fejekhez, inch**

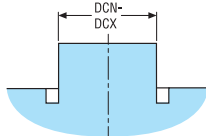
Bevezetés

Fúrás

Dörzsárazás

Kiesztergálás

Melléklet

|   | Tartomány<br>DCN-DCX Ø<br>inch*   | Csap melletti<br>beszúró szerszám<br>Megnevezés | Beszúró<br>szerszámtartó<br>pozíció** | Kivitel         | Méretek inch-ben |        |       |        |       |       | Horony<br>max.<br>mélység CDX |       |       |
|---|---|---|---------------------------------------|-----------------|------------------|--------|-------|--------|-------|-------|-------------------------------|-------|-------|
|   |   |   |                                       |                 | BD               | CW     | LF    | LB     | WF    | RE    |                               |       |       |
| <p>Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt.</p>   | 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   |   | <b>0-E / 4-I</b>                      | 1/2             | 0.984            | 0.0394 | 1.339 | 0.709  | 0.116 | 0.006 | 0.079                         |       |       |
|   | 1.732-1.929   |   | <b>1-E / 5-I</b>                      | 1/2             | 0.984            | 0.0394 | 1.339 | 0.709  | 0.116 | 0.006 | 0.079                         |       |       |
|   | 1.929-2.126   |   | <b>2-E / 6-I</b>                      | 1/2             | 0.984            | 0.0394 | 1.339 | 0.709  | 0.116 | 0.006 | 0.079                         |       |       |
|   | 2.126-2.323   |   | <b>3-E / 7-I</b>                      | 1/2             | 0.984            | 0.0394 | 1.339 | 0.709  | 0.116 | 0.006 | 0.079                         |       |       |
|   | 2.323-2.520   |   | <b>4-E / 8-I</b>                      | 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                         |       |       |
|   | <p>Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek :</p> <ul style="list-style-type: none"> <li>• Axiabore™ Plus fej (A760 03)</li> <li>• MPA (BDA16BS25100)</li> <li>• I (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>• furat homlokbeszúró szerszám (AFG...82), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> |   | 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   |   | <b>0-E / 4-I</b>                                | 1/2                                   |                 | 0.984            | 0.0591 | 1.339 | 0.709  | 0.116 | 0.006 | 0.118                         |       |       |
| 1.732-1.929   |   | <b>1-E / 5-I</b>                                | 1/2                                   |                 | 0.984            | 0.0591 | 1.339 | 0.709  | 0.116 | 0.006 | 0.118                         |       |       |
| 1.929-2.126   |   | <b>2-E / 6-I</b>                                | 1/2                                   |                 | 0.984            | 0.0591 | 1.339 | 0.709  | 0.116 | 0.006 | 0.118                         |       |       |
| 2.126-2.323   |   | <b>3-E / 7-I</b>                                | 1/2                                   |                 | 0.984            | 0.0591 | 1.339 | 0.709  | 0.116 | 0.006 | 0.118                         |       |       |
| 2.323-2.520   |   | <b>4-E / 8-I</b>                                | 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                         |       |       |
| <p>Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek :</p> <ul style="list-style-type: none"> <li>• Axiabore™ Plus fej (A760 03)</li> <li>• MPA (BDA16BS25100)</li> <li>• I (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>• furat homlokbeszúró szerszám (AFG...82), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> |   | 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   | <b>0-E / 4-I</b>                                |                                       | 1/2             | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 1.732-1.929   | <b>1-E / 5-I</b>                                |                                       | 1/2             | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 1.929-2.126   | <b>2-E / 6-I</b>                                |                                       | 1/2             | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 2.126-2.323   | <b>3-E / 7-I</b>                                |                                       | 1/2             | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 2.323-2.520   | <b>4-E / 8-I</b>                                |                                       | 1/2             | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 2.520-2.717   | 5-E   |                                       | 2               | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 2.717-2.913   | 6-E   |                                       | 2               | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 2.913-3.110   | 7-E   |                                       | 2               | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |
|   | 3.110-3.307   | 8-E   |                                       | 2               | 0.984            | 0.0787 | 1.339 | 0.709  | 0.116 | 0.006 | 0.157                         |       |       |

\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve. A beszúró szerszámok részletes leírását lásd a 594 old.

**Kiválasztó táblázat:  
Beszúró szerszám - csap melletti - MPA-val történő beszúráshoz, FB 760 fejekhez,  
Metrikus**

**Kivitel 1**

**Kivitel 2**

|  | Átmérő<br>DCN-DCX* | Csap melletti<br>beszúró szerszám<br>Megnevezés | Beszúró<br>szerszámtartó<br>pozíció** | Kivitel | Méretek mm-ben |     |      |      |      |      | Horony<br>max.<br>mélység CDX |
|--|--------------------|---|---------------------------------------|---------|----------------|-----|------|------|------|------|-------------------------------|
|  |                    |   |                                       |         | BD             | CW  | LF   | LB   | WF   | RE   |                               |
| <p>Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt.</p> <p>Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek :</p> <ul style="list-style-type: none"> <li>• Axiabore™ Plus fej (A760 03)</li> <li>• MPA (BDA16BS25100)</li> <li>• I (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>• furat homlokbeszúró szerszám (AFG...82), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> | 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              |   | <b>0-E / 4-I</b>                      | 1/2     | 25             | 2,5 | 34   | 18   | 2,95 | 0,15 | 5,0                           |
|  | 44-49              |   | <b>1-E / 5-I</b>                      | 1/2     | 25             | 2,5 | 34   | 18   | 2,95 | 0,15 | 5,0                           |
|  | 49-54              |   | <b>2-E / 6-I</b>                      | 1/2     | 25             | 2,5 | 34   | 18   | 2,95 | 0,15 | 5,0                           |
|  | 54-59              |   | <b>3-E / 7-I</b>                      | 1/2     | 25             | 2,5 | 34   | 18   | 2,95 | 0,15 | 5,0                           |
|  | 59-64              |   | <b>4-E / 8-I</b>                      | 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              |   | 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  | <b>0-E / 4-I</b>   | 1/2   | 25                                    | 3       | 34             | 18  | 2,95 | 0,15 | 6,0  |      |                               |
| 44-49  | <b>1-E / 5-I</b>   | 1/2   | 25                                    | 3       | 34             | 18  | 2,95 | 0,15 | 6,0  |      |                               |
| 49-54  | <b>2-E / 6-I</b>   | 1/2   | 25                                    | 3       | 34             | 18  | 2,95 | 0,15 | 6,0  |      |                               |
| 54-59  | <b>3-E / 7-I</b>   | 1/2   | 25                                    | 3       | 34             | 18  | 2,95 | 0,15 | 6,0  |      |                               |
| 59-64  | <b>4-E / 8-I</b>   | 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  |      |                               |

\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve.  
A beszúró szerszámok részletes leírását lásd a 594 old.

**Kiválasztó táblázat:**  
**Beszúró szárszám - csap melletti - MPA-val történő beszúráshoz, FB 760 fejekhez, inch**

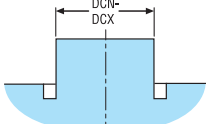
Bevezetés

Fúrás

Dörzsárazás

Kiesztorgálás

Melléklet

|  | Tartomány<br>DCN-DCX Ø<br>inch* | Csap melletti<br>beszúró szárszám<br>Megnevezés | Beszúró<br>szárszám<br>pozíció** | Kivitel | Méretek inch-ben |        |        |       |       |       | Horony<br>max.<br>mélység CDX |       |
|--|---------------------------------|---|----------------------------------|---------|------------------|--------|--------|-------|-------|-------|-------------------------------|-------|
|  |                                 |   |                                  |         | BD               | CW     | LF     | LB    | WF    | RE    |                               |       |
| <p>Válasszon egy megfelelő beszúró szárszámot, és jegyezze meg a beszúró szárszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt.</p>  <p>Megjegyzés: A csap melletti beszúró szárszámhoz a következők szükségesek:</p> <ul style="list-style-type: none"> <li>Axiabore™ Plus fej (A760 03)</li> <li>MPA (BDA16BS25100)</li> <li>I (belső) és E (külső) beszúró szárszám befogó (BAS25FGI35 és BAS25FGE35) beszúró szárszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>furat homlokbeszúró szárszám (AFG...82), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> | 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 |                               |       |

\* +0.2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve. A beszúró szárszámok részletes leírását lásd a 594 old.

Kiválasztó táblázat:  
Beszúró szerszám - furat melletti - MPA-val beszúráshoz, FB 760 fejekhez, Metrikus

**Kivitel 3**

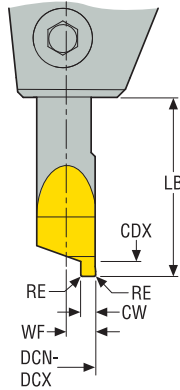
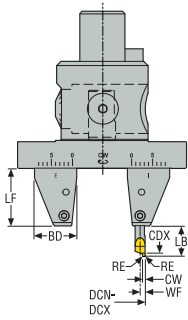
**Kivitel 4**

|   | Átmérő DCN-DCX* | Csap melletti beszúró szerszám Megnevezés | Beszúró szerszámtartó pozíció** | Kivitel | Méretek mm-ben |     |      |      |      |      | Horony max. mélység CDX |
|---|-----------------|---|---------------------------------|---------|----------------|-----|------|------|------|------|-------------------------|
|   |                 |   |                                 |         | BD             | CW  | LF   | LB   | WF   | RE   |                         |
| <p>Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt.</p> <p>Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek:</p> <ul style="list-style-type: none"> <li>Axiabore™ Plus fej (A760 03)</li> <li>MPA (BDA16BS25100)</li> <li>1 (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>furat homlokbeszúró szerszám (AFG...81), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> | 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           |   | 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   | 0-I             | 3   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 39-41   | 1-I             | 3   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 41-46   | 2-I             | 3   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 46-51   | 3-I             | 3   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 51-56   | 0-E / 4-I       | 3/4                                       | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 56-61   | 1-E / 5-I       | 3/4                                       | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 61-66   | 2-E / 6-I       | 3/4                                       | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 66-71   | 3-E / 7-I       | 3/4                                       | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 71-76   | 4-E / 8-I       | 3/4                                       | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 76-81   | 5-E             | 4   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 81-86   | 6-E             | 4   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 86-91   | 7-E             | 4   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |
| 91-96   | 8-E             | 4   | 25                              | 2       | 34             | 18  | 2,95 | 0,15 | 4,0  |      |                         |

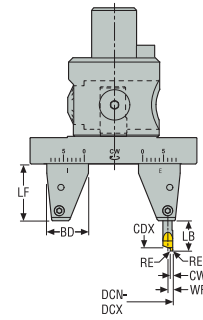
\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve. A beszúró szerszámok részletes leírását lásd a 594 old.

**Kiválasztó táblázat:**  
**Beszúró szerszám - furat melletti - MPA-val beszuráshoz, FB 760 fejekhez, inch**

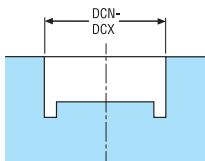
Kivitel 3



Kivitel 4



|   | Tartomány<br>DCN-DCX Ø<br>inch* | Csap melletti<br>beszúró szerszám<br>Megnevezés | Beszúró<br>szerszámtartó<br>pozíció** | Kivitel | Méretek inch-ben |        |       |       |       |       | Horony<br>max.<br>mélység CDX |
|---|---------------------------------|---|---------------------------------------|---------|------------------|--------|-------|-------|-------|-------|-------------------------------|
|   |                                 |   |                                       |         | BD               | CW     | LF    | LB    | WF    | RE    |                               |
| Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszurási átmérőt. | 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                     |   | 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   | 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 |       |                               |



Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek:

- Axiabore™ Plus fej (A760 03)
- MPA (BDA16BS25100)
- I (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)
- furat homlokbeszúró szerszám (AFG...81), melyet a beszurás szélessége és átmérője alapján kell kiválasztani a táblázatból.

\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve. A beszuró szerszámok részletes leírását lásd a 594 old.

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**Kiválasztó táblázat:**  
**Beszúró szerszám - furat melletti - MPA-val beszúráshoz, FB 760 fejekhez, Metrikus**

**Kivitel 3**

**Kivitel 4**

|   | Átmérő<br>DCN-DCX* | Csap melletti<br>beszúró szerszám<br>Megnevezés | Beszúró<br>szerszámtartó<br>pozíció** | Kivitel         | Méretek mm-ben |     |    |    |      |      | Horony<br>max.<br>mélység CDX |      |     |
|---|--------------------|---|---------------------------------------|-----------------|----------------|-----|----|----|------|------|-------------------------------|------|-----|
|   |                    |   |                                       |                 | BD             | CW  | LF | LB | WF   | RE   |                               |      |     |
| <p>Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt.</p> <p>Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek :</p> <ul style="list-style-type: none"> <li>• Axiabore™ Plus fej (A760 03)</li> <li>• MPA (BDA16BS25100)</li> <li>• I (belső) és E (külső) beszúró szerszámbefogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>• furat homlokbeszúró szerszám (AFG...81), melyet a beszúrás szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> | 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                           |      |     |

\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve. A beszúró szerszámok részletes leírását lásd a 594 old.

**Kiválasztó táblázat:**  
**Beszúró szerszám - furat melletti - MPA-val beszúráshoz, FB 760 fejekhez, inch**

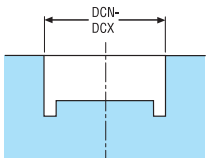
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|   | Tartomány<br>DCN-DCX Ø<br>inch* | Csap melletti<br>beszúró szerszám<br>Megnevezés | Beszúró<br>szerszámtartó<br>pozíció** | Kivitel | Méretek inch-ben |        |       |       |       |       | Horony<br>max.<br>mélység CDX |
|---|---------------------------------|---|---------------------------------------|---------|------------------|--------|-------|-------|-------|-------|-------------------------------|
|   |                                 |   |                                       |         | BD               | CW     | LF    | LB    | WF    | RE    |                               |
| <p>Válasszon egy megfelelő beszúró szerszámot, és jegyezze meg a beszúró szerszámhelyzetét az MPA-n, hogy megkapja a kívánt beszúrási átmérőt.</p>  <p>Megjegyzés: A csap melletti beszúró szerszámhoz a következők szükségesek :</p> <ul style="list-style-type: none"> <li>• Axiabore™ Plus fej (A760 03)</li> <li>• MPA (BDA16BS25100)</li> <li>• I (belső) és E (külső) beszúró szerszám befogó (BAS25FGI35 és BAS25FGE35) beszúró szerszám befogásához vagy ellensúlyként (lásd a beállítási helyzetet a táblázatban)</li> <li>• furat homlokbeszúró szerszám (AFG...81), melyet a beszúrási szélessége és átmérője alapján kell kiválasztani a táblázatból.</li> </ul> | 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 |       |                               |

\* +0,2 mm (0.008") kiegészítő átmérő is elérhető. \*\* Az ajánlott értékek vastaggal kiemelve.  
 A beszúró szerszámok részletes leírását lásd a 594 old.



## Előírások

### Maximális sebességek az AxiaBore™ típusú fejekhez

Az alkalmazás további részletei a kiesztorgáló fejhez és a GL rudakkal szállított mellékelt használati utasításban található.

| Fej   | Tartomány $\varnothing$ mm (inch) | Max. fordulat<br>szerszámmal<br>(RPM) | Max. fordulat<br>MPA-val<br>(RPM) | Max. forgácsolási<br>sebesség $v_c$<br>a min. átm.-nél<br>m/perc (sf/min) | Max. forgácsolási<br>sebesség $v_c$<br>a max. átm.-nél<br>m/perc (sf/min) |
|---|-----------------------------------|---------------------------------------|-----------------------------------|---|---|
| Axiabore™ típus szélesség Graflex® csatlakozás    |                                   |                                       |                                   |   |   |
| 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™ típus szélesség Seco-Capto™ csatlakozás |                                   |                                       |                                   |   |   |
| C5-391.0760-03                                    | 6-108 (0.236-4.25)                | 8000*                                 | 5000                              | 151* (495*)   | 1000** (3281**)   |

**Megjegyzés:** A maximum fordulatszámok függenek a kiesztorgáló fej mechanikus kivitelétől és kiegyensúlyozási minőségétől. Az ezeken a korlátokon belül lévő fordulatszámokat a többi forgácsolási feltétel alapján kell kiválasztani, pl. munkadarab anyaga, vágóél (lapka), szerszám hossza, gép főorsó. kb. 8000 és magasabb fordulatszámnál fi nom-kiegyensúlyozni kell a tartótűskéket és a köztes elemeket. Kiegyensúlyozható fejek használatánál a fi nom-kiegyensúlyozott befogók növelik a szerszámélettartamot és a kiesztorgáló teljesítményt még kis sebességeknél is.

\* A maximális vágósebesség a max. fordulattal.

\*\* Nem érhető el minden szerszámmal, lásd \*\*\*.

\*\*\* Max vágósebesség nem léphető túl.

## Hibaelhárítási utasítások (a radiális simító kiesztergáló fejekre is vonatkoznak)

| Pozíció  | Lehetséges ok                                      | Megoldás  |
|--|--|---|
| Rövid szerszám éltartam                                  | Nem megfelelő lapkaminőség                         | Válasszon kopásállóbb minőséget                               |
|  | Túl nagy vágósebesség                              | Csökkentse a vágósebességet                                   |
|  | Túl nagy fogásmélység                              | Csökkentse a fogásmélységet                                   |
| Kopogás és vibráció                                      | Túl nagy vágósebesség                              | Csökkentse a vágósebességet                                   |
|  | Magas L/D arány                                    | Rövidítse a szerszámot a merevség növeléséhez                 |
|  |  | Használjon erősebb kiesztergáló szerszámot                    |
|  |  | Steadyline rúd használata                                     |
|  | Használjon keményfém vagy nehézfém hosszabbítókat  |   |
| Nem megfelelő lapka                                      | Csökkentse a lapka csúcsrádiusát                   |   |
| Nem megfelelő tűrés                                      | Használjon köszörült geometriájú lapkákat          |   |
|  | Módosítsa az előfúrt furat átmérőjét               |   |
| Nem megfelelő a furatátmérő tűrése és megismételhetősége | Nem pontos szerszámcsere                           | Kopott és károsodott szerszámszár: csere                      |
|  | Változó ráhagyás                                   | Tisztítsa meg a főorsót és a szerszámszárat                   |
|  | Gyenge főorsó stabilitás                           | Végezzen elősimító kiesztergálást                             |
| Nem megfelelő körköröség                                 | Kiesztergáló szerszám kiegyensúlyozatlansága       | Használjon élesebb, köszörült geometriájú lapkákat            |
|  |  | Ellenőrizze a főorsó ütését                                   |
|  |  | Váltson LIBRAFLEX® kiesztergáló fejre                         |
|  |  | Ellenőrizze a kiegyensúlyozó gyűrű beállítását                |
|  |  | Csökkentse a sebességet                                       |
| Túl nagy vágóerők  | Ellenőrizze a tűrést és az előtolási sebességet    |   |
| Nem megfelelő a munkadarab befogása                      | Ellenőrizze, hogy egyforma-e a munkadarab befogása |   |
| Nem szimmetrikus munkadarab                              | Csökkentse a vágóerőt, válasszon köszörült lapkát  |   |
|  | Növelje a vágósebességet, csökkentse az előtolást  |   |
| Rossz helyzetűtűrés                                      | Az eredeti furat nem egytengelyű                   | Végezzen elősimító kiesztergálást is                          |
|  | Túl nagy fogásmélység                              | Csökkentse a fogásmélységet, két lépésben végezze a műveletet |
| Gyenge felületi minőség                                  | Rossz lapkarádiusz                                 | Válasszon nagyobb lapkarádiuszt                               |
|  | Túl nagy előtolás                                  | Csökkentse az előtolást, max. a lapka rádiusz 30%-ára         |
|  | Nem megfelelő forgácsiholdás                       | Alkalmazzon belső hűtést                                      |
| Váltson nagyobb szögű lapkára (HSS-re)                   |  |   |
| Kúpos furat  | Túl gyors szerszámkopás                            | Ellenőrizze a fogásmélységet                                  |
|  |  | Válasszon kopásállóbb minőséget                               |
|  |  | Módosítsa a vágósebességet                                    |
|  |  | Növelje a hűtőfolyadék áramlását                              |

Bevezetés

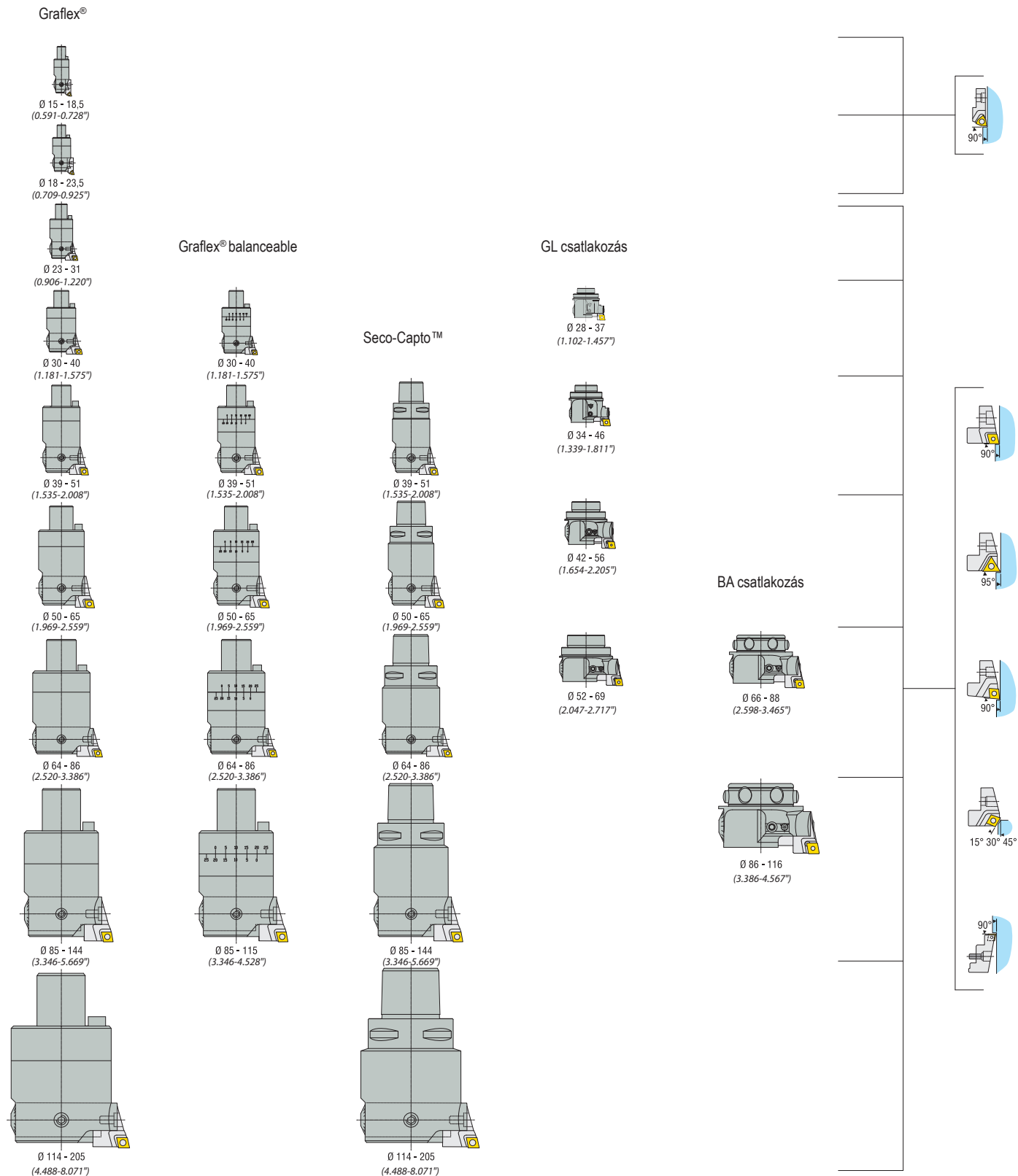
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## Simító kiesztergáló fejek – Útmutató

### Jellemzők

A radiális típusú simító kiesztergáló fej szerelvény test (fej) és lapkatartó kombinációja. FB 620, FB 780 és FB 790 radiális, simító kiesztergáló fejek jellemzői:

### Termékválaszték

A Seco kínálatában számos radiális simító kiesztergáló fej szerepel az igényeinek legmegfelelőbb megoldás kiválasztására:

### FB 620, FB 780 és FB 790 radiális, simító kiesztergáló fejek



- Mikrométeres pontosságú beállítás: Lapkatartó beállító mechanizmus mikrométeres beállító csavarral (1 osztás = 0,01 mm (0.0004") átmérő) és finombeállító skálával (2,5 µm (98,4 µin) átmérő)
- A mechanizmus pontossága garantálja az ismétlési pontosságot
- A vágóél ferde orientációja a DIN 69871/ISO 7388 szerinti az SA és ISO 12164 szerinti a HSK esetén
- A hűtőfolyadék közvetlenül a vágóélre van irányítva
- Az FB 780 és FB 620 kiesztergáló fejek a közepes átmérő beállítás alapján előre ki vannak egyensúlyozva. Az FB 790 típusok kiegyensúlyozhatók az optimális teljesítmény érdekében.

**Megjegyzés:** A jellemzők, előírások (lapkatartó beszerelés, átmérő beállítás, visszaeszttergálási utasítások, hibaelhárítás, ajánlott megmunkálási feltételek, maximális sebességek), alkalmazható lapkatartók és lapkák ugyanazok az FB 620, FB 780 és FB 790 simító kiesztergáló fejek egyazon méreteihez, függetlenül a gépdali csatlakozás típusától.

### FB 620 simító kiesztergáló fejek, radiális típusok a Steadyline® rezgéscsillapító rudakhoz



GL



BA

- 4 simító kiesztergáló fej, GL gépdali csatlakozással , Ø 27–69 mm (Ø 1.102–2.717")
- 2 simító kiesztergáló fej, BA gépdali csatlakozással, Ø 66–116 mm (Ø 2.598–4.567")

Kompakt kialakításuk a Steadyline® GL eszttergáló és kiesztergáló rudakon teszi lehetővé a legjobb csillapítási teljesítményt.

## FB 780 Simító kiesztorgáló fejek, radiális típusok

**9 precíziós kiesztorgáló fej Graflex® gépdali csatlakozással** Ø 15–205 mm (Ø 0.591–8.071") méretű simító kiesztorgáláshoz, radiálisan szerelt lapkatartókkal.

**5 precíziós kiesztorgáló fej Seco-Capto™ gépdali csatlakozással** simító kiesztorgáláshoz, Ø 39–205 mm (Ø 1.535–8.071").

**Seco-Capto™ adapter és Graflex® fej:** Ø 15-40 mm (Ø 0.591–1.575").

**Megjegyzés:** A legkisebb Capto™ simító kiesztorgáló fejekkel készíthető legkisebb furatméret Ø 39 mm (Ø 1.535"), a kapható legkisebb Capto™ C3 csatlakozóval. Ø 15–40 mm (Ø 0.591–1.575") furathoz használja a G0–G2 csatlakozóméretű Graflex® kiesztorgáló fejeket a megfelelő Capto™/Graflex® adapterrel. Ez szintén használható a kiesztorgálási hossz változtatására, amikor Graflex® hosszabbítókat használunk.

**Megjegyzés:** A jellemzők, előírások (lapkatartó beszerelés, átmérő beállítás, visszaesztorgálási utasítások, hibaelhárítás, ajánlott megmunkálási feltételek, maximális sebességek), alkalmazható lapkatartók és lapkák ugyanazok mindkét FB 780 simító kiesztorgáló fejek egyazon méreteihez, függetlenül a csatlakozás típusától.

## FB 790 Kiegyensúlyozható simító kiesztorgáló fejek, radiális típusok

**5 kiegyensúlyozható „Libraflex®” kiesztorgáló fej Graflex® gépdali csatlakozással** Ø 30–115 mm (Ø 1.181–4.528") furatok simító kiesztorgálásához nagy, akár 1500 m/perc (4921 ft/min) sebességgel, radiálisan szerelt lapkatartókkal.

A kiegyensúlyozás csökkenti a főorsó terhelését, a forgácsolási paraméterek optimalizálhatók, még hagyományos sebességek esetén is jobb megmunkálási mennyiségek érhetők el.

A kiegyensúlyozás úgy történik, hogy mindkét gyűrűt a kiesztorgálni kívánt átmérőnek megfelelően kell beállítani.



## Jellemzők

### Lapkatartók

A radiális típusú simító kiesztorgáló fej szerelvény test (fej) és lapkatartó kombinációja.

A kiesztorgáló, élettörő és visszaesztorgáló lapkatartók széles választéka az FB 620, FB 780 és FB 790 simító kiesztorgáló fejekkel, radiális típusokkal használható.

### Simító kiesztorgáló lapkatartók

FBIH 782: forgácsolási szög 90° WB lapkákhoz

FBIH 724: forgácsolási szög 90° TC lapkákhoz

FBIH 725: forgácsolási szög 90° CC lapkákhoz

FBIH 726: forgácsolási szög 95° CC lapkákhoz

**Megj.:** 95° élelhelyezési szögű lapkatartókat úgy kell használni, hogy ne érintkezzenek szemből váll kiesztorgálásakor.

### Élettörő lapkatartók, $\varnothing 23\text{--}160\text{ mm}$ ( $\varnothing 0.906\text{--}6.299''$ )

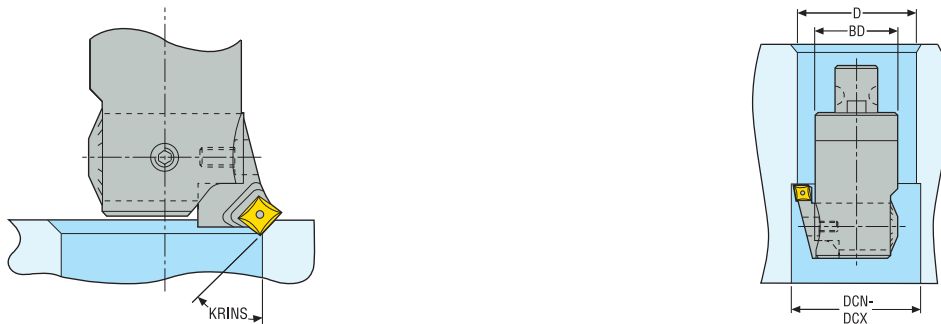
FBIH 729: kapható 15°, 30° és 45° forgácsolási szöggel CC lapkákhoz.

A Libraflex® kiegyensúlyozás élettörő lapkatartók esetén is elvégezhető.

### Visszaesztorgáló lapkatartók, $\varnothing 26,5\text{--}164\text{ mm}$ ( $\varnothing 1.043\text{--}6.457''$ )

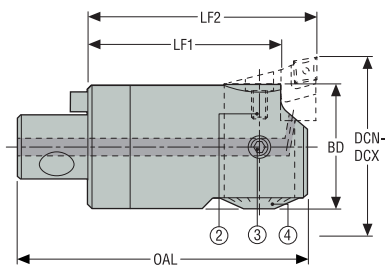
FBIH A789: forgácsolási szög 90° WB és CC lapkákhoz.

A Libraflex® kiegyensúlyozás visszaesztorgáló lapkatartók esetén nem lehetséges. Ebben az esetben a legjobban úgy csökkenthető a kiegyensúlyozatlanság, hogy mindkét kiegyensúlyozó gyűrűt a legnagyobb osztásra kell állítani.



FB780

Graflex®



- 2. Szerszám rögzítő csavar
- 3. Rögzítő csavar
- 4. Mikrométeres állító csavar



- Mikrométeres pontosságú állítással (0,01 mm-es léptékkel és átmérőben 2,5 µm).

| Cikkszám | Megnevezés | Gép oldal<br>Graflex méret | Munkadarab oldal Átmérő<br>DCN-DCX Ø |                | OAL            | LF1           | LF2            | BD            | Súly          | Váltólapka tartó<br>méret |
|----------|------------|----------------------------|--------------------------------------|----------------|----------------|---------------|----------------|---------------|---------------|---------------------------|
|          |            |                            | mm<br>Inch                           | mm<br>Inch     |                |               |                |               |               |                           |
| 00056632 | A78008     | G0                         | 15,0<br>0.591                        | 18,5<br>0.728  | 44,0<br>1.732  | 27,5<br>1.083 | 35,0<br>1.378  | 14,0<br>0.551 | 0,1<br>0.220  | 09                        |
| 00056633 | A78009     | G0                         | 18,0<br>0.709                        | 23,5<br>0.925  | 44,0<br>1.732  | 27,5<br>1.083 | 35,0<br>1.378  | 17,0<br>0.669 | 0,1<br>0.220  | 09                        |
| 00072991 | A78010     | G1                         | 23,0<br>0.906                        | 31,0<br>1.220  | 51,5<br>2.028  | 32,5<br>1.280 | 40,0<br>1.575  | 21,5<br>0.846 | 0,11<br>0.240 | 10                        |
| 00072992 | A78020     | G2                         | 30,0<br>1.181                        | 40,0<br>1.575  | 59,5<br>2.343  | 37,5<br>1.476 | 45,0<br>1.772  | 27,0<br>1.063 | 0,22<br>0.490 | 20                        |
| 00072993 | A78030     | G3                         | 39,0<br>1.535                        | 51,0<br>2.008  | 82,0<br>3.228  | 54,5<br>2.146 | 65,0<br>2.559  | 35,0<br>1.378 | 0,5<br>1.100  | 30                        |
| 00072995 | A78040     | G4                         | 50,0<br>1.969                        | 65,0<br>2.559  | 93,0<br>3.661  | 61,5<br>2.421 | 72,0<br>2.835  | 43,0<br>1.693 | 0,8<br>1.760  | 40                        |
| 00072996 | A78050     | G5                         | 64,0<br>2.520                        | 86,0<br>3.386  | 109,0<br>4.291 | 71,5<br>2.815 | 82,0<br>3.228  | 54,0<br>2.126 | 1,49<br>3.280 | 50                        |
| 00056551 | A78060     | G6                         | 85,0<br>3.346                        | 144,0<br>5.669 | 140,0<br>5.512 | 88,5<br>3.484 | 105,0<br>4.134 | 70,0<br>2.756 | 3,1<br>6.830  | 60/65                     |
| 00056552 | A78070     | G7                         | 114,0<br>4.488                       | 205,0<br>8.071 | 160,0<br>6.299 | 98,5<br>3.878 | 115,0<br>4.528 | 95,0<br>3.740 | 6,3<br>13.890 | 70/75                     |

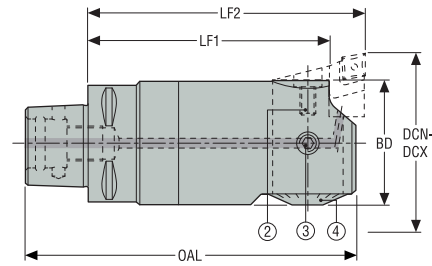
A lapkatartókat külön kell rendelni, lásd a 618, 619-621 old.  
Megj.: súly a lapkatartó nélkül

Pótalkatrészek

| Megnevezés | Összeszerelő csavar | Kulcs (T-típus) | Kulcs     | Rögzítő csavar | Retesz |
|------------|---------------------|-----------------|-----------|----------------|--------|
| 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™



- Mikrométeres pontosságú állítással (0,01 mm-es léptékkel és átmérőben 2,5 µm).

2. Szerszám rögzítő csavar
3. Rögzítő csavar
4. Mikrométeres állító csavar

| Megnevezés     | Cikkszám | Gép oldal | Munkadarab oldal Átmérő |                | OAL            | LF1            | LF2            | BD            | Súly           | Váltólapka tartó méret |
|----------------|----------|-----------|-------------------------|----------------|----------------|----------------|----------------|---------------|----------------|------------------------|
|                |          |           | DCN-DCX Ø               | mm<br>Inch     |                |                |                |               |                |                        |
| C3-391.0780-30 | 02809740 | C3        | 39,0<br>1.535           | 51,0<br>2.008  | 86,0<br>3.386  | 59,5<br>2.343  | 70,0<br>2.756  | 35,0<br>1.378 | 0,48<br>1.060  | 30                     |
| C4-391.0780-40 | 02809742 | C4        | 50,0<br>1.969           | 65,0<br>2.559  | 103,0<br>4.055 | 71,5<br>2.815  | 82,0<br>3.228  | 43,0<br>1.693 | 0,89<br>1.960  | 40                     |
| C5-391.0780-50 | 02809744 | C5        | 64,0<br>2.520           | 86,0<br>3.386  | 119,0<br>4.685 | 81,5<br>3.209  | 92,0<br>3.622  | 54,0<br>2.126 | 1,62<br>3.570  | 50                     |
| C6-391.0780-60 | 02809745 | C6        | 85,0<br>3.346           | 144,0<br>5.669 | 150,0<br>5.906 | 100,5<br>3.957 | 117,0<br>4.606 | 70,0<br>2.756 | 3,3<br>7.280   | 60                     |
| C8-391.0780-70 | 02809747 | C8        | 114,0<br>4.488          | 205,0<br>8.071 | 181,0<br>7.126 | 121,5<br>4.783 | 138,0<br>5.433 | 95,0<br>3.740 | 7,15<br>15.760 | 70                     |

A lapkatartókat külön kell rendelni, lásd a 618, 619-621 old.  
Megj.: súly a lapkatartó nélkül

## Pótalkatrészek

| Megnevezés     | Összeszerelő csavar | Kulcs (zászló) | Kulcs (T-típus) | Kulcs     | Rögzítő csavar |
|----------------|---------------------|----------------|-----------------|-----------|----------------|
| 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       |

Bevezetés

Fűrés

Dörzsárazás

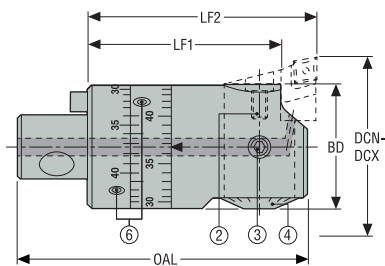
Kiesztergálás

Melléklet



## FB780 Libraflex® kiegyensúlyozható

Graflex®



- 2. Szerszám rögzítő csavar
- 3. Rögzítő csavar 1
- 4. Mikrométeres állító csavar
- 6. Rögzítő csavar 2



- Mikrométeres pontosságú állítással (0,01 mm-es léptékkel és átmérőben 2,5 µm).
- A kiegyensúlyozás úgy történik, hogy mindkét gyűrűt a kiesztergálni kívánt átmérőnek megfelelően kell beállítani.
- Sebességek  $v_c$  egészen 1 495 m/perc-ig és több, lásd a 622 old.

| Cikkszám | Megnevezés | Gép oldal<br>Graflex méret | Munkadarab oldal Átmérő |                | OAL            | LF1           | LF2            | BD            | Súly          | Váltólapka tartó méret |
|----------|------------|----------------------------|-------------------------|----------------|----------------|---------------|----------------|---------------|---------------|------------------------|
|          |            |                            | DCN-DCX Ø               | DCN-DCX Ø      |                |               |                |               |               |                        |
|          |            |                            | mm<br>Inch              | mm<br>Inch     | mm<br>Inch     | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | kg<br>lbs     |                        |
| 00055932 | A79020     | G2                         | 30,0<br>1.181           | 40,0<br>1.575  | 59,5<br>2.343  | 37,5<br>1.476 | 45,0<br>1.772  | 27,0<br>1.063 | 0,19<br>0.420 | 20                     |
| 00056005 | A79030     | G3                         | 39,0<br>1.535           | 51,0<br>2.008  | 82,0<br>3.228  | 54,5<br>2.146 | 65,0<br>2.559  | 35,0<br>1.378 | 0,45<br>0.990 | 30                     |
| 00056006 | A79040     | G4                         | 50,0<br>1.969           | 65,0<br>2.559  | 93,0<br>3.661  | 61,5<br>2.421 | 72,0<br>2.835  | 43,0<br>1.693 | 0,78<br>1.720 | 40                     |
| 00056007 | A79050     | G5                         | 64,0<br>2.520           | 86,0<br>3.386  | 109,0<br>4.291 | 71,5<br>2.815 | 82,0<br>3.228  | 54,0<br>2.126 | 1,42<br>3.130 | 50                     |
| 00001451 | A79060     | G6                         | 85,0<br>3.346           | 115,0<br>4.528 | 140,0<br>5.512 | 88,5<br>3.484 | 105,0<br>4.134 | 70,0<br>2.756 | 2,87<br>6.330 | 60                     |

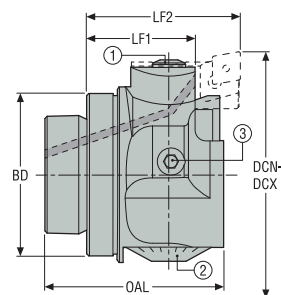
A lapkatarthoz külön kell rendelni, lásd a 618, 619-621 old.  
Megj.: súly a lapkatarthoz nélkül

### Pótalkatrészek

| Fej    | Összeszerelő csavar | Kulcs (T-típus) | Kulcs     | Rögzítő csavar 1 | Rögzítő csavar 2 | Retes |
|--------|---------------------|-----------------|-----------|------------------|------------------|-------|
| 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 – Simító kiesztergáló fejek, kompakt, GL csatlakozóval

GL



- GL25, GL32, GL40 és GL50 Steadyline® esztergáló és kiesztergáló rudakhoz tervezve
- Belső hűtés a lapkákra
- Mikrométeres pontosságú állítással (0,01 mm-es léptéssel és átmérőben 2,5 µm).

1. Szerszám rögzítő csavar
2. Mikrométeres állító csavar
3. Rögzítő csavar

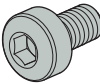



| Megnevezés    | Cikkszám | Gép oldal<br>GL méret | Munkadarab oldal Átmérő |               | OAL           | LF1            | LF2           | BD            | Súly          | Max. ford.** |
|---------------|----------|-----------------------|-------------------------|---------------|---------------|----------------|---------------|---------------|---------------|--------------|
|               |          |                       | DCN-DCX Ø               | Átmérő        |               |                |               |               |               |              |
|               |          |                       | mm<br>Inch              | mm<br>Inch    | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |              |
| GL25-FB620-10 | 03307855 | GL25                  | 27,0<br>1.063           | 35,0<br>1.378 | 29,5<br>1.161 | 17,7<br>0.697  | 28,0<br>1.102 | 25,0<br>0.984 | 0,1<br>0.220  | 9000         |
| GL32-0620-20  | 02904469 | GL32                  | 34,0<br>1.339           | 46,0<br>1.811 | 35,2<br>1.386 | 23,75<br>0.935 | 32,1<br>1.264 | 32,0<br>1.260 | 0,13<br>0.290 | 7000         |
| GL40-0620-30  | 02904470 | GL40                  | 42,0<br>1.654           | 56,0<br>2.205 | 40,7<br>1.602 | 24,75<br>0.974 | 35,1<br>1.382 | 40,0<br>1.575 | 0,22<br>0.490 | 5600         |
| GL50-0620-40  | 02904471 | GL50                  | 52,0<br>2.047           | 69,0<br>2.717 | 43,7<br>1.720 | 25,75<br>1.014 | 36,1<br>1.421 | 50,0<br>1.969 | 0,32<br>0.710 | 4800         |

A lapkataratókat külön kell rendelni, lásd a 618, 619-621 old.

\*\* Megjegyzések a max fordulatszámokról, lásd az Utasítás oldalakat.

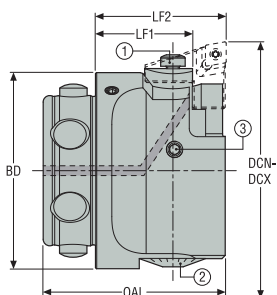
Megj.: súly a lapkatarató nélkül

## Pótalkatrészek

| Fej           | Összeszerelő csavar  | Rögzítő kulcs   | Kulcs (T-típus)  | Rögzítő csavar   |
|---------------|--|---|--|--|
| 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 – Simító kiesztergáló fejek, BA csatlakozóval

BA



1. Szerszám rögzítő csavar
2. Mikrométeres állító csavar
3. Rögzítő csavar



- BA60 és BA80 Steadyline® esztergáló és kiesztergáló rudakhoz tervezve
- Belső hűtés a lapkákra
- Mikrométeres pontosságú állítással (0,01 mm-es léptékkel és átmérőben 2,5 µm).

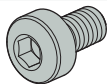
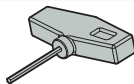

| Megnevezés     | Cikkszám | Gép oldal<br>BA méret | Munkadarab oldal Átmérő |                | OAL           | LF1           | LF2           | BD            | Súly         | Max. ford.** |
|----------------|----------|-----------------------|-------------------------|----------------|---------------|---------------|---------------|---------------|--------------|--------------|
|                |          |                       | DCN-DCX Ø               | Átmérő         |               |               |               |               |              |              |
|                |          |                       | mm<br>Inch              | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs    |              |
| BA060-FB620-50 | 03204094 | BA060                 | 65,0<br>2.559           | 87,0<br>3.425  | 55,7<br>2.193 | 29,7<br>1.169 | 40,0<br>1.575 | 60,0<br>2.362 | 0,7<br>1.540 | 4000         |
| BA080-FB620-60 | 03204095 | BA080                 | 85,0<br>3.346           | 115,0<br>4.528 | 58,2<br>2.291 | 26,7<br>1.051 | 41,2<br>1.622 | 80,0<br>3.150 | 1,1<br>2.430 | 3000         |

A lapkatartókat külön kell rendelni, lásd a 576 old.

\*\* Megjegyzések a max fordulatszámokról, lásd az Utasítás oldalakat.

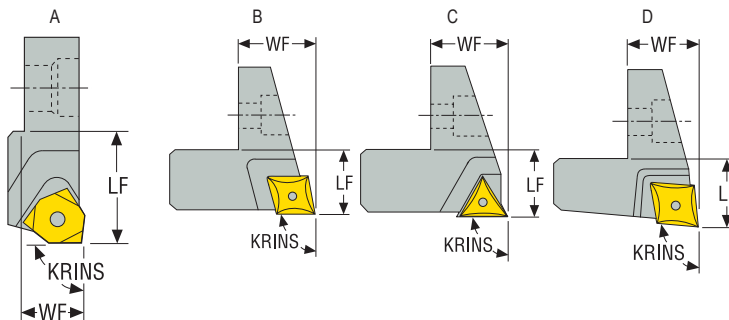
Megj.: súly a lapkatartó nélkül

### Pótalkatrészek

| Fej            | Összeszerelő csavar   | Kulcs (zásló)  | Kulcs (T-típus) | Kulcs     | Rögzítő csavar |
|----------------|---|--|-----------------|-----------|----------------|
| BA060-FB620-50 |  19TB04075 |  03M03C | –               | –         | 950L0608       |
| BA080-FB620-60 |  950D0514  | –  | DOUBLE-T        | H6B-H5.0L | 950L0608       |

## Lapka tartó

az simító kiesztergáló fejekhez FB 620/ 780/ 790

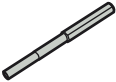




- Alkalmazható a FB 780/ 790/ 620 radiális kiesztergáló fejekhez
- \*\*Az FB A790 fejek precíziós kiegyensúlyozása nem lehetséges mikor nagy lapkatartókat használnak.

| Megnevezés | Cikkszám | Lapkatartó típus    | Átmérő DCN-DCX Ø |                | LF            | WF            | Súly          | Fej                              | KRINS° | ** | Váltólapka tartó méret | Használható lapka méret | Kivitel |
|------------|----------|---------------------|------------------|----------------|---------------|---------------|---------------|----------------------------------|--------|----|------------------------|-------------------------|---------|
|            |          |                     | mm               | mm             |               |               |               |                                  |        |    |                        |                         |         |
| A78209     | 00056634 | 90°-os WB lapkákhöz | 15,0<br>0.591    | 23,5<br>0.925  | 7,2<br>0.283  | 4,0<br>0.157  | 0,01<br>0.020 | FB 78008 / FB 78009              | 90     | -  | 09                     | WB...0301...            | A       |
| A72510     | 00056580 | 90°-os CC lapkákhöz | 23,0<br>0.906    | 31,0<br>1.220  | 10,3<br>0.406 | 4,5<br>0.177  | 0,01<br>0.020 | FB 78010 / FB62010               | 90     | -  | 10                     | CC...0602...            | B       |
| A72520     | 00056581 | 90°-os CC lapkákhöz | 30,0<br>1.181    | 46,0<br>1.811  | 8,3<br>0.327  | 5,0<br>0.197  | 0,02<br>0.040 | FB 78020 / FB 79020 / FB 62020   | 90     | -  | 20                     | CC...0602...            | B       |
| A72530     | 00056582 | 90°-os CC lapkákhöz | 39,0<br>1.535    | 56,0<br>2.205  | 10,3<br>0.406 | 8,0<br>0.315  | 0,02<br>0.040 | FB 78030 / FB 79030 / FB 62030   | 90     | -  | 30                     | CC...0602...            | B       |
| A72540     | 00056583 | 90°-os CC lapkákhöz | 50,0<br>1.969    | 69,0<br>2.717  | 10,3<br>0.406 | 9,5<br>0.374  | 0,02<br>0.040 | FB 78040 / FB 79040 / FB 62040   | 90     | -  | 40                     | CC...0602...            | B       |
| A72550     | 00056584 | 90°-os CC lapkákhöz | 64,0<br>2.520    | 86,0<br>3.386  | 10,3<br>0.406 | 12,5<br>0.492 | 0,02<br>0.040 | FB 78050 / FB 79050 / FB 62050   | 90     | -  | 50                     | CC...0602...            | B       |
| A7256A     | 02689978 | 90°-os CC lapkákhöz | 85,0<br>3.346    | 115,0<br>4.528 | 14,5<br>0.571 | 18,5<br>0.728 | 0,05<br>0.110 | BA080-FB620-60                   | 90     | -  | 6A                     | CC...09T3...            | B       |
| A72560     | 00056585 | 90°-os CC lapkákhöz | 85,0<br>3.346    | 115,0<br>4.528 | 16,5<br>0.650 | 18,9<br>0.744 | 0,08<br>0.180 | FB 78060 / FB 79060 / FB 731S500 | 90     | -  | 60                     | CC...09T3...            | B       |
| A72565     | 00056587 | 90°-os CC lapkákhöz | 114,0<br>4.488   | 144,0<br>5.669 | 16,5<br>0.650 | 33,7<br>1.327 | 0,09<br>0.200 | FB 78060 / FB 79060 / FB 731S500 | 90     | ** | 65                     | CC...09T3...            | B       |
| A72570     | 00056588 | 90°-os CC lapkákhöz | 114,0<br>4.488   | 160,0<br>6.299 | 16,5<br>0.650 | 18,9<br>0.744 | 0,09<br>0.200 | FB 78070                         | 90     | -  | 70                     | CC...09T3...            | B       |
| A72575     | 00056589 | 90°-os CC lapkákhöz | 159,0<br>6.260   | 205,0<br>8.071 | 16,5<br>0.650 | 41,7<br>1.642 | 0,12<br>0.260 | FB 78070                         | 90     | -  | 75                     | CC...09T3...            | B       |
| A72430     | 00056572 | 90°-os TC lapkákhöz | 39,0<br>1.535    | 56,0<br>2.205  | 10,3<br>0.406 | 7,9<br>0.311  | 0,01<br>0.020 | FB 78030 / FB 79030 / FB 62030   | 90     | -  | 30                     | TC...1102...            | C       |
| A72440     | 00056573 | 90°-os TC lapkákhöz | 50,0<br>1.969    | 69,0<br>2.717  | 10,3<br>0.406 | 9,4<br>0.370  | 0,02<br>0.040 | FB 78040 / FB 79040 / FB 62040   | 90     | -  | 40                     | TC...1102...            | C       |
| A72450     | 00056574 | 90°-os TC lapkákhöz | 64,0<br>2.520    | 86,0<br>3.386  | 10,3<br>0.406 | 12,4<br>0.488 | 0,02<br>0.040 | FB 78050 / FB 79050 / FB 62050   | 90     | -  | 50                     | TC...1102...            | C       |
| A72460     | 00056575 | 90°-os TC lapkákhöz | 85,0<br>3.346    | 115,0<br>4.528 | 16,3<br>0.642 | 18,9<br>0.744 | 0,08<br>0.180 | FB 78060 / FB 79060 / FB 731S500 | 90     | -  | 60                     | TC...1102...            | C       |
| A72465     | 00056577 | 90°-os TC lapkákhöz | 114,0<br>4.488   | 144,0<br>5.669 | 16,5<br>0.650 | 33,7<br>1.327 | 0,09<br>0.200 | FB 78060 / FB 79060 / FB 731S500 | 90     | ** | 65                     | TC...1102...            | C       |
| A72470     | 00056578 | 90°-os TC lapkákhöz | 114,0<br>4.488   | 160,0<br>6.299 | 16,3<br>0.642 | 18,9<br>0.744 | 0,1<br>0.220  | FB 78070                         | 90     | -  | 70                     | TC...1102...            | C       |
| A72475     | 00056579 | 90°-os TC lapkákhöz | 159,0<br>6.260   | 205,0<br>8.071 | 16,5<br>0.650 | 41,7<br>1.642 | 0,13<br>0.290 | FB 78070                         | 90     | -  | 75                     | TC...1102...            | C       |
| A72610     | 00056590 | 95°-os CC lapkákhöz | 23,0<br>0.906    | 31,0<br>1.220  | 10,3<br>0.406 | 4,5<br>0.177  | 0,01<br>0.020 | FB 78010                         | 95     | -  | 10                     | CC...0602...            | D       |
| A72620     | 00056591 | 95°-os CC lapkákhöz | 30,0<br>1.181    | 46,0<br>1.811  | 8,3<br>0.327  | 5,0<br>0.197  | 0,01<br>0.020 | FB 78020 / FB 79020 / FB 62020   | 95     | -  | 20                     | CC...0602...            | D       |
| A72630     | 00056592 | 95°-os CC lapkákhöz | 39,0<br>1.535    | 56,0<br>2.205  | 10,3<br>0.406 | 8,0<br>0.315  | 0,01<br>0.020 | FB 78030 / FB 79030 / FB 62030   | 95     | -  | 30                     | CC...0602...            | D       |
| A72640     | 00056593 | 95°-os CC lapkákhöz | 50,0<br>1.969    | 69,0<br>2.717  | 10,3<br>0.406 | 9,5<br>0.374  | 0,02<br>0.040 | FB 78040 / FB 79040 / FB 62040   | 95     | -  | 40                     | CC...0602...            | D       |

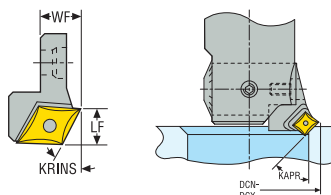
| Megnevezés | Cikkszám | Lapkatartó típus    | Átmérő DCN-DCX Ø |                | LF            | WF            | Súly          | Fej                              | KRINS° | ** | Váltólapka tartó méret | Használható lapka méret | Kivitel |
|------------|----------|---------------------|------------------|----------------|---------------|---------------|---------------|----------------------------------|--------|----|------------------------|-------------------------|---------|
|            |          |                     | mm<br>Inch       | mm<br>Inch     |               |               |               |                                  |        |    |                        |                         |         |
| A72650     | 00056594 | 95°-os CC lapkákhoz | 64,0<br>2.520    | 86,0<br>3.386  | 10,3<br>0.406 | 12,5<br>0.492 | 0,02<br>0.040 | FB 78050 / FB 79050 / FB 62050   | 95     | -  | 50                     | CC...0602...            | D       |
| A72660     | 00056595 | 95°-os CC lapkákhoz | 85,0<br>3.346    | 115,0<br>4.528 | 16,5<br>0.650 | 18,9<br>0.744 | 0,07<br>0.150 | FB 78060 / FB 79060 / FB 731S500 | 95     | -  | 60                     | CC...09T3...            | D       |
| A72665     | 00056597 | 95°-os CC lapkákhoz | 114,0<br>4.488   | 144,0<br>5.669 | 16,5<br>0.650 | 33,7<br>1.327 | 0,09<br>0.200 | FB 78060 / FB 79060 / FB 731S500 | 95     | ** | 65                     | CC...09T3...            | D       |
| A72670     | 00056598 | 95°-os CC lapkákhoz | 114,0<br>4.488   | 160,0<br>6.299 | 16,5<br>0.650 | 18,9<br>0.744 | 0,09<br>0.200 | FB 78070                         | 95     | -  | 70                     | CC...09T3...            | D       |
| A72675     | 00056599 | 95°-os CC lapkákhoz | 159,0<br>6.260   | 205,0<br>8.071 | 16,5<br>0.650 | 41,7<br>1.642 | 0,12<br>0.260 | FB 78070                         | 95     | -  | 75                     | CC...09T3...            | D       |

## Pótalkatrészek

| Lapka méret  | Lapka kulcs   | Lapka csavar   | Kulcs (T-típus)   |
|--------------|---|--|---|
| WB...0301... | H4B-T06P<br> | C02035-T06P<br> | DOUBLE-T<br> |
| CC...0602... | H4B-T07P  | C02504-T07P  | DOUBLE-T  |
| CC...09T3... | H4B-T15P  | C04008-T15P  | DOUBLE-T  |
| TC...1102... | H4B-T07P  | C02504-T07P  | DOUBLE-T  |

## Életörő lapka tartók

az simító kiesztorgáló fejekhez FB 620/ 780/ 790



- Alkalmazható a FB 780/ 790/ 620 radiális kiesztorgáló fejekhez

| Cikkszám | Megnevezés   | Fej                               | Váltólapka tartó méret | Átmérő DCN-DCX Ø |                | LF            | WF            | Súly          | KRINS° | Használható lapka méret |
|----------|--------------|-----------------------------------|------------------------|------------------|----------------|---------------|---------------|---------------|--------|-------------------------|
|          |              |                                   |                        | mm<br>Inch       | mm<br>Inch     |               |               |               |        |                         |
| 00086885 | A72910CC0630 | FB 78010                          | 10                     | 23,0<br>0.906    | 31,0<br>1.220  | 10,8<br>0.425 | 4,5<br>0.177  | 0,01<br>0.020 | 30     | CC...0602...            |
| 00086888 | A72920CC0630 | FB 78020 / FB 79020/ GL32-0620-20 | 20                     | 30,0<br>1.181    | 36,0<br>1.417  | 10,0<br>0.394 | 4,9<br>0.193  | 0,01<br>0.020 | 30     | CC...0602...            |
| 00086891 | A72930CC0630 | FB 78030 / FB 79030 / FB 62030    | 30                     | 39,0<br>1.535    | 56,0<br>2.205  | 10,5<br>0.413 | 8,1<br>0.319  | 0,01<br>0.020 | 30     | CC...0602...            |
| 00086894 | A72940CC0630 | FB 78040 / FB 79040 / FB 62040    | 40                     | 50,0<br>1.969    | 69,0<br>2.717  | 10,5<br>0.413 | 9,5<br>0.374  | 0,02<br>0.040 | 30     | CC...0602...            |
| 00086897 | A72950CC0630 | FB 78050 / FB 79050               | 50                     | 64,0<br>2.520    | 86,0<br>3.386  | 10,5<br>0.413 | 12,5<br>0.492 | 0,02<br>0.040 | 30     | CC...0602...            |
| 00086900 | A72960CC0930 | FB 78060 / FB 79060 / A731S500    | 60                     | 85,0<br>3.346    | 115,0<br>4.528 | 16,5<br>0.650 | 19,1<br>0.752 | 0,08<br>0.180 | 30     | CC...09T3...            |
| 00086903 | A72970CC0930 | FB 78070                          | 70                     | 114,0<br>4.488   | 160,0<br>6.299 | 16,4<br>0.646 | 18,8<br>0.740 | 0,09<br>0.200 | 30     | CC...09T3...            |
| 00086886 | A72910CC0645 | FB 78010                          | 10                     | 23,0<br>0.906    | 31,0<br>1.220  | 11,5<br>0.453 | 4,5<br>0.177  | 0,01<br>0.020 | 45     | CC...0602...            |
| 00086889 | A72920CC0645 | FB 78020 / FB 79020 / FB 62020    | 20                     | 30,0<br>1.181    | 46,0<br>1.811  | 10,0<br>0.394 | 5,0<br>0.197  | 0,01<br>0.020 | 45     | CC...0602...            |
| 00086892 | A72930CC0645 | FB 78030 / FB 79030 / FB 62030    | 30                     | 39,0<br>1.535    | 56,0<br>2.205  | 10,5<br>0.413 | 8,1<br>0.319  | 0,01<br>0.020 | 45     | CC...0602...            |
| 00086895 | A72940CC0645 | FB 78040 / FB 79040 / FB 62040    | 40                     | 50,0<br>1.969    | 69,0<br>2.717  | 10,5<br>0.413 | 9,5<br>0.374  | 0,02<br>0.040 | 45     | CC...0602...            |
| 00086898 | A72950CC0645 | FB 78050 / FB 79050               | 50                     | 64,0<br>2.520    | 86,0<br>3.386  | 10,3<br>0.406 | 12,4<br>0.488 | 0,02<br>0.040 | 45     | CC...0602...            |
| 00086901 | A72960CC0945 | FB 78060 / FB 79060 / A731S500    | 60                     | 85,0<br>3.346    | 115,0<br>4.528 | 16,5<br>0.650 | 19,1<br>0.752 | 0,07<br>0.150 | 45     | CC...09T3...            |
| 00086904 | A72970CC0945 | FB 78070                          | 70                     | 114,0<br>4.488   | 160,0<br>6.299 | 16,4<br>0.646 | 18,8<br>0.740 | 0,09<br>0.200 | 45     | CC...09T3...            |

Tartalék lapka csavar és tartalék lapka kulcs, lásd a . oldalon. 654 old.

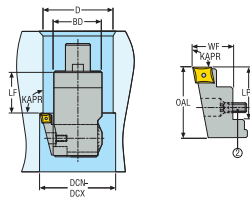
\*\*A kiesztorgáló fejek átmérője a Hid rúd és Jumbo hid rúd kiesztorgálókhoz 630 old.

## Pótalkatrészek

| Lapka méret  | Lapka kulcs | Lapka csavar | Kulcs (T-típus) |
|--------------|-------------|--------------|-----------------|
| CC...0602... | H4B-T07P    | C02504-T07P  | DOUBLE-T        |
| CC...09T3... | H4B-T15P    | C04008-T15P  | DOUBLE-T        |

## Simító vissza-esztergáló lapkatartók

az simító kiesztergáló fejekhez FB 620/ 780/ 790



- Alkalmazható a FB 780/ 790/ 620 radiális kiesztergáló fejekhez
- Az FB 790 kiesztergáló fejek precíziós kiegyensúlyozása nem lehetséges mikor vissza esztergáló lapka tartókat használ
- KRINS 90°
- Alkalmos lapka méert: CC...0602...

| Megnevezés    | Cikkszám | Fej                         | Back-boring capacity |                 | LF           | BD           | OAL          | LPR          | WF           | Súly         |
|---------------|----------|-----------------------------|----------------------|-----------------|--------------|--------------|--------------|--------------|--------------|--------------|
|               |          |                             | DCN-DCX Ø            |                 |              |              |              |              |              |              |
|               |          |                             | mm                   | (Inch)          | mm (Inch)    | mm (Inch)    | mm (Inch)    | mm (Inch)    | mm (Inch)    | kg (lbs)     |
| A789X10CC0690 | 00086907 | A78010                      | 39,5-47,5            | (1.555-1.870)   | 16,5 (0.650) | 21,5 (0.846) | 30,5 (1.201) | 16,0 (0.630) | 12,8 (0.504) | 0,01 (0.020) |
|               |          | A78020 & A79020             | 46-56                | (1.811-2.205)   | 21,5 (0.846) | 27 (1.063)   |              |              |              |              |
|               |          | GL32-0620-20                | 49,7-61,7            | (1.957-2.429)   | 7,75 (0.305) | 32 (1.260)   |              |              |              |              |
| A789X30CC0690 | 00086910 | A78030 & A79030             | 53-65                | (2.087-2.559)   | 32 (1.260)   | 35 (1.378)   | 30,0 (1.181) | 23,0 (0.906) | 15,0 (0.591) | 0,03 (0.070) |
|               |          | A78040 & A79040             | 61-76                | (2.402-2.992)   | 39 (1.535)   | 43 (1.693)   |              |              |              |              |
|               |          | A78050 & A79050             | 69-91                | (2.717-3.583)   | 49 (1.929)   | 54 (2.126)   |              |              |              |              |
|               |          | GL40-0620-30                | 57,6-70,2            | (2.268-2.764)   | 1,75 (0.069) | 40 (1.575)   |              |              |              |              |
|               |          | GL50-0620-40                | 67,6-80,2            | (2.661-3.157)   | 2,75 (0.108) | 50 (1.969)   |              |              |              |              |
| A789X60CC0690 | 00086909 | A78060 & A79060<br>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)  |

\*A visszaesztergáló kiesztergáló fejek átmérője a Híd rúd és Jumbo híd rúd kiesztergálókhöz 634 old.

Tartalék lapka csavar és tartalék lapka kulcs, lásd a . oldalon. 654 old.

A simító vissza esztergáló lapkatartók szállítása tartalmaz egy speciális lapkatartó rögzítő csavart, amit cserélni kell a fejben lévő csavarral.

DCN/DCX mini = D+BD / 2 + 0,5 mm (0.02") Ø 39,5 - 47,5 (1.555" - 1.870")

DCB/DCX mini = D+BD / 2 + 1 mm (0.039") Ø 46 - 64 (1.811" - 2.520")

### Pótalkatrészek

| Megnevezés    | Összeszerelő csavar | Lapka csavar | Kulcs (T-típus) | Kulcs    |
|---------------|---------------------|--------------|-----------------|----------|
| 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 simító kiesztergáló fejek – Utasítások

### Ajánlott megmunkálási feltételek

Az alkalmazás további részletei a kiesztergáló fejhez és a GL rudakkal szállított mellékelt használati utasításban található.

### Maximális fordulatszám simító kiesztergáló fejekhez, radiális típus

A kiesztergáló fejek Termékoldalain látható maximum fordulatszámok a kiesztergáló fej mechanikus kivitelétől és kiegyensúlyozási minőségétől függenek. Az ezeken a korlátokon belül lévő fordulatszámokat a többi forgácsolási feltétel alapján kell kiválasztani, pl. munkadarab anyaga, vágóél (lapka), szerszám hossza, géporsó.

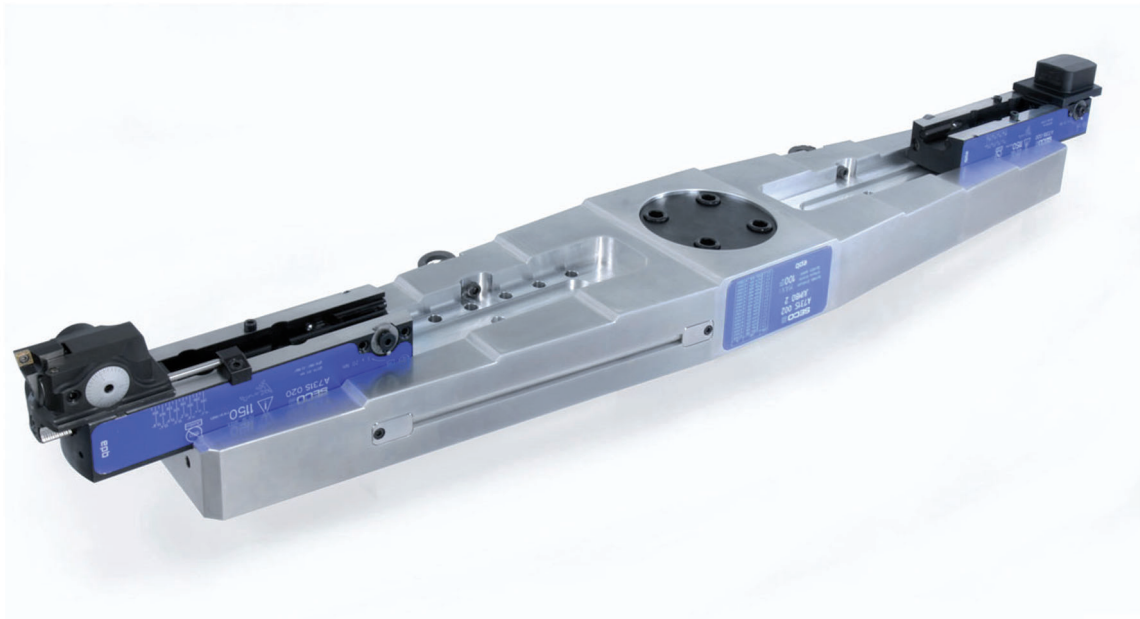
A Steadyline® rudakkal végzett kiesztergáló alkalmazások esetén győződjön meg róla, hogy nem lépi túl a rudak maximális fordulatszámát: Lásd a Steadyline® rudakhoz mellékelt használati utasítást.

Lent megtalálja a max. fordulatszámokat az összeszerelt kiesztergáló fejekhez. Amikor visszaeszttergáló lapkatartót használ az FB 620, FB 790 vagy FB 780 típusú fejekben, a max. fordulatszám az A780.. típusúval azonos, ugyanazon méretre.

| Fej   | Tartomány Ø mm (inch) | Max. ford. | Adódó max. vágósebesség $v_c$ min. átm. méret m/perc (sf/min) | Adódó max. vágósebesség $v_c$ max. átm. méret m/perc (sf/min) |
|---|-----------------------|------------|---|---|
| FB 620 simító kiesztergáló fejek GL és BA gépdali csatlakozással, a Steadyline® rezgéscsillapított eszttergáló és kiesztergáló rudakhoz |                       |            |   |   |
| 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 Simító kiesztergáló fejek, balanceable, szélesség Graflex® csatlakozás   |                       |            |   |   |
| 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 Simító kiesztergáló fejek, szélesség Graflex® csatlakozás  |                       |            |   |   |
| 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 Simító kiesztergáló fejek szélesség Seco-Capto™ csatlakozás  |                       |            |   |   |
| 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)   |

**Megjegyzés:** A maximum fordulatszámok függenek a kiesztergáló fej mechanikus kivitelétől és kiegyensúlyozási minőségétől. Az ezeken a korlátokon belül lévő fordulatszámokat a többi forgácsolási feltétel alapján kell kiválasztani, pl. munkadarab anyaga, vágóél (lapka), szerszám hossza, géporsó. kb. 8000 és magasabb fordulatszámánál finom-kiegyensúlyozni kell a tartóüskéket és a köztes elemeket.





## Hídhidak

A Seco hídrudak és Jumbo hídrudak teljes választékát kínálja nagy átmérők kiesztorgálási és visszaesztorgálási műveleteihez.

- A hídrudak standard termékcsaládja a maximális flexibilitás érdekében nagy, 204–655 mm (8.03–25.78 inch) átmérőtartományt fed le
- A Seco Jumbo hídrudak nagy szilárdságú alumíniumból készültek acél illesztőfelületekkel, és a 654–2155 mm (25.75–84.843 inch) átmérőtartományt fedik le

Áttekintés

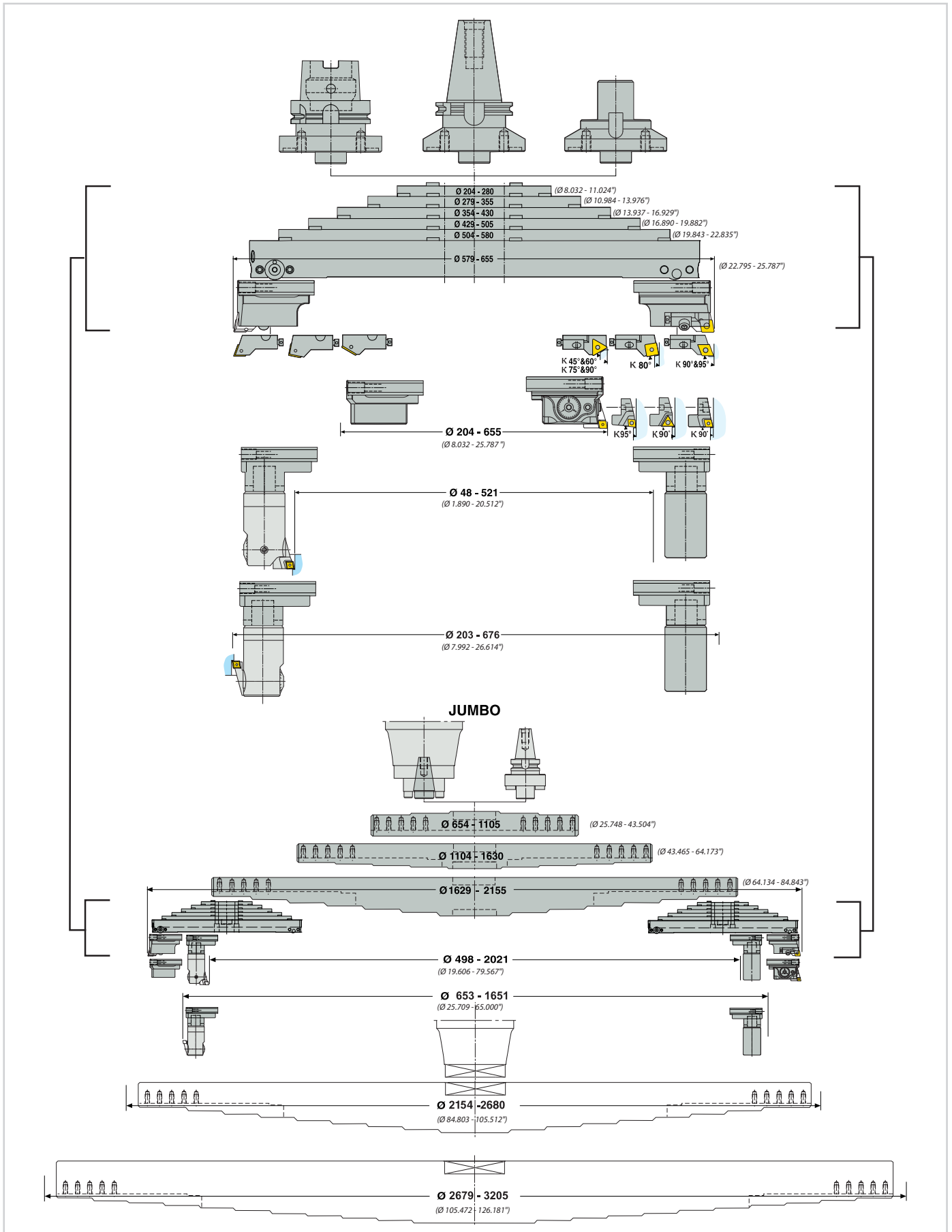
Bevezetés

Fúrás

Dörzsárazás

Kiesztergálás

Melléklet



## Jellemzők

### 5 hídrúd kiesztergáláshoz

Ø 654–3205 mm (Ø 25.748–126.181"), csap-visszaesztergáláshoz,  
Ø 498–3071 mm  
(Ø 19.606–120.906") és visszásüllyesztéshez is, Ø 653–3226 mm  
(Ø 25.709–127.008").

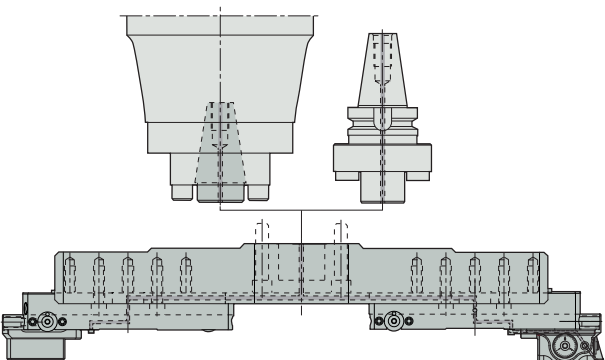
A Jumbo hídrudakat nagy szilárdságú alumíniumból acél csatlakozóval gyártjuk, és úgy vannak tervezve, hogy két szabványos hídrudat különböző pozíciókban megtartsanak.

Méretetek A731S004-... és A731S005-... kérésre elérhető - legyen megfelelő szabványos vagy speciális főorsó végződés a géptől függően:

| Tartomány Ø mm<br>(inch)        | Megnevezés    | DCB | Méretetek mm-ben (inch), lásd a termék oldalon |                  |                   |      |                     |      | Súly |
|---------------------------------|---------------|-----|--|------------------|-------------------|------|---------------------|------|------|
|                                 |               |     | LF   | HTB              | LB                | CBDP | WB                  | DCON |      |
| 2154-2680<br>(84.803-105.512")  | A731S004-...* | *   | 70<br>(2.75591")                               | 300<br>(11.811") | 160<br>(6.29921") | *    | 2140<br>(84.25197") | *    | *    |
| 2679-3205<br>(105.472-126.181") | A731S005-...* | *   | 110<br>(4.33071")                              | 400<br>(15.748") | 200<br>(7.87402") | *    | 2665<br>(104.9213") | *    | *    |

\* megnevezés és méret legyen összhangban a főorsó rögzítési típusával.

### Főbb jellemzők, Jumbo hídrúd



Az „S” jelű Jumbo hídrudak jellemzője az átmenő hűtés, hogy biztosítsa a hűtőfolyadékot a befogástól a két szabványos hídrúddhoz, és van egy kiegészítő rögzítő csavar a szabványos hídrudaknak.

**Figyelem!** Ezek az új Jumbo Híd ruda 'S' be tudják fogni az összes klasszikus Híd rudat (az új 'S', vagy az előző típust): mikor az előző típust használja, akkor a kiegészítő rögzítő csavart nem használható. Az átmenő hűtést az élre csak akkor tudjuk alkalmazni, ha az 'S' jelzésű Jumbo Híd rudakat és az 'S' jelzésű szabványos Híd rudakat használjuk. Ne keverje az új és a régi blokkokat ugyanazon a híd rúdon, az egyensúly megtartása érdekében.

## Jellemzők

### 6 hídrúd kiesztergáláshoz

Ø 204–655 mm (Ø 8.032–25.787") csap-visszaesztéráláshoz, Ø 48–521 mm (Ø 1.890–20.512") és visszásüllyesztéshez is.

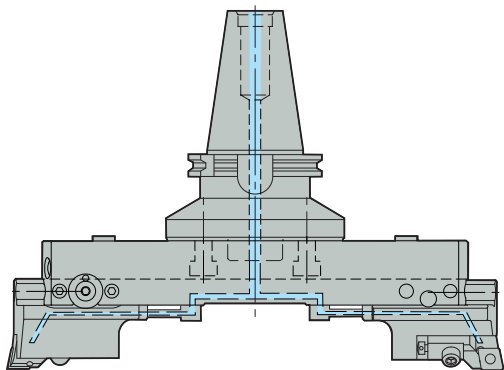
A hídrudak Ø 130 mm (Ø 5.118") géppoldali csatlakozóval rendelkeznek, hogy közvetlenül felszerelhetők legyenek a hídrúd tuskékre (SA és HSK) vagy a Graflex® adapterre.

A Graflex® adapter használata esetén hosszabbítások és orsó karimás befogás is használható, lásd a Graflex® moduláris rendszert. A hídrúd ferde helyzetbe is állítható, 30°-onként a tuskéken vagy a Graflex® adapteren, a könnyebb tárolási lehetőségek érdekében.

A hídrudakba nagyoló és simító kiesztergáló vagy ellensúly Graflex® egységet is be lehet fogni.

A kiesztergáló blokk a hídrúdra két hengeres csappal és három rögzítő csavarral van feltéve: Az egyik rögzítőcsavarnak van egy ütköző tárcsája, mely megakadályozza a blokk csúszását a hídrúdon. A pontos és lépcsőzetes blokk csúszás biztosítja az átmérő állítást (38 mm (Ø 1.496") sugárirányban) a blokk állító csavarral, mely csatlakozik a hídrúd csapjához.

A hídrudak és a kiesztergáló fejek hűtőfurattal rendelkeznek a vágóélhez.



A híd és jumbo hídrudak kiválasztásához a kiesztergálásra, csap-visszaesztérálásra vagy visszásüllyesztésre vonatkozóan lásd a hídrudak táblázatát az alábbi oldalakon: 629-634.

Max fordulatszám, lásd: 640.

**Figyelem!** Ezek a hídrudak (A731S 0\_0) nem tudják befogni a kiesztergáló fejek előző (A731 \_00 - S- nélküli) típusait.

## Jellemzők

### Nagyoló kiesztorgáló blokk

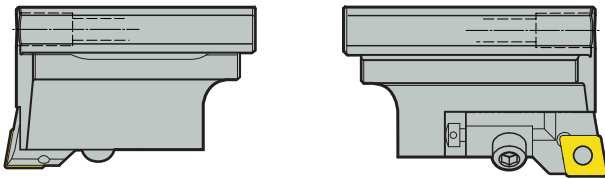
Egy nagy iker nagyoló kiesztorgáló fej szerelhető össze két nagyoló kiesztorgáló egységből, melyek mindegyike beépíthető betéttel van felszerelve. A nagyoló kiesztorgáló fejek hűtőfurattal rendelkeznek a lapkákhöz.

A Graflex® adapter használata esetén hosszabbítások és orsó karimás befogás is használható, lásd a Graflex® moduláris rendszert.

A hídrúd ferde helyzetbe is állítható, 30°-onként a tüskéken vagy a Graflex® adapteren, a könnyebb tárolási lehetőségek érdekében.

A hírudakba nagyoló és simító kiesztorgáló vagy ellensúly Graflex® egységet is be lehet fogni.

#### Kazetták



A betétek nagy választékban kaphatók:

- 90° forgácsolási szögű beépíthető betétek, a legtöbb nagyoló alkalmazáshoz ajánlottak a kisebb teljesítményfelvétel érdekében.
- 80° forgácsolási szögű beépíthető betétek, átmenő furatokhoz (és élettöréshez) ajánlottak, különösen öntvényekben, a kilépési hibák megelőzése érdekében. A teljesítmény szükséglet nagyobb.
- Más, ISO5611/h1 = 16 mm (0.629") illesztési felületű betétek is megfelelők.

**Figyelem!** Két beépíthető betét állítható be ugyanarra az átmérőre vagy lépcsőzetesen eltolva. A lapkatartó sarokemelő alátét pótalkatrészként áll rendelkezésre (18LS0316). Összeszerelési és beállítási eljárások, lásd: 629-634.

### Simító kiesztorgáló blokk és ellensúly

Egy nagy simító kiesztorgáló fejhez szükséges simító kiesztorgáló blokk és egy ellensúly.

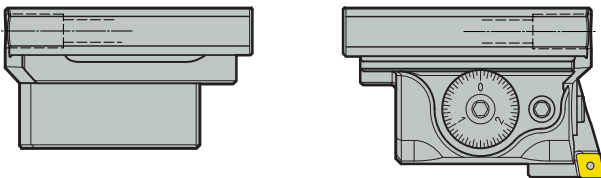
A simító kiesztorgáló blokk mikronos átmérő-beállító csavarja van (1 osztás = 5 mm (0.197") az átmérőn).

A beállító rendszer olajozott és védett teljes élettartamra.

A precíz mechanizmus biztosítja az ismétlési pontosságot. Az átmérő beállító csavar a blokk oldalán található a könnyű állíthatóság érdekében.

A nagyoló kiesztorgáló fejek hűtőfurattal rendelkeznek a lapkákhöz.

#### Megfelelő simító kiesztorgáló lapkatartók, A72460, A72560 vagy A72660



A megfelelő simító kiesztorgáló lapkatartók: A72460, A72560 vagy A72660 külön rendelendők: ezek ugyanazok, mint a radiális típusú kiesztorgáló fejekhez, lásd: 618, 619.

Összeszerelési és beállítási eljárások, lásd: 629-634.

## Jellemzők

### Graflex® kiesztergáló blokkok, csap-visszaesztérgeáláshoz és visszasüllyesztéshez

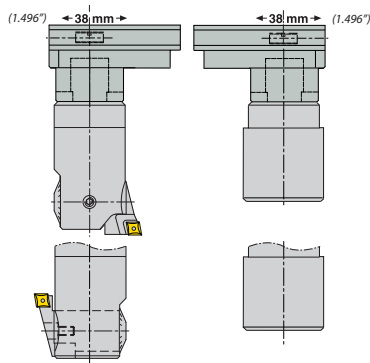
Ennek a blokknak van egy Graflex® G5 méretű csatlakozója (furat).

Bármilyen Graflex® kiesztergáló fej, G5 méretű speciális vagy standard Graflex® modul felszerelhető a hídrudakra, pl. az ábrán látható egy beállítás csapkörbeesztérgeálásra vagy visszaesztérgeálásra, ahol két Graflex® kiesztergáló blokk van felszerelve egy Graflex® A78050 simító fej lapkataratóval (pl. A72550 csapesztérgeáláshoz), egy csapesztérgeáló lapkataratóval (pl. A789X30CC0690) és egy Graflex® ellensúlyal (pl. BM050W78050 cikkszám).

A Graflex® modul két pozíciója lehetséges a blokkon, mert 2x2 gömbvégű csavar pozícióval és két 180°-kal elforgatott retesszel rendelkezik. A blokk és a nagyoló kiesztergáló fej hűtőfurattal rendelkezik a lapkákhoz.

Összeszerelési és beállítási eljárások, lásd: 629-634.

#### Graflex® kiesztergáló blokkok, csap-visszaesztérgeáláshoz és visszasüllyesztéshez



Ezek a kiesztergáló blokkok (cikksz: A731S 400, A731S 500, A731S 600, A731S 40128) szintén alkalmazhatók a korábbi típusú hídrudakon (A731 0\_0 - S- nélkül).

Az összeszerelési eljárás és a max. fordulatszám a korábbi hídrúd típusokkal megegyezik.

Ne keverje az új és a régi blokkokat ugyanazon a hídrúdon, az egyensúly megtartása érdekében.

**Figyelem!** Ezek az új típusú kiesztergáló blokkok szintén felszerelhetők az előző típusú hídrudakra

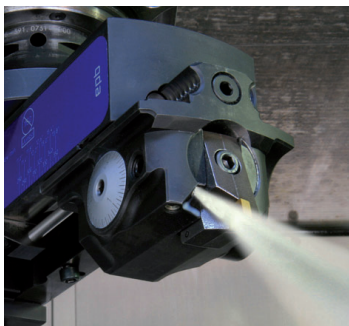
### Tanácsok a belső hűtési tartozékok kiválasztáshoz

#### Nagyolás (hídrúd 2 nagyoló fej blokkal):

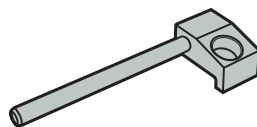
A közvetlen hűtőfolyadék rávezetéshez mindkét élre, használjon 2 hűtőfolyadék csövet (cikkszám: AU731S00700), a hídrúdba szerelve, és két közvetlen hűtőfúvóka szettet (cikkszám: AU731S40700), a nagyoló egységbe szerelve. Normális esetben a hűtőfolyadék az egység furatán keresztül megy, a két hűtőfolyadék csövön (cikkszám: AU731S00700), amely a hídrúdba van beszerelve.

#### Simítás (hídrúd 1 simító kiesztergáló blokkal és 1 ellensúlyal):

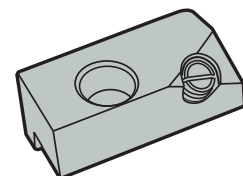
1 hűtőfolyadék csövet kell alkalmazni (cikkszám: AU731S00700), mely a hídrúdba van beszerelve, biztosítva a kapcsolatot a simító kiesztergáló blokkal. A simító egység jellemzője a közvetlen hűtő fúvóka, mely direktben hűt. Csapkiesztergeálásnál (pl. hídrúd 2 Graflex® kiesztergáló blokk egy simító fejjel és egy ellensúlyal) Használjon egy hűtő csövet (AU731S00700), beszerelve a hídrúdba, biztosítva a kapcsolatot a Graflex® egységre helyezett kiesztergáló fejjel. A Graflex® kiesztergáló blokk központi hűtőcsatornája a hűtő-kenő folyadékot a felszerelt kiesztergáló fejhez vezeti.



Hűtő-kenő folyadék csőcsatlakozó  
(Cikkszám: AU731S00700)



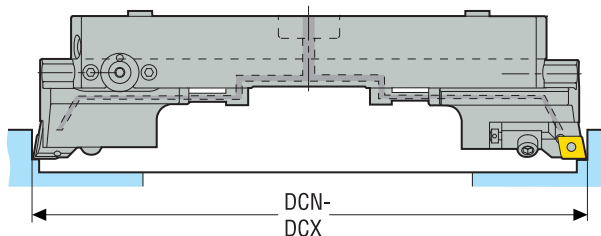
Írányítható hűtőfolyadékfúvóka-szett  
(Cikkszám: AU731S40700)



**Figyelem!** Megengedett hűtőközeg nyomása = 70 bar maximum.

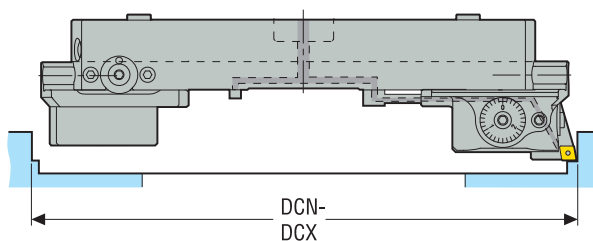
## Hídrúd kiesztorgáló egységek

A nagyoló kiesztorgáló egységhez  $\varnothing 655 \text{ mm}$  ( $\varnothing 25.787''$ ) furatméretig az alábbiak szükségesek: 1 hídrúd (A731S 0\_0) + 2 nagyoló kiesztorgáló blokk (2x A731S 400) 2 lapkatartóval\*.



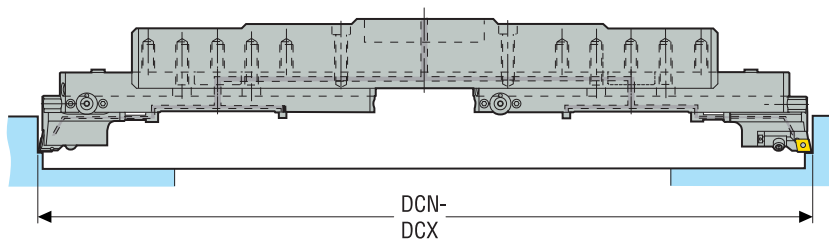
1. ábra

A simító kiesztorgáló egységhez  $\varnothing 655 \text{ mm}$  ( $\varnothing 25.787''$ ) furatméretig az alábbiak szükségesek: 1 hídrúd (A731S 0\_0) + 1 simító kiesztorgáló blokk (A731S 500) 1 simító kiesztorgáló lapkatartóval, 60-as méret\*\* + 1 ellensúly (A731S 600).



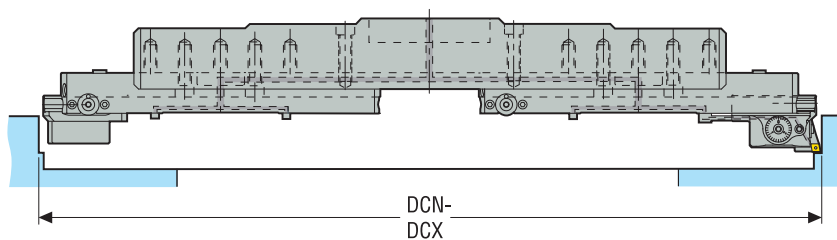
2. ábra

A nagyoló kiesztorgáló egységhez  $\varnothing 3205 \text{ mm}$  ( $\varnothing 126.181''$ ) furatméretig az alábbiak szükségesek: 1 Jumbo hídrúd (A731S 00\_) + 2 hídrúd (A731S 0\_0) + 2 nagyoló kiesztorgáló blokk (2x A731S 400) 2 lapkatartóval\*.



3. ábra

A simító kiesztorgáló egységhez  $\varnothing 3205 \text{ mm}$  ( $\varnothing 126.181''$ ) furatméretig az alábbiak szükségesek: 1 Jumbo hídrúd (A731S 00\_) + 2 hídrúd (A731S 0\_0) + 1 simító kiesztorgáló blokk (A731S 500) 1 simító kiesztorgáló lapkatartóval 60-as méret\*\* + 1 ellensúly (A731S 600).



4. ábra

\* A betéteket külön kell megrendelni.

\*\* A lapkatartókat külön kell megrendelni.

## Híd rúd kiesztergáló összeszerelése: Híd rudak kiválasztó táblázat, a kívánt KIESZTERGÁLÁSI átmérő eléréséhez

| Kiesztergáláshz DCN-DCX Ø<br>mm | Kiesztergáláshz DCN-DCX Ø<br>inch | Jumbo híd rúd | Klasszikus híd rúd(ak) | Nagyoló kiesztergálásra      |      | Simító kiesztergáláshoz                  |      |
|---------------------------------|-----------------------------------|---------------|------------------------|------------------------------|------|--|------|
|                                 |                                   |               |                        |                              | Ábra |  | Ábra |
| 204-280                         | 8.031-11.024                      | -             | A731S 010              | 2x A731S 400<br>+ 2 kazetták | 1    | A731S 500 + 1 Lapka tartó +<br>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<br>+ 2 kazetták | 3    | A731S 500 + 1 Lapka tartó +<br>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<br>+ 2 kazetták | 3    | A731S 500 + 1 Lapka tartó +<br>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<br>+ 2 kazetták | 3    | A731S 500 + 1 Lapka tartó +<br>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<br>+ 2 kazetták | 3    | A731S 500 + 1 Lapka tartó +<br>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<br>+ 2 kazetták | 3    | A731S 500 + 1 Lapka tartó +<br>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           |                              |      |  |      |

Bevezetés

Fúrás

Dörzsárazás

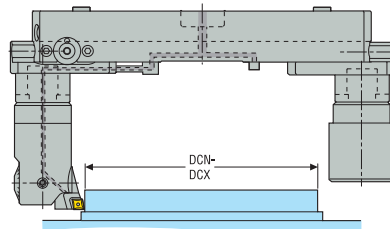
Kiesztergálás

Melléklet



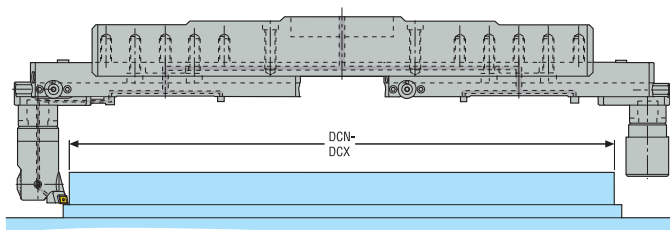
## Hídrúd csapesztorgáló összeszerelése:

A simító csap-visszaesztorgáló egységhez  $\varnothing 521$  mm ( $\varnothing 20.512$ ") furatméretig az alábbiak szükségesek: 1 Hídrúd (A731S 0\_0) + 2 Graflex® blokk (2x A731S 40128) + pl. 1 simító kiesztorgáló fej (A780 50) 1 simító kiesztorgáló 60-as\* lapkatartó + 1 ellensúly (BM050W78050).



1. ábra

A nagyoló kiesztorgáló egységhez  $\varnothing 3205$  mm ( $\varnothing 120.906$ ") furatméretig az alábbiak szükségesek: 1 Jumbo hídrúd (A731S 00\_) + 2 hídrúd (A731S 0\_0) + 2 nagyoló kiesztorgáló blokk (2x A731S 400) 2 lapkatartóval\*.



2. ábra

\* A lapkatartókat külön kell rendelni.

Híd rúd külső átmérő kiesztergáló összeszerelése:  
Híd rudak kiválasztó táblázat, a kívánt CSAP-ESZTERGÁLÁSI átmérő eléréséhez

| Csap kiesztergálásához<br>DCN-DCX Ø mm | Csap kiesztergálásához<br>DCN-DCX Ø inch | Jumbo híd rúd | Klasszikus híd rúd(ak) | Csap simító kiesztergálásához                                   | Ábra |
|--|--|---------------|------------------------|---|------|
| 48-146                                 | 1.890-5.748                              | -             | A731S 010              | 2x A731S 40128 + 1x A780 50 + 1 Lapka tartó + 1x<br>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 Lapka tartó + 1x<br>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 Lapka tartó + 1x<br>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 Lapka tartó + 1x<br>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 Lapka tartó + 1x<br>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 Lapka tartó + 1x<br>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           |   |      |

Bevezetés

Fúrás

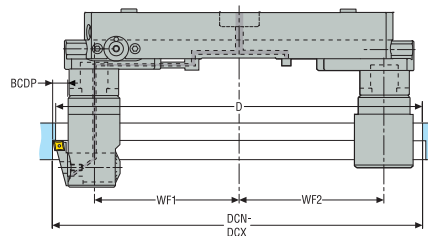
Dörzsárazás

Kiesztergálás

Melléklet

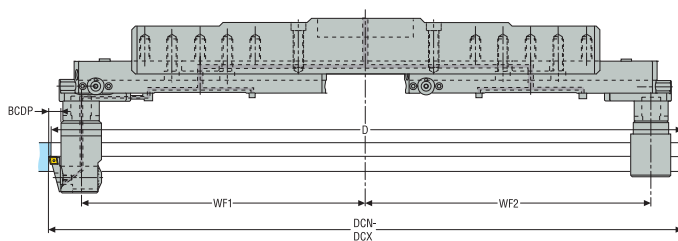
## Hídrúd kiesztorgáló egységek építése:

A simító visszacsülylesztő egységhez Ø 676 mm (Ø 26.614") furatméretig az alábbiak szükségesek: 1 hídrúd (A731S 0\_0) + 2 Graflex® blokk (2 db A731S 40128) + pl. 1 simító kiesztorgáló fej (A780 50) 1 visszacsülylesztő 50-es\* lapkartartóval + 1 ellensúly (BM050W78050).



1. ábra

A simító visszacsülylesztő egységhez Ø 3226 mm (Ø 127.008") furatméretig az alábbiak szükségesek: 1 Jumbo hídrúd (A731S 00\_) + 2 hídrúd (A731S 0\_0) + e.g. 1 simító kiesztorgáló blokk (A780 50) 1 simító visszacsülylesztő lapkartartóval 50-es méretben\* + 1 ellensúly (BM050W78050).



2. ábra

\* A lapkartartókat külön kell rendelni.

### A minimális elérhető átmérő (D min) meghatározása

Egyensúlyozási feltétel:  $WF1 = WF2$

$D_{min} = DC + 5 - BCDP$

BCDP = a lapka vágóéle és a felszerelt kiesztorgáló fej A78050 teste közötti távolság ( $7,5 < BCDP < 18,5$ ).

### A két szélsőséges eset:

A78050 kiesztorgáló fej az alsó véghelyzetébe beállítva:  $D_{min} = DCN - 2,5$

A78050 kiesztorgáló fej a felső véghelyzetébe beállítva:  $D_{min} = DCX - 13,5$

## Híd rúd vissza-esztergáló összeszerelése: Híd rudak kiválasztó táblázat,a kívánt VISSZA-ESZTERGÁLÁSI átmérő eléréséhez

| Vissza-esztergáláshoz<br>DCN-DCX Ø mm | Vissza-esztergáláshoz<br>DCN-DCX Ø inch | Jumbo híd rúd | Klasszikus híd rúd(ak) | Simító visszacsisztergáló fejhez  | Ábra |
|---------------------------------------|---|---------------|------------------------|---|------|
| 203-301                               | 7.992-11.850                            | -             | A731S 010              | 2x A731S 40128 + 1x A780 50 + 1 vissza-esztergáló lapkatartók +<br>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 vissza-esztergáló lapkatartók +<br>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 vissza-esztergáló lapkatartók +<br>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                           |               | 2x A731S 010           |   |      |
| 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 vissza-esztergáló lapkatartók +<br>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                         |               | 2x A731S 010           |   |      |
| 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  |                        |   |      |

Bevezetés

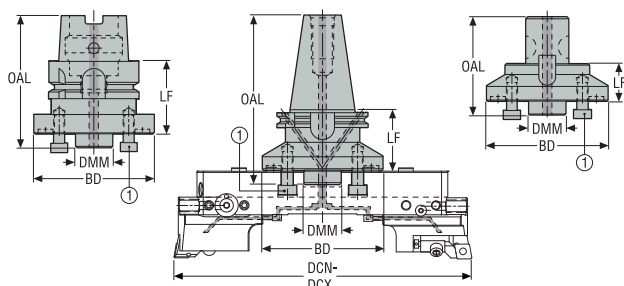
Fűrés

Dörzsárazás

Kiesztergálás

Melléklet

## ABB 731 200 – Befogó és adapter a Híd rúd tartókhoz

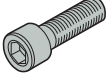





1. Állító csavar

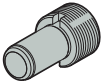

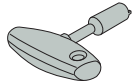
- HSK és SA befogók rövid szerelvényekhez.
- Graflex® adapter a hosszabbított szerelvényekhez.
- Híd rúd pozicionálás 30°-onként.
- Szállítva a csap tömítő O-gyűrűvel  $\varnothing 58 \times 3$  mm.

| Megnevezés  | Cikkszám | Géploldali csatlakozás   | Méret     | Munkadarab oldal Átmérő |                 | OAL             | LF            | BD             | DMM           | Súly           |
|-------------|----------|--------------------------|-----------|-------------------------|-----------------|-----------------|---------------|----------------|---------------|----------------|
|             |          |                          |           | DCN-DCX $\varnothing$   |                 |                 |               |                |               |                |
|             |          |                          |           | mm                      | mm              | mm              | mm            | mm             | mm            | kg             |
|             |          |                          |           | Inch                    | Inch            | Inch            | Inch          | Inch           | Inch          | lbs            |
| E3471731200 | 02503392 | DIN 69871-ADB            | DIN50 ADB | 204,0<br>8.031          | 655,0<br>25.787 | 166,75<br>6.565 | 65,0<br>2.559 | 130,0<br>5.118 | 40,0<br>1.575 | 5,74<br>12.650 |
| E3416731200 | 02503393 | BT JIS B 6339-ADB        | BT50 ADB  | 204,0<br>8.031          | 655,0<br>25.787 | 166,75<br>6.565 | 65,0<br>2.559 | 130,0<br>5.118 | 40,0<br>1.575 | 5,64<br>12.430 |
| E9306731200 | 02417268 | ISO 12164-1/ DIN 69893-A | HSK-A100  | 204,0<br>8.031          | 655,0<br>25.787 | 115,0<br>4.528  | 65,0<br>2.559 | 130,0<br>5.118 | 40,0<br>1.575 | 4,72<br>10.410 |
| A731200     | 00056616 | GRAFLEX                  | G7        | 204,0<br>8.031          | 655,0<br>25.787 | 90,0<br>3.543   | 40,0<br>1.575 | 130,0<br>5.118 | 40,0<br>1.575 | 3,78<br>8.330  |

### Pótalkatrészek

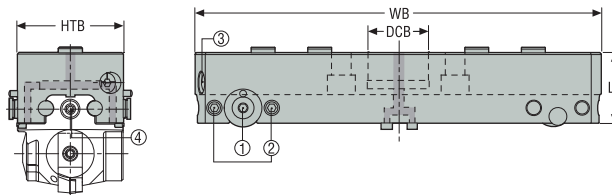
| Megnevezés  | Összeszerelő csavar   | Kulcs   | Tömítő csavar   | Retes   |
|-------------|---|---|---|---|
|             |  |  |  |  |
| E3471731200 | 950D1230  | 10SMS795  | 950A0606  | -   |
| E3416731200 | 950D1230  | 10SMS795  | 950A0606  | -   |
| E9306731200 | 950D1230  | 10SMS795  | -   | -   |
| A731200     | 950D1230  | 10SMS795  | -   | 90M7  |

### Kiegészítők

| Megnevezés  | Hűtőfolyadék cső  | Tömítő dugó   | Csavar kulcs  |
|-------------|---|---|---|
|             |  |  |  |
| E3471731200 | -   | -   | -   |
| E3416731200 | -   | -   | -   |
| E9306731200 | 20E9306   | 02E9306   | 03E9306   |
| A731200     | -   | -   | -   |

Meghúzási nyomaték 80 Nm. Alkalmazási részleteket a híd rudak és kiesztergáló blokkok művelet iinstrukciójánál.  
Kiegészítők, külön rendelendő

## BB 731S0x0 – Híd rudak



1. Rögzítő csavar végállással
2. Rögzítő csavar
3. Rögzítő csap
4. Átmérőbeállítási folyamat

- Hűtőfuratos híd rúd

| Megnevezés | Cikkszám | Munkadarab oldal Átmérő DCN-DCX Ø |                 | HTB           | WB              | DCB           | LF            | Súly                    |
|------------|----------|-----------------------------------|-----------------|---------------|-----------------|---------------|---------------|-------------------------|
|            |          | mm                                | mm              |               |                 |               |               |                         |
|            |          | <i>Inch</i>                       | <i>Inch</i>     | <i>Inch</i>   | <i>Inch</i>     | <i>Inch</i>   | <i>Inch</i>   | <i>kg</i><br><i>lbs</i> |
| A731S010   | 02753664 | 204,0<br>8.031                    | 280,0<br>11.024 | 70,0<br>2.756 | 195,0<br>7.677  | 40,0<br>1.575 | 47,0<br>1.850 | 3,43<br>7.560           |
| A731S020   | 02753668 | 279,0<br>10.984                   | 355,0<br>13.976 | 70,0<br>2.756 | 269,0<br>10.591 | 40,0<br>1.575 | 47,0<br>1.850 | 4,92<br>10.850          |
| A731S030   | 02753670 | 354,0<br>13.937                   | 430,0<br>16.929 | 70,0<br>2.756 | 344,0<br>13.543 | 40,0<br>1.575 | 47,0<br>1.850 | 6,4<br>14.110           |
| A731S040   | 02753673 | 429,0<br>16.890                   | 505,0<br>19.882 | 70,0<br>2.756 | 419,0<br>16.496 | 40,0<br>1.575 | 47,0<br>1.850 | 7,9<br>17.420           |
| A731S050   | 02753675 | 504,0<br>19.843                   | 580,0<br>22.835 | 70,0<br>2.756 | 494,0<br>19.449 | 40,0<br>1.575 | 47,0<br>1.850 | 10,4<br>22.930          |
| A731S060   | 02753677 | 579,0<br>22.795                   | 655,0<br>25.787 | 70,0<br>2.756 | 569,0<br>22.402 | 40,0<br>1.575 | 47,0<br>1.850 | 12,3<br>27.120          |

### Pótalkatrészek

| DCN-DCX | Kulcs (T-típus) | Kulcs     | Rögzítő kulcs | Rögzítő csavar |
|---------|-----------------|-----------|---------------|----------------|
| 204-655 | DOUBLE-T        | H6B-H5.0L | 03HL05        | 19A71060       |

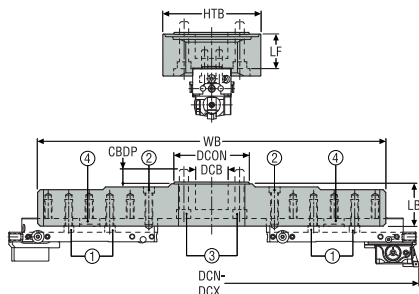
A rögzítő csavar (2) meghúzási nyomatéka 20 Nm és a rögzítő csavar végállással (1).\*\*\*

Rögzítés előtt győződjön meg, hogy a csap rögzítve van. Alkalmazási részleteket a híd rudak és kiesztergáló blokkok művelet instrukciójánál.

Max fordulatszám a 640 old. \*Csap esztergálási átmérő, lásd a 631-632 old.

Nagyobb átmérők, Jumbo híd rudak a 637 old.

## JBB 731S00 – Jumbo Híd rúd



1. Szerszám rögzítő csavar
2. Rögzítő csavar
3. Rögzítő csavar
4. Tömítő dugó



- A Jumbo kiesztorgáló fejekbe két klasszikus Híd rúd foghatunk be különböző pozíciókban.
- Belső hűtéssel a Jumbo híd rudak

| Megnevezés | Cikkszám | Munkadarab oldal Átmérő |                  | HTB            | LF            | WB               | DCON           | DCB           | CBDP          | LB            | Súly            | ** |
|------------|----------|-------------------------|------------------|----------------|---------------|------------------|----------------|---------------|---------------|---------------|-----------------|----|
|            |          | DCN-DCX Ø               | mm               |                |               |                  |                |               |               |               |                 |    |
| A731S001   | 02828506 | 654,0<br>25.748         | 1105,0<br>43.504 | 180,0<br>7.087 | 63,0<br>2.480 | 640,0<br>25.197  | 135,0<br>5.315 | 60,0<br>2.362 | 24,0<br>0.945 | 77,0<br>3.031 | 20,25<br>44.640 | -  |
| A731S002   | 02828516 | 1104,0<br>43.465        | 1630,0<br>64.173 | 200,0<br>7.874 | 50,0<br>1.969 | 1090,0<br>42.913 | 135,0<br>5.315 | 60,0<br>2.362 | 24,0<br>0.945 | 80,0<br>3.150 | 34,5<br>76.060  | -  |
| A731S003   | 02904383 | 1629,0<br>64.134        | 2155,0<br>84.843 | 200,0<br>7.874 | 50,0<br>1.969 | 1615,0<br>63.583 | 135,0<br>5.315 | 60,0<br>2.362 | 24,0<br>0.945 | 80,0<br>3.150 | 58,0<br>127.870 | ** |

Kiesztorgáló és csap felesztorgálási átmérők a Jumbo és híd rúd kombinációkkal, lásd a 629-634 old.

\*\*Nagyobb méretek A731S004-... (Ø 2154-2680 mm) és A731S005-... (Ø 2679-3205 mm) kérésre elérhető, lásd az Útmutató oldalt 625 old.

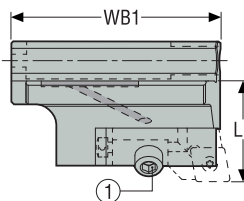
**Kiegészítők**, külön rendelendő

### Pótalkatrészek

| DCN-DCX   | Összeszerelő csavar | Állító csavar | Billenő könyök csavar | Rögzítő csavar | O-gyűrű | Tömítő dugó | Központosító csap |
|-----------|---------------------|---------------|-----------------------|----------------|---------|-------------|-------------------|
| 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        |

Az O-gyűrű szett tartalmaz 6 db O-gyűrűt Ø 6 mm (0.236") a hűtőcsatornához és 1 db 1 O-gyűrűt Ø 60 mm (2.362") a Jumbo híd rúd kiesztorgáló alaptartójához.

## BBB 731S0xx – for boring blocks and Jumbo bridge bars



- Híd rúdra történő illesztéséhez.
- Hűtőfuratos nagyoló, simító és Graflex kiesztergáló egységek.

1. Szerszám rögzítő csavar

| Cikkszám | Megnevezés | Kiesztergáló blokk típusa   | Munkadarab oldal |                  | DCB           | BD            | WB1           | WB2           | LF            | LF1           | HTB           | Súly          | Kivitel |
|----------|------------|-----------------------------|------------------|------------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------------|---------|
|          |            |                             | Átmérő DCN-DCX Ø |                  |               |               |               |               |               |               |               |               |         |
|          |            |                             | mm<br>Inch       | mm<br>Inch       | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | mm<br>Inch    | kg<br>lbs     |         |
| 02753679 | A731S400   | Nagyoló kiesztergáló blokk* | 204,0<br>8.031   | 2155,0<br>84.843 | -             | -             | 97,0<br>3.819 | -             | 47,0<br>1.850 | -             | 70,0<br>2.756 | 1,33<br>2.930 | A       |
| 02753680 | A731S500   | Simító kiesztergáló blokk** | 204,0<br>8.031   | 2155,0<br>84.843 | -             | -             | 97,0<br>3.819 | -             | 47,0<br>1.850 | -             | 70,0<br>2.756 | 1,41<br>3.110 | B       |
| 02753682 | A731S600   | Ellensúly                   | 204,0<br>8.031   | 2155,0<br>84.843 | -             | -             | 97,0<br>3.819 | -             | -             | -             | 70,0<br>2.756 | 1,49<br>3.280 | C       |
| 02753687 | A731S40128 | Graflex G5 méret***         | 48,0<br>1.890    | 2021,0<br>79.567 | 28,0<br>1.102 | 50,0<br>1.969 | 97,0<br>3.819 | 30,0<br>1.181 | 38,0<br>1.496 | 25,0<br>0.984 | 70,0<br>2.756 | 0,98<br>2.160 | D       |

### Pótalkatrészek

| Megnevezés | Összeszerelő csavar | Szerszám rögzítőcsavar | Kulcs (T-típus) | Kulcs     | Rögzítő kulcs | O-gyűrű |
|------------|---------------------|------------------------|-----------------|-----------|---------------|---------|
| 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  |

\* A beépíthető betétek külön rendelendők, 639 old.

\*\* A 60-as méretű lapkatartó külön rendelendő, lásd a 618, 619 old.

\*\*\* Az A78050 kiesztergáló fejhez használjon ellensúlyt BM050W78050, lásd az alkatrészeket lejjebb.

Az O-gyűrű szett tartalmaz 6 db O-gyűrűt Ø 6 mm (0.236") a hűtőcsatornához és 1 db 1 O-gyűrűt Ø 60 mm (2.362") a Jumbo híd rúd kiesztergáló alaptartójához.

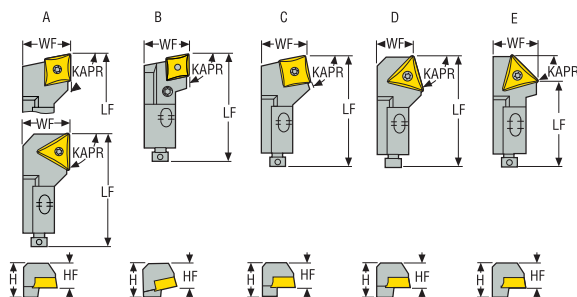
**Kiegészítők**, külön rendelendő

### Kiegészítők

| Megnevezés | Csatlakozó cső | Hűtőfolyadék készlet | Sarok alátét | Ellensúly   |
|------------|----------------|----------------------|--------------|-------------|
| A731S400   | AU731S00700    | AU731S40700          | 18LS0316     | -           |
| A731S500   | AU731S00700    | -                    | -            | -           |
| A731S600   | -              | -                    | -            | -           |
| A731S40128 | AU731S00700    | -                    | -            | BM050W78050 |



## Kazetták a nagyoló egységekhez, Híd rudakhoz A731S400



- Nagyoló állítható kiesztergáló fejhez való illesztéshez

| Megnevezés    | Cikkszám | KAPR° | LF            | WF             | H             | HF            | Súly         | Használható lapka méret | Kivitel |
|---------------|----------|-------|---------------|----------------|---------------|---------------|--------------|-------------------------|---------|
|               |          |       | mm<br>Inch    | mm<br>Inch     | mm<br>Inch    | mm<br>Inch    |              |                         |         |
| SCGCL16CA-16  | 00039871 | 90    | 55,0<br>2.165 | 25,0<br>0.984  | 20,0<br>0.787 | 16,0<br>0.630 | 0,2<br>0.440 | CC..16..                | A       |
| STGCL16CA-16  | 00009197 | 90    | 63,0<br>2.480 | 24,96<br>0.983 | 25,0<br>0.984 | 16,0<br>0.630 | 0,2<br>0.440 | TC..16T3..              | A       |
| STGCL16CA-22  | 02600181 | 90    | 55,0<br>2.165 | 25,0<br>0.984  | 20,0<br>0.787 | 16,0<br>0.630 | 0,2<br>0.440 | TC..2204..              | A       |
| PCGNL16CA-12  | 02484356 | 90    | 63,0<br>2.480 | 25,0<br>0.984  | 25,0<br>0.984 | 16,0<br>0.630 | 0,2<br>0.440 | CN..12..                | B       |
| SSRCL16CA-15  | 00039872 | 75    | 63,0<br>2.480 | 25,0<br>0.984  | 20,0<br>0.787 | 16,0<br>0.630 | 0,2<br>0.440 | SC..15..                | C       |
| STRCL16CA-16  | 00008750 | 75    | 63,0<br>2.480 | 24,96<br>0.983 | 25,0<br>0.984 | 16,0<br>0.630 | 0,2<br>0.440 | TC..16T3..              | D       |
| STRCL16CA-22  | 02585320 | 75    | 63,0<br>2.480 | 25,0<br>0.984  | 20,0<br>0.787 | 16,0<br>0.630 | 0,2<br>0.440 | TC..2204..              | D       |
| STTCL16CA-16  | 00009194 | 60    | 63,0<br>2.480 | 14,96<br>0.589 | 25,0<br>0.984 | 16,0<br>0.630 | 0,2<br>0.440 | TC..16T3..              | D       |
| STSCCL16CA-16 | 00009193 | 45    | 53,0<br>2.087 | 24,96<br>0.983 | 25,0<br>0.984 | 16,0<br>0.630 | 0,2<br>0.440 | TC..16T3..              | E       |

Spare parts for cartridges; see catalog Turning

## Ajánlott megmunkálási feltételek

A legjobb teljesítmény belső hűtőfolyadékkal érhető el (jobb forgácsolási paraméterek, jobb felületi minőség, jobb forgács kihordás).

Nagyoló kiesztergálás esetén nagyobb termelékenység érhető el a beépíthető betétek szimmetrikus beállításával (a legáltalánosabb módszer, kétszeres előtolás a lépcsőzetes beállításhoz képest).

A jó feltételek melletti simító kiesztergálás esetén csermet lapkákat ajánlunk a nagy fordulatszámok és hosszú élettartam elérése érdekében.

Részletes utasításokért olvassa el a kiesztergáló fejekkel és a Steadyline® rudakkal szállított mellékelt használati utasítást. A használati utasítás a [www.secotools.com](http://www.secotools.com) webhelyről is letölthető.

## Problémamegoldás

Megtalálja a hibaelhárítási tanácsokat a nagyoló kiesztergáló 568 és simító kiesztergáló 608 fejezetekben. A kiegyensúlyozás úgy történik, hogy mindkét gyűrűt a kiesztergálni kívánt átmérőnek megfelelően kell beállítani.

## Maximális fordulatszám a hídrudakhoz

A nagy méretű hídrúd kiesztergálók nem megfelelő fordulatszám-programozása kiszámíthatatlan károkat okozhat.

Alul megtalálhatók a hídrúd kiesztergálók max. fordulatszámjai, a hídrúd típusok (cikkszám: A731S 0\_0) nagyoló fej, simító fej és ellensúly blokkok (cikkszám: A731S \_00) és Jumbo hídrúd (cikkszám: A731 00\_). Egyéb összeszerelésekhez keresse az Ön helyi Seco üzletkötőjét, képviselőjét.

**FIGYELEM!** Amikor ezeket a kiesztergáló blokkokat használja (A731S 400, A731S 500, A731S 600, A731S 40128) a korábbi típusú hídrudakban (cikksz. A731 0\_0 - S-nélkül), a max. fordulatszám alacsonyabb, mint az előző típusú hídrúdra. Ne keverje az új és korábbi típusú blokkokat ugyanazon a hídrúdon. Ne keverje az új és a régi blokkokat ugyanazon a hídrúdon, az egyensúly megtartása érdekében.

| Fej   | Tartomány Ø mm (inch)          | Max. ford. | Adódó max. vágósebesség $v_c$ min. átm. méret m/perc (sf/min) | Adódó max. vágósebesség $v_c$ max. átm. méret m/perc (sf/min) |
|---|--------------------------------|------------|---|---|
| Gyártási tűrés fűrő   |                                |            |   |   |
| 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 hídrudak (2 azonosítóval Híd rúd és kiesztergáló blokk) |                                |            |   |   |
| 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)  |

**Megjegyzés:** A maximum fordulatszámok függnek a kiesztergáló fej mechanikus kivitelétől és kiegyensúlyozási minőségétől. Az ezeken a korlátokon belül lévő fordulatszámokat a többi forgácsolási feltétel alapján kell kiválasztani, pl. munkadarab anyaga, vágóél (lapka), szerszám hossza, géporos.

## Egyedi kiesztorgálási megoldások

A Seco Tools Tooling Systems jelentős tapasztalatokkal rendelkezik a kiesztorgálási műveletekhez szükséges egyedi készítésű megoldások tervezésében:

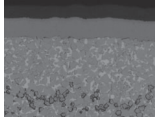
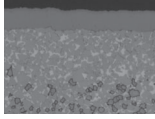
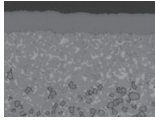
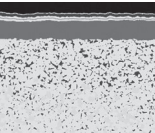
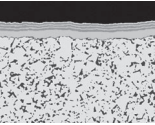
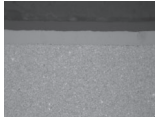
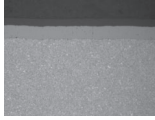
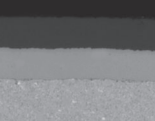
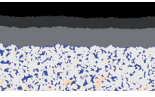


- Steadyline® rezgésillapítók nagyoló és simító kiesztorgálási megoldásokhoz,
- Többélű kiesztorgáló rudak,
- Speciális hosszabbítók vezető támaszokkal a hosszan kinyúló műveletekhez,
- Kombinált rudak fúrási, kiesztorgálási, élettörő, dörzsárazó, menetvágó műveletekhez...

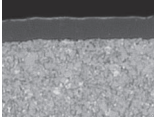
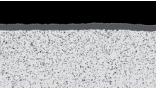
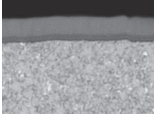
További információval kapcsolatban keresse a helyi Seco kapcsolattartót.



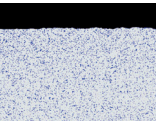

## CVD bevonatos minőségek, kiesztorgáláshoz ajánlott

|        |   |   |
|--------|---|---|
| TP1501 |    | <b>Duratomic®</b> technológiájú bevonat. Magas hő- és kopásállóságú minőség, kitűnően alkalmazható acélok hatékony esztorgálásához és használható más anyagcsoportokban is.<br><br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>                               |
| TP2501 |    | <b>Duratomic®</b> technológiájú bevonat. Nagy kopásállósággal és élerőséggel tervezve széles esztorgálási megmunkálásokhoz, acélok, korrózióálló acélok és öntöttvas megmunkálásához.<br><br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>                     |
| TP3501 |    | Azon acélok és korrózióálló acélok kiesztorgálásához lett kifejlesztve, melyeknél elsődleges követelmény a szívósság és a megbízhatóság.<br>Ti (C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC®  |
| TP200  |    | A TP200 egy sokoldalú, univerzális minőség. A minőség az esztorgálási megmunkálások széles körére lett kifejlesztve acélokhoz és korrózióálló acélokhoz és öntvényeknél is jó választás lehet.<br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> + TiN          |
| TP40   |   | Alap minőség a P40-es tartományban. Nagyon szívós, öntvények, kovácsolt és korrózióálló acélok nagy igénybevételrel járó megmunkálásához.<br>TiC/Ti (C, N) + TiN  |
| TK0501 |  | DURATOMIC® technológiájú bevonat. Egy nagyon kopásálló minőség öntöttvas általános és acél megmunkálására, és a minőség alkalmas gömbgrafitos öntöttvas megmunkálására és megszakított forgácsoláshoz is.<br><br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> |
| TK1501 |  | DURATOMIC® technológiájú bevonat. Egy különösen kopásálló optimalizált minőség szürkeöntvények megmunkálásához és gömbgrafitos öntvényekhez.<br><br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>  |
| TH1500 |  | DURATOMIC® technológiájú bevonat. Nagyon kemény mikroszemcsés minőség, ajánlott részben edzett acél munkadarabokhoz és alternatíva öntöttvas simításához.<br><br>Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>   |
| 25     |  | Általános minőség.<br>Ez a minőség acél, korrózióálló acél és öntöttvas kiesztorgálásához való.<br>A kopásállóság és szívósság jó kombinációja.<br>Ti (C, N) + Al <sub>2</sub> O <sub>3</sub> .   |

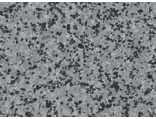
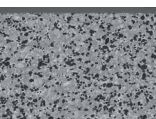
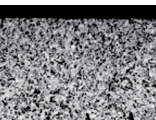
## PVD bevonatos minőségek, kiesztergáláshoz ajánlott

|              |   |   |
|--------------|---|---|
| TS2000       |  | Kemény mikroszemcsés minőség szuperötvözetek és titán ötvözetek simítására. Korroszióálló acélok simításánál is jól teljesít.<br>(Ti,Al)N + TiN   |
| CP500 & 26G6 |  | Nagyon szívós mikroszemcsés bevonat, mely korroszióálló acélok simítására és közepes nagyolásra lett kifejlesztve. Megszakított felületű megmunkálásra is alkalmas. A CP500 alumínium ötvözeteknél is jó választás lehet.<br>(Ti,Al)N + TiN               |
| TH1000       |  | Nagyon kemény mikroszemcsés minőség, ajánlott részben edzett acél munkadarabokhoz és olyan anyagokhoz is mint a szuperötvözetek és ahol szükséges az élszivósság, szintén jól alkalmazható megszakított forgácsolásnál és kemény felület eltávolításához. |

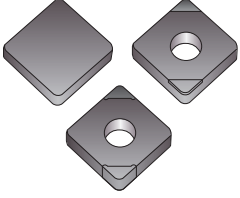

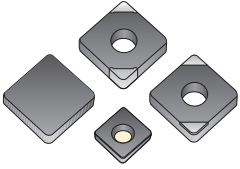
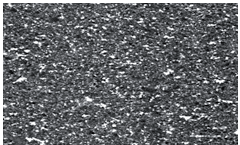
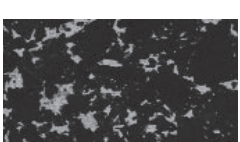
## Bevonat nélküli minőségek, kiesztergáláshoz ajánlott

|           |   |  |
|-----------|---|--|
| KX & 03G3 |   | Alumínium és más, nem vas alapú anyagok megmunkálására kifejlesztett szemcseszerkezet.   |
| HX        |  | Univerzális bevonat nélküli minőség, ajánlott öntöttvas és edzett acélok megmunkálásához, szintén alkalmazható színesfémeknél. |

## Cermet, kiesztergáláshoz ajánlott

|        |   |  |
|--------|---|--|
| TP1020 |  | Cermet minőség nagy kopásállósággal a legmagasabb felületi követelményekhez, megbízhatóan és ellenőrizhetően, acélokhoz és korroszióálló acélokhoz.                  |
| TP1030 |  | PVD-bevonatú Cermet nagy kopásállósággal a magas felületi és termelékenységi követelményekhez acélokban és korroszióálló acélokban. Ti-Al-Si-N nanolaminált bevonat. |
| 51G1   |  | Cermet nagyon nagy kopásállósággal. Acélok és korroszióálló acélok simító megmunkálására lett kifejlesztve, ahol szigorú követelmény a jó felületi minőség.          |

## A CBN és PCD minőségek simító kiesztorgáláshoz ajánlottak

|              |   |   |
|--------------|---|---|
| CBN010       |    | <p>Forma: Tömör, teljes felületű forrasztott és forrasztott csúcs (egy és két oldalas).<br/>Összetétel: 50% CBN tartalom, közepes szemcse nagyság (2 µm) és TiC kerámia kötőanyag.<br/>Bevonat: Nincs bevonat.</p>  |
| CBN10 & 81B1 |    | <p>CBN, köbös bór-nitrid minőségek, simító kiesztorgáláshoz edzett acélban (7 csoport) folytonos vagy közepesen megszakított felületekhez.</p>  |
| CBN060K      |    | <p>Tömör, forrasztott csúcs (egy vagy két oldalas) vagy szinterezett felület<br/>Elsőválasztás a folyamatostól a közepesen megszakított felületekig, edzett acéloknál (<math>a_p &lt; 0.020</math> inch).<br/>Új (Ti,Si,Al)N PVD bevonat nagy sebességű megmunkálásra fejlesztve.<br/>Új különleges szuperötvezetű kötőanyag.</p> |
| CBN200       |   | <p>CBN, köbös bór-nitrid minőség, perlités öntvény és szinterezett öntvény simító megmunkálásához.</p>  |
| PCD20 & 91J3 |  | <p>PCD, polikristályos gyémánt simító kiesztorgáláshoz alumíniumban és Al-ötvözetekben, rézben, sárgarézben, bronzban és szintetikus anyagokban (16 -17 csoport).</p>   |

## Lapkák, nagyoló kiesztorgáláshoz, forgácsolási adatokkal

| Megnevezés     | Bevonat nélküli, köszörült hát és préselt forgácstörő |          |          | Bevonatos Préselt forgácstörő |          |          |          |          | Bevonatos Köszörült hát préselt forgácstörő, balos vágóél | Fogásmélység $a_p$ mm (inch) | Előtölés mm (inch)          |
|----------------|---|----------|----------|-------------------------------|----------|----------|----------|----------|---|------------------------------|-----------------------------|
|                | KX  | HX       | 03D3     | TP2501                        | TP3501   | TP40     | 25C4     | TK1501   |   |                              |                             |
| CPGT050204     |   |          | 02434654 |                               |          |          | 02434652 |          |   | 2<br>(0.079)                 | 0,08-0,2<br>(0.0031-0.0079) |
| CCMT060204-F1  |   |          |          | 02960857                      | 03095430 | 00008505 |          | 03062942 | 00096854  | 2<br>(0.079)                 | 0,1-0,22<br>(0.0039-0.0087) |
| CCMT060204-F2  |   | 74011732 |          |                               |          | 74018652 |          |          |   | 2<br>(0.079)                 | 0,1-0,22<br>(0.0039-0.0087) |
| CCGT060204L-UX |   |          |          |                               |          |          |          |          | 02497631  | 2<br>(0.079)                 | 0,1-0,22<br>(0.0039-0.0087) |
| CCGT060204F-AL | 00015710  |          |          |                               |          |          |          |          |   | 2<br>(0.079)                 | 0,1-0,22<br>(0.0039-0.0087) |
| CCMT060204-M3  |   |          |          | 02960858                      | 03095431 |          |          | 03062944 |   | 2<br>(0.079)                 | 0,1-0,22<br>(0.0039-0.0087) |
| CCMT09T308-F1  |   |          |          | 02960861                      | 03095443 | 00008518 |          | 03063857 | 00096858  | 2,5<br>(0.098)               | 0,1-0,3<br>(0.0039-0.0118)  |
| CCMT09T308-MF2 |   |          |          | 02956309                      | 03095446 |          |          |          | 02754822  | 2,5<br>(0.098)               | 0,1-0,3<br>(0.0039-0.0118)  |
| CCGT09T304L-UX |   |          |          |                               |          |          |          |          | 02497640  | 2,5<br>(0.098)               | 0,1-0,3<br>(0.0039-0.0118)  |
| CCGT09T308F-AL | 00015754  |          |          |                               |          |          |          |          |   | 2,5<br>(0.098)               | 0,1-0,3<br>(0.0039-0.0118)  |
| CCMT120408-F1  |   |          |          | 02960854                      | 03095449 |          |          | 03062626 |   | 4<br>(0.157)                 | 0,15-0,4<br>(0.0059-0.0157) |
| CCMT120408-MF2 |   |          |          | 02956311                      | 03095452 |          |          |          |   | 4<br>(0.157)                 | 0,15-0,4<br>(0.0059-0.0157) |
| CCGT120408L-UX |   |          |          |                               |          |          |          |          | 02610062  | 4<br>(0.157)                 | 0,15-0,4<br>(0.0059-0.0157) |
| CCGT120408F-AL | 00015790  |          |          |                               |          |          |          |          |   | 5<br>(0.197)                 | 0,15-0,4<br>(0.0059-0.0157) |
| SCMT060204-M3  |   |          |          | 02960423                      | 03096621 |          |          |          |   | 2,5<br>(0.098)               | 0,1-0,22<br>(0.0039-0.0087) |
| SCMT09T308-F1  |   |          |          | 02960396                      | 03096625 |          |          | 03062629 | 00099708  | 2,5<br>(0.098)               | 0,1-0,3<br>(0.0039-0.0118)  |
| SCMT09T308-MF2 |   |          |          | 02956318                      | 03096627 |          |          |          | 02755042  | 2,5<br>(0.098)               | 0,1-0,3<br>(0.0039-0.0118)  |
| SCMT120408-F1  |   |          |          | 02960397                      | 03096630 |          |          |          | 00099804  | 4<br>(0.157)                 | 0,15-0,4<br>(0.0059-0.0055) |
| SCMT120408-M3  |   |          |          | 02960429                      | 03096631 |          |          | 03063990 |   | 4<br>(0.157)                 | 0,15-0,4<br>(0.0059-0.0055) |
| TCMT16T308-F1  |   |          |          | 02960408                      | 03096643 | 74004572 |          |          | 00091357  | 5<br>(0.197)                 | 0,15-0,4<br>(0.0059-0.0055) |
| TCMT16T308-MF2 |   |          |          | 02956323                      | 03096645 |          |          |          | 02755046  | 5<br>(0.197)                 | 0,15-0,4<br>(0.0059-0.0055) |
| TCGT16T308F-AL | 00015875  |          |          |                               |          |          |          |          |   | 4<br>(0.157)                 | 0,15-0,4<br>(0.0059-0.0055) |
| SCMT150512-F2  |   |          |          |                               |          | 74007348 |          |          |   | 7<br>(0.276)                 | 0,2-0,5<br>(0.0079-0.0197)  |

Az ajánlott vágósebességeket lásd a 650-653 old.

Bevezetés

Fúrás

Dörzsárazás

Kiesztorgálás

Melléklet



## CN.. lapkák, ajánlott nagyoló kiesztorgáláshoz (két oldalas)

| Megnevezés     | Bevonatos<br>Préselt forgácstörő |          |        |       | Fogásmélység $a_p$ mm<br>(inch) | Előtolás<br>mm<br>(inch)       |
|----------------|----------------------------------|----------|--------|-------|---------------------------------|--------------------------------|
|                | TP3500                           | TP40     | TM4000 | TP200 |                                 |                                |
| CNMG120408-M3  |                                  |          |        |       | 4,5<br>(0.177)                  | 0,25-0,35<br>(0.00984-0.01378) |
| CNMG120408-MF3 |                                  | 74030598 |        |       | 4,5<br>(0.177)                  | 0,25-0,35<br>(0.00984-0.01378) |
| CNMG120408-MF4 |                                  |          |        |       | 4,5<br>(0.177)                  | 0,25-0,35<br>(0.00984-0.01378) |
| CNMG120408-MF1 |                                  |          |        |       | 4,5<br>(0.177)                  | 0,25-0,35<br>(0.00984-0.01378) |
| CNMG120408-MR7 |                                  | 74017309 |        |       | 4,5<br>(0.177)                  | 0,25-0,35<br>(0.00984-0.01378) |

Az ajánlott vágósebességeket lásd a 650-653 old.

## Lapok, simító kiesztergáláshoz, forgácsolási adatokkal

| Megnevezés           | Bevonatos |          |          |          |          |          |          | Cermet   |          |          | Fogásmélység $a_p$<br>mm<br>(inch) | Előtolás<br>mm<br>(inch)          |
|----------------------|-----------|----------|----------|----------|----------|----------|----------|----------|----------|----------|------------------------------------|-----------------------------------|
|                      | TP1501    | TS2000   | TK1501   | CP500    | 26G6     | TH1000   | TH1500   | 51G1     | TP1020   | TP1030   |                                    |                                   |
| CCGT060200           |           |          |          |          |          |          |          | 00083915 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT0602005-F1       |           |          |          | 02430287 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060201-F1        |           |          |          | 02430307 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060202           |           |          |          |          | 00039546 |          |          | 00096634 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060204           |           |          |          |          | 00081826 |          |          | 00048334 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060204L-UX       |           |          |          | 02497631 |          |          |          |          |          |          | 2<br>(0.079)                       | 0,1-0,22<br>(0.0039-0.0087)       |
| CCMT060202-F1        | 02960383  | 02614299 |          | 00096853 |          |          |          |          | 02754786 | 02754435 | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMT060204-F1        | 02960856  | 02615873 | 03062942 | 00096854 |          | 02825858 | 02825859 |          | 02754791 | 02754792 | 2<br>(0.079)                       | 0,1-0,22<br>(0.0039-0.0087)       |
| CCMW060202F-L1       |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMW060204F-L1       |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW060202S-01020-LF |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW060204S-01020-LF |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW060204E-L1-B     |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T301-F1        |           |          |          | 02430311 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T302           |           |          |          |          | 00048337 |          |          | 00048339 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T304           |           |          |          |          | 00077338 |          |          | 00048344 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T304L-UX       |           |          |          | 02497640 |          |          |          |          |          |          | 2,5<br>(0.098)                     | 0,1-0,3<br>(0.0039-0.0118)        |
| CCMT09T302-F1        | 02960837  |          |          | 00096856 |          |          |          |          | 02754805 | 02754806 | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMT09T304-F1        | 02960844  | 02615874 | 03063856 | 00096857 |          | 02731806 | 02731808 |          | 02754811 | 02754812 | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMT09T308-F1        | 02960853  | 02615876 | 03063857 | 00096858 |          | 02731807 | 02731809 |          |          | 02754821 | 2,5<br>(0.098)                     | 0,1-0,3<br>(0.0039-0.0118)        |
| CCMW09T304F-L1       |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMW09T308F-L1       |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T304E-L1-B     |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T308E-L1-B     |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T304S-01020-LF |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T308S-01020-LF |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGT110204           |           |          |          |          |          |          |          | 00000721 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGT110201-F1        |           |          |          | 02430376 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMT110202-F1        |           |          |          | 02430419 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMT110204-F1        | 02960401  |          |          | 02430421 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMT110208-F1        | 02960403  |          |          | 00098986 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110204E-L1-C     |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110208E-L1-C     |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110204S-01020-LF |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110208S-01020-LF |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMW110204F-L1       |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030100            |           |          |          |          |          |          |          | 00083089 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030102            |           |          |          |          |          |          |          | 00091845 |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030102L           |           |          |          | 02416632 |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030102            |           |          |          |          |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |

The table continues on next page.

Az ajánlott vágósebességeket lásd a 650-653 old.

## Lapkák, simító kiesztergáláshoz, forgácsolási adatokkal

| Megnevezés           | CBN      |          |          |          | PCD      |          | Fogásmélység $a_p$<br>mm<br>(inch) | Előtolás<br>mm<br>(inch)          |
|----------------------|----------|----------|----------|----------|----------|----------|------------------------------------|-----------------------------------|
|                      | CBN010   | CBN060K  | CBN200   | 81B1     | PCD20    | 91J3     |                                    |                                   |
| CCGT060200           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT0602005-F1       |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060201-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060202           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060204           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT060204L-UX       |          |          |          |          |          |          | 2<br>(0.079)                       | 0,1-0,22<br>(0.0039-0.0087)       |
| CCMT060202-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMT060204-F1        |          |          |          |          |          |          | 2<br>(0.079)                       | 0,1-0,22<br>(0.0039-0.0087)       |
| CCMW060202F-L1       |          |          |          |          | 00089760 |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMW060204F-L1       |          |          |          |          | 00005684 |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW060202S-01020-LF |          |          | 02464698 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW060204S-01020-LF | 02916281 |          | 02464699 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW060204E-L1-B     | 02843086 | 02776337 | 02649599 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T301-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T302           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T304           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGT09T304L-UX       |          |          |          |          |          |          | 2,5<br>(0.098)                     | 0,1-0,3<br>(0.0039-0.0118)        |
| CCMT09T302-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMT09T304-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMT09T308-F1        |          |          |          |          |          |          | 2,5<br>(0.098)                     | 0,1-0,3<br>(0.0039-0.0118)        |
| CCMW09T304F-L1       |          |          |          |          | 00005686 |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCMW09T308F-L1       |          |          |          |          | 00095357 |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T304E-L1-B     | 02843126 | 02776338 | 02649607 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T308E-L1-B     | 02937148 |          | 02649608 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T304S-01020-LF | 02916282 |          | 02464702 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| CCGW09T308S-01020-LF |          |          | 02464703 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGT110204           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGT110201-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMT110202-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMT110204-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMT110208-F1        |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110204E-L1-C     | 02848657 | 02776346 |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110208E-L1-C     | 02848792 |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110204S-01020-LF |          |          | 02464742 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCGW110208S-01020-LF |          |          | 02464744 |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| TCMW110204F-L1       |          |          |          |          | 00005689 |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030100            |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030102            |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030102L           |          |          |          |          |          |          | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |
| WBG030102            |          |          |          | 00096761 |          | 00096763 | 0,01-0,3<br>(0.000394-0.01181)     | 0,03-0,15<br>(0.001181-0.0059055) |

Az ajánlott vágósebességeket lásd a 650-653 old.

Ajánlott vágósebesség kiesztergáláshoz (a munkadarab anyagától és a lapkaminőségtől függ) – Metrikus

| SMG | $v_c$ (m/perc) |         |        |         |        |        |        |        |        |        |         |
|-----|----------------|---------|--------|---------|--------|--------|--------|--------|--------|--------|---------|
|     | 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 anyag csoport  $v_c = m/min$  (sf/min) Minden forgácsolási paraméter kezdeti érték

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## Ajánlott vágósebesség kiesztorgáláshoz (a munkadarab anyagától és a lapkaminőségtől függ) – inch

| SMG | $v_c$ (sf/perc) |          |         |          |         |         |         |         |         |         |          |
|-----|-----------------|----------|---------|----------|---------|---------|---------|---------|---------|---------|----------|
|     | 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 anyag csoport  $v_c = \text{m/min}$  (sf/min) Minden forgácsolási paraméter kezdeti érték

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Ajánlott vágósebesség kiesztergáláshoz (a munkadarab anyagától és a lapkaminőségtől függ) – Metrikus

| SMG | v <sub>c</sub> (m/perc) |        |        |         |         |         |                  |        |          |          |          |          |          |
|-----|-------------------------|--------|--------|---------|---------|---------|------------------|--------|----------|----------|----------|----------|----------|
|     | 26                      | 25     | TS2000 | TP1020  | TP1030  | 51      | CBN10/<br>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 anyag csoport v<sub>c</sub> = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

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## Ajánlott vágósebesség kiesztorgáláshoz (a munkadarab anyagától és a lapkaminőségtől függ) – inch

| SMG | $v_c$ (sf/perc) |         |         |          |          |          |                  |          |          |          |          |          |          |
|-----|-----------------|---------|---------|----------|----------|----------|------------------|----------|----------|----------|----------|----------|----------|
|     | 26              | 25      | TS2000  | TP1020   | TP1030   | 51       | CBN10/<br>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 anyag csoport  $v_c$  = m/min (sf/min) Minden forgácsolási paraméter kezdeti érték

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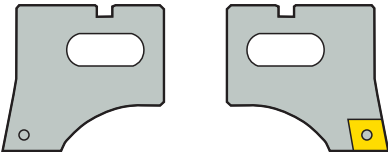
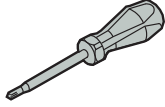

Melléklet

## Az összes kiesztorgáló lapkartartó, szerszám és kazetta kulcsai és csavarjai

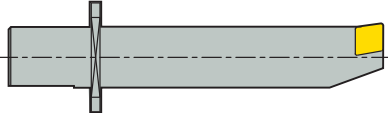
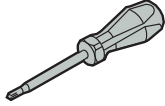

A CN.. típusú lapkartartók alkatrészei a CN.. típusú tartók termék oldalain. Lapka rögzítő alkatrészek az RB 610 lapkartartóhoz a termék a 575 old..

Emlékeztető: A pótalkatrészek részei a szállítmánynak, lapka tartók, szerszámok, kazetták.

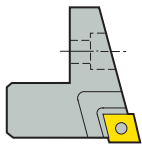
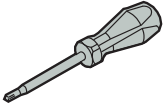

A kiegészítőket nem tartalmazza a szállítmány, külön kell megrendelni.

|  |             | Kiegészítők   |             |             | Pótalkatrészek  |  |
|--|-------------|---|-------------|-------------|---|--|
|  |             | Torxkulcs a lapka rögzítő csavarhoz*  |             |             | Lapka rögzítő csavar  |  |
|  |             |  |             |             |  |  |
| Nagyoló<br>kiesztorgáló<br>lapkartartókhoz                                       | Lapka méret | Megnevezés  | Torx Plus   | Megnevezés  | Torx Plus   |  |
|  | 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          |   |  |

\* Egy Torx kulcsot szállítunk minden nagyoló kiesztorgáló fejhez.

|  |              | Kiegészítők   |           |             | Pótalkatrészek  |  |
|--|--------------|---|-----------|-------------|---|--|
|  |              | Torxkulcs a lapka rögzítő csavarhoz*  |           |             | Lapka rögzítő csavar  |  |
|  |              |  |           |             |  |  |
| For Axiabore™ típus<br>szerszám  | Lapka méret  | Megnevezés  | Torx Plus | Megnevezés  | Torx Plus   |  |
|  | WB...0301... | T06P-3  | 06        | C02035-T06P | 06  |  |
|  | CC...0602... | T07P-3  | 07        | C02504-T07P | 07  |  |
| -  | -            | T15P-3  | 15        | C04008-T15P | 15  |  |

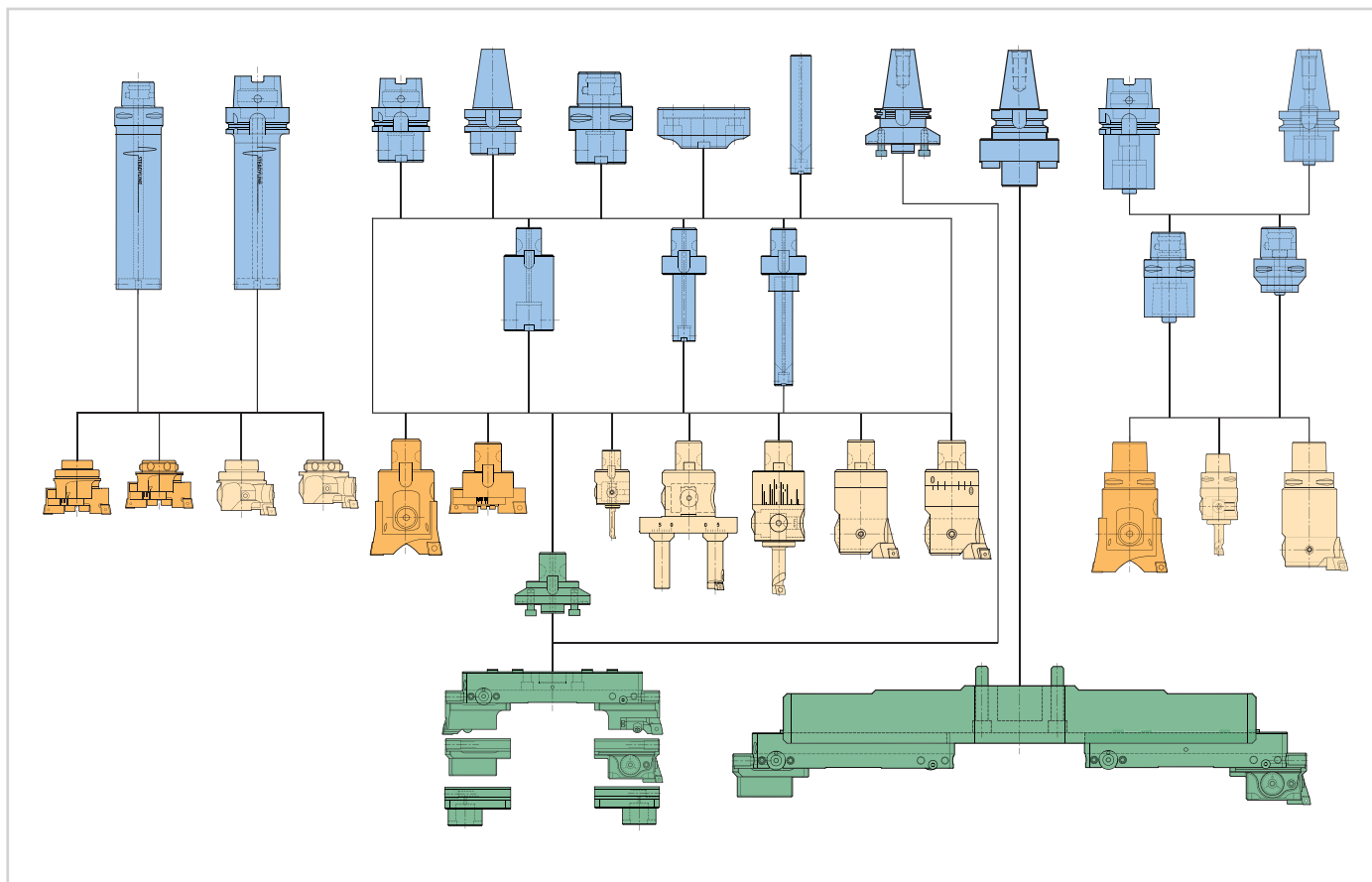
## Tartalék alkatrészek a lapka tartókhoz

|   |              | Pótalkatrészek  |             |   |           |
|---|--------------|---|-------------|---|-----------|
|   |              | Lapka kulcs   |             | Lapka csavar  |           |
|                |              |  |             |  |           |
| Simító kiesztorgáló<br>lapkartartók,<br>életőrlő lapkartartók és<br>visszacsztorgáló lapkartartók | Lapka méret  | Megnevezés  | Torx Plus   | Megnevezés  | Torx Plus |
|   | 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  |           |

|   |             | Kiegészítők   |           |             | Pótalkatrészek  |  |
|---|-------------|---|-----------|-------------|---|--|
|   |             | Torxkulcs a lapka rögzítő csavarhoz*  |           |             | Lapka rögzítő csavar  |  |
|  |             |  |           |             |  |  |
| Kazettákhoz   | Lapka méret | Megnevezés  | Torx Plus | Megnevezés  | Torx Plus   |  |
|   | 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  |  |



## Alaptartók kiesztorgáló fejekhez



## A kiesztorgáló fejek Graflex®, Seco-Capto™, GL vagy BA géppoldali csatlakozással rendelkeznek

A kiesztorgáló fejek bármely olyan gépen használhatók, amelyek megfelelő Graflex® adapterrel, Seco-Capto™ adapterrel vagy Steadyline® rezgéscsillapító kiesztorgáló/esztorgáló rúddal szereltek.

### Steadyline® rezgéscsillapítás a kiesztorgáló műveletekhez

A GL vagy BA géppoldali csatlakozásokkal ellátott kiesztorgáló fejek a HSK-T/A és Seco-Capto™ géppoldali csatlakozásokkal ellátott Steadyline® kiesztorgáló/esztorgáló rudakra szerelhetők fel. Ez lehetővé teszi a 6xD, 8xD és 10xD nagyoló és simító kiesztorgálást nagyon stabil körülmények között.

### Moduláris Graflex® és Seco-Capto™ kiesztorgáló rudak

A 6xD méretig terjedő összes furathossz elérhető a szükséges Graflex® toldatok, pl. a nagyon hosszú, keményfém hosszabbítóval ellátott toldatok kiválasztásával. Nagyobb összeszerelési merevség nyerhető a hosszabb és szélesebb csatlakozóval, mint a kisebb közdarabokkal.

A Graflex® és Seco-Capto™ csatlakozás garantálja a kiesztorgáló fejek megfelelő elhelyezését, elérve ezzel a lapkák ISO szerinti élhelyezését. A Graflex® modulok az oldalai mentén rögzíthetők egymáshoz.

A GL géppoldali csatlakozással ellátott kiesztorgáló fejek Steadyline® csatlakozásához válassza a legrövidebb Steadyline® rudat a Felszerszámozás katalógusából. Ez a rúd HSK-T/A és Seco-Capto™ géppoldali csatlakozással érhető el. Más típusú főorsókat a legrövidebb Seco-Capto™ adapterekkel lehet felszerelni.

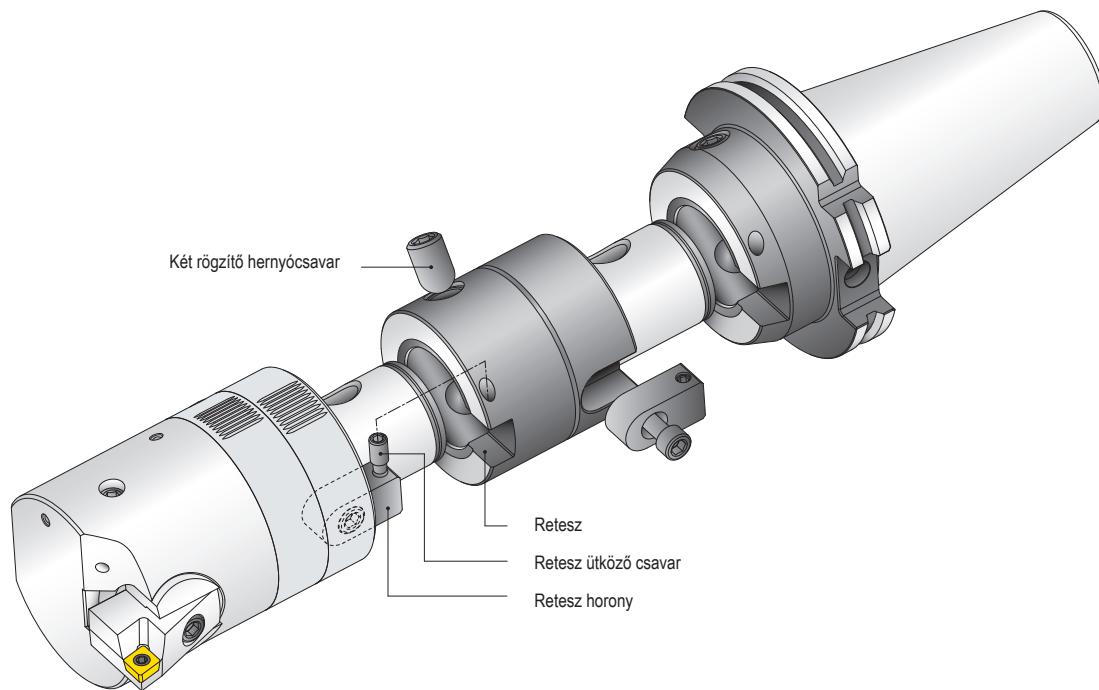
A klasszikus kiesztorgáló fejekhez (acél), válassza a klasszikus Graflex® és Seco-Capto™ befogókat és közbetéteket a Felszerszámozás katalógusból. A hidrudakhoz lásd a Graflex® adaptereket és tartókat a(z) 635 oldalon.

**Figyelem!** A Jumbo hidrudakat úgy terveztük, hogy befoghatók legyenek a maró befogókba vagy közvetlenül a gép főorsójára.

## Rögzítési tanács a Graflex® klasszikus, G típusú csatlakozójához (retesz használata ütközőcsavarral).

Kiesztergáláshoz, nem szükséges meghúzni a retesz rögzítő csavart, az önzárás megfelelő.  
Nagyoló megmunkáláshoz, ajánljuk a nagy nyomaték átvitelhez a Graflex® gömbvégű csavarok alkalmazását.

Lásd még a részletes „Graflex® csatlakozó összeszerelési eljárást” a Felszerszámozás katalógusban.



## Rögzítési tanács a Seco-Capto™ csatlakoztatásához C. típusú fejekkel: Nincs speciális tanács. A kiesztergáló fejekhez az általános utasítások alkalmazhatók, lásd lent.

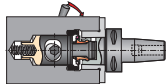
Meghúzási nyomaték a Seco-Capto™ fogadó csatlakozóhoz, központi csavarral (alaptartók, közbetétek).

| Seco-Capto Méret | Központi csavar meghúzási nyomaték (Nm) | Központi csavar meghúzási nyomaték (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                                     |



Meghúzási nyomaték a Seco-Capto™ fogadó csatlakozóhoz, szegmens rögzítéssel, oldalsó tengellyel mozgatva (peremes rögzítés)

| Seco-Capto Méret | Tengely meghúzási nyomaték (Nm) | Tengely meghúzási nyomaték (ft/lbs) |
|------------------|---------------------------------|-------------------------------------|
| C3               | 35                              | 26                                  |
| C4               | 50                              | 37                                  |
| C5               | 70                              | 52                                  |
| C6               | 90                              | 66                                  |
| C8               | 130                             | 96                                  |

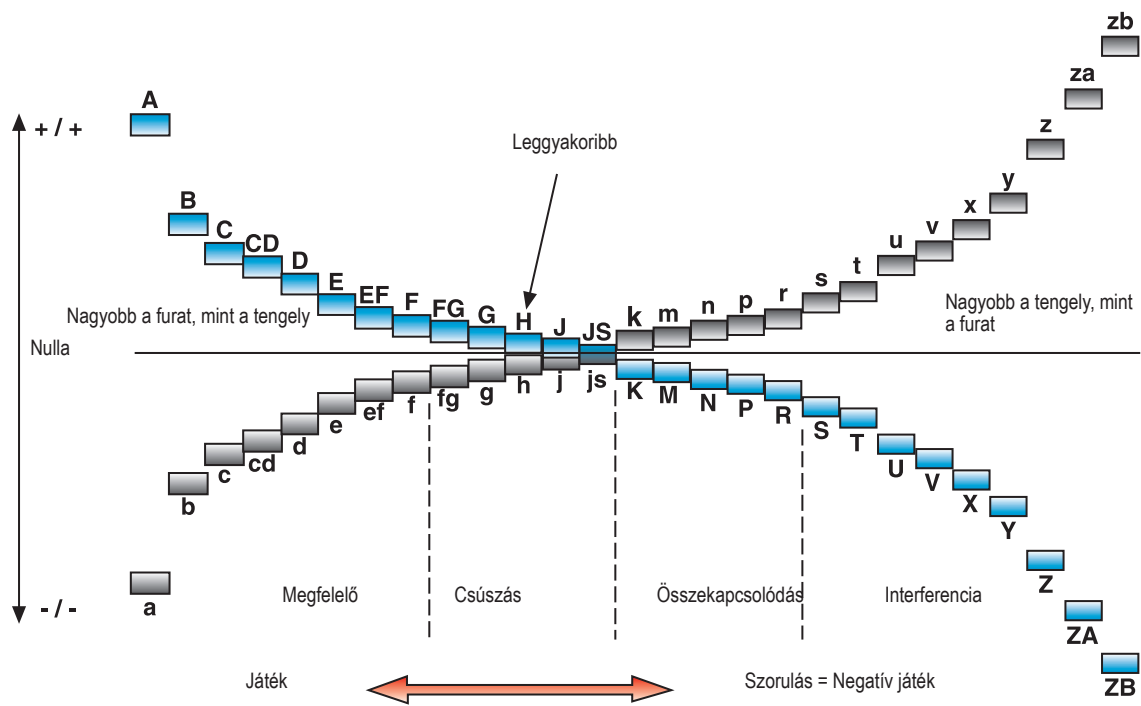
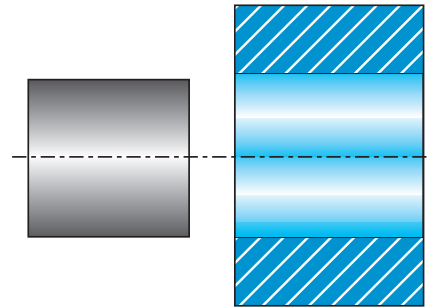


A Seco-Capto™ kötés egy önzáró kúp. Ahol a központi csavar rögzítés van alkalmazva, hajtsa ki a központi csavart, amíg a csavar feje a befogóhoz nem ér és eltolja a kúptól. Ha oldalrögzítő rendszert használ, akkor a tengely túlforgatása nyomja le a kúptól.

## ISO szabványos tűrés a furatokhoz és tengelyekhez – Tengelytűrések

A tengelytűrés helyzetét **kisbetűvel** jelöljük

A furatok tűrését **NAGYBETŰKKEL**.



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## ISO tűréstáblázat

| ISO tűrések furatokhoz (mm) (μm) |              |              |             |             |            |           |          |          |          |           |           |           |           |
|----------------------------------|--------------|--------------|-------------|-------------|------------|-----------|----------|----------|----------|-----------|-----------|-----------|-----------|
| Furat Ø mm (inch)                | D10          | E9           | F7          | F8          | G7         | G9        | H6       | H7       | H8       | H9        | H10       | H11       | H12       |
| ≤ 3 (0.118")                     | +60<br>+20   | +39<br>+14   | +16<br>+6   | +20<br>+6   | +12<br>+2  | +27<br>+2 | +6<br>0  | +10<br>0 | +14<br>0 | +25<br>0  | +40<br>0  | +60<br>0  | +100<br>0 |
| 3 ≥ 6 (0.236")                   | +78<br>+30   | +50<br>+20   | +22<br>+10  | +28<br>+10  | +16<br>+4  | +34<br>+4 | +8<br>0  | +12<br>0 | +18<br>0 | +30<br>0  | +48<br>0  | +75<br>0  | +120<br>0 |
| 6 ≥ 10 (0.394")                  | +98<br>+40   | +61<br>+25   | +28<br>+13  | +35<br>+13  | +20<br>+5  | +41<br>+5 | +9<br>0  | +15<br>0 | +22<br>0 | +36<br>0  | +58<br>0  | +90<br>0  | +150<br>0 |
| 10 ≥ 18 (0.708")                 | +120<br>+50  | +75<br>+32   | +34<br>+16  | +43<br>+16  | +24<br>+6  | +49<br>+6 | +11<br>0 | +18<br>0 | +27<br>0 | +43<br>0  | +70<br>0  | +110<br>0 | +180<br>0 |
| 18 ≥ 30 (1.181")                 | +149<br>+65  | +92<br>+40   | +41<br>+20  | +53<br>+20  | +28<br>+7  | +59<br>+7 | +13<br>0 | +21<br>0 | +33<br>0 | +52<br>0  | +84<br>0  | +130<br>0 | +210<br>0 |
| 30 ≥ 50 (1.969")                 | +180<br>+80  | +112<br>+50  | +50<br>+25  | +64<br>+25  | +34<br>+9  | +71<br>+9 | +16<br>0 | +25<br>0 | +39<br>0 | +62<br>0  | +100<br>0 | +160<br>0 | +250<br>0 |
| 50 ≥ 65 (2.559")                 | +220<br>+100 | +134<br>+60  | +60<br>+30  | +76<br>+30  | +40<br>+10 | -         | +19<br>0 | +30<br>0 | +46<br>0 | +74<br>0  | +120<br>0 | +190<br>0 | +300<br>0 |
| 65 ≥ 80 (3.150")                 |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 80 ≥ 100 (3.937")                | +260<br>+120 | +159<br>+72  | +71<br>+36  | +90<br>+36  | +47<br>+12 | -         | +22<br>0 | +35<br>0 | +54<br>0 | +87<br>0  | +140<br>0 | +220<br>0 | +350<br>0 |
| 100 ≥ 120 (4.724")               |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 120 ≥ 140 (5.512")               | +305<br>+145 | +185<br>+85  | +83<br>+43  | +106<br>+43 | +54<br>+14 | -         | +25<br>0 | +40<br>0 | +63<br>0 | +100<br>0 | +160<br>0 | +250<br>0 | +400<br>0 |
| 140 ≥ 160 (6.299")               |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 160 ≥ 180 (7.087")               |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 180 ≥ 200 (7.874")               | +355<br>+170 | +215<br>+110 | +96<br>+50  | +122<br>+50 | +61<br>+15 | -         | +29<br>0 | +46<br>0 | +72<br>0 | +115<br>0 | +185<br>0 | +290<br>0 | +460<br>0 |
| 200 ≥ 225 (8.858")               |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 225 ≥ 250 (9.843")               |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 250 ≥ 280 (11.0236")             | +400<br>+190 | +240<br>+110 | +108<br>+56 | +137<br>+56 | +69<br>+17 | -         | +32<br>0 | +52<br>0 | +81<br>0 | +130<br>0 | 210<br>0  | +320<br>0 | +520<br>0 |
| 280 ≥ 315 (12.402")              |              |              |             |             |            |           |          |          |          |           |           |           |           |
| 315 ≥ 355 (13.976")              | +440<br>+210 | +265<br>+125 | +119<br>+62 | +151<br>+62 | +75<br>+18 | -         | +36<br>0 | +57<br>0 | +89<br>0 | +140<br>0 | +230<br>0 | +360<br>0 | +570<br>0 |
| 355 ≥ 400 (15.748")              |              |              |             |             |            |           |          |          |          |           |           |           |           |

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## ISO tűréstáblázat

| ISO tűrések furatokhoz (mm) (µm) |              |              |             |             |            |           |           |           |           |            |             |            |
|----------------------------------|--------------|--------------|-------------|-------------|------------|-----------|-----------|-----------|-----------|------------|-------------|------------|
| Furat Ø mm (inch)                | H13          | JS7          | JS9         | K6          | K7         | M6        | M7        | N7        | N9        | P7         | P9          | R7         |
| ≤ 3 (0.118")                     | +140<br>0    | +/-5         | +/-12,5     | 0<br>-6     | 0<br>-10   | -2<br>-8  | -2<br>-12 | -4<br>-14 | -4<br>-29 | -6<br>-16  | -6<br>-31   | -10<br>-20 |
| 3 ≥ 6 (0.236")                   | +180<br>0    | +/-6         | +/-15       | +2<br>-6    | +3<br>-9   | -1<br>-9  | 0<br>-12  | -4<br>-16 | 0<br>-30  | -8<br>-20  | -12<br>-42  | -11<br>-23 |
| 6 ≥ 10 (0.394")                  | +220<br>0    | +/-7,5       | +/-18       | +2<br>-7    | +5<br>-10  | -3<br>-12 | 0<br>-15  | -4<br>-19 | 0<br>-36  | -9<br>-24  | -15<br>-51  | -13<br>-28 |
| 10 ≥ 18 (0.708")                 | +270<br>0    | +/-9         | +/-21,5     | +2<br>-9    | +6<br>-12  | -4<br>-15 | 0<br>-18  | -5<br>-23 | 0<br>-43  | -11<br>-29 | -18<br>-61  | -16<br>-34 |
| 18 ≥ 30 (1.181")                 | +330<br>0    | +/-10,5      | +/-26       | +2<br>-11   | +6<br>-15  | -4<br>-17 | 0<br>-21  | -7<br>-28 | 0<br>-52  | -14<br>-35 | -22<br>-74  | -20<br>-41 |
| 30 ≥ 50 (1.969")                 | +390<br>0    | +/-12,5      | +/-31       | +3<br>-13   | +7<br>-18  | -4<br>-20 | 0<br>-25  | -8<br>-33 | 0<br>-62  | -17<br>-42 | -26<br>-88  | -25<br>-50 |
| 50 ≥ 65 (2.559")                 | +460<br>0    | +/-15        | +/-37       | +4<br>-15   | +9<br>-21  | -5<br>-24 | 0<br>-30  | -9<br>-39 | 0<br>-74  | -21<br>-51 | -32<br>-106 | -30<br>-62 |
| 65 ≥ 80 (3.150")                 |              |              |             |             |            |           |           |           |           |            |             |            |
| 80 ≥ 100 (3.937")                | +260<br>+120 | +159<br>+72  | +71<br>+36  | +90<br>+36  | +47<br>+12 | -         | +22<br>0  | +35<br>0  | +54<br>0  | +87<br>0   | +140<br>0   | +350<br>0  |
| 100 ≥ 120 (4.724")               |              |              |             |             |            |           |           |           |           |            |             |            |
| 120 ≥ 140 (5.512")               | +305<br>+145 | +185<br>+85  | +83<br>+43  | +106<br>+43 | +54<br>+14 | -         | +25<br>0  | +40<br>0  | +63<br>0  | +100<br>0  | +160<br>0   | +400<br>0  |
| 140 ≥ 160 (6.299")               |              |              |             |             |            |           |           |           |           |            |             |            |
| 160 ≥ 180 (7.087")               |              |              |             |             |            |           |           |           |           |            |             |            |
| 180 ≥ 200 (7.874")               | +355<br>+170 | +215<br>+110 | +96<br>+50  | +122<br>+50 | +61<br>+15 | -         | +29<br>0  | +46<br>0  | +72<br>0  | +115<br>0  | +185<br>0   | +460<br>0  |
| 200 ≥ 225 (8.858")               |              |              |             |             |            |           |           |           |           |            |             |            |
| 225 ≥ 250 (9.843")               |              |              |             |             |            |           |           |           |           |            |             |            |
| 250 ≥ 280 (11.0236")             | +400<br>+190 | +240<br>+110 | +108<br>+56 | +137<br>+56 | +69<br>+17 | -         | +32<br>0  | +52<br>0  | +81<br>0  | +130<br>0  | 210<br>0    | +520<br>0  |
| 280 ≥ 315 (12.402")              |              |              |             |             |            |           |           |           |           |            |             |            |
| 315 ≥ 355 (13.976")              | +440<br>+210 | +265<br>+125 | +119<br>+62 | +151<br>+62 | +75<br>+18 | -         | +36<br>0  | +57<br>0  | +89<br>0  | +140<br>0  | +230<br>0   | +570<br>0  |
| 355 ≥ 400 (15.748")              |              |              |             |             |            |           |           |           |           |            |             |            |

Bevezetés

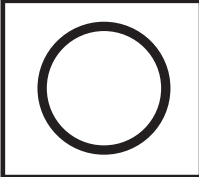
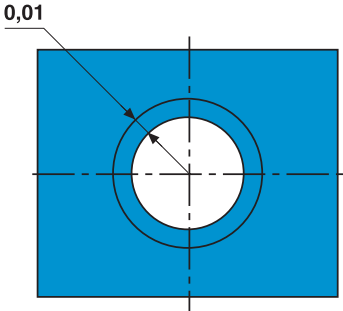

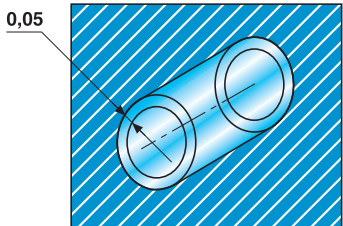

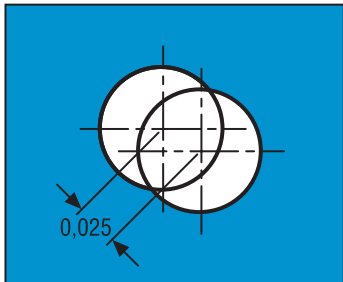
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## Geometriai tűrés

|                      | Rajz szimbólum   | Tűrésterület         |   |
|----------------------|--|----------------------|---|
| Körköröség           |  <table border="1" data-bbox="807 584 1010 759"> <tr> <td>0,01 mm<br/>(0.0004")</td> </tr> </table>     | 0,01 mm<br>(0.0004") |    |
| 0,01 mm<br>(0.0004") |  |                      |   |
| Hengeresség          |  <table border="1" data-bbox="807 999 1010 1173"> <tr> <td>0,05 mm<br/>(0.0020")</td> </tr> </table>   | 0,05 mm<br>(0.0020") |   |
| 0,05 mm<br>(0.0020") |  |                      |   |
| Egytengelyűség       |  <table border="1" data-bbox="807 1429 1010 1603"> <tr> <td>0,05 mm<br/>(0.0020")</td> </tr> </table> | 0,05 mm<br>(0.0020") |  |
| 0,05 mm<br>(0.0020") |  |                      |   |

## Acélok, ferrites és martenzites korrózióálló acélok.

| SMG | Megnevezés   | Tulajdonságok      | Jellemző   | $k_{c1.1}$ | $m_c$ |
|-----|--|--------------------|--|------------|-------|
| P1  | Könnyen forgácsolható acélok.  | $360 < R_m < 880$  | 11 SMn30<br>$R_m = 385 \text{ N/mm}^2$           | 1500       | 0,14  |
| P2  | Gyengén ötvözött ferrites acélok, $C < 0.25\% \text{ wt}$<br>Gyengén ötvözött hegeszthető általános szerkezeti acélok          | $320 < R_m < 600$  | S235JRG2<br>$R_m = 420 \text{ N/mm}^2$           | 1600       | 0,23  |
| P3  | Ferrites & ferrites/perlites acélok, $C < 0.25\% \text{ wt}$<br>Hegeszthető általános szerkezeti acélok<br>Betét edzett acélok | $430 < R_m < 610$  | 16 MnCr 5<br>$R_m = 550 \text{ N/mm}^2$          | 1800       | 0,14  |
| P4  | Gyengén ötvözött szerkezeti acélok, $0.25\% < C < 0.67\% \text{ wt}$<br>Gyengén ötvözött edzett & temperált acélok             | $520 < R_m < 1200$ | C 45E<br>$R_m = 660 \text{ N/mm}^2$              | 2000       | 0,15  |
| P5  | Szerkezeti acélok, $0.25\% < C < 0.67\% \text{ wt}$<br>edzett & temperált acélok   | $550 < R_m < 1200$ | 42 CrMo 4<br>$R_m = 700 \text{ N/mm}^2$          | 2020       | 0,18  |
| P6  | Gyengén ötvözött átédzett acélok, $C > 0.67\% \text{ wt}$<br>Gyengén ötvözött rugó és csapágy acélok                           | $520 < R_m < 1200$ | C 100S<br>$R_m = 600 \text{ N/mm}^2$             | 2100       | 0,17  |
| P7  | Átédzett acélok, $C > 0.67\% \text{ wt}$<br>Rugó és csapágy acélok   | $600 < R_m < 1200$ | 100 Cr 6<br>$R_m = 650 \text{ N/mm}^2$           | 2160       | 0,17  |
| P8  | Szerszám acélok<br>Gyorsacélok (HSS)   | $600 < R_m < 1200$ | X 40 CrMoV 5 1<br>$R_m = 700 \text{ N/mm}^2$     | 2400       | 0,20  |
| P11 | Ferrites és martenzites korrózióálló acélok.   | $415 < R_m < 1200$ | X 20 Cr 13<br>$R_m = 675 \text{ N/mm}^2$         | 2000       | 0,15  |
| P12 | Martenzites öregített és kiválásra keményedő korrózióálló acélok   | $500 < R_m < 1200$ | X 5 CrNiCuNb 16 4<br>$R_m = 1100 \text{ N/mm}^2$ | 2100       | 0,17  |

## Könnyen forgácsolható, ausztenites és duplex korrózióálló acélok.

| SMG | Megnevezés   | Tulajdonságok | Jellemző           | $k_{c1.1}$ | $m_c$ |
|-----|--|---------------|--------------------|------------|-------|
| M1  | Könnyen forgácsolható ausztenites korrózióálló acélok.           |               | X10 CrNiS 18 9     | 1700       | 0,14  |
| M2  | Gyengén ötvözött ausztenites korrózióálló acélok                 |               | X 5 CrNi 18 10     | 1920       | 0,18  |
| M3  | Közepesen ötvözött ausztenites korrózióálló acélok               |               | X 2 CrNiMo 18 14 3 | 2070       | 0,17  |
| M4  | Erősen ötvözött ausztenites és duplex korrózióálló acélok        |               | X 2 CrNiMoN 22 5 3 | 2230       | 0,16  |
| M5  | Nagyon erősen ötvözött ausztenites és duplex korrózióálló acélok |               | X 2 CrNiMoN 25 7 4 | 2510       | 0,13  |



## Öntöttvasak

| SMG | Megnevezés                                 | Tulajdonságok | Jellemző              | $k_{c1.1}$ | $m_c$ |
|-----|--|---------------|-----------------------|------------|-------|
| K1  | Szürkeöntvények (GCI)                      |               | EN-GJL-250            | 930        | 0,32  |
| K2  | Féreggrafitos öntöttvas (CGI)              |               | EN-GJV-400            | 1000       | 0,35  |
| K3  | Alakítható öntöttvas (MCI)                 |               | EN-GJMB-550-4         | 1050       | 0,37  |
| K4  | Gömbgrafitos öntvények (SGI)               |               | EN-GJS-500-7          | 1160       | 0,37  |
| K5  | Ausztémperált gömbgrafitos öntöttvas (ADI) |               | EN-GJS-1000-5         |            |       |
| K6  | Auszténites lamellás öntöttvasak           |               | EN-GJLA-XNiCuCr15-6-2 |            |       |
| K7  | Auszténites gömbgrafitos öntöttvasak       |               | EN-GJSA-XNiMn23-4     |            |       |

## Színesfémek

| SMG | Megnevezés                         | Tulajdonságok | Jellemző             | $k_{c1.1}$ | $m_c$ |
|-----|------------------------------------|---------------|----------------------|------------|-------|
| N1  | Alumínium ötvözetek, Si < 9%       |               | AW-7075              |            |       |
| N2  | Alumínium ötvözetek, 9% < Si < 16% |               | AC-44200<br>Si = 12% |            |       |
| N3  | Alumínium ötvözetek, Si > 16%      |               | AISI17Cu5            |            |       |
| N11 | Réz ötvözetek                      |               | CW614N               | 740        | 0,26  |

## Szuperötvözetek és titán

| SMG | Megnevezés  | Tulajdonságok | Jellemző    | $k_{c1.1}$ | $m_c$ |
|-----|---|---------------|-------------|------------|-------|
| S1  | Vasalapú szuperötvözetek                            |               | Disalloy    |            |       |
| S2  | Kobalt alapú szuperötvözetek                        |               | Stellite 21 |            |       |
| S3  | Nikkel alapú szuperötvözetek                        |               | Inconel 718 | 2530       | 0,21  |
| S11 | Titán, gyengén ötvözött, ( $\alpha$ )               |               | Ti          |            |       |
| S12 | Titán, közepesen ötvözött, ( $\alpha+\beta$ )       |               | TiAl6V4     | 1500       | 0,24  |
| S13 | Titán, erősen ötvözött, (közel $\beta$ és $\beta$ ) |               | Ti10V2Fe3Al |            |       |

## Edzett anyagok

| SMG | Megnevezés   | Tulajdonságok                | Jellemző   | $k_{c1.1}$ | $m_c$ |
|-----|--|------------------------------|--|------------|-------|
| H3  | Betétt edzett acélok   | 58 < HRC < 62                | 16 MnCr 5<br>60 HRC  | 2070       | 0,14  |
| H5  | Edzett és megeresztett acélok                                      | 38 < HRC < 56                | 42 CrMo 4<br>50 HRC  | 2320       | 0,18  |
| H7  | Edzett & Temperált acélok<br>Csapágy acélok                        | 56 < HRC < 64                | 100 Cr 6<br>60 HRC   | 2480       | 0,17  |
| H8  | Szerszám acélok<br>Gyorsacélok (HSS)                               | 38 < HRC < 64                | X 40 CrMoV 5 1<br>50 HRC                                     | 2750       | 0,20  |
| H11 | Martenzites korrózióálló acélok                                    | 38 < HRC < 50                | X 20 Cr 13<br>45 HRC   | 2300       | 0,15  |
| H12 | Martenzites öregített<br>folyadékban edzett korrózióálló<br>acélok | 1200 < R <sub>m</sub> < 1650 | X 5 CrNiCuNb 16 4 R <sub>m</sub> = 1450<br>N/mm <sup>2</sup> | 2410       | 0,17  |
| H21 | Mangánacélok   | 23 < HRC < 64                | X 120 Mn 12<br>50 HRC  |            |       |
| H31 | Fehérvas öntvény   | 50 < HRC < 64                | EN-GJN-HV600(XCr11)<br>55 HRC                                |            |       |

## Egyéb nehezen megmunkálható anyagok

| SMG | Megnevezés  | Tulajdonságok | Jellemző                                 | $k_{c1.1}$ | $m_c$ |
|-----|---|---------------|--|------------|-------|
| PM1 | Gyengén ötvözött PM anyagok   |               | F-0008 Fe-0.7C                           |            |       |
| PM2 | Közepesen ötvözött PM<br>anyagok  |               | FLC-4608<br>Fe2Cu1.8Ni<br>0.5Mo0.2Mn0.8C |            |       |
| PM3 | Erősen ötvözött PM anyagok<br>Kipufogó szelepelemek anyagok,<br>stb.                                  |               |  |            |       |
| HF1 | Kemény felületű ötvözetek<br>Lánggal vagy plazmával<br>felhordott vas alapú ötvözetek                 |               |  |            |       |
| HF2 | Kemény felületű ötvözetek<br>Lánggal vagy plazmával<br>felhordott kobalt és nikkal alapú<br>ötvözetek |               |  |            |       |
| CC1 | Keményfém   |               | G50                                      |            |       |

## Műanyagok és kompozitok

| SMG | Megnevezés                             | Tulajdonságok | Jellemző                                  | $k_{c1.1}$ | $m_c$ |
|-----|--|---------------|---|------------|-------|
| TS1 | Hőre keményedő polimerek               |               | Karbamid formaldehid (UF)                 |            |       |
| TS2 | Hőre keményedő szénzálal kompozitok    |               | T300 T700 T800 HTA-S IMA - Epoxy (M21)... |            |       |
| TS3 | Hőre keményedő üvegszálal kompozitok   |               | Epoxy - HX..(42..)E üveg (7781...)...     |            |       |
| TS4 | Hőre keményedő kevlárszálal kompozitok |               | Kevlar 49                                 |            |       |
| TP1 | Hőre lágyuló polimerek                 |               | Polycarbonate (PC)                        |            |       |
| TP2 | Hőre lágyuló szénzálal kompozitok      |               | PPS/PEEK - T300..                         |            |       |
| TP3 | Hőre lágyuló üvegszálal kompozitok     |               | PPS/PEEK - E üveg vagy A üveg...          |            |       |
| TP4 | Hőre lágyuló kevlárszálal kompozitok   |               |   |            |       |

## Grafit

| SMG | Megnevezés | Tulajdonságok | Jellemző | $k_{c1.1}$ | $m_c$ |
|-----|------------|---------------|----------|------------|-------|
| GR1 | Grafit     |               | R 8500   |            |       |

SMG

| SMG            | EN            | EN-Nr  | W.-Nr        | DIN            | AFNOR           | BS              | UNI              | JIS             | SS        | UNS    |
|----------------|---------------|--------|--------------|----------------|-----------------|-----------------|------------------|-----------------|-----------|--------|
| P1             | 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     |                 |           |        |
|                | 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         | 34 C 10, XC 10 | 045 M 10        | C 10            | S 10 C           |                 |           | G10100 |
|                |               | 1.0401 | C 15         | 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      |                  |                 | 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        |                 |           |        |
| P3             | 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      |                 |           |        |
|                | 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    |        |
| P4             | 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 |
|                |               |        | 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 |
| P5             |               |        | 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        |                 |           | T51620 |
|                |               |        | 1.2542       | 45 WCrV 7      |                 | BS 1            | 45 WCrV 8 KU     |                 | 2710      | T41901 |
|                |               |        | 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 |
|                | 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    |        |
| 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             |                 |           |        |

Bevezetés

Fűrés

Dörzsárazás

Késztergálás

Melléklet

## SMG

| U.N.E./ I.H.A. | AISI / ASTM         | GOST     | ČSN    | Vegyes Márkák | Állapot            | Szuktúra |
|----------------|---------------------|----------|--------|---------------|--------------------|----------|
|                | 1213                |          |        |               | lágyított          |          |
|                | 12 L 13             |          |        |               | lágyított          |          |
|                | 1108                |          |        |               | lágyított          |          |
|                | 11 L 08             |          |        |               | lágyított          |          |
|                |                     |          |        |               | lágyított          |          |
|                | 1140                | 40       |        |               | lágyított          |          |
|                | 1146                |          |        |               | lágyított          |          |
|                | 1215                |          |        |               | lágyított          |          |
|                | 12 L 14             |          |        |               | lágyított          |          |
|                |                     | 16D      |        |               | lágyított          |          |
|                | A573 Grade 58       | 18kp     | 11 378 |               | lágyított          |          |
|                | A573 Grade 70       | St14kP   | 11 448 |               | lágyított          |          |
|                | 1010                | 10       |        |               | lágyított          |          |
| F.1110         | 1015                | 15       |        |               | lágyított          |          |
|                | 1020 1023           | 20       | 12 024 |               | lágyított          |          |
|                |                     | 17G1S    | 11 523 |               | lágyított          |          |
| F.1511         | 1015                | 15       |        |               | lágyított          |          |
| F.1120         | 1025                | 25       |        |               | lágyított          |          |
|                |                     |          |        |               | lágyított          |          |
|                | A204 Grade A        |          | 15 020 |               | lágyított          |          |
|                | 4520                |          |        |               | lágyított          |          |
|                | 3310 9314           | 20X2H4A  | 16 420 |               | lágyított          |          |
|                | 4320                |          | 16 220 |               | lágyított          |          |
|                |                     |          |        |               | lágyított          |          |
| F.1516         | 5115                | 12KHN2   | 14 220 |               | lágyított          |          |
|                |                     | 18HG     |        |               | lágyított          |          |
|                | 5120                | 20KH     | 14 221 |               | lágyított          |          |
|                | 5120 H              | 20KH     |        |               | lágyított          |          |
|                | A182-F11, A182-F12  | 12KHM    | 15 121 |               | lágyított          |          |
|                | A387 Grade 12 Cl. 2 |          |        |               | lágyított          |          |
| F.155          | A182-F22            | 12KH8    | 15 313 |               | lágyított          |          |
| F.1130         | 1035                | 35       | 12 040 |               | lágyított          |          |
| F.5110         | 1045                | 45       | 12 050 |               | lágyított          |          |
|                | 1040                | 40       | 12 041 |               | lágyított          |          |
| F.1150         | 1055                | 55       |        |               | lágyított          |          |
|                | 1060                | 60       | 12 061 |               | lágyított          |          |
|                | 1039                | 40G      |        |               | lágyított          |          |
|                | 1330                | 30G2     |        |               | lágyított          |          |
| F.1135         | 1035                | 35       |        |               | lágyított          |          |
| F.1140         | 1045                | 45       | 12 050 |               | lágyított          |          |
| F.1150         | 1064                | 60       |        |               | lágyított          |          |
|                | 1060                | 60       |        |               | lágyított          |          |
| F.144          | 9255                | 55S2     |        |               | lágyított          |          |
| F.1250         | 4135                | 35KHM    |        |               | lágyított          |          |
| F.5241         | S1                  | 5KHV2S   |        |               | lágyított          |          |
|                | L6                  | 5KHNV    |        |               | lágyított          |          |
|                | 5045                |          |        |               | lágyított          |          |
|                | 3135                |          |        |               | Edzett & Temperált |          |
|                | 3435                |          |        |               | lágyított          |          |
|                | 9840                |          |        |               | Edzett & Temperált |          |
| F.1280         | 4340                | 38H2N2MA | 16 343 |               | lágyított          |          |
|                | 5132                | 35KH     |        |               | Edzett & Temperált |          |
|                | 5140                | 40H      | 14 140 |               | Edzett & Temperált |          |
| F.1251         | 4130                | 20KHM    | 15 130 |               | Edzett & Temperált |          |
| F.1252         | 4142 4140           | 38HM     | 15 142 |               | lágyított          |          |
| F.1252         | 4142 4140           | 38HM     | 15 142 |               | Edzett & Temperált |          |
|                |                     |          |        |               | Edzett & Temperált |          |
| F.143          | 6150                | 50KHFA   | 15 260 |               | Edzett & Temperált |          |
| F.1740         | A355 Cl. A          |          |        |               | lágyított          |          |
| F.5103         | 1070                | 70       |        |               | lágyított          |          |
| F.5117         | 1095                |          |        |               | lágyított          |          |
| F.5118         | W1                  | U10A     |        |               | lágyított          |          |
|                |                     | U10      |        |               | lágyított          |          |
|                | W1                  | U13      |        |               | lágyított          |          |

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 DKCWW 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 WKCW 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 DCWW 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          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | 70 CrMo 15           | 1.4109              | 1.4109   | 65 CrMo 14             | Z 70 D 14                 |           |                     | SUS 440 A          |         |               |        |
|                      | 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          |        |
|                      | 105 CrMo 17          | 1.4125              | 1.4125   | 105 CrMo 17            | Z 100 CD 17               |           | 105 CrMo 17         | SUS 440 C          |         |               |        |
|                      | 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          |        |
|                      | X 18 CrNi 28         | 1.4749              | 1.4749   | X 18 CrNi 28           | Z 18 C 25                 |           |                     |                    |         | 2322          |        |
|                      | 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 CNU Nb 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              | 1.4548   | X 5 CrNiCuNb 17 4      | Z 6 CNU 17.4              |           |                     | SCS 24, SUS 630    |         |               |        |
| 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   |                           |           |                     |                    |         |               |        |
| X 2 NiCoMoTi 18 9 5  |                      | 1.6358              | 1.6358   | X 2 NiCoMoTi 18 9 5    | Z 2 NKD 19-09             |           |                     |                    |         |               |        |
| X 2 NiCoMo 18 9 5    |                      | 1.6358              | 1.6358   | X 2 NiCoMoTi 18 9 5    | Z 2 NKD 19-09             |           |                     |                    |         |               |        |
| X 2 NiCoMo 18 8 5    |                      | 1.6359              | 1.6359   | X 2 NiCoMo 18 8 5      |                           | S 162     |                     |                    |         |               |        |
| 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          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | X 6 CrNiNb 18 10     | 1.4550              | 1.4550   | X 6 CrNiNb 18 10       | Z 6 C NNb 18.10           | 347 S 31  | X 6 CrNiNb 18 11    | SUS 347            |         | 2338          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | 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          |        |
| M2                   | X 9 CrNiSiN 21 11 2  | 1.4835              | 1.4893   | X 9 CrNiSiN 21 11 2    |                           | 310 S 31  |                     |                    |         | 2368          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | X 2 CrNiMoSi 19 5    | 1.4424              | 1.4417   | X 2 CrNiMoSi 19 5      | Z 2 CND 18.05.03          |           |                     |                    |         | 2376          |        |
|                      | 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          |        |
|                      | 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          |        |
|                      | X 5 CrNiCuNb 16 4    | 1.4980              | 1.4943   | X 4 NiCrTi 25 15       | Z 6 NCTDV 25.15           | HR 51     |                     |                    |         | 2570          |        |
|                      | 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          |        |
|                      | X 1 CrNiMoN 25 22 8  | 1.4652              | 1.4652   | X 2 CrNiMoN 25 22 7    |                           |           |                     |                    |         |               |        |
|                      | X 10 NiCrAlTi 32 20  | 1.4876              | 1.4876   | X 10 NiCrAlTi 32 20    | Z 10 NC 32.21             |           |                     |                    | NCF 800 |               |        |
|                      | 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          |        |

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| U.N.E./I.H.A. | AIISI / ASTM | GOST           | ČSN    | Vegyes Márkák             | Állapot            | Sztruktúra           |
|---------------|--------------|----------------|--------|---------------------------|--------------------|----------------------|
| F.520L        | L2           | 11KHF          |        |                           | lágylított         |                      |
| F.5220        | O1           | 9KHVG          |        |                           | lágylított         |                      |
|               | O2           | 9G2F           |        |                           | lágylított         |                      |
| F.5230        | 52100        | SHKH15         | 14 109 |                           | lágylított         |                      |
| F.5212        | D3           | KH12           |        |                           | lágylított         |                      |
|               | H11          | 4KH5MFS        |        |                           | lágylított         |                      |
| F.5318        | H13          | 4KH5MF1S       |        |                           | lágylított         |                      |
| F.5227        | A2           | 9KH5VF         |        |                           | lágylított         |                      |
|               | H10          | 3KH3M3F        |        |                           | lágylított         |                      |
| F.5213        |              | KH12           |        |                           | lágylított         |                      |
|               |              | KH12MF         |        |                           | lágylított         |                      |
| F.520.S       | L6           | 5KHNM          |        |                           | lágylított         |                      |
| F.5613        | M35          | R6M5K5         |        |                           | lágylított         |                      |
|               | M42          | R2AM9K5        |        |                           | lágylított         |                      |
|               | T4           | R18K5F2        |        |                           | lágylított         |                      |
| F.5603        | M2           | R6M5           |        |                           | lágylított         |                      |
|               | M7           |                |        |                           | lágylított         |                      |
|               | T1           | R18            |        |                           | lágylított         |                      |
|               | 403          | 08KH13         |        |                           | lágylított         | Ferrites             |
| F.3401        | 410, CA-15   | 12KH13, 08KH13 |        |                           | lágylított         | Martenzites          |
| F.3113        | 430          | 12KH17         |        |                           | lágylított         | Ferrites             |
| F.5261        | 420          | 20KH13         | 17 022 |                           | lágylított         | Martenzites          |
| F.3404        | 420          | 40KH13         |        |                           | lágylított         | Martenzites          |
|               | 440 A        |                |        |                           | lágylított         | Martenzites          |
|               | 440 B        | 95KH18         |        |                           | lágylított         | Martenzites          |
|               | 440 C        | 95KH18         |        |                           | lágylított         | Martenzites          |
|               | A182 F6NM    |                |        | F6NM                      | lágylított         | Martenzites          |
|               | 446          | 15KH28         |        |                           | lágylított         | Ferrites             |
|               | XM-13        |                |        | PH 13-8 Mo                | Folyadékban edzett | Auszténites          |
|               | XM-12        |                |        | 15-5 PH                   | H1150              | Martenzites          |
|               | XM-12        |                |        | 15-5 PH                   | Folyadékban edzett | Martenzites          |
|               | XM-12        |                |        | 15-5 PH                   | H1025              | Martenzites          |
|               | SAE 630      |                |        | 17-4 PH                   | H1150              | Martenzites          |
|               | 630          |                |        | 17-4 PH                   | Folyadékban edzett | Martenzites          |
|               | 631          | 09KH17N7YU1    |        | 17-7 PH                   | Folyadékban edzett | Auszténites/Ferrites |
|               | AMS 6515     |                |        | Marage 350                | Folyadékban edzett | Martenzites          |
|               | AMS 6521     |                |        | Marage 300                | Folyadékban edzett | Martenzites          |
|               | AMS 6514     |                |        | Marage 300, Vascomax C300 | Folyadékban edzett | Martenzites          |
|               | AMS 6512     |                |        | Marage 250                | Folyadékban edzett | Martenzites          |
|               | AMS 6512     |                |        | Marage 250, Vascomax C250 | Folyadékban edzett | Martenzites          |
| F.3508        | 303          | 12KH19N9       |        |                           | lágylított         | Auszténites          |
| F.3504        | 304 L        | 03KH18N11      |        |                           | lágylított         | Auszténites          |
| F.3504        | 304          | 08KH18N10      | 17 240 |                           | lágylított         | Auszténites          |
| F.3534        | 316          | 08KH17H13M2T   | 17 346 |                           | lágylított         | Auszténites          |
| F.3524        | 347          | 08KH18N12B     |        |                           | lágylított         | Auszténites          |
| F.3517        | 301          | 07KH16N6       |        |                           | lágylított         | Auszténites          |
|               | 302          | 12KH18N9       |        |                           | lágylított         | Auszténites          |
| F.3533        | (316 L)      | 03KH17N14M3    | 17 349 |                           | lágylított         | Auszténites          |
|               | 316 LN       | 03KH16N15M3    |        |                           | lágylított         | Auszténites          |
| F.3541        | 304 LN       | 03KH18N11      |        |                           | lágylított         | Auszténites          |
|               | 317          | 08KH17H15M3T   |        |                           | lágylított         | Auszténites          |
|               |              |                |        | 253 MA                    | lágylított         | Auszténites          |
|               | 310 S        | 12KH25N20      |        |                           | lágylított         | Auszténites          |
|               | 329 LN       |                |        | SAF 2205                  | lágylított         | Duplex               |
|               |              |                |        | 3RE60                     | lágylított         | Duplex               |
|               | 904L         |                |        |                           | lágylított         | Szuper auszténites   |
|               | 329          |                |        |                           | lágylított         | Duplex               |
|               | 660          |                |        | A286                      | Folyadékban edzett | Auszténites          |
|               |              |                |        | 254 SMO                   | lágylított         | Szuper auszténites   |
|               |              |                |        | 654 SMO                   | lágylított         | Szuper auszténites   |
|               |              |                |        | Alloy 800                 | lágylított         | Auszténites          |
|               | F 53         |                |        | SAF 2507                  | lágylított         | Szuper duplex        |

SMG

| SMG      | EN                     | EN-Nr       | W-Nr          | DIN               | AFNOR            | BS           | UNI       | JIS         | SS       | UNS         |         |
|----------|------------------------|-------------|---------------|-------------------|------------------|--------------|-----------|-------------|----------|-------------|---------|
| K1       | EN-GJL-150             | 0.6150      | 0.6150        | GG-15             | Fl 15 D          | Grade 150    | G15       | FC 150      | 01 15-00 | F11601      |         |
|          | EN-GJL-200             | 0.6200      | 0.6200        | GG-20             | Fl 20 D          | Grade 220    | G20       | FC 200      | 01 20-00 | F12101      |         |
|          | EN-GJL-250             | 0.6250      | 0.6250        | GG-25             | Fl 25 D          | Grade 260    | G25       | FC 250      | 01 25-00 | F12401      |         |
|          | EN-GJL-350             | 0.6350      | 0.6350        | GG-35             | Fl 35 D          | Grade 350    | G35       | FC 350      | 01 35-00 | F13502      |         |
|          | EN-GJL-215             |             |               | GG-220 HB         |                  |              |           |             | 02 19    |             |         |
| K2       | EN-GJV-300             |             |               | GJV-300           |                  |              |           |             |          |             |         |
|          | EN-GJV-350             |             |               | GJV-350           |                  |              |           |             |          |             |         |
|          | EN-GJV-400             |             |               | GJV-400           |                  |              |           |             |          |             |         |
|          | EN-GJV-450             |             |               | GJV-450           |                  |              |           |             |          |             |         |
|          | EN-GJV-500             |             |               | GJV-500           |                  |              |           |             |          |             |         |
| K3       | EN-GJMB-550-4          | 0.8155      |               | GTS-55-04         | P 540/5          | P 540/5      | P 55-04   | PCMP55-04   | 08 54-00 | F24130      |         |
| K4       | EN-GJS-350-22          | 0.7033      | 0.7033        | GGG-35.3          | FGS 370-17       | Grade 350/22 |           | FCD 350-22L | 07 17-15 |             |         |
|          | EN-GJS-400-15          | 0.7040      | 0.7040        | GGG-40            | FGS 400-12       | Grade 420/12 | GS 400-12 | FCD 400-18L | 07 17-02 | F32800      |         |
|          | EN-GJS-400-18          | 0.7043      | 0.7043        | GGG-40.3          | FGS 370-17       | Grade 370/17 | GSO 42/17 |             | 07 17-12 | F32800      |         |
|          | EN-GJS-500-7           | 0.7050      | 0.7050        | GGG-50            | FGS 500-7        | Grade 500/7  | GS 500-7  | FCD 500-7   | 07 27-02 | F33800      |         |
|          | EN-GJS-600-3           | 0.7060      | 0.7060        | GGG-60            | FGS 600-3        | Grade 600/3  | GS 600-3  | FCD 600-3   | 07 32-03 | F34100      |         |
|          | EN-GJS-700-2           | 0.7070      | 0.7070        | GGG-70            | FGS 700-2        | Grade 700/2  | GS 700-2  | FCD 700-2   | 07 37-01 | F34800      |         |
| K5       | EN-GJS-1000-5          |             |               | GJS-1000-5        |                  |              |           |             |          | ADI grade 5 |         |
|          | EN-GJS-1200-2          |             |               | GJS-1200-2        |                  |              |           |             |          | ADI grade 2 |         |
|          | EN-GJS-1400-1          |             |               | GJS-1400-1        |                  |              |           |             |          | ADI grade 3 |         |
|          | EN-GJS-800-8           |             |               | GJS-800-8         |                  |              |           |             |          | ADI grade 4 |         |
|          | EN-GJS-800-8           |             |               | GJS-800-8         |                  |              |           |             |          | ADI grade 1 |         |
| K6       | EN-GJLA-XNiCr 20-2     | 0.6660      | 0.6660        | GGL-NiCr 20 2     | FGL Ni20 Cr2     | Grade F2     |           |             | 05 23-00 | F41002      |         |
|          | EN-GJLA-XNiCr 30-3     | 0.6676      | 0.6676        | GGL-NiCr 30 3     | FGL Ni30 Cr3     | Grade F3     |           |             |          | F41004      |         |
|          | EN-GJLA-XNiCuCr 15-6-2 | 0.6655      | 0.6655        | GGL-NiCuCr 15 6 2 | FGL Ni15 Cu6 Cr2 | Grade F1     |           |             |          | F41000      |         |
| K7       | EN-GJSA-XNiMn 13-7     | 0.7652      | 0.7652        | GGG-NiMn 13 7     | FGS Ni13 Mn7     | Grade S6     |           |             | 07 72-00 |             |         |
|          | EN-GJSA-XNiCr 20-2     | 0.7660      | 0.7660        | GGG-NiCr 20 2     | FGS Ni20 Cr2     | Grade S2     |           |             |          | F43000      |         |
|          | EN-GJSA-XNiMn 23-4     | 0.7673      | 0.7673        | GGG-NiMn 23 4     | FGS Ni23 Mn4     | Grade S2M    |           |             |          | F43010      |         |
|          | EN-GJSA-XNiCr 30-3     | 0.7676      | 0.7676        | GGG-NiCr 30 3     | FGS Ni30 Cr3     | Grade S3     |           |             |          | F43003      |         |
|          | EN-GJSA-XNi 35         | 0.7683      | 0.7683        | GGG-Ni 35         | FGS Ni35         |              |           |             |          | F43006      |         |
|          | AW-1050A               | Al99.5      | 3.0255        | Al99.5            | A-5/1050A        | 1B           |           | (A1050)     | 4007     |             | AA1050A |
| AW-2011  | AlCuBiPb               | 3.1655      | AlCuBiPb      | A-U5PbBi/2011     | FC1              |              | A2011     | 4355        |          | AA2011      |         |
| AW-2014  | AlCuSiMn               | 3.1255      | AlCuSiMn      | A-U4SG/2014       | H15              |              |           | 4338        |          | AA2014      |         |
| AW-5005  | AlMg1                  | 3.3315      | AlMg1         | A-G0.6            | N41              |              |           | 4106        |          | AA5005      |         |
| AW-6060  | AlMgSi0.5              | 3.3206      | AlMgSi0.5     | A-GS/6060         | (H9)             |              |           | 4103        |          | AA6060      |         |
| AW-6063  | AlMgSi0.7              | 3.3210      | AlMgSi0.7     | A-GSUC/6061       | (H10)            |              | (A6063)   | 4104 4107   |          | AA6005      |         |
| AW-3103  | AlMn1                  | 3.0515      | AlMn1         |                   | N3               |              |           | 4054        |          | AA3103      |         |
| AW-3003  | AlMn1Cu                | 3.0517      | AlMn1Cu       | A-M1/3003         |                  |              | A3003     |             |          | AA3003      |         |
| AW-7020  | AlZn4.5Mg1             | 3.4335      | AlZn4.5Mg1    | A-Z5G/7020        | H17              |              |           | 4425        |          | AA7020      |         |
| AW-7075  |                        | 3.4365      | AlZnMgCu1.5   | A-Z5GU/7075       | 2L95/2L96        |              |           | A7075       |          | AA7075      |         |
| AC-42000 |                        | 3.2341      | G-AlSi5Mg     | A-S7G             | LM25             | 3599         |           | AC 4C       | 4244     |             |         |
| AC-46200 | AlSi8Cu3(Si)           | 3.2161      | G-AlSi8Cu3    |                   |                  |              |           |             | 4251     | A13800      |         |
| MG-P-63  | MgAl6Zn                | 3.5612      | G-MgAl6Zn     | G-A6-Z1           | MAG-E-121        |              |           |             |          | M11600      |         |
| MG-P-61  | MgAl8Zn                | 3.5812      | G-MgAl8Zn     | (G-A7-Z1)         |                  |              |           |             |          |             |         |
| MN65120  | MgSe3Zn2Zr1            | 3.5103      | G-MgSe3Zn2Zr1 | ZRE1              | MAG6-TE          |              |           |             |          | M12330      |         |
| AC-43400 | AlSi10Mg(Fe)           | 3.2381      | G-AlSi10Mg    | A-S10G            | LM9              |              |           |             | 4253     | A13600      |         |
| AC-44200 | AlSi12                 | 3.2382      | GD-AlSi12     |                   |                  |              |           |             |          |             |         |
| AW-6082  | AlMgSi1                | 3.2315      | AlMgSi1       | A-SGM0.7/6082     | H30              |              |           |             | 4212     | AA6082      |         |
| N3       | AlSi17Cu5              |             |               |                   |                  |              |           | ADC14       |          |             |         |
| N11      | CC331G                 |             | 2.0940.01     | CuAl10Fe          | CuAl10Fe         | AB1          |           |             | 5710     | C95200      |         |
|          | CC333G                 |             | 2.0975.01     | CuAl10Ni          | CuAl10Ni5Fe5     | AB2          |           |             | 5716     | C95500      |         |
|          |                        | CuNi10Fe1Mn | 2.0872        | CuNi10Fe1Mn       | CuNi10Fe1Mn      | CN102        |           |             | 5667     |             | C70600  |
|          |                        |             |               | CuNi10Zn45        |                  |              |           |             |          |             |         |
|          |                        | CW408J      | 2.0790        | CuNi18Zn19Pb      | CuNi18Zn19Pb1    |              |           |             |          |             | C76300  |
|          | CW352H                 |             | 2.1176        | CuPb10Sn          | CuSn10Pb10       | LB2          |           |             | 5640     |             | C93700  |
|          | CC480K                 |             | 2.1050.01     | CuSn10            | CuSn10           | CT1          |           |             | 5443     |             | C90700  |
|          |                        |             | 2.1087        | CuSn10Zn          |                  |              |           |             | 5458     |             | C90500  |
|          | CW452K                 | CuSn6       | 2.1020        | CuSn6             | CuSn6            | PB103        |           | C5191       | 5428     |             | C51900  |
|          | CW502L                 | CuZn15      | 2.0240        | CuZn15            | CuZn15           | CZ102        |           | C2300       | 5112     |             | C23000  |
|          | CW706R                 | CuZn28Sn1   | 2.0470        | CuZn28Sn1         | CuZn29Sn1        |              |           |             | 5220     |             | C44300  |
|          | CW508L                 | CuZn37      | 2.0321        | CuZn37            | CuZn37           | CZ108        |           |             | 5150     |             | C27200  |
|          | CW717R                 | CuZn38Sn1   | 2.0530        | CuZn38Sn1         |                  |              |           |             |          |             | C46400  |
|          | CW614N                 | CuZn39Pb3   | 2.0401        | CuZn39Pb3         | CuZn39Pb3        | CZ121        |           |             | 5170     |             | C38500  |
|          | CW612N                 | CuZn40Pb2   | 2.0402        | CuZn40Pb2         | CuZn39Pb2        | CZ120        |           |             | 5168     |             | C37800  |
|          | CW622N                 | CuZn44Pb2   | 2.0410        | CuZn44Pb2         |                  | CZ104        |           |             | 5272     |             | C68700  |

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|-----|---|--------|--------|----------------------|---------------------------|-----------------|---------------------|-------------|-----------|------------------|
| S1  |   |        |        |                      |                           |                 |                     |             |           |                  |
| S2  |   |        |        |                      |                           |                 |                     |             |           |                  |
| S3  | NiMo30                                    |        | 2.4810 |                      |                           |                 |                     |             |           | N10002           |
|     | NiMo16Cr15W                               |        | 2.4819 |                      |                           |                 |                     |             |           | N10276           |
|     | NiCr19Fe19Nb5Mo3                          |        | 2.4668 |                      |                           |                 |                     |             |           | N07718           |
|     |   |        | 2.4669 |                      |                           |                 |                     |             |           | N07750           |
|     | NiCr20TiAl                                |        | 2.4631 |                      |                           |                 |                     |             |           | N07080           |
|     | NiCr19Co18Mo4Ti3Al3<br>NiCr20Co13Mo4Ti3Al |        | 2.4654 |                      |                           |                 |                     |             |           | N07500<br>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           |
| H7  | 42 CrMo 4                                 | 1.7225 | 1.7225 | 42 CrMo 4            | 42 CD 4                   | 708 M 40        | 42 CrMo 4           | SCM 440 (H) | 2244      | G41400           |
|     | 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           |
|     | 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           |
| H8  | 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 CrMoV 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      |                  |
| H11 | HS 2-10-1-8                               | 1.3247 | 1.3247 | S 2-10-1-8           | Z 110 DKCWV 09-08-        | 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           |
|     | 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           |
|     | 70 CrMo 15                                | 1.4109 | 1.4109 | 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           |
|     | 105 CrMo 17                               | 1.4125 | 1.4125 | 105 CrMo 17          | Z 100 CD 17               |                 | 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 NiCoMo 18 8 5                         | 1.6359 | 1.6359 | X 2 NiCoMo 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           |

Bevezetés

Fúrás

Dörzsárazás

Késztergálás

Melléklet

## SMG

| U.N.E./ I.H.A. | AISI / ASTM       | GOST        | ČSN    | Vegyes Márkák       | Állapot                 | Szuktúra         |
|----------------|-------------------|-------------|--------|---------------------|-------------------------|------------------|
|                |                   |             |        | Discalloy           | Kiválásos keményített   |                  |
|                |                   |             |        | Haynes 25           |                         |                  |
|                |                   |             |        | Stellite 21         |                         |                  |
|                |                   |             |        | Hastelloy C         |                         |                  |
|                |                   | KHN65MV     |        | Hastelloy C-276     |                         |                  |
|                |                   |             |        | IN 100              |                         |                  |
|                |                   |             |        | Inconel 718         |                         |                  |
|                |                   |             |        | Inconel X-750       | Folyadékban edzett      |                  |
|                |                   |             |        | Nimonic 80A         |                         |                  |
|                |                   |             |        | René 41             |                         |                  |
|                |                   |             |        | Udimet 500          |                         |                  |
|                |                   |             |        | Waspalloy           |                         |                  |
|                |                   |             |        | Ti                  | Kereskedelmi tisztaságú | Ti (α)           |
|                | AMS 4919          |             |        | Ti 6-2-4-2          | lágított                | Ti (α)           |
|                | AMS 4943          |             |        | Ti 3Al-2.5V (grd 9) | lágított                | Ti (α+β)         |
|                | AMS 4920, Grade 5 | VT6         |        | Ti 6Al-4V           | lágított                | Ti (α+β)         |
|                | AMS 4986          |             |        | Ti 10V-2Fe-3Al      | lágított                | Ti (β)           |
| F.1516         | 5115              | 12KHN2      | 14 220 |                     | Beítéd edzett           |                  |
| F.5103         | 1070              | 70          |        |                     | Edzett & Temperált      |                  |
| F.5107         | 1078 1080         | 75          |        |                     | Edzett & Temperált      |                  |
| F.5117         | 1095              |             |        |                     | Edzett & Temperált      |                  |
| F.5118         | W1                | U10A        |        |                     | Edzett & Temperált      |                  |
|                | S1                | 5KHV2SF     |        |                     | Edzett & Temperált      |                  |
|                | 5155              |             |        |                     | Edzett & Temperált      |                  |
| F.1252         | 4142 4140         | 38HM        | 15 142 |                     | Edzett & Temperált      |                  |
| F.520L         | L2                | 11KHF       |        |                     | Edzett & Temperált      |                  |
| F.5220         | O1                | 9KHVG       |        |                     | Edzett & Temperált      |                  |
|                | O2                | 9G2F        |        |                     | Edzett & Temperált      |                  |
| F.5230         | 52100             | SHKH15      | 14 109 |                     | Edzett & Temperált      |                  |
| F.5318         | H13               | 4KH5MF1S    |        |                     | Edzett & Temperált      |                  |
| F.5227         | A2                | 9KH5VF      |        |                     | Edzett & Temperált      |                  |
| F.5211         | D2                | KH12MF      |        |                     | Edzett & Temperált      |                  |
| F.5213         |                   | KH12        |        |                     | Edzett & Temperált      |                  |
|                |                   | KH12MF      |        |                     | Edzett & Temperált      |                  |
| F.520.S        | L6                | 5KHNM       |        |                     | Edzett & Temperált      |                  |
| F.5613         | M35               | R6M5K5      |        |                     | Edzett & Temperált      |                  |
|                | M42               | R2AM9K5     |        |                     | Edzett & Temperált      |                  |
|                | T1                | R18         |        |                     | Edzett & Temperált      |                  |
| F.5261         | 420               | 20KH13      | 17 022 |                     | Edzett & Temperált      | Martenzites      |
|                | 440 A             |             |        |                     | Edzett & Temperált      | Martenzites      |
|                | 440 B             | 95KH18      |        |                     | Edzett & Temperált      | Martenzites      |
|                | 440 C             | 95KH18      |        |                     | Edzett & Temperált      | Martenzites      |
|                | XM-12             |             |        | 15-5 PH             | H900                    | Martenzites      |
|                | SAE 630           |             |        | 17-4 PH             | H1025                   | Martenzites      |
|                | SAE 630           |             |        | 17-4 PH             | H900                    | Martenzites      |
|                | AMS 5528          | 09KH17N7YU1 |        | 17-7 PH             | TH1050                  | Martenzites      |
|                | 632               |             |        | PH 15-7 Mo          | TH1050                  | Martenzites      |
|                | 660               |             |        | A286                | Kiválásos keményített   | Auszténites      |
|                | AMS 6512          |             |        | Marage 250          | Kiválásos keményített   | Martenzites      |
|                | AMS 6521          |             |        | Marage 300          | Kiválásos keményített   | Martenzites      |
|                | AMS 6521          |             |        | Marage 300          | Kiválásos keményített   | Martenzites      |
|                | AMS 6515          |             |        | Marage 350          | Kiválásos keményített   | Martenzites      |
|                | A128 Grade A      |             |        | Hadfield            |                         |                  |
|                | A532 IB (NiCr-LC) |             |        | Ni-Hard 2           |                         | Fehérvas öntvény |
|                | A532 IA (NiCr-HC) |             |        | Ni-Hard 1           |                         | Fehérvas öntvény |
|                | A532 ID (Ni-HiCr) |             |        | Ni-Hard 4           |                         | Fehérvas öntvény |

## Keményfém lapkák és szerszámok

A keményfém lapkák és szerszámok a Seco Tools-tól megfelelnek a szükséges követelményeknek. Mindazonáltal a Seco Tools a következő nyilatkozatot teszi. Ezek a termékek megfelelnek mindazon követelményeknek, amit az RoHS, WEEE és ELV előír. (Veszélyes összetevők és elektromos, elektronikus hulladékok kezelése). A termékek nem tartalmaznak higanyt, ólmot, krómot, kadmiumot, CFC, HCFC, égés késleltető vagy oldószereket, melyek meghaladják a szabályban előírtakat.

### Köszörlés:

A száraz vagy nedves köszörlés folyamán keletkezik olyan veszélyes por vagy pára, mely irritálja a bőrt, szemet, orrot, torkot és okozhat tüdő sérülést, betegségeket. Elkerülhető a sérülés megfelelő biztonsági óvintézkedésekkel és védőfelszereléssel.

### Hulladékkezelés:

A Seco Tools vissza fogja vásárolni a használt lapkákat és keményfém szerszámokat újrahasznosításra. A lapkákat és keményfém szerszámokat el kell különíteni az egyéb hulladékoktól (acél, alumínium, réz, stb.). Minden csomagoló anyag újrahasznosítható.

## CBN és PCD-lapkák

A lapkák a Seco Tools-tól megfelelnek a szükséges követelményeknek. Mindazonáltal a Seco Tools a következő nyilatkozatot teszi. Ezek a termékek megfelelnek mindazon követelményeknek, amit az RoHS, WEEE és ELV előír. (Veszélyes összetevők és elektromos, elektronikus hulladékok kezelése). A termékek nem tartalmaznak higanyt, ólmot, krómot, kadmiumot, CFC, HCFC, égés késleltető vagy oldószereket, melyek meghaladják a szabályban előírtakat.

### Köszörlés:

A száraz vagy nedves köszörlés folyamán keletkezik olyan veszélyes por vagy pára, mely irritálja a bőrt, szemet, orrot, torkot és okozhat tüdő sérülést, betegségeket. Elkerülhető a sérülés megfelelő biztonsági óvintézkedésekkel és védőfelszereléssel.

### Hulladékkezelés:

A Seco Tools vissza fogja vásárolni a használt CBN vagy PCD-lapkákat újrahasznosításra. A lapkákat és el kell különíteni az egyéb hulladékoktól (acél, alumínium, réz, stb.). A tömör CBN-lapkák lerakhatók a hulladékgyűjtőben. Minden csomagoló anyag újrahasznosítható.

## Fekete oxidos (barnított) szerszámok

A szerszámok a Seco Tools-tól megfelelnek a szükséges követelményeknek. Mindazonáltal a Seco Tools a következő nyilatkozatot teszi. Ezek a termékek megfelelnek mindazon követelményeknek, amit az RoHS, WEEE és ELV előír. (Veszélyes összetevők és elektromos, elektronikus hulladékok kezelése). A termékek nem tartalmaznak higanyt, ólmot, krómot, kadmiumot, CFC, HCFC, égés késleltető vagy oldószereket, melyek meghaladják a szabályban előírtakat.

### Hulladékkezelés:

A szerszámokat el lehet küldeni újrahasznosításra az általános acél hulladékkal együtt. Minden csomagoló anyag újrahasznosítható.

## Cermet lapkák

A lapkák a Seco Tools-tól megfelelnek a szükséges követelményeknek. Mindazonáltal a Seco Tools a következő nyilatkozatot teszi.

Ezek a termékek megfelelnek mindazon követelményeknek, amit az RoHS, WEEE és ELV előír. (Veszélyes összetevők és elektromos, elektronikus hulladékok kezelése). A C15M cermet minőségű lapkák nikkelt tartalmaznak és a bőrrel való érintkezéskor nikkelt válik ki belőlük. A kiválás mennyisége nagyobb mint az SS-EN 1811 referencia tesztben, ha az érintkezés közvetlenül történik a bőrrel. Ezek a normák vonatkoznak a termékekre, hogy ha közvetlenül és hosszan tartóan érintkezik a bőrrel, de nem közvetlenül a cermet lapkára. Azok a személyek akik tudják, hogy allergiásak a nikkelle, ajánlott a védőkesztyű viselése cermetlapka érintésekor.

### Köszörlés:

A száraz vagy nedves köszörlés folyamán keletkezik olyan veszélyes por vagy pára, mely irritálja a bőrt, szemet, orrot, torkot és okozhat tüdő sérülést, betegségeket. Elkerülhető a sérülés megfelelő biztonsági óvintézkedésekkel és védőfelszereléssel.

### Hulladékkezelés:

Használt lapkákat lehet újrahasznosítani. A lapkákat és el kell különíteni az egyéb fémhulladékoktól (acél, alumínium, réz, stb.), a cementált keményfém lapkákat is beleértve. Minden csomagoló anyag újrahasznosítható.

## Nikkel bevonatos szerszámok

A szerszámok a Seco Tools-tól megfelelnek a szükséges követelményeknek. Mindazonáltal a Seco Tools a következő nyilatkozatot teszi.

Ezek a termékek megfelelnek mindazon követelményeknek, amit az RoHS, WEEE és ELV előír. (Veszélyes összetevők és elektromos, elektronikus hulladékok kezelése). A termékek nem tartalmaznak higanyt, ólmot, krómot, kadmiumot, CFC, HCFC, égés képleltető vagy oldószereket, melyek meghaladják a szabályban előírtakat.

A szerszámok nikkelt tartalmaznak és bőrrel érintkezve nikkelt válik ki azokból. A kiválás mennyisége nem nagyobb mint a SS-EN 1811 referencia tesztben, ha az érintkezés közvetlenül történik a bőrrel.

Ezek a normák vonatkoznak a termékekre, hogy ha közvetlenül és hosszan tartóan érintkeznek a bőrrel, de nem közvetlenül a nikkelt bevonatos szerszámokra. Azok a személyek akik tudják, hogy allergiásak a nikkelle, ajánlott a védőkesztyű viselése cermet lapka érintésekor.

### Hulladékkezelés:

A szerszámokat el lehet küldeni újrahasznosításra az általános acél hulladékkal együtt. Minden csomagoló anyag újrahasznosítható.

## Hozzáadott ötvöző elemek

| Minőség | Keménység |    |    |    |    |    |    |    |   |   |    | Bevonat |    |   |   |   |    |    |
|---------|-----------|----|----|----|----|----|----|----|---|---|----|---------|----|---|---|---|----|----|
|         | 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     | ■         |    |    |    | ■  | ■  |    |    | ■ |   |    | ■       |    | ■ | ■ | ■ |    |    |

Bevezetés

Fűrés

Dörzsárazás

Kiesztérgálás

Melléklet

Seco Tools és a szerkesztők célja ezzel a kiadvánnyal, hogy a fémforgácsolásról és a kapcsolódó területekről általános felvilágosítást és útmutatást nyújtsanak. Amennyiben az egyedi alkalmazásokhoz professzionális szolgáltatások szükségesek, úgy megfelelő szakértői közreműködést kell igénybe venni.

A kiadványban foglalt információk tájékoztató jellegűek. Seco Tools és a szerkesztők kizárnak mindennemű kifejezett és hallgatólagos nyilatkozatot és szavatosságot, ideértve többek között a piacképességre, valamilyen konkrét célra való alkalmasságra, tulajdonra, harmadik fél jogainak tiszteletben tartására vonatkozó szavatosságot. Seco Tools, illetve a kiadvány szerkesztői nem tartoznak felelősséggel az információk felhasználásából eredő közvetlen, közvetett, különleges vagy egyéb következményes károkért, még akkor sem, ha Seco Tools vagy a kiadvány szerkesztői tudomással bírnak az ilyen jellegű károk felmerülésének lehetőségéről.

A közölt információk csak tájékoztató jellegűek. A tényleges árak, leírások, és a termékleírások véglegesítése az eladáskor és a helytől függően változhatnak. A közölt információk változtatás jogát fenntartjuk előzetes értesítés nélkül.

**[WWW.SECOTOOLS.COM](http://WWW.SECOTOOLS.COM)**

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