Seco

Catalog & ghid tehnic

Prelucrarea alezajelor 2026.1



La Seco, realizăm unelte, tehnologii și soluții pentru cele mai avansate provocări de fabricație de pe Pământ. De la înființarea noastră în Fagersta Suedia, până la compania globală de astăzi, afacerea noastră a fost întotdeauna făcută pe măsură și construită pe încredere.

Combinând uneltele de precizie de ultimă oră, de precizie, cu parteneriate personale durabile, suntem o adevărată companie de oameni care îi ajută pe partenerii noștri să descopere viitorul industriei prelucrătoare.

Suntem mândri să creăm pentru creatori, să inventăm pentru inventatori și să fim parteneri cu pionierii. Impulsionăm viitorul cu accentul pe inovație. Pe scurt - dacă există unealta potrivită pentru lucrare, o vom livra. Dacă nu, o vom crea.

Suntem mândri să punem sustenabilitatea în centrul a tot ceea ce facem, să provocăm percepțiile asupra industriei noastre, să schimbăm procesul de fabricație și să jucăm un rol mic în modelarea unui viitor mai luminos.

Made for Makers

Ghid

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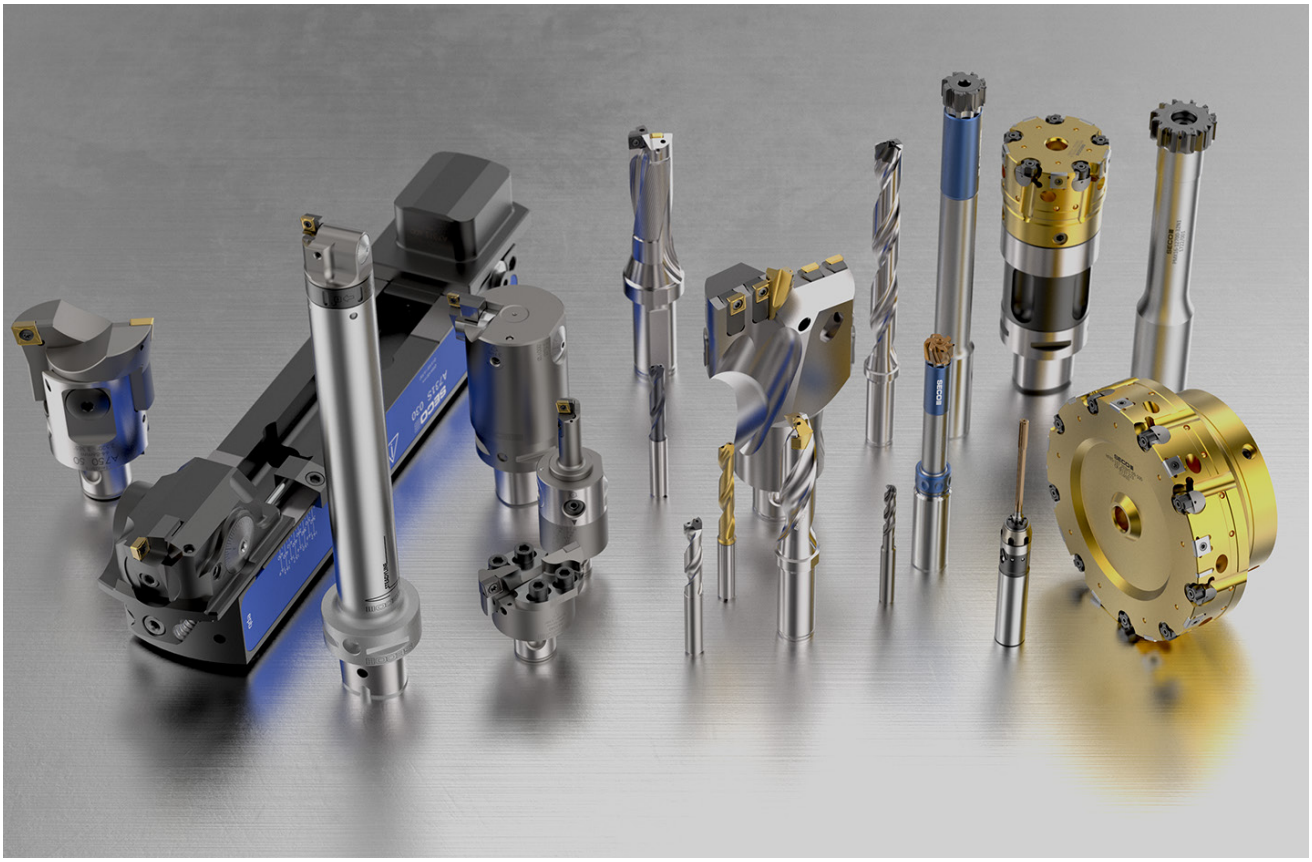
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Depășiţi orice dificultate în realizarea găurilor

Realizarea de găuri poate însemna diferenţa dintre profit sau piese aruncate, iar succesul necesită scule de cea mai înaltă calitate, pentru cel mai mare nivel de îmbunătăţire a productivităţii și oportunităţi de reducere a costurilor. Pentru a obţine acest nivel de succes, producătorii au nevoie de un partener care să poată contribui la stabilirea proceselor și poate testa noi soluţii. Un partener cu capacitatea de a face faţă tuturor provocărilor dumneavoastră unice, cu o gamă cu adevărat cuprinzătoare de scule de găurire, alezare, găurire și filetare.

Seco Tools este furnizorul dumneavoastră se sursă unică pentru soluţii cuprinzătoare de realizare a găurilor. Cu ani de experienţă în dezvoltarea de soluţii de realizare a găurilor pentru aplicaţiile dificile ale clienţilor, avem competenţa în cercetare și dezvoltare și prelucrare prin așchiere pentru a ajuta producătorii să obţină procese complet optime.

Suntem dedicaţi productivităţii clienţilor noștri în realizarea de găuri. Acest lucru înseamnă că puteţi achiziţiona scule, puteţi beneficia de asistenţă tehnică, vă puteţi consulta cu experţi și puteţi dezvolta soluţii cu un singur furnizor și cu acces la cea mai cuprinzătoare gamă de burghie amovibile și solide, alezoare, dispozitive de filetat și capete de alezare din domeniu.



Ce căutaţi la prelucrarea alezajelor?

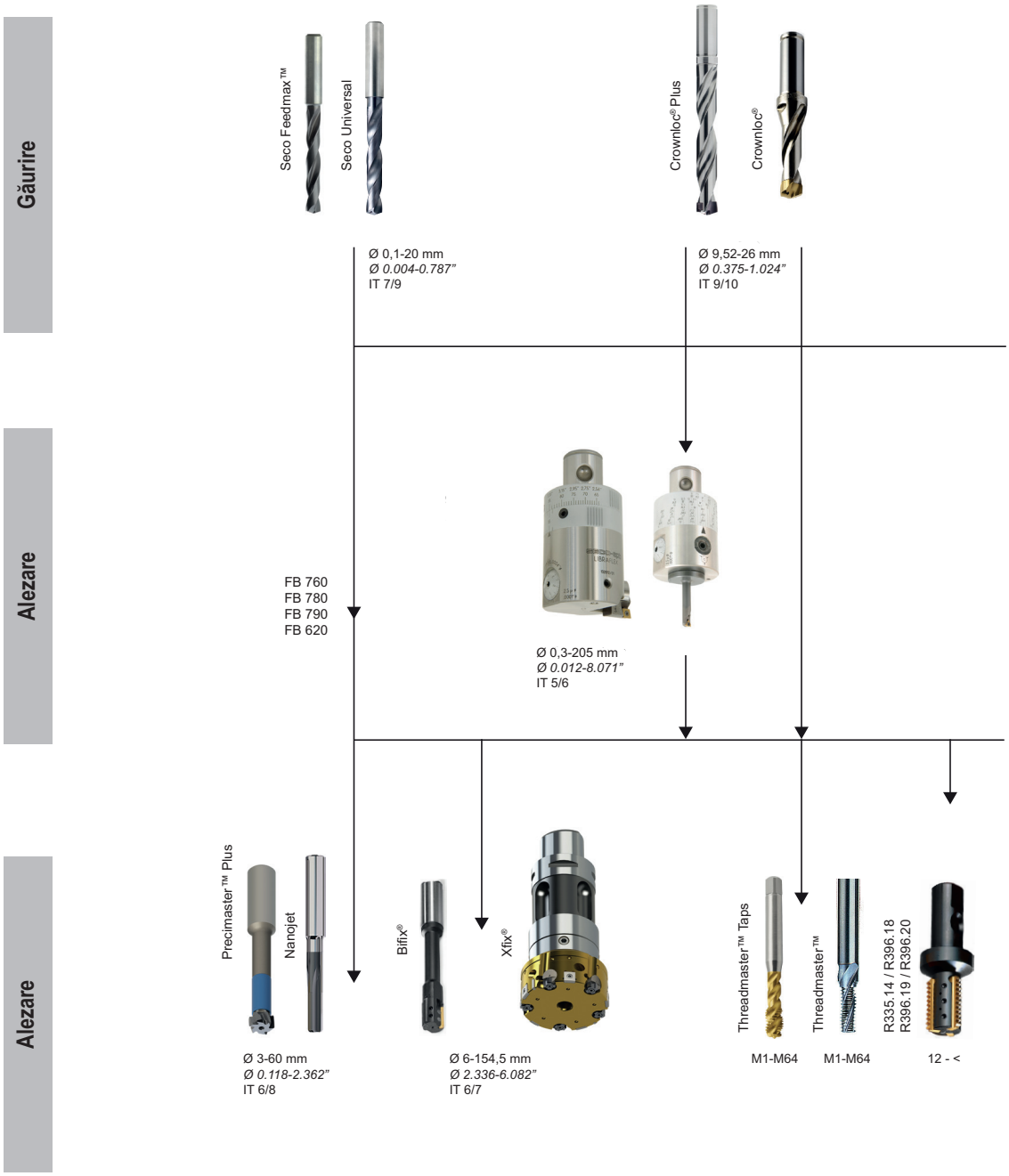
	Găurire			Alezare				Alezare		Filetare			
	Seco Universal Seco Feedmax™	Crownloc® Crownloc® Plus	Perfomax®	Precimaster™ Plus	Nanojet	Bifix®	Xfix™	Alezare de degroşare	Alezare de finisare	Threadmaster™	Tarozi Threadmaster™		Filetare prin frezare 396.18/.19/.20
Pag.	29-166	185-237	238-324	329-366	367-392	393-419	420-459	598-501	502-552	Consultaţi catalogul Filetare			
													
IT	7-9	9-10	12	6-8	6-8	6-7	6-7	9-10	5-6	–	–	–	–
⌖	0,02 mm *(0.0008")*	0,05 mm *(0.002")*	–	După pregăurire	După pregăurire	După pregăurire	După pregăurire	0,005 mm *(0.0002")*	0,005 mm *(0.0002")*	–	După pregăurire	După pregăurire	–
⌀	0,02 mm *(0.0008")*	0,05 mm *(0.002")*	–	0,007 mm *(0.0003")*	0,007 mm *(0.0003")*	0,005 mm *(0.0002")*	0,005 mm *(0.0002")*	0,02 mm *(0.0008")*	0,01 mm *(0.0004")*	–	–	–	–
$\sqrt{R_a}$	1,0 µm *(39 µin)*	1,6 µm *(63 µin)*	2,0 µm *(79 µin)*	0,6 µm *(24 µin)*	0,6 µm *(24 µin)*	0,25 µm *(10 µin)*	0,8 µm *(31 µin)*	1,0 µm *(39 µin)*	0,6 µm *(24 µin)*	–	–	–	–
TCTR	–	–	–	–	–	–	–	–	–	–	6H 6HX 6G 2B Normal	5HX 2BX Normal-X 6HX 6GX	–
Forma filetului	–	–	–	–	–	–	–	–	–	M MF UNC UNF NPT NPTF BSP	M MF UNC UNF G NPT NPTF	M MF UNC UNF G	ISO UN W NPT NPTF BSPT

Ghid pentru scule

Feedmax, Crownloc și Perfomax sunt utilizate pentru a realiza găuri de la 0,1 la 160 mm diametru (0,004-6,299"), cu toleranțe de la IT7 la IT12.
Pentru găurile gata turnate, alezare de degroșare sau semifinisare la diametre mari se pot utiliza barele Bridge și barele Jumbo Bridge.
În final, alezajele de înaltă calitate sunt executate cu alezoare solide sau reglabile, în clasa de toleranță IT5 sau IT6.
* Degroșare IT9/10, ** De precizie IT 5/6

Threadmaster DTM, TM, TM2, 396.18 și 396.19;
Cu aceeași sculă aşchietoare se pot prelucra fileturi pe dreapta și pe stânga. Versiunea Metric și UN sunt doar pentru filetarea interioară. De asemenea, se pot realiza toate tipurile de toleranţe cu aceeași sculă aşchietoare.

Tarod Threadmaster:
Disponibil pentru majoritatea fileturilor și toleranțelor, reliate prin aşchiere sau prin formare.



Alezaje turnate

Perfomax®



SD602





RB 750
RB 610

Ø 15-85 mm
Ø 0.591-3.346”
IT 12

Ø 60-160 mm
Ø 2.362-6.299”
IT 12

Ø 18-205 mm
Ø 0.709-8.071”
IT 9/10

Alezare de degroșare



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

Alezare de finisare





FB 760
FB 780
FB 790
FB 620

Ø 0,3-205 mm
Ø 0.012-8.071”
IT 5/10

Plaja de găurire – Alegerea burghiului

Burghie din carbură solidă Seco Feedmax™



PRODUCTIVITATE
- Viteze de aşchiere şi avansuri mari
- Toleranţă strânsă a găurii
- Pentru aplicaţii cu stabilitate ridicată
- Pentru toate tipurile de semifabricate

Burghie cu coroane interschimbabile Crownloc® şi Crownloc® Plus



FLEXIBILITATE
- Vârfuri din carbură amovibile
- Geometrii optimizate pentru diferite semifabricate.
- Fără reascuţire
- Capete cu diametre diferite pentru fiecare corp de burghiu

Burghie cu plăcuţe amovibile Perfomax®



EFICIENȚA COSTURILOR
- Calităţi şi geometrii optimizate pentru toate tipurile de semifabricate
- Plăcuţe indexabile pătrate pentru un preţ scăzut per alezaj
- Găurire, plonjare, găuri străpunse cu intrare sau ieşire în unghi, alezare, etc.
- Securitate mare a aplicaţiei

Atribute ISO

Atribut ISO	Explicaţie
ADJLN	Limita minimă de reglaj
ADJLX	Limita maximă de reglaj
ADJRG	Plaja de reglare
AN	Degajarea unghiului major
APMX	Adâncime de așchiere maximă
AZ	Adâncimea maximă axială
B	Lăţimea cozii
BD	Diametru corp
BD1	Diametrul corpului 1
BD2	Diametrul corpului 2
BDX	Diametrul maxim al corpului
BHTA	Unghi de înclinaţie jumătatea corpului
BLQ	Codul calităţii echilibrării
BN	Lăţimea feţei
CBDP	Adâncimea alezajului conexiunii
CDX	Adâncime de așchiere maximă
CEDC	Numărul de muchii de așchiere
CHA	Unghiul găurii traversate
CHW	Lăţimea șanfrenului la colţ
CNT	Mărimea filetului la intrarea agentului de răcire
CW	Lăţime de așchiere
CZC	Cod dimensiune de conexiune
D1	Diametrul găurii de fixare
DC	Diametru de așchiere
DCB	Diametrul găurii de conexiune
DCBN	Diametrul minim al alezajului conexiunii
DCBX	Diametrul maxim al alezajului conexiunii
DCB1	Diametrul alezajului conexiunii 1
DCC	Codul configuraţiei designului
DCINN	Diametrul minim de așchiere interior
DCINX	Diametrul maxim de așchiere interior
DCN	Diametru minim de așchiere
DCON	Diametrul conexiunii
DCX	Diametrul maxim de așchiere
DF	Diametrul flanșei
DMM	Diametru coadă
FLGW	Lăţimea flanșei
GAN	Unghiul de degajare al plăcuţei
GB	Unghiul feţei
HTB	Înălţimea corpului
IC	Diametru cerc înscris
INSD	Diametrul plăcuţei
INSL	Lungimea plăcuţei
KRINS	Unghiul major al muchiei de așchiere
L	Lungimea muchiei așchietoare
LB	Lungimea corpului
LB1	Lungimea corpului 1
LCF	Lungimea canelurii
LE	Lungimea efectivă a muchiei așchietoare
LF	Lungimea funcţională
LFS	Lungimea funcţională secundară
LH	Lungime cap

Atribut ISO	Explicaţie
LPR	Lungimea proeminentă
LS	Lungimea cozii
LSC	Lungimea prinderii
LU	Lungime utilizabilă
LUX	Lungimea maximă utilizabilă
M	Dimensiunea-M
OAL	Lungime totală
RE	Rază la vârf
S	Grosimea plăcuţei
TDZ	Mărimea diametrului filetului
WB	Lăţimea corpului
WF	Lăţime funcţională

SMG – Introducere

Ca exemplu, materialele de referinţă EN C45E pentru SMG P4 şi EN 42 CrMo 4 atât pentru SMG P5, cât şi pentru SMG H5, vedeţi detalii suplimentare în tabelele următoare.
Clasificarea SMG a materialelor de piesă de prelucrat implică un anumit standard de material într-o anumită stare alocat ca referinţă, pentru a permite reglarea uşoară şi clară a regimurilor de frezare pentru orice material efectiv în comparaţie cu orice material de referinţă Seco. Ca exemple, materialele de referinţă EN C45E pentru SMG P4 şi EN 42 CrMo 4 atât pentru SMG P5, cât şi pentru SMG H5, indicate mai jos în tabelul 1 unde este indicată proprietatea materialului la nivel de referinţă.

Baza pentru SMG este o clasificare a materialelor de piesă de prelucrat în funcţie de tipul lor, mai degrabă decât prelucrabilitatea lor şi, în consecinţă, conţine materiale de piesă de prelucrat cum ar fi compozitele. Este suficient de cuprinzător, dar totuşi uşor de identificat cărui SMG îi aparţine un anumit material.
Fiecare SMG are un anumit standard de material într-o anumită stare alocat ca referinţă, pentru a permite reglarea uşoară regimurilor de frezare pentru orice material efectiv în comparaţie cu orice material de referinţă Seco, consultaţi paginile 658-669.

SMG	Descriere	Proprietăţi	Referinţă
P4	Oţeluri structurale slab aliate, 0,25% < C < 0,67% wt Oţeluri slab aliate călite şi temperate	520 < R_m < 1200	C 45E R_m = 660 N/mm^2
P5	Oţeluri structurale, 0,25% < C < 0,67% wt Oţeluri călite şi temperate	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm^2

SMG	Descriere	Proprietăţi	Referinţă
H5	Oţeluri călite	38 < HRC < 56	42 CrMo 4 50 HRC

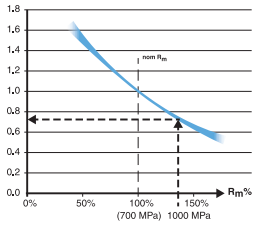
Concentrându-ne special pe EN 42 CrMo 4 în stare recoaptă, rezistenţa la tracţiune finală R_m poate varia, de obicei, între R_m = 630 N/mm^2 şi R_m = 780 N/mm^2, ceea ce oferă un nivel de referinţă pentru SMG P5.

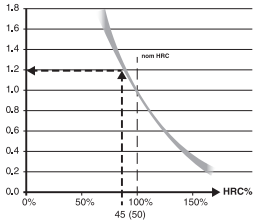
În stare călită şi temperată, rezistenţa la tracţiune finală Rm poate fi, de obicei, între R_m = 900 N/mm^2 şi R_m = 1100 N/mm^2, aşadar ţine tot de SMG P5. Totuşi, dacă este călită peste R_m = 1200 N/mm^2, ţine atunci de SMG H5.

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

Oţelul călit şi temperat EN 42CrMo4 ar putea fi utilizat pentru a ilustra dependenţa de prelucrabilitate a stării materialelor.

Graficele de mai jos indică modul în care pot fi reglate recomandările de viteză pentru condiţii de material nominale pentru R_m relativ (diagrama din stânga valabilă pentru ISO-P) şi pentru HRC relativ (valabil pentru ISO-H).





Pentru a ilustra în continuare modul în care v_c nominală SMG P5 poate fi reglată la o v_c recomandată mai precisă, avem nevoie de date Rm de rezistenţă la tracţiune finală şi în acest caz utilizăm EN 42 CrMo 4 călit şi temperat la R_m = 1000 N/mm2, conform tabelului de mai sus (săgeţi albastre îngroşate). Să presupunem că descoperim v_c nominală SMG P5 = 280 m/min pentru un anumit produs şi o anumită prelucrare.
Atunci, v_c recomandată efectivă = 280 m/min x 0,75 = 210 m/min. În consecinţă, în SMG H5, v_c nominală poate fi reglată utilizând EN 42 CrMo 4 călit la HRC 45 (săgeţile gri mai mici).

Să presupunem că v_c nominală SMG H5 = 50 m/min pentru un anumit produs şi prelucrare utilizând o sculă din carbură cementată acoperită; atunci, v_c recomandată efectivă = 50 m/min x 1,2 = 60 m/min.
Pentru detalii suplimentare privind materialul piesei de prelucrat, consultaţi paginile 658-669 şi regimurile de frezare sugerate la paginile aplicabile.
Pentru gestionarea mai comodă a regimurilor de frezare, vă recomandăm sculele aplicabile în My Pages – Suggest pe www.secotools.com

Soluţii de înaltă performanţă și Universal

Ce urmăriţi la aplicaţia de găurire cu burghiu din carbură?

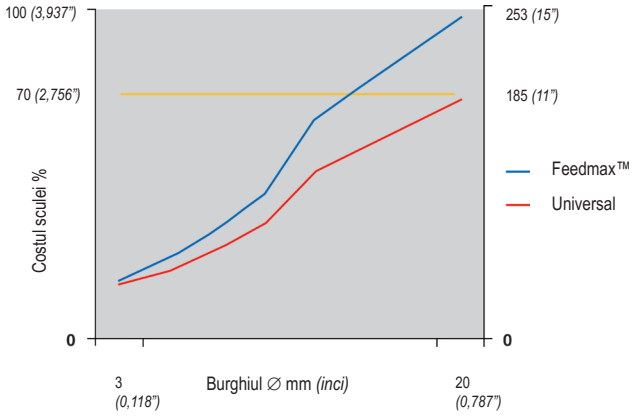
Universal – burghiu de carbură solidă de uz general

Universal este un burghiu din carbură solidă pentru uz general, care poate fi folosit într-o gamă largă de materiale și aplicaţii din toate sectoarele industriale. Datorită designului cu un vârf cu autocentrare de 140 grade, caneluri rectificate și o excelentă calitate a execuţiei burghiului - asigură o utilizare optimă, un maxim de securitate a aplicaţiei și adaptabilitate la un preţ redus. Cu Universal se poate obţine o reducere a costului stocului și o mai mare flexibilitate la prelucrare, ducând astfel la reducerea timpului de reglare. Universal este o alternativă pentru Feedmax™ acolo unde obiectivele principale sunt reducerea costului stocului și flexibilitatea.

Feedmax™ – burghiu din carbură solidă productiv de înaltă performanţă

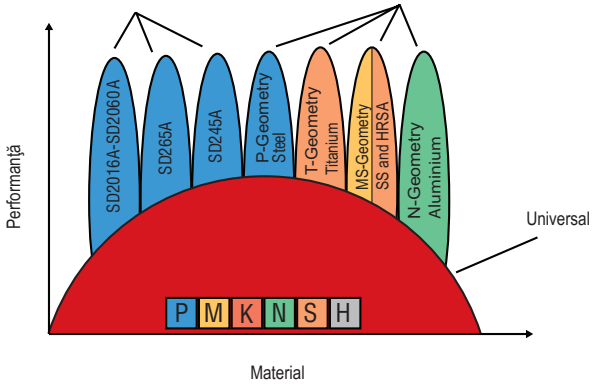
Feedmax™ oferă o combinaţie unică de tehnologii de carbură, acoperire și geometrie de ultimă oră.
Feedmax™ este conceput pentru productivitate ridicată și cost scăzut per gaură, cu avansuri mari de până la 0,70 mm/rot *(0,028 in/rot)* si viteze de aşchiere mari de până la 220 m/min *(720 sf/min)*. Cu capabilităţi excelente de centrare, se obţine o calitate ridicată a găurii fără a fi necesare operaţiuni de găurire centrală. Datorită acoperirii moderne cu o rezistenţă mare la căldură, a muchiilor de aşchiere protejate, a durităţii mari a barei de carbură, a capabilităţii excelente de evacuare a aşchiilor precum și a calităţii muchiei de aşchiere - se obţine o durată de viaţă lungă și predictibilă.
Feedmax™ are o gamă largă de geometrii optimizate pentru diferite materiale și aplicaţii, pentru a obţine o gaură de calitate bună, la cel mai scăzut preţ.

MRR, rata de evacuare
a metalului (cm^3/min)

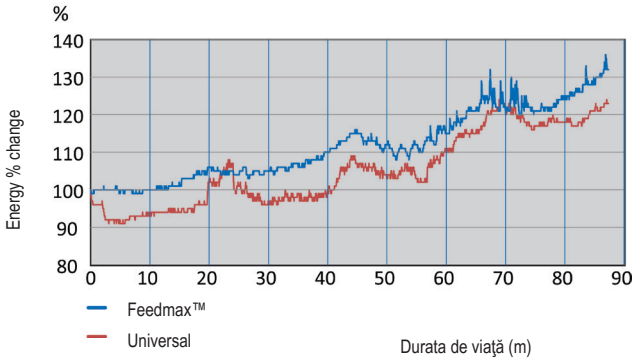


Feedmax™
Geometrii
optimizate pentru aplicaţie

Feedmax™
Geometrii
optimizate pentru material



Durata de viaţă, parametri de aşchiere reduși

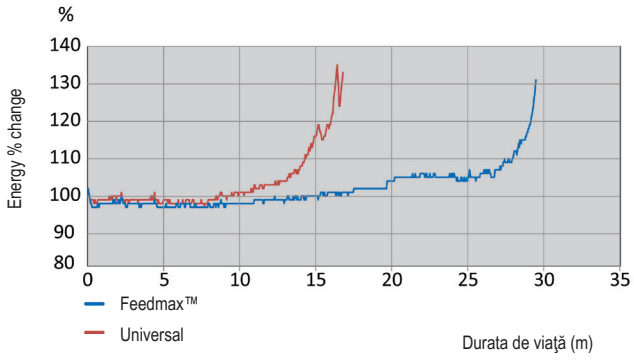


Prima gaură este setată ca referinţă, 100% bazată pe puterea capului de alezare
Regim de frezare
v_c = 90 m/min
f = 0,15 mm/rot

v_c = 295 sf/min
f = 0,006 in/rot

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

Durata de viaţă, parametri de aşchiere ridicaţi

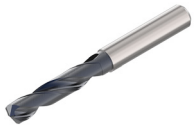
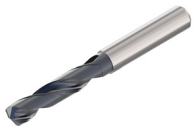
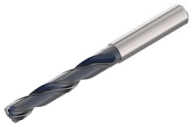


Prima gaură este setată ca referinţă, 100% bazată pe puterea capului de alezare
Regim de frezare
v_c = 160 m/min
f = 0,24 mm/rot

v_c = 525 sf/min
f = 0,009 in/rot

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

Privire generală

Universal & Feedmax™	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD1103 	Pag. 30, 31, 32, 33, 34	Ø 3-20 mm *(0.118-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD1103A 	Pag. 35, 36, 37, 38, 39	Ø 3-20 mm *(0.118-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD1105A 	Pag. 40, 41, 42, 43, 44, 45	Ø 3-20 mm *(0.118-0.787")*	~ 5 x D	m7	IT 8-9	Ra 1-3 µm *(Ra 39-118 µin)*
SD1108A 	Pag. 46, 47, 48, 49	Ø 3-20 mm *(0.118-0.787")*	~ 8 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD1112A 	Pag. 50, 51, 52	Ø 3-20 mm *(0.118-0.787")*	~ 12 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD203A-P 	Pag. 54, 55, 56, 57, 58, 59	Ø 2-20 mm *(0.078-0.787")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-P 	Pag. 60, 61, 62, 63, 64, 65, 66	Ø 2-20 mm *(0.078-0.787")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD206, SD206A 	Pag. 67, 68	Ø 0,7-2,0 mm *(0.027-0.078")*	~ 6 x D	h6	IT 9	Ra 1-2 µm *(Ra 39-79 µin)*
SD207A-P 	Pag. 69, 70, 71	Ø 3-20 mm *(0.118-0.787")*	~ 7 x D	m7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*

1) pot apărea variaţii în funcţie de material şi de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire și materialul pot provoca deteriorarea finisajului suprafeței.

Privire generală

Feedmax™	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD2016A 	Pag. 72	Ø 3-12 mm *(0.118-0.472")*	~ 16 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2020A 	Pag. 73	Ø 3-10 mm *(0.118-0.393")*	~ 20 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2025A 	Pag. 74	Ø 3-10 mm *(0.118-0.393")*	~ 25 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2030A 	Pag. 75	Ø 3-10 mm *(0.118-0.393")*	~ 30 x D	h7	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2040A 	Pag. 76	Ø 3-8 mm *(0.118-0.315")*	~ 40 x D	e8	IT 9-10	Ra 1-3 µm *(Ra 39-118 µin)*
SD2050A 	Pag. 77	Ø 3-6,35 mm *(0.118-0.250")*	~ 50 x D	e8	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*
SD2060A 	Pag. 78	Ø 3-5 mm *(0.118-0.197")*	~ 60 x D	e8	IT 9	Ra 1-3 µm *(Ra 39-118 µin)*

1) pot apărea variaţii în funcţie de material și de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire și materialul pot provoca deteriorarea finisajului suprafeţei.

Privire generală

Feedmax™	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD245A 	Pag. 79-80, 81	Ø 5-14 mm *(0.196-0.551")*	~ 5 x D	m7	IT 8	Ra 1-2 µm *(Ra 39-79 µin)*
SD265A 	Pag. 83	Ø 6-16 mm *(0.236-0.630")*	~ 5 x D	js6	IT 7	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-MS Superaliaje 	Pag. 90, 91, 92, 93	Ø 2-20 mm *(0.079-0.551")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-MS Superaliaje 	Pag. 94, 95, 96, 97	Ø 2-20 mm *(0.079-0.551")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-M 	Pag. 98, 99, 100	Ø 3-14,25 mm *(0.118-0.561")*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD205A-M 	Pag. 101, 102, 103	Ø 2,5-16 mm *(0.098-0.630")*	~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-T, SD205A-T 	Pag. 104, 105	Ø 4,73-12 mm *(0.188-0.472")*	~ 3 x D, ~ 5 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*
SD203A-N 	Pag. 106, 107	Ø 2,5-14 mm *(0.098-0.551)*	~ 3 x D	m7	IT 8-9	Ra 1-2 µm *(Ra 39-79 µin)*

1) pot apărea variaţii în funcţie de material şi de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire și materialul pot provoca deteriorarea finisajului suprafeței.

Privire generală

Feedmax™	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD205A-C1, -C2 	Pag. 111-112	Ø 6-9,55 mm *(0.236-0.376")*	~ 5 x D	m7	IT 9	–
SD203-CX1 	Pag. 113	Ø 3,26-9,53 mm *(0.128-0.375")*	~ 5 x D	m7	IT 9	–
SD22 	Pag. 115, 116, 117, 118, 119, 120	Ø 0,1-2,0 mm *(0.004-0.079")*	~ 2 x D	0,005/0 mm (+0.0002"/0)	–	–
SD26 	Pag. 121, 122, 123, 124, 125, 126	Ø 0,1-2,0 mm *(0.004-0.079")*	~ 6 x D	0/-0,004 mm (0/-0.00016")	–	–

1) pot apărea variaţii în funcţie de material şi de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire şi materialul pot provoca deteriorarea finisajului suprafeţei.

Codificări

Universal

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

1.
Tip de burghiu - Burghiu din carbură solidă:
SD1103: ~3 x D
SD1105: ~5 x D
SD1108: ~8 x D
SD1112: ~12 x D

2.
Agent de răcire intern

3.
Diametru burghiu

4.
Adâncimea de găurire

5.
Diametru coadă

6.
Sens de rotaţie spre dreapta

7.
Tip de coadă
1. Cilindrică

Feedmax™

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



1.
Tip de burghiu - Burghiu din carbură solidă:
SD203: ~3 x D
SD205: ~5 x D
SD207: ~7 x D
SD2040: ~40 x D
SD2050: ~50 x D
SD2060: ~60 x D

2.
Agent de răcire intern

3.
Diametru burghiu

4.
Adâncimea de găurire

5.
Diametru coadă

6.
Sens de rotaţie spre dreapta

7.
Tip de coadă
1. Cilindrică

8.
P – geometrie pentru oţel
MS – geometrie pentru superaliaje şi oţel inox

Feedmax™

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

1.
Tip de burghiu - Burghiu din carbură solidă:
SD206: ~6 x D
SD2016A: ~16 x D
SD2020A: ~20 x D
SD2025A: ~25 x D
SD2030A: ~30 x D
SD245: ~5 x D
SD265: ~5 x D
SD22: ~2 x D
SD26: ~6 x D

2.
Agent de răcire intern

3.
Diametru burghiu

4.
Adâncimea de găurire

5.
Diametru coadă

6.
Sens de rotaţie spre dreapta

7.
Tip de coadă
1. Cilindrică
5. Whistle Notch

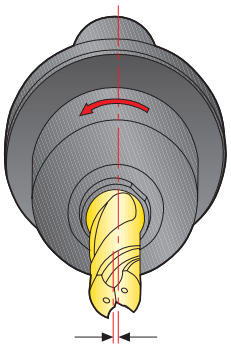
8.
M – geometrie pentru superaliaje
T – geometrie pentru aliaje de titan
N – geometrie pentru aluminiu
C1 – geometrie pentru CFRP și pentru ieșiri in CFRP
C2 – geometrie pentru CFRP și ieșiri în Ti sau Al
CX1 – burghie PCD pentru CFRP și GFRP

Configurare

Prindere/bătaie radială
Burghiele cu coadă cilindrică pot fi folosite împreună cu port-sculele Shrinkfit, mandrinele hidraulice sau mandrinele cu pensete.
Menţineţi bătaia radială indicată totală pentru burghiu sub 0,04 mm (0,0016”) măsurată la capul de alezare.
Pentru cele mai bune rezultate, menţineţi bătaia radială sub 0,02 mm (0,0008”).

Stabilitate
Stabilitatea aplicaţiei este importantă pentru a obţinea cea mai bună durată de viaţă a sculei și precizie a găurii.
Verifică starea arborelui mașinii, fixarea și prinderea componentelor pentru a asigura un maxim de stabilitate și rigiditate.
Condiţiile instabile pot duce la distrugerea sculei.

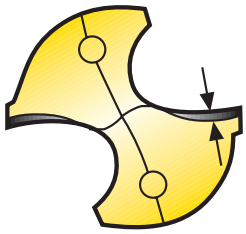
Port-scule recomandate



Pentru cele mai bune rezultate utilizează conurile:
Tip 5603 – port-scule Shrinkfit, tip DIN
Tip 5834/HC/HCR/HCS
Tip 5672 – mandrine cu pensete de înaltă precizie
Pentru mai multe informaţii, consultaţi catalogul de port-scule

Max. 0,02 mm (0.0008”)

Durata de viaţă a sculei
Nu trebuie utilizate burghie care au o uzură a flancului mai mare de 0,1-0,3 mm (0,004-0,012”) măsurată în zona maximă.



0,1-0,3 mm (0,004-0,012”)

Port-sculă Shrinkfit
(doar pentru cozi cilindrice, R1)



Mandrină hidraulică
(doar pentru cozi cilindrice, R1)



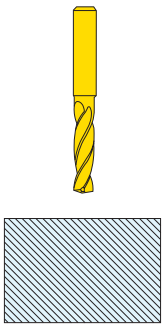
Mandrine cu bucșe elastice de mare precizie
(doar pentru cozi cilindrice, R1)



Metode de prelucrare

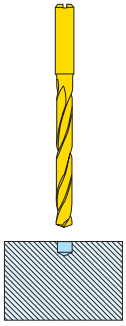
Intrarea la găurirea unei suprafeţe prelucrate

3-15 x D



Nu sunt necesare pregăurirea sau condiţii speciale la intrare.

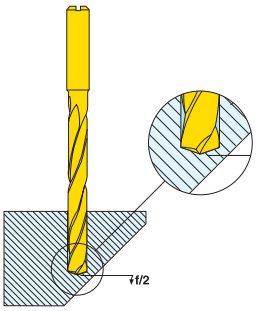
> 16 x D



Atunci când se utilizează un burghiu mai lung este recomandat să se execute o gaură de ghidare.

Ieșiri înclinate din gaură

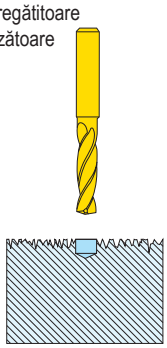
Înainte de ieșirea din gaură reduceţi avansul/rotaţia cu 50%.



sau utilizaţi burghie SD245A.

Intrarea neregulată/înclinată în gaură

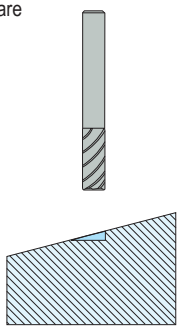
La intrarea în gaură neregulată sau înclinată utilizaţi operaţii pregătitoare corespunzătoare



Intrare obișnuită în gaură

Pre-găurire cu un burghiu standard Feedmax scurt.

Alternative de pre-prelucrare

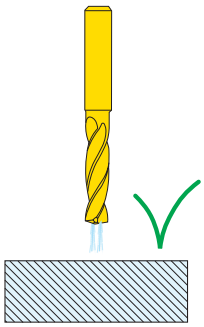


Intrarea înclinată în gaură

Prelucraţi o suprafaţă plană cu o freză cilindro-frontală din gama Seco.

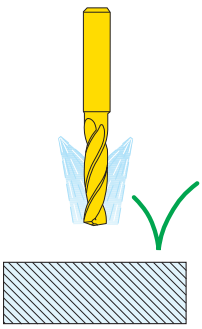
Recomandări privind lichidul de răcire

1.



Prima alegere

2.



≤ 5 x D

1. Presiunea lichidului de răcire*
Presiune minimă recomandată a lichidului de răcire 10 bari cu ≤ 5 x D
Presiune minimă recomandată a lichidului de răcire 30 bari cu > 5 x D
Presiune minimă recomandată a lichidului de răcire 40 bari cu > 16 x D

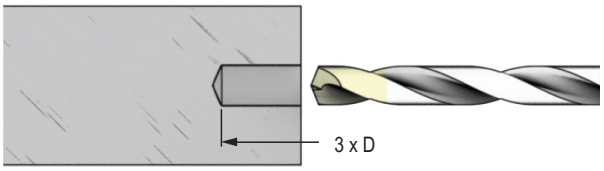
2. Amestec de lichid de răcire
Amestec emulsie recomandat 6-8%.
Când se găurește în oţel inox, superaliaje și oţeluri de înaltă rezistenţă se recomandă un amestec de 10%.

* Dacă se utilizează lichid de răcire cu presiune scăzută, reglaţi prin reducerea corespunzătoare a regimului de frezare.

Strategia de prelucrare – Productivitate

SD2016A (16 x D) până la SD2040A (40 x D)

1. Burghiu de ghidare

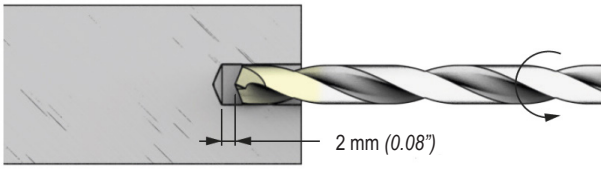




≥10 bari
ON

– SD2030A

2. Avans în

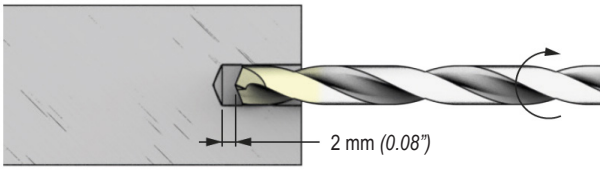




OFF

– Până la SD2040A
– Cu rotaţie în sens antiorar şi oprire la 2 mm deasupra adâncimii orificiului
– n_{max} = 100 rpm
– v_f = 1000 mm/min

3. Schimbaţi rotaţia axului

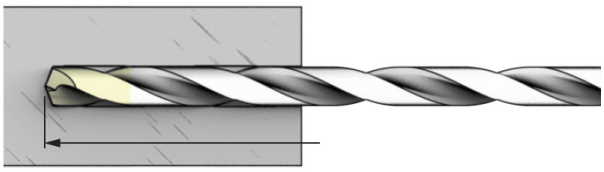




≥40 bari
ON

– Până la SD2040A
– Schimbaţi rotaţia în sens orar şi porniţi lichidul de răcire

4. Realizarea găurilor adânci

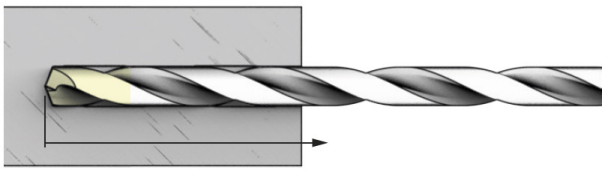




≥40 bari
ON

– Până la SD2040A
– v_c = 100%
– v_f = 100%

5. Retragere





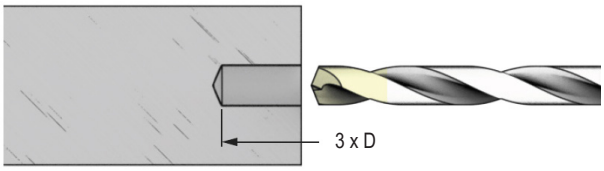
OFF

– Până la SD2040A
– n_{max} = 100 rpm
– v_f = 1000 mm/min

Strategia de prelucrare – Reducerea costurilor cu sculele

SD2030A (30 x D) până la SD2060A (60 x D)

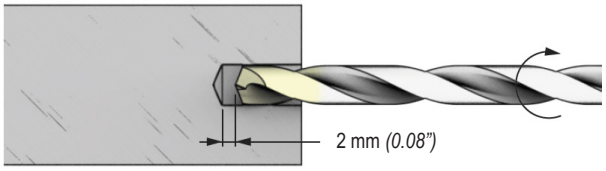
1. Burghiu de ghidare



≥10 bari
ON

- SD2030A

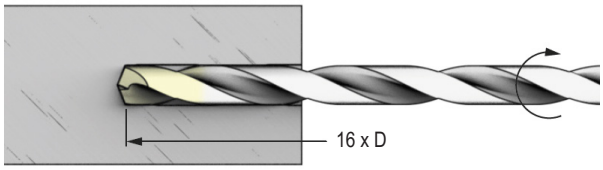
2. Avans în



OFF

- SD2016A
- Cu rotaţie în sensorar şi oprire la 2 mm deasupra adâncimii orificiului
- n_{max} = 100 rpm
- v_f = 1000 mm/min

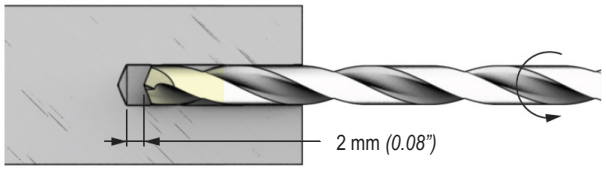
3. Pre-găurire



≥10 bari
ON

- Până la SD2016A
- v_c = 100%
- v_f = 100%

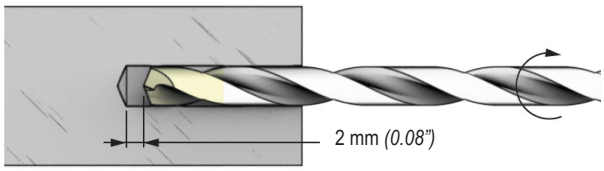
4. Avans în



OFF

- SD2030A - SD2060A
- Cu rotaţie în sens antiorar şi oprire la 2 mm deasupra adâncimii orificiului
- n_{max} = 100 rpm
- v_f = 1000 mm/min

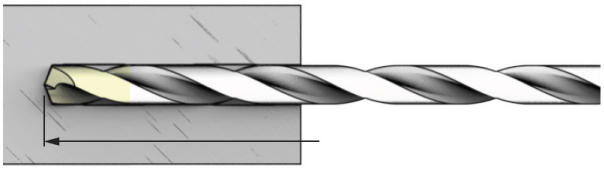
5. Schimbaţi rotaţia axului



≥40 bari
ON

- SD2030A - SD2060A
- Schimbaţi rotaţia în sens orar şi porniţi lichidul de răcire

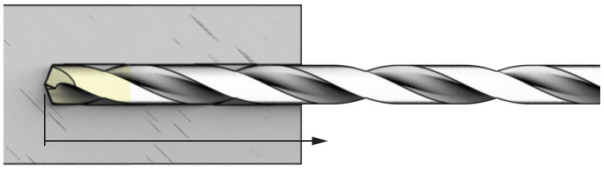
6. Realizarea g[urilor adânci



≥40 bari
ON

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

7. Retragere

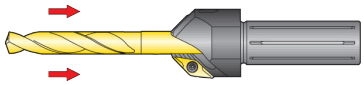


OFF

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

Instrucţiuni de montare modul şanfrenare

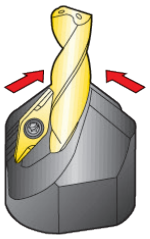
1.



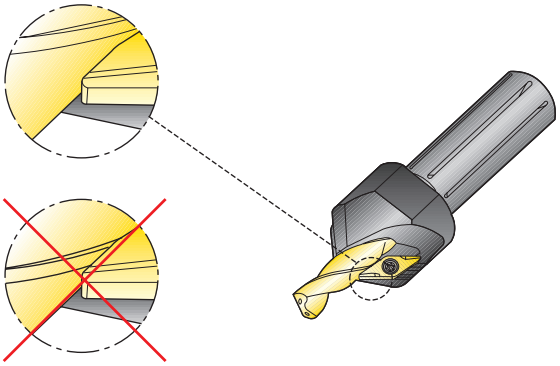
2.

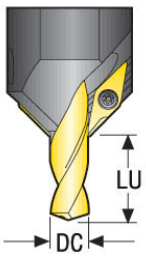


3.

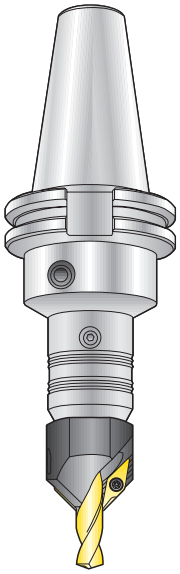


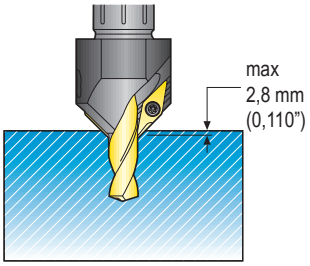
4.





Adâncimea maximă a şanfrenului





Diametru burghiu DC		Adâncimea de găurire LU (min-max)					
		SD1103 / SD203A		SD1105 / SD205A		SD207A	
mm	*inci*	mm	*inci*	mm	*inci*	mm	*inci*
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*

Se va folosi doar cu coadă cilindrică (R1).



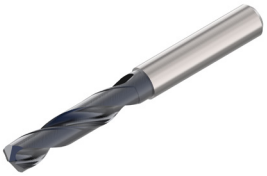
Seco Universal – burghie cu diametru unic

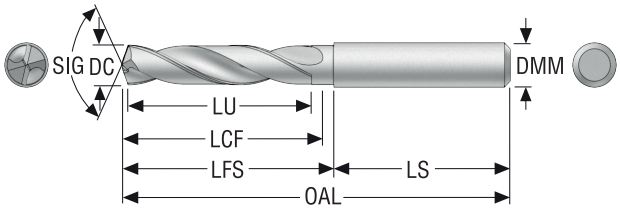
Burghiele din carbură solidă Seco Universal reprezintă o soluţie rentabilă și versatilă, care se potrivesc perfect pentru producţie în loturi mici și mijlocii. Burghiele Seco Universal sunt adecvate pentru majoritatea aplicaţiilor din toate sectoarele industriale.

— Geometrie a vârfului multifuncţională, cu 4 faţete, care oferă o capacitate excelentă de centrare
— Acoperirea TiAlN foarte rezistentă la uzură oferă protecţie pentru o durată de viaţă îndelungată a sculei
— Pot fi utilizate în combinaţie cu tarozi Threadmaster™ și în operaţii de pregăurire cu Nanojet/ Precimaster™ Plus

SD1103

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Lichid de răcire extern
—Regimuri de așchiere, vezi pagina(paginile) 137
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

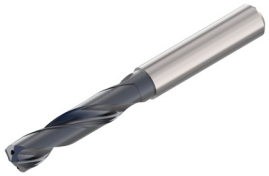
Reper Nr.	Număr reper	DC mm *Inci*	LU mm *Inci*	OAL mm *Inci*	LFS mm *Inci*	LS mm *Inci*	LCF mm *Inci*	DMM mm *Inci*	Unghi la vârf	Acoperirea	Toleranța găurii
SD1103-0760-029-08R1 *SD_DRILL_7.6MM_3XD*	02899037	7,6 *0.299*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°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

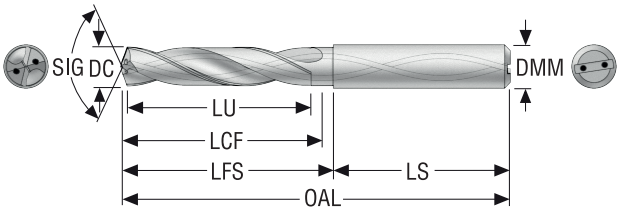
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD1103-1072-040-12R1 *SD_DRILL_27/64_3XD*	02899076	10,716 *0.422*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0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

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

SD1103A

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 138
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

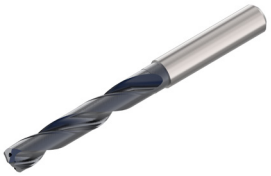
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD1103A-0760-029-08R1 *SD_DRILL_7.6MM_3XD_A*	02898307	7,6 *0.299*	29,0 *1.142*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*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

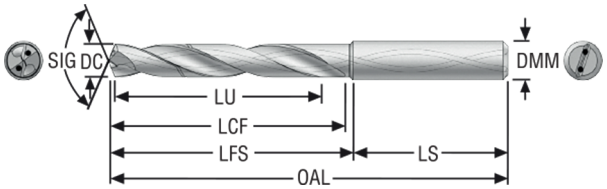
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranța găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD1103A-1090-040-12R1 *SD_DRILL_10.9MM_3XD_A*	02898346	10,9 *0.429*	40,0 *1.575*	102,0 *4.016*	57,0 *2.244*	45,0 *1.772*	55,0 *2.165*	12,0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

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

SD1105A

Adâncime de găurire ~ 5 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 139
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

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

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

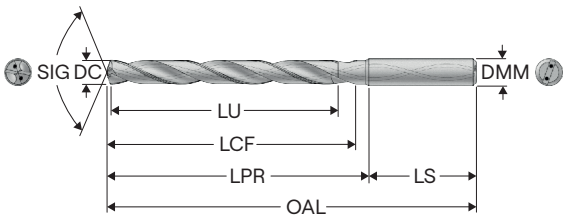
Reper Nr.	Număr reper	DC mm *Inci*	LU mm *Inci*	OAL mm *Inci*	LFS mm *Inci*	LS mm *Inci*	LCF mm *Inci*	DMM mm *Inci*	Unghi la vârf	Acoperirea	Toleranța găurii
SD1105A-1300-060-14R1 *SD_DRILL_13.0MM_5XD_A*	02897979	13,0 *0.512*	60,0 *2.362*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*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

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

SD1108A

Adâncime de găurire ~ 8 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 140
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

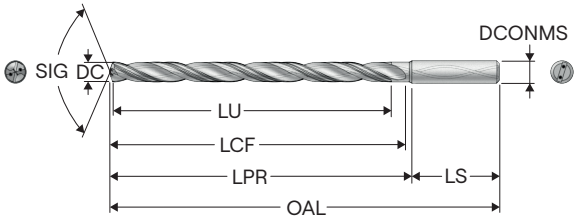
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranța găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD1108A-0790-064-08R1 *SD_DRILL_7.9MM_8XD_A*	03295031	7,9 *0.311*	64,0 *2.520*	116,0 *4.567*	80,0 *3.150*	36,0 *1.417*	76,0 *2.992*	8,0 *0.315*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

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

SD1112A

Adâncime de găurire ~ 12 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 141
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

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



Feedmax -P – burghie cu diametru unic

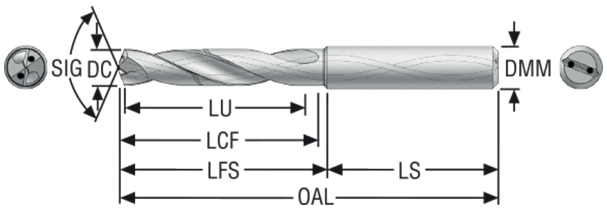
Concepute pentru productivitate ridicată și cost scăzut per gaură, oferind o combinaţie unică de carbură, acoperire și tehnologie de geometrie de ultimă generaţie.

— Geometrie cu autocentrare pentru găuri de înaltă calitate, fără a fi necesară o operaţie de găurire centrală.
— O acoperire specială TiAlN conferă burghielor Seco Feedmax o duritate ridicată la temperatură ridicată care, în combinaţie cu o muchie aşchietoare robustă, asigură o durată de viaţă lungă și previzibilă a sculei

SD203A-P

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 142-143
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

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

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

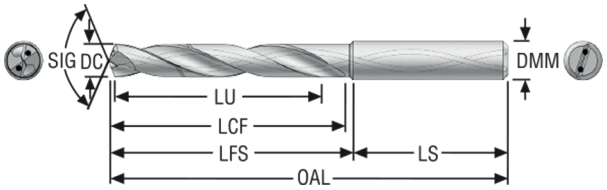
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD203A-1210-043-14R1-P	03046022	12,1 *0.476*	43,0 *1.693*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN	IT8-9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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD203A-1700-051-18R1-P	03046054	17,0 *0.669*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9
SD203A-1750-051-18R1-P	03046055	17,5 *0.689*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9
SD203A-1800-051-18R1-P	03046056	18,0 *0.709*	51,0 *2.008*	123,0 *4.843*	75,0 *2.953*	48,0 *1.890*	73,0 *2.874*	18,0 *0.709*	140°	TiAlN	IT8-9
SD203A-1850-055-20R1-P	03046057	18,5 *0.728*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1900-055-20R1-P	03046058	19,0 *0.748*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1905-055-20R1-P	03046089	19,05 *0.750*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1950-055-20R1-P	03046059	19,5 *0.768*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-1980-055-20R1-P	03138156	19,8 *0.780*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9
SD203A-2000-055-20R1-P	03046060	20,0 *0.787*	55,0 *2.165*	131,0 *5.157*	81,0 *3.189*	50,0 *1.969*	79,0 *3.110*	20,0 *0.787*	140°	TiAlN	IT8-9

SD205A-P

Adâncime de găurire ~ 5 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 144-145
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

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

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

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

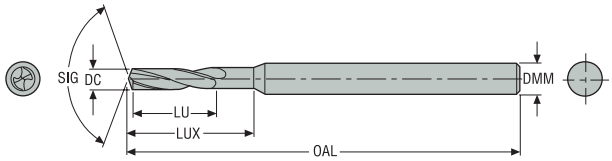
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-1470-063-16R1-P	03046269	14,7 *0.579*	63,0 *2.480*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN	IT8-9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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-1820-077-20R1-P	03046308	18,2 *0.717*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1850-077-20R1-P	03046311	18,5 *0.728*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1880-077-20R1-P	03046314	18,8 *0.740*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1890-077-20R1-P	03046315	18,9 *0.744*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1900-077-20R1-P	03046316	19,0 *0.748*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1905-077-20R1-P	03046353	19,05 *0.750*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1910-077-20R1-P	03046317	19,1 *0.752*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1930-077-20R1-P	03046319	19,3 *0.760*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1950-077-20R1-P	03046321	19,5 *0.768*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1980-077-20R1-P	03046324	19,8 *0.780*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-1990-077-20R1-P	03046325	19,9 *0.783*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9
SD205A-2000-077-20R1-P	03046326	20,0 *0.787*	77,0 *3.031*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN	IT8-9

SD206

Adâncime de găurire ~ 6 x D – Metric/Inci





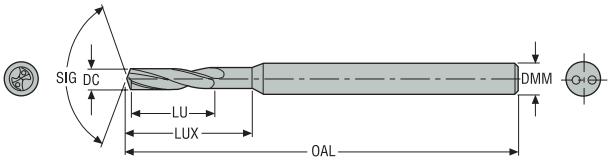
—Coadă cilindrică
—Lichid de răcire extern
—Regimuri de așchiere, vezi pagina(paginile) 146

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

SD206A

Adâncime de găurire ~ 6 x D – Metric/Inci





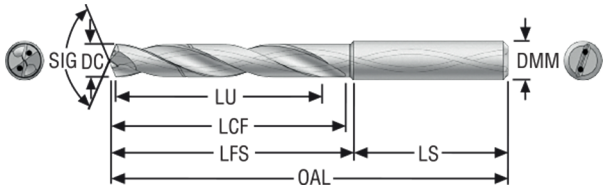
—Coadă cilindrică
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 147

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

SD207A-P

Adâncime de găurire ~ 7 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 148
—Pentru diametre intermediare, consultaţi software-ul My Design

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

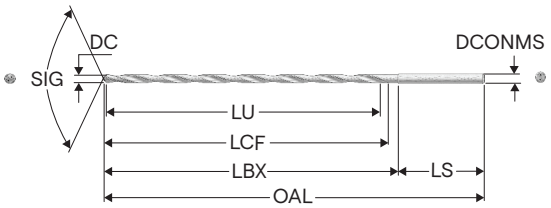
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD207A-0953-062-10R1-P	03046377	9,525 *0.375*	62,0 *2.441*	122,0 *4.803*	82,0 *3.228*	40,0 *1.575*	80,0 *3.150*	10,0 *0.394*	140°	TiAlN	IT9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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD207A-1900-112-20R1-P	03046398	19,0 *0.748*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-1905-112-20R1-P	03046399	19,05 *0.750*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-1980-112-20R1-P	03046406	19,8 *0.780*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9
SD207A-2000-112-20R1-P	03046400	20,0 *0.787*	112,0 *4.409*	200,0 *7.874*	150,0 *5.906*	50,0 *1.969*	148,0 *5.827*	20,0 *0.787*	140°	TiAlN	IT9

SD2016A

Adâncime de găurire ~ 16 x D – Metric/Inci





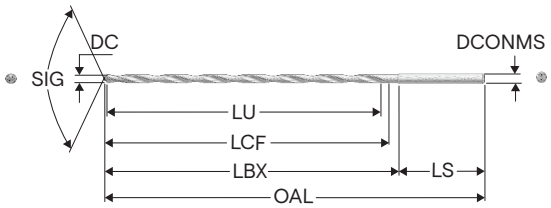
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—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 149
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD2020A

Adâncime de găurire ~ 20 x D – Metric/Inci





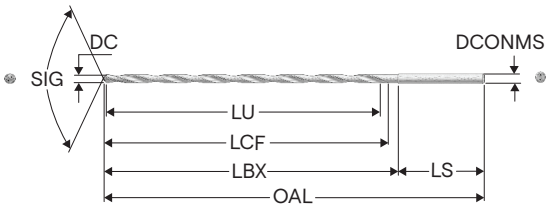
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 149
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD2025A

Adâncime de găurire ~ 25 x D– Metric/Inci





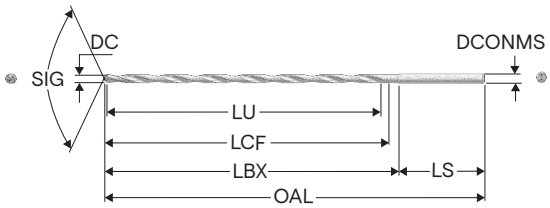
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 149
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD2030A

Adâncime de găurire ~ 30 x D – Metric/Inci





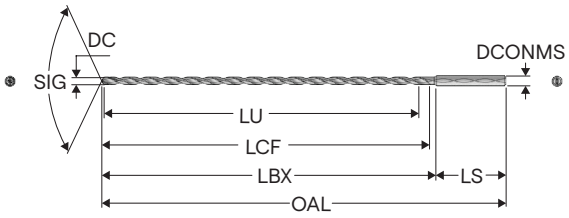
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 149
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD2040A

Adâncime de găurire ~ 40 x D – Metric/Inci





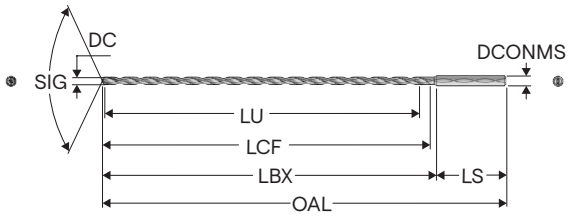
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 150
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD2050A

Adâncime de găurire ~ 50 x D – Metric/Inci





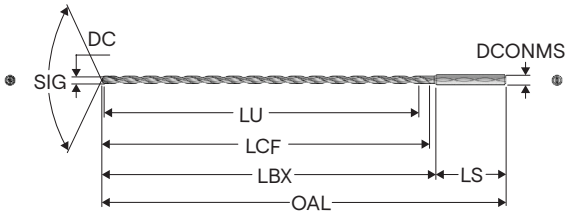
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 150
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD2060A

Adâncime de găurire ~ 60 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 150
—Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper	DC	LU	LCF	LB	OAL	LS	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD2060A-0300-180-04R1	10188290	3,0 *0.118*	180 *7.087*	187,5 –	191,0 *7.520*	218,0 *8.583*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9
SD2060A-0400-240-04R1	10188291	4,0 *0.157*	240 *9.449*	249,0 –	253,0 *9.961*	280,0 *11.024*	27,0 *1.063*	4,0 *0.157*	133°	TiAlN + TiN	IT9
SD2060A-0450-270-06R1	10188292	4,5 *0.177*	270 *10.630*	280,0 –	283,0 *11.142*	319,0 *12.559*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9
SD2060A-0500-300-06R1	10188293	5,0 *0.197*	300 *11.811*	310,5 –	314,0 *12.362*	350,0 *13.780*	36,0 *1.417*	6,0 *0.236*	133°	TiAlN + TiN	IT9



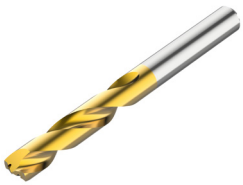
Feedmax™ SD245A

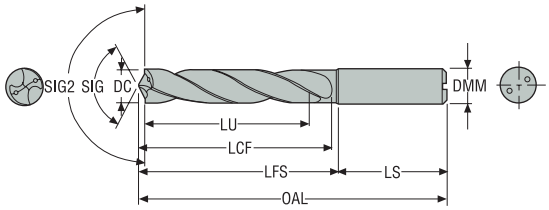
Burghiele din carbură solidă Seco Feedmax SD245A oferă niveluri ridicate de stabilitate și performanţe generale de prelucrare îmbunătăţite pentru aplicaţii de alezare cu ieșiri neregulate și întreruperi pe parcursul găurii. Următoarele caracteristici permit utilizatorului să obţină o geometrie bună a găurilor:

- Patru suprafeţe de așezare
- Un punct de autocentrare optimizat
- Acoperire TiAlN + TiN foarte rezistentă la uzură
- Pregătire a muchiei îmbunătăţită

SD245A

Adâncime de găurire ~ 5 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 151
—Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD245A-13.5-59-14R1	02691710	13,5 *0.5314*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8
SD245A-14.0-59-14R1	02691711	14,0 *0.551*	59,0 *2.323*	124,0 *4.882*	79,0 *3.110*	45,0 *1.772*	77,0 *3.031*	14,0 *0.551*	140°/180°	TiAlN + TiN	IT8



Feedmax™ SD265A

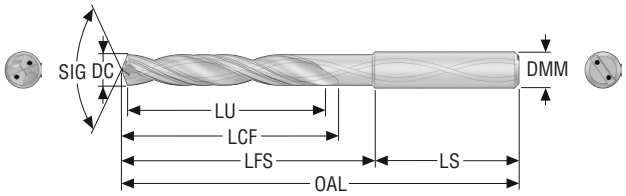
Burghiele de înaltă precizie Seco Feedmax SD265A IT 7 oferă precizie impecabilă. În plus, un burghiu SD265A poate înlocui mai multe scule și simplifica sarcinile complexe de găurire. Următoarele caracteristici permit utilizatorului să execute găuri dintr-o singură trecere:

- Geometrie îmbunătăţită a burghiului și vârf cu autocentrare
- 6 muchii de așezare în total
- Toleranţe de fabricaţie mici (±3µ)
- Acoperire TiAlN pentru frecare redusă și rezistenţă excelentă la uzură

SD265A

Adâncime de găurire ~ 5 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 152
—Pentru diametre intermediare, consultaţi software-ul My Design

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



Feedmax™ – burghie pentru șanfrenat

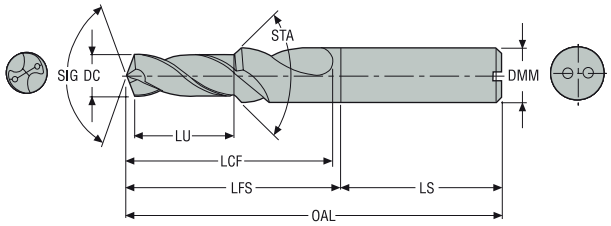
Burghiele pentru șanfrenat Seco Feedmax™ combină găurirea și șanfrenarea într-un singur proces pentru a maximiza eficienţa. Gama standard din stoc acoperă aplicaţii de pregăurire pentru filete metrice standard comune, de la M4 până la M16.

- Versiunea specială minimizează costul per gaură și mărește productivitatea
- Acoperirea specială cu frecare redusă oferă duritate ridicată la temperatură ridicată și o îndepărtare excelentă a așchiilor
- Geometria cu autocentrare asigură o calitate ridicată a găurii utilizând un unghi de șanfrenare de 45 de grade (unghi inclus de 90 de grade)

Burghie de şanfrenare – Filet M4 - M16

Metric/Inci





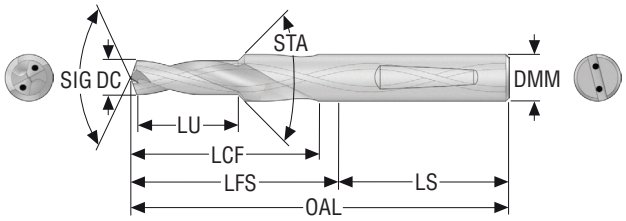
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Acoperirea: TiAlN + TiN
—Toleranţa găurii: IT8-9
—Unghiul de şanfrenare inclus = 90°
—Regimuri de aşchiere, vezi pagina(paginile) 142, 143

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

Burghie de şanfrenare – Filet M4 - M16

Metric/Inci



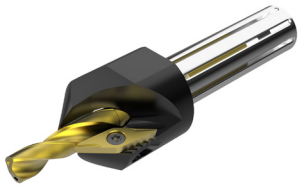


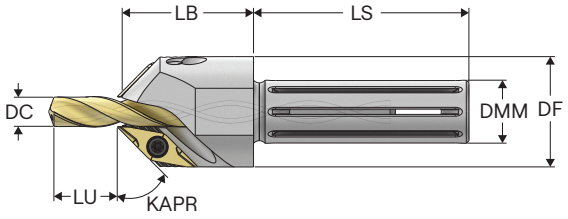
—Coadă Whistle Notch DIN6537B
—Agent de răcire intern
—Acoperirea: TiAlN + TiN
—Toleranţa găurii: IT8-9
—Unghiul de şanfrenare inclus = 90°
—Regimuri de aşchiere, vezi pagina(paginile) 142, 143

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

Modul de șanfrenare pentru burghiele Universal și Feedmax

Metric



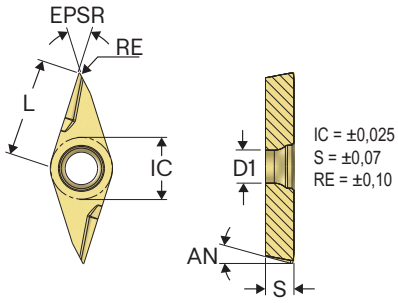


Reper Nr.	Număr reper	DC	Adâncimea de găurire LU 3 x D (min-max)	5 x D (min-max)	7 x D (min-max)	Adâncime max. șanfren (mm)	LB	DF	LS	DMM	KAPR°
		mm	mm	mm	mm	mm	mm	mm	mm	mm	
SD200-C45-6R1	02510275	4,01-6,1	4,0-17,0	10,0-27,0	30,0-45,0	2,8	25,0	21,0	41,0	12,0	45
SD200-C45-8R1	02510278	6,01-8,0	15,0-27,0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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Cheie plăcuţă	Șurub de blocare a plăcuţei	Cheie de blocare	Șurub de blocare	Casetă
					
	Plăcuţă amovibilă	Plăcuţă amovibilă	Modul	Modul	Modul
4,00 - 16,00	T07P-2	C02205-T07P	H1.5-2D	SH3040	SD200-3X7.3

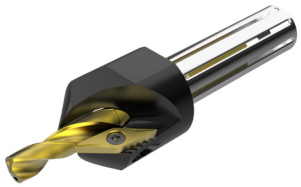
Plăcuţă amovibilă

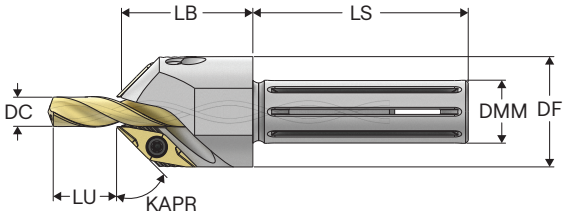


Toleranţe: mm	Dimensiune	L mm	EPSR	RE mm	IC mm	D1 mm	AN	S mm
	C45	9,000	45°	0,200	5,556	2,900	7°	2,500
	Calitate: T400D							
	Denumire: SD200-C45							
	Număr reper: 02510325							

Modul de șanfrenare pentru burghiele Universal și Feedmax

Inci



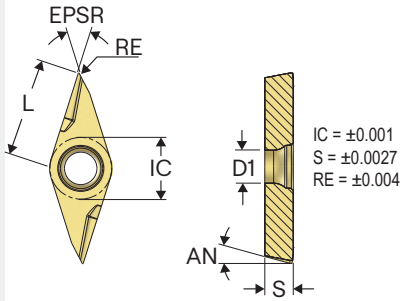


Descriere	Număr reper	DC	Adâncimea de găurire LU 3 x D (min-max)	5 x D (min-max)	7 x D (min-max)	Adâncime max. șanfren (mm)	DF	LB	LS	DMM	KAPR°
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	
SD200-C45-6-500R1	02510287	0.158-0.240	0.157-0.669	0.394-1.063	1.181-1.772	0.110	0.827	0.984	1.614	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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Cheie plăcuţă	Şurub de blocare a plăcuţei	Cheie de blocare	Casetă
				
	Plăcuţă amovibilă	Plăcuţă amovibilă	Modul	Modul
0.158 - 0.630	T07P-2	C02205-T07P	H1.5-2D	SD200-3X7.3

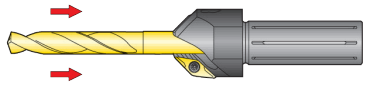
Plăcuţă amovibilă



Toleranţe: inci	Dimensiune	L inci	EPSR	RE inci	IC inci	D1 inci	AN	S inci
	C45	0.3543	45°	0.0078	0.2187	0.1141	7°	0.0984
	Calitate: T400D							
	Denumire: SD200-C45							
	Număr reper: 02510325							

Instrucţiuni de montare modul șanfrenare

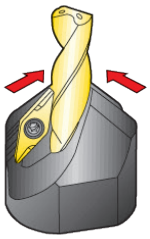
1.



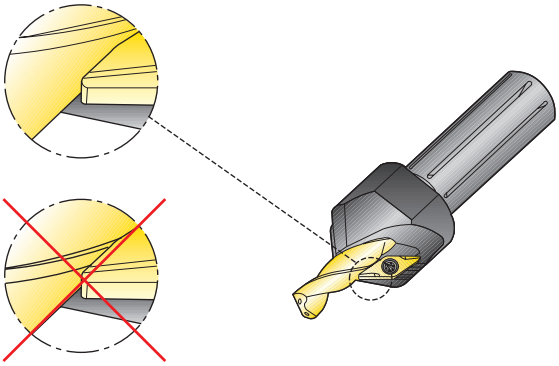
2.

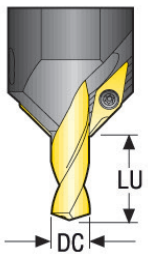


3.

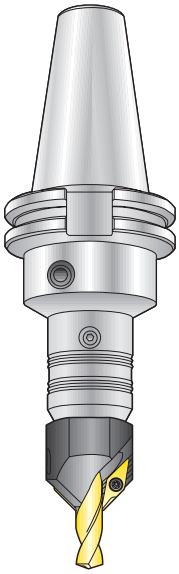


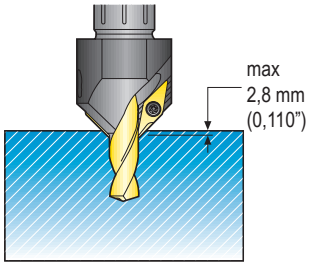
4.





Adâncimea maximă a șanfrenului





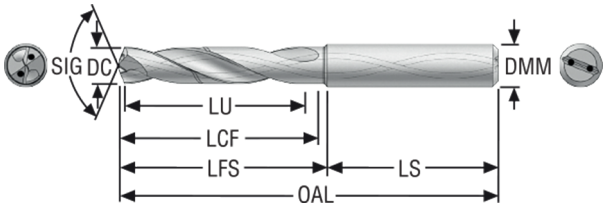
Diametru burghiu DC		Adâncimea de găurire LU (min-max)					
		SD1103 / SD203A		SD1105 / SD205A		SD207A	
mm	*inci*	mm	*inci*	mm	*inci*	mm	*inci*
4,00-4,75	*.157-.187*	4-17	*.157-.669*	10-27	*.394-1.063*	30-45	*1.181-1.772*
4,76-6,00	*.187-.236*	6-20	*.236-.787*	18-32	*.709-1.260*	30-45	*1.181-1.772*
6,01-8,00	*.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*

Se va folosi doar cu coadă cilindrică (R1).

SD203A, -MS

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 153-154
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

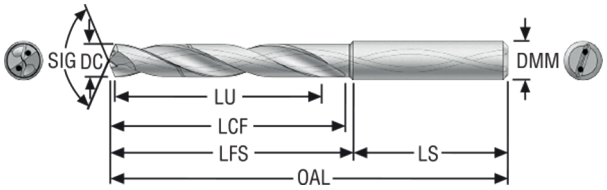
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD203A-0740-025-08R1-MS	10004134	7,4 *0.291*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	41,0 *1.614*	8,0 *0.315*	140°	TiAlN + NbN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

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

SD205A, -MS

Adâncime de găurire ~ 5 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 155-156
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

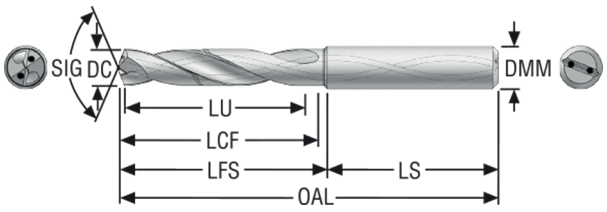
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-0870-045-10R1-MS	10004252	8,7 *0.343*	45,0 *1.772*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	140°	TiAlN +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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-1700-071-18R1-MS	10004300	17,0 *0.669*	64,0 *2.520*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD205A-1750-071-18R1-MS	10004301	17,5 *0.689*	66,0 *2.598*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD205A-1800-071-18R1-MS	10004302	18,0 *0.709*	66,0 *2.598*	143,0 *5.630*	95,0 *3.740*	48,0 *1.890*	93,0 *3.661*	18,0 *0.709*	140°	TiAlN + NbN	IT8-9
SD205A-1850-077-20R1-MS	10004303	18,5 *0.728*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD205A-1900-077-20R1-MS	10004304	19,0 *0.748*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9
SD205A-2000-077-20R1-MS	10004307	20,0 *0.787*	71,0 *2.795*	153,0 *6.024*	103,0 *4.055*	50,0 *1.969*	101,0 *3.976*	20,0 *0.787*	140°	TiAlN + NbN	IT8-9

SD203A, -M

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 157-158
—Pentru diametre intermediare, consultaţi software-ul My Design

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

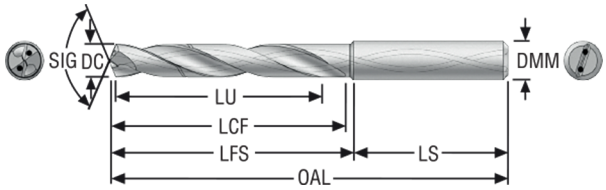
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD203A-7.0-25-8R1-M	02450081	7,0 *0.276*	25,0 *0.984*	79,0 *3.110*	43,0 *1.693*	36,0 *1.417*	34,0 *1.339*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD203A-12.5-36-14R1-M	02450099	12,5 *0.492*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-05000-142-0551R1-M	02450115	12,7 *0.500*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-12.9-36-14R1-M	02538263	12,9 *0.508*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-13.0-36-14R1-M	02450100	13,0 *0.512*	36,0 *1.417*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-13.5-37-14R1-M	02450101	13,5 *0.531*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-14.0-37-14R1-M	02450102	14,0 *0.551*	37,0 *1.457*	107,0 *4.213*	62,0 *2.441*	45,0 *1.772*	60,0 *2.362*	14,0 *0.551*	140°	TiAlN + TiN	IT8-9
SD203A-14.25-38-16R1-M	02592715	14,25 *0.561*	38,0 *1.496*	115,0 *4.528*	67,0 *2.638*	48,0 *1.890*	65,0 *2.559*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9

SD205A, -M

Adâncime de găurire ~ 5 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 159- 160
—Pentru diametre intermediare, consultaţi software-ul My Design

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

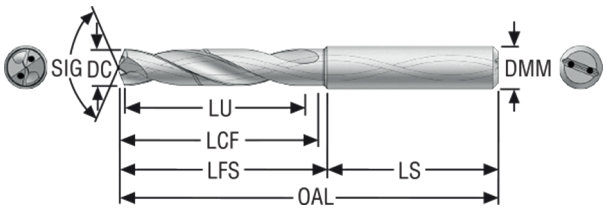
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-6.5-35-8R1-M	02450036	6,5 *0.256*	35,0 *1.378*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	TiAlN + TiN	IT8-9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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-14.5-60-16R1-M	03117534	14,5 *0.571*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9
SD205A-15.0-60-16R1-M	02570652	15,0 *0.591*	60,0 *2.362*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9
SD205A-15.5-62-16R1-M	02543076	15,5 *0.610*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9
SD205A-16.0-62-16R1-M	02555961	16,0 *0.630*	62,0 *2.441*	133,0 *5.236*	85,0 *3.346*	48,0 *1.890*	83,0 *3.268*	16,0 *0.630*	140°	TiAlN + TiN	IT8-9

SD203A, -T

Adâncime de găurire ~ 3 x D – Metric/Inci





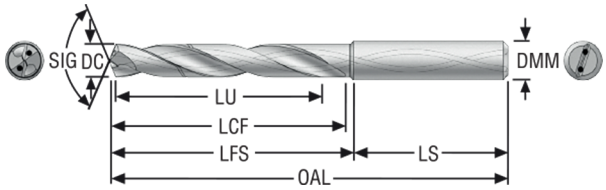
—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Parametri de aşchiere - www.secotools.com
—Pentru diametre intermediare, consultaţi software-ul My Design

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

SD205A, -T

Adâncime de găurire ~ 5 x D – Metric/Inci





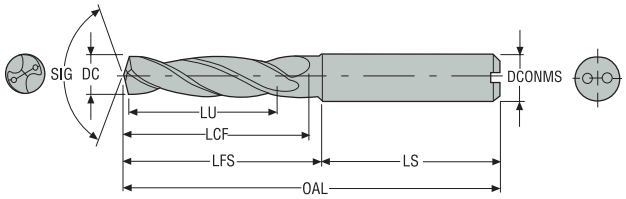
—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Parametri de aşchiere - www.secotools.com
—Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea	Toleranţa găurii
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			
SD205A-8.0-42-8R1-T	02569164	8,0 *0.315*	42,0 *1.654*	91,0 *3.583*	55,0 *2.165*	36,0 *1.417*	53,0 *2.087*	8,0 *0.315*	140°	Neacoperit	IT8-9
SD205A-12.0-56-12R1-T	02527621	12,0 *0.472*	56,0 *2.205*	118,0 *4.646*	73,0 *2.874*	45,0 *1.772*	71,0 *2.795*	12,0 *0.472*	140°	Neacoperit	IT8-9

SD203A, -N

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Toleranţă DC m7
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 142- 143
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

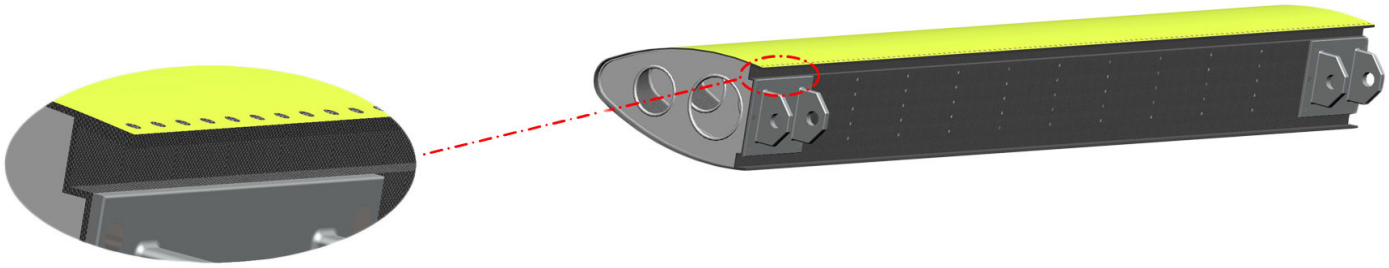


Găurire de compozite

Seco oferă două soluţii distincte pentru găurirea de compozite: burghie acoperite cu diamant și burghie din diamant policristalin (PCD). Aceste scule dispun de geometrii care sunt optimizate special pentru compozite obișnuite sau materiale suprapuse.

- C1 și CX1 sunt geometrii optimizate pentru aplicaţii în materiale CFRP
- C2: geometrie plată pentru materiale compozite suprapuse care încorporează straturi de aluminiu sau titan
- CX1 sunt burghie din diamant policristalin (PCD) care oferă o productivitate și o durata de viaţă a sculei îmbunătăţite faţă de burghiele convenţionale la prelucrarea materialelor compozite
- Atât C1 cât și C2 sunt burghie din carbură acoperite cu diamant, dispunând de o acoperire cu diamant Dura care oferă o duritate și o rezistenţă la abraziune foarte bune

Prelucrare compozit



Atunci când cea mai importantă este calitatea găurii

Atunci când pot apărea aşchii sau delaminări la intrare şi ieşire, direcţia de urmat este clară; proiectarea de scule optimizate anume pentru aplicaţii în compozite şi scule optimizate anume pentru materiale suprapuse. În ambele cazuri s-a pus accentul pe performanţe excelente la intrarea şi la ieşirea în/din material. (La materialele suprapuse este posibil ca ieşirea să fie în Al sau Ti).

– Fără delaminare la intrare
– Fără delaminare la ieşire

Acoperirea cu diamant Dura asigură o toleranţă dimensională bună pe toată durata lungă de viaţă a sculei.





Model de aplicaţie

Material CFRP/GFRP simplu
(ieşire în material compozit)

Geometrie C1
Geometrie CX1





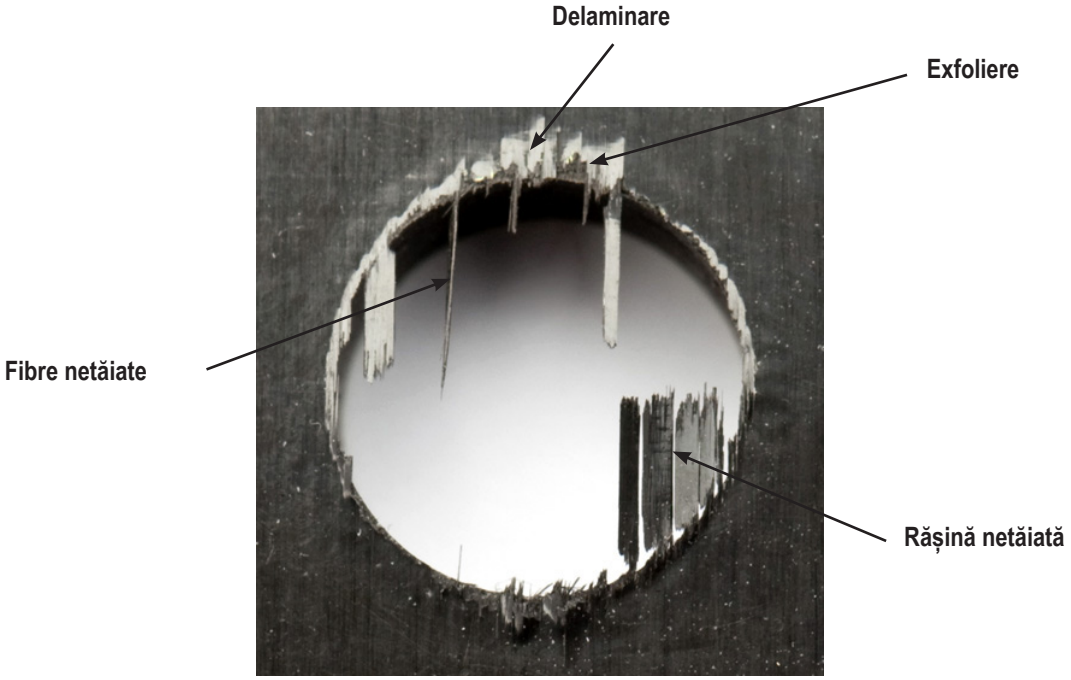
Material suprapus
(ieşire în Al/Ti)

Geometrie C2





Depanare – ieșirea din gaură

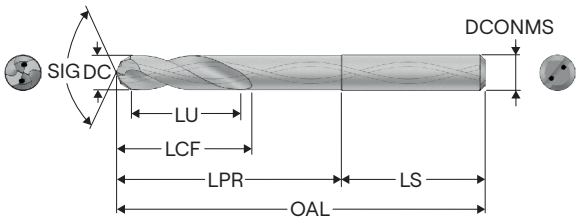


Problemă:	Delaminare (exfoliere / umflare)	Exfoliere	Fibre netăiate	Rășină netăiată
Soluţie:	**Exfoliere** ▪Utilizaţi o sculă cu o geometrie mai negativă ▪Reduceţi avansul/rotaţia **Umflare** ▪ Reduceţi avansul/rotaţia	▪Utilizaţi o sculă cu o geometrie mai pozitivă ▪ Reduceţi avansul/ rotaţia	▪ Utilizaţi o sculă cu o geometrie mai ascuţită ▪Reduceţi avansul/rotaţia	▪Utilizaţi o sculă cu o geometrie mai ascuţită ▪Reduceţi avansul/rotaţia ▪ Reduceţi viteza de așchiere
Problemă:	**Rășină topită (prea multă căldură)**	**Viaţă scurtă a sculei**		
Soluţie:	▪Reduceţi viteza de așchiere.	▪Reduceţi viteza de așchiere.		

SD205A-C1

Adâncime de găurire ~ 5 x D – Metric/Inci





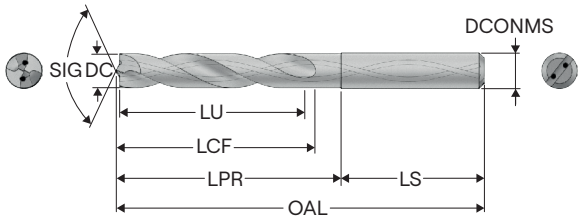
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 161

Reper Nr.	Număr reper	Toleranţa găurii		DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea
		mm	*Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		
SD205A-6.0-31-6R1-C1	02740089	5,975/6,025	*0.2352/0.2372*	6,0 *0.236*	31,0 *1.220*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	60°/130°	Dura diamond
SD205A-9.55-46-10R1-C1	02740092	9,525/9,576	*0.3750/0.3770*	9,55 *0.376*	46,0 *1.811*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	60°/130°	Dura diamond

SD205A-C2

Adâncime de găurire ~ 5 x D – Metric/Inci





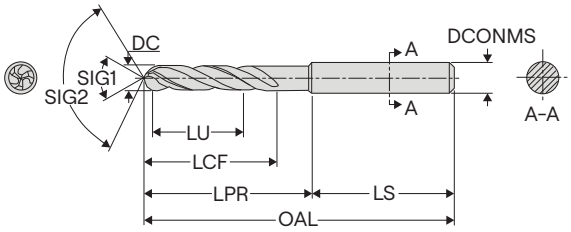
—Coadă cilindrică DIN 6537A
—Agent de răcire intern
—Regimuri de așchiere, vezi pagina(paginile) 161

Reper Nr.	Număr reper	Toleranţa găurii		DC	LU	OAL	LFS	LS	LCF	DMM	Unghi la vârf	Acoperirea
		mm	*Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		
SD205A-6.0-32-6R1-C2	02740099	5,975/6,025	*0.2352/0.2372*	6,0 *0.236*	32,0 *1.260*	82,0 *3.228*	46,0 *1.811*	36,0 *1.417*	44,0 *1.732*	6,0 *0.236*	60°/130°	Dura diamond
SD205A-9.55-48-10R1-C2	02740103	9,525/9,576	*0.3750/0.3770*	9,55 *0.376*	48,0 *1.890*	103,0 *4.055*	63,0 *2.480*	40,0 *1.575*	61,0 *2.402*	10,0 *0.394*	60°/130°	Dura diamond

SD203-CX1

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă cilindrică DIN 6537A
—Muchii de așchiere PCD
—Regimuri de așchiere, vezi pagina(paginile) 161

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



Micro-găurire

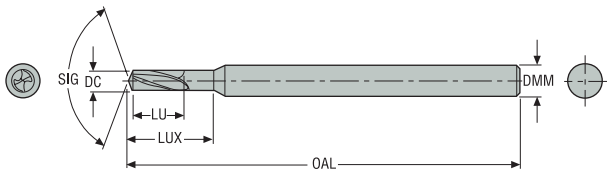
Seco abordează aplicaţiile de micro-găurire cu un portofoliu de produse dedicate care include gamele SD22 și SD26 de micro-burghie din carbură solidă mici.

— Capabile să ofere creșteri spectaculoase de performanţă în comparaţie cu burghiele HSS tradiţionale
— Adecvate pentru aplicaţii din industria auto și medicală, precum și pentru producţie de piese mici din industria generală mecanică

SD22

Adâncime de găurire ~ 2 x D (burghiu pilot) – Metric/Inci





—Coadă cilindrică
—Lichid de răcire extern
—Regimuri de așchiere, vezi pagina(paginile) 162-166

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

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

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

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

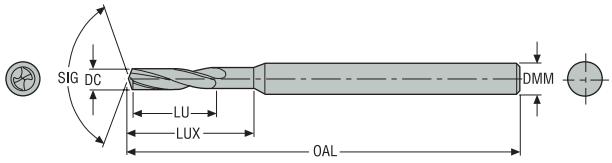
Reper Nr.	Număr reper	DC	LU	OAL	LUX	DMM	Unghi la vârf	Acoperirea
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		
SD22-1.41-2.82-3R1	02730568	1,41 *0.056*	2,82 *0.111*	38,0 *1.496*	4,6 *0.181*	3,0 *0.118*	130°	Neacoperit
SD22-1.42-2.84-3R1	02730569	1,42 *0.056*	2,84 *0.112*	38,0 *1.496*	4,6 *0.181*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

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

SD26

Adâncime de găurire ~ 6 x D – Metric/Inci





—Coadă cilindrică
—Lichid de răcire extern
—Regimuri de așchiere, vezi pagina(paginile) 162-166

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

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

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

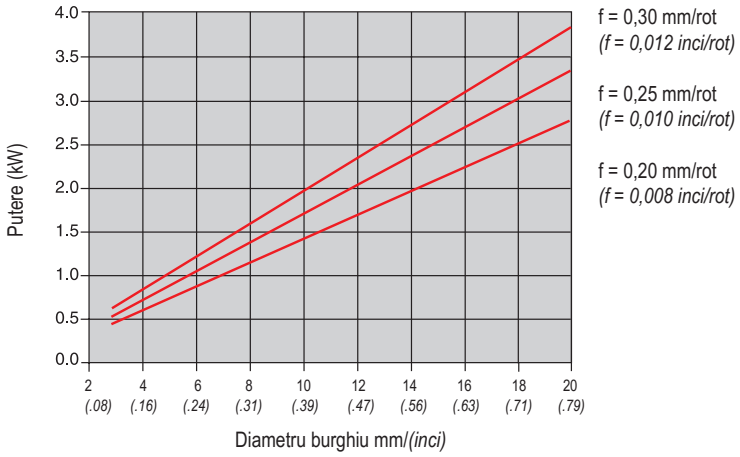
Reper Nr.	Număr reper	DC	LU	OAL	LUX	DMM	Unghi la vârf	Acoperirea
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		
SD26-1.06-7.30-3R1	02730701	1,06 *0.042*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*	3,0 *0.118*	130°	Neacoperit
SD26-1.07-7.30-3R1	02730702	1,07 *0.042*	7,3 *0.287*	38,0 *1.496*	9,0 *0.354*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

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

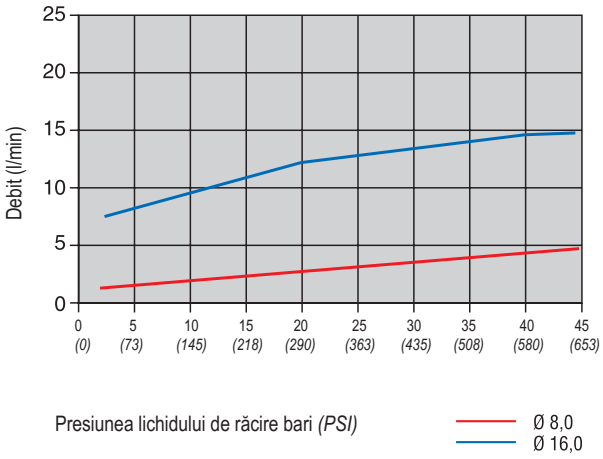
Reper Nr.	Număr reper	DC	LU	OAL	LUX	DMM	Unghi la vârf	Acoperirea
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		
SD26-1.76-11.20-3R1	02730764	1,76 *0.069*	11,2 *0.441*	38,0 *1.496*	13,4 *0.528*	3,0 *0.118*	130°	Neacoperit
SD26-1.77-11.20-3R1	02730765	1,77 *0.070*	11,2 *0.441*	38,0 *1.496*	13,4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

Parametri de prelucrare

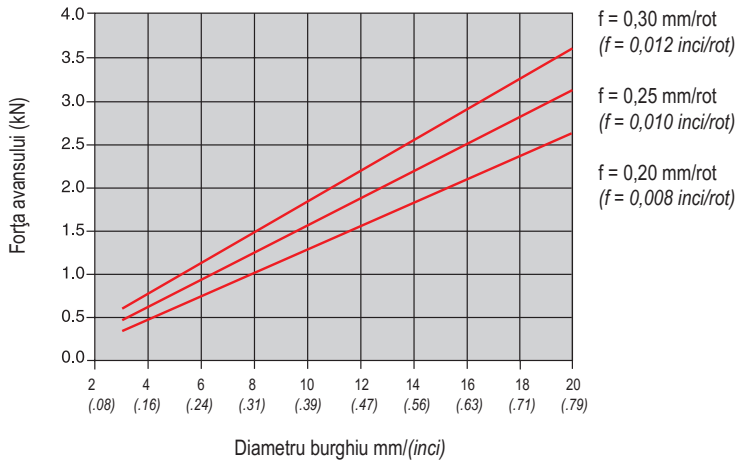
Consumul net de putere



Debitul lichidului de răcire la diferite presiuni



Forţa avansului



Metodă:
Măriţi sau micşoraţi avansul pentru a obţine cea mai bună formare a aşchiilor.
Un avans/rotaţie mai mare duce la aşchii mai scurte.

Valorile de mai sus care arată puterea netă și consumul de putere la avans sunt valori de bază și pot varia in funcţie de regimul de aşchiere, uzura materialului și a sculei.

Parametri de prelucrare

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

Burghiu ∅ DC (mm)	Toleranţa IT9 (µm)	Toleranţa IT10 (µm)	Burghiu ∅ DC *(inci)*	Toleranţa IT9 *(inci)*	Toleranţa IT10 *(inci)*
< 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*

*Deteriorarea finisării suprafeţei poate apărea când găuriţi în oţel cu conţinut redus de carbon sau în oţel inoxidabil.

Depanare – puncte de verificare inițiale

- Stabilitatea prinderii
- Starea arborelui mașinii
- Starea port-sculei

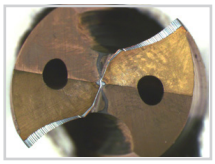
- Prinderea sculei:
  – bătaie radială maximă 0,04 TIR
  – dacă se utilizează pregăurire maxim 0,04 TIR

- Îndepărtarea așchiilor:
  – regimuri de frezare

- Lichid de răcire:
  - Presiune
  - Debit
  - Concentrație

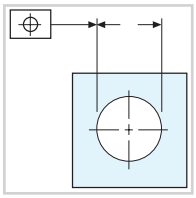
Uzură rapidă a părților laterale

- Reduceți viteza de așchiere
- Mărește concentrația lichidului de răcire



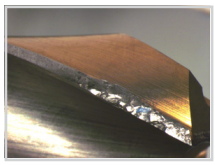
Toleranța diametrului nesatisfăcătoare

- Măriți avansul/rotația
- Utilizați o operație de alezare, consultați paginile 328
- Utilizați o operație de alezare adâncă, consultați paginile 479-480



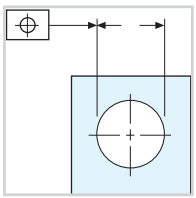
Uzură/Așezare periferică

- Reduceți viteza de așchiere
- Mărește concentrația lichidului de răcire



Poziționarea găurii nesatisfăcătoare

- Reduceți avansul/rotația la intrare
- Reduceți avansul/rotația
- Utilizați o operațiune de alezare, consultați paginile 479-480
- Dacă găuriți prin suprafețe tari, neregulate și înclinate, reduceți avansul cu 30%-50% la intrare și la ieșire
- Centrați burghiul cu un unghi la vârf de 140˚



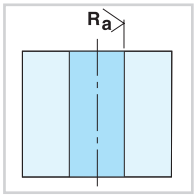
Ciobituri/Centru

- Reduceți avansul/rotația la intrare
- Reduceți avansul/rotația
- Utilizați o operațiune de alezare, consultați paginile 479-480



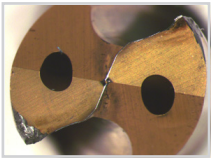
Finisare slabă a suprafeței

- Reduceți avansul/rotația
- Măriți viteza de așchiere
- Utilizați o operațiune de alezare, consultați paginile 328



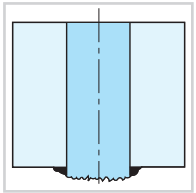
Ciobituri/Colț exterior, muchia de așchiere

- Reduceți avansul la intrare/ieșire
- Reduceți viteza de așchiere
- Măriți concentrația lichidului de răcire
- Reascuțiți burghiul



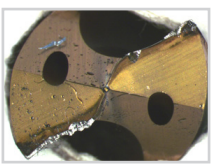
Bavuri la ieșire

- Reduceți avansul/rotația la ieșire
- Micșorați lățimea pregătirii muchiei (BN)



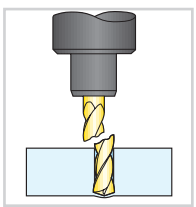
Aderențe pe muchia de așchiere

- Dacă este aproape de periferie, măriți viteză de așchiere
- Dacă este aproape de centru, măriți avansul
- Dacă burghiul este uzat, trebuie reascuțit



Ruperea burghiului la contact/la terminarea găurii

- Reduceți avansul/rotația la intrare/ieșire
- Reglați regimul de frezare pentru o îndepărtare mai bună a așchiilor

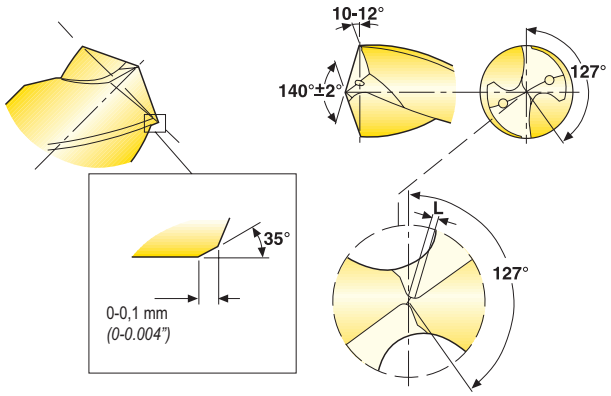


Instrucţiuni de reascuţire pentru SD1103, SD1103A, SD1105A, SD1108A și SD1112A

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Degajarea vârfului: Forma roţii 12A2 Granulaţia D54 (fig.1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Șanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 4).

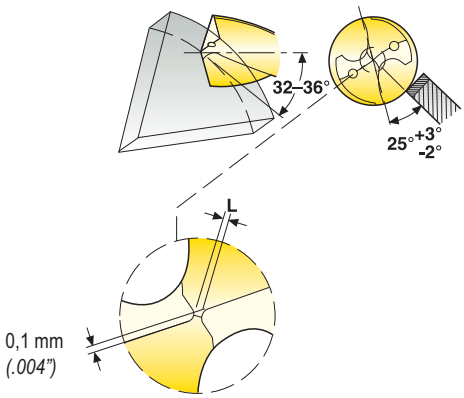
Important:
▪Muchiile aşchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
▪Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei aşchietoare.

1. Vârf cu patru faţete



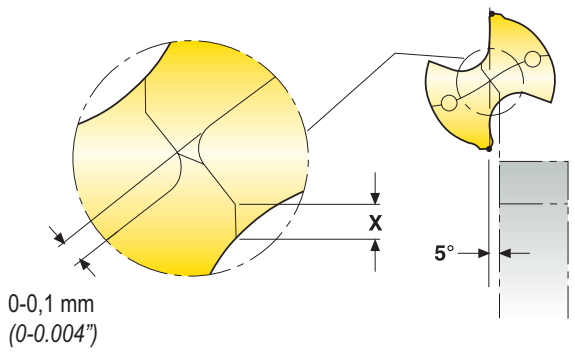
Distanţa înălţimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm *(0,008")*

2. Web thinning



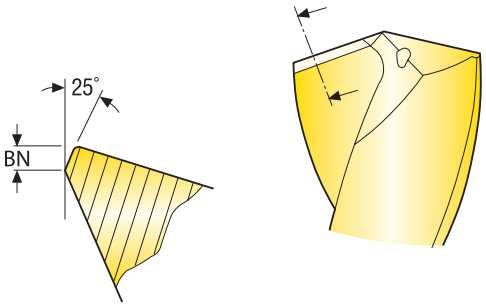
Burghiu ∅ DC mm	L mm	Burghiu ∅ DC *inch*	L *inch*
2-10	0,1-0,3	*0.079-0.394*	*0.004-0.012*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Grinding of flat X



X = 0,08 x (0,003) x diametrul burghiului DC

4. Pregătirea muchiei



Material piesă de lucru	BN Burghiu ∅ ≤ 10 mm	> 10 mm	≤ 0.394 *inch*	> 0.394 *inch*
Oţel	0,05	0,10	*0.002*	*0.004*
Oţel inoxidabil	0,05	0,05	*0.002*	*0.002*
Fontă	0,05	0,10	*0.002*	*0.004*

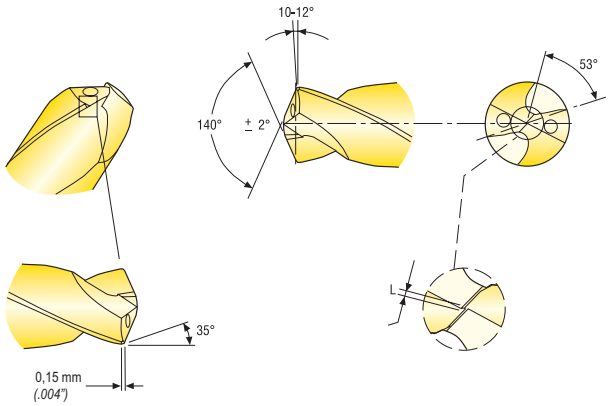
Uzura maximă pe flanc înainte de reascuţire este de 0,1-0,3 mm *(0,004-0,012")* măsurată în zona maximă.

Instrucţiuni de reascuţire pentru SD203A, SD205A și SD207A geometrie P

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Ajustaj conic: Forma roţii 12A2 Granulaţia D54 (fig.1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Șanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 4).

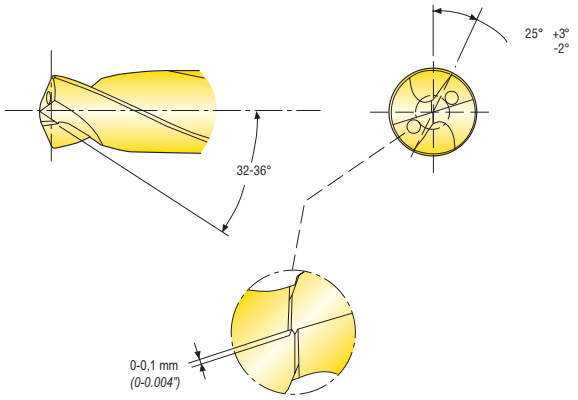
Important:
▪Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
▪Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei așchietoare.

1. Flanc conic



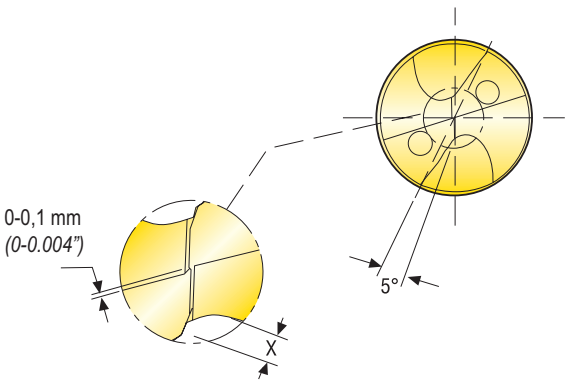
Distanţa înălţimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm *(0,008")*

2. Web thinning



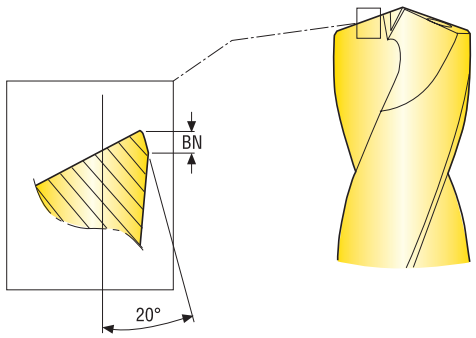
Burghiu ∅ DC mm	L mm	Burghiu ∅ DC *inch*	L *inch*
2-10	0,1-0,3	*0.079-0.394*	*0.004-0.012*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Grinding of flat X



X = 0,08 x (0,003) x diametrul burghiului DC

4. Pregătirea muchiei



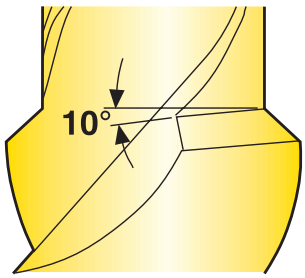
Material piesă de lucru	BN Burghiu ∅ ≤ 10 mm	> 10 mm	≤ 0.394 *inch*	> 0.394 *inch*
Oţel	0,05	0,10	*0.002*	*0.004*
Oţel inoxidabil	0,05	0,05	*0.002*	*0.002*
Fontă	0,05	0,10	*0.002*	*0.004*

Uzura maximă pe flanc înainte de reascuţire este de 0,1-0,3 mm *(0,004-0,012")* măsurată în zona maximă.

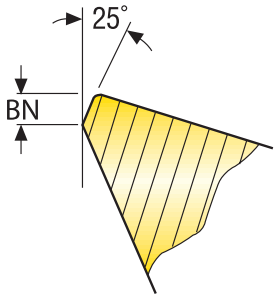
Instrucţiuni de reascuţire pentru burghie pentru șanfrenare.

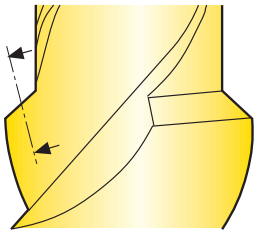
Instrucţiunile de reascuţire sunt identice cu cele pentru SD203, SD203A, SD205A and SD207A cu excepţia șanfrenului.

1. Degajarea șanfrenului



2. Pregătirea muchiei, șanfren





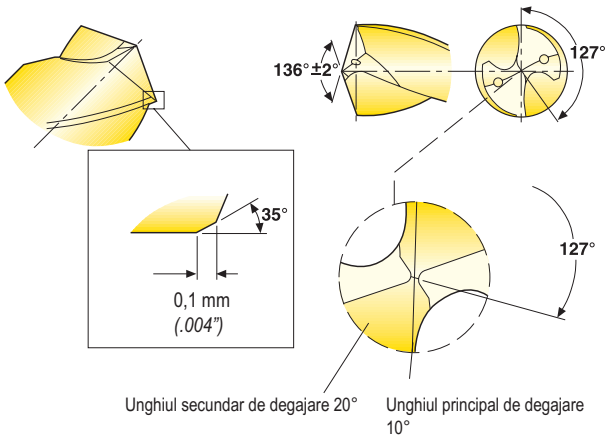
Material piesă de lucru	BN Burghiu ∅ ≤ 10 mm	> 10 mm	≤ 0.394 *inch*	> 0.394 *inch*
Oţel	0,05	0,05	*0.002*	*0.002*
Oţel inoxidabil	0,05	0,05	*0.002*	*0.002*
Fontă	0,05	0,05	*0.002*	*0.002*

Instrucţiuni de reascuţire pentru SD212A, SD216A, SD220A, SD225A și SD230A

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Degajarea vârfului: Forma roţii 11V9 Granulaţia D54 (fig. 1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Șanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 4).

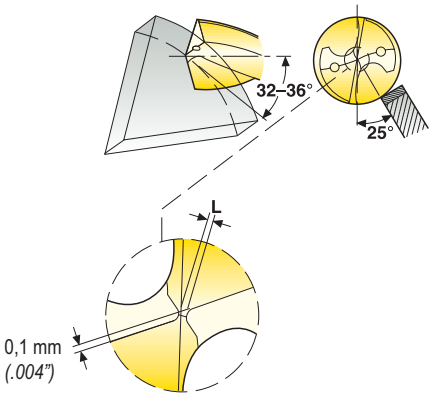
Important:
- Muchiile aşchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei aşchietoare.

1. Flanc conic



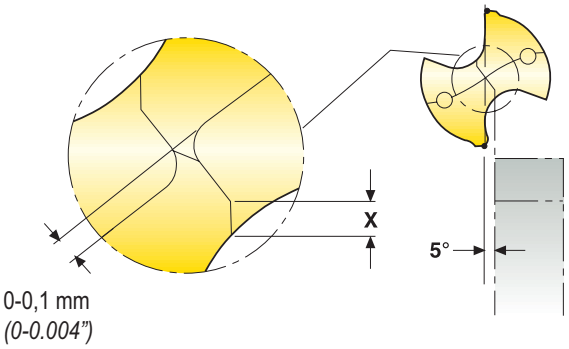
Distanţa înălţimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm *(0,008")*

2. Web thinning



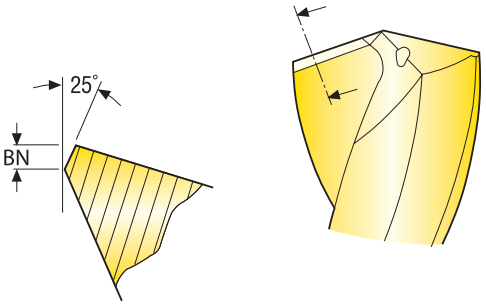
Burghiu ∅ DC mm	L mm	Burghiu ∅ DC *inch*	L *inch*
2-10	0,2	*0.079-0.394*	*0.008*
10-20	0,4	*0.394-0.787*	*0.016*

3. Grinding of flat X



X = 0,08 x (0,003) x diametrul burghiului DC

4. Pregătirea muchiei

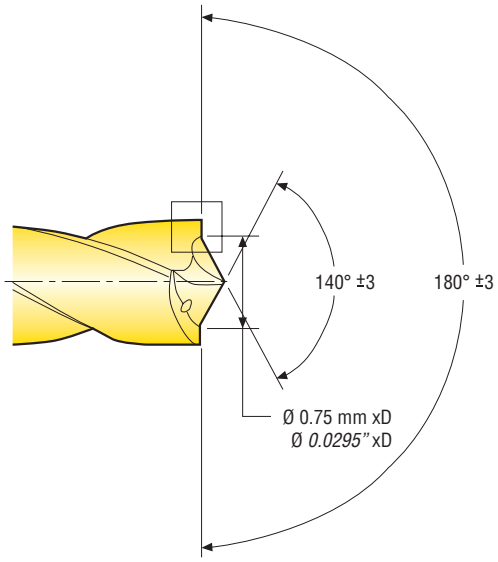


Material piesă de lucru	BN Burghiu ∅ ≤ 10 mm	BN Burghiu ∅ > 10 mm	BN Burghiu ∅ ≤ 0.394 *inch*	BN Burghiu ∅ > 0.394 *inch*
Oţel	0,05	0,10	*0.002*	*0.004*
Oţel inoxidabil	0,05	0,05	*0.002*	*0.002*
Fontă	0,05	0,10	*0.002*	*0.004*

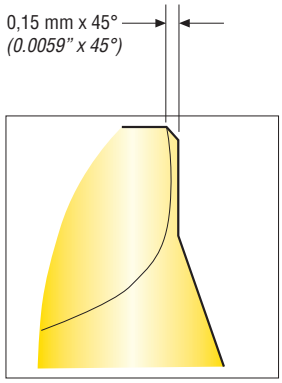
Uzura maximă pe flanc înainte de reascuţire este de 0,1-0,3 mm *(0,004-0,012")* măsurată în zona maximă.

Instrucţiuni de reascuţire pentru SD243, SD243A, SD245A și SD247A

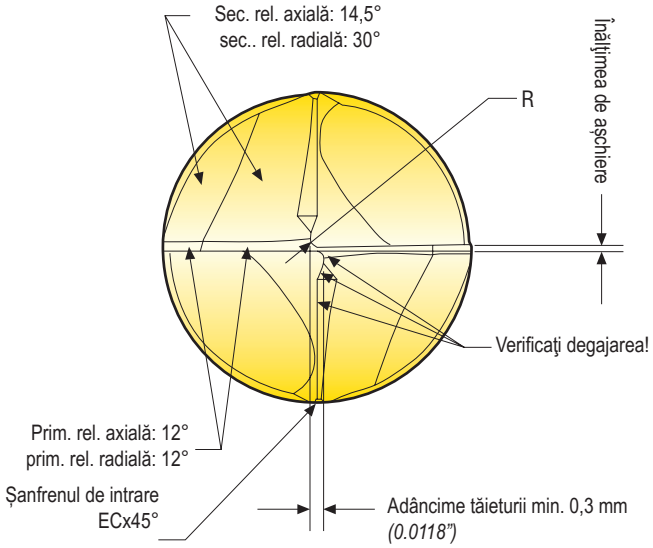
1. Unghiri la vârf



2. Șanfrenul la colţ

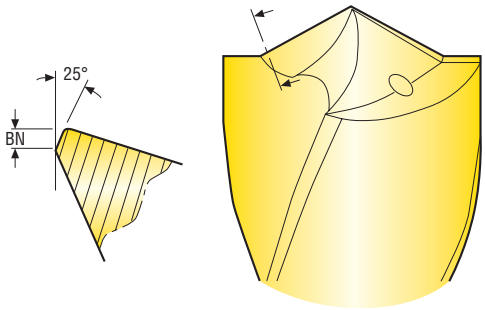


3.



Dimensiuni în mm *(inch)*	Înălţimea de aşchiere mm *(inch)*	R mm *(inch)*	EC mm *(inch)*
– 10 *(0.3937)*	0,2 *(0.0079)*	0,2 *(0.0079)*	0,3 *(0.0118)*
10,01 *(0.3941)* –	0,3 *(0.0118)*	0,4 *(0.0157)*	0,5 *(0.0197)*

4. Pregătirea muchiei



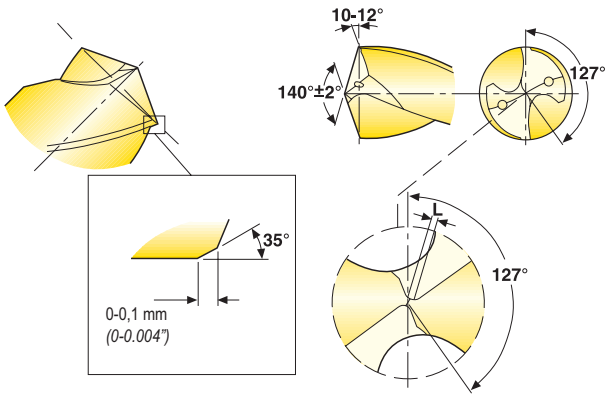
Material piesă de lucru	BN Burghiu ∅			
	≤ 10 mm	> 10 mm	≤ 0.394 *inch*	> 0.394 *inch*
Oţel	0,05	0,10	*0.002*	*0.004*
Oţel inoxidabil	0,05	0,05	*0.002*	*0.002*
Fontă	0,05	0,10	*0.002*	*0.004*

Instrucţiuni de reascuţire pentru SD265A

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Ajustaj conic: Forma roţii 12A2 Granulaţia D54 (fig.1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Şanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 4).

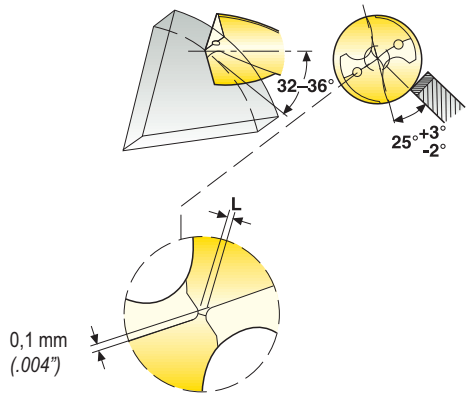
Important:
▪Muchiile aşchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeaşi mărime.
▪Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei aşchietoare.

1. Flanc conic



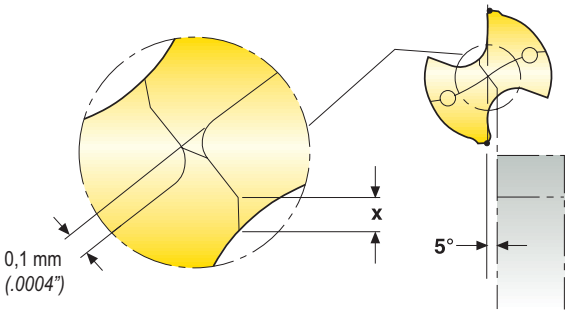
Distanţa înălţimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm *(0,008")*

2. Web thinning



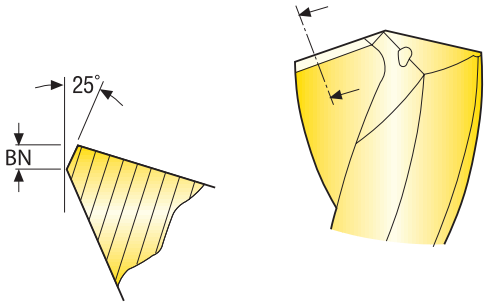
Burghiu ∅ DC mm	L mm	Burghiu ∅ DC *inch*	L *inch*
2-10	0,2	*0.079-0.394*	*0.008*
10-20	0,4	*0.394-0.787*	*0.016*

3. Grinding of flat X



X = 0,08 x (0,003) x diametrul burghiului DC

4. Pregătirea muchiei



Material piesă de lucru	BN Burghiu ∅ ≤ 10 mm	BN Burghiu ∅ > 10 mm	BN Burghiu ∅ ≤ 0.394 *inch*	BN Burghiu ∅ > 0.394 *inch*
Oţel	0,05	0,10	*0.002*	*0.004*
Oţel inoxidabil	0,05	0,05	*0.002*	*0.002*
Fontă	0,05	0,10	*0.002*	*0.004*

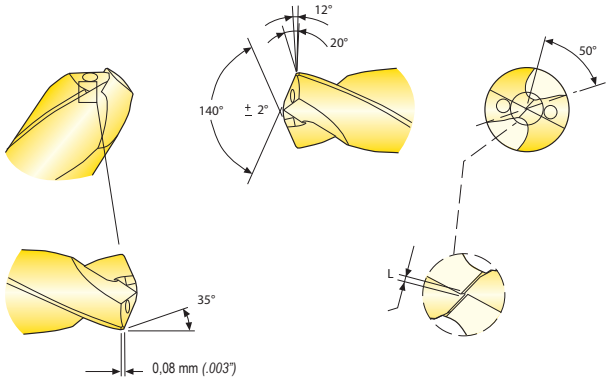
Uzura maximă pe flanc înainte de reascuţire este de 0,1-0,3 mm *(0,004-0,012")* măsurată în zona maximă.

Instrucţiuni de reascuţire pentru geometria – MS

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Ajustaj conic: Forma roţii 12A2 Granulaţia D54 (fig.1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Șanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 4).

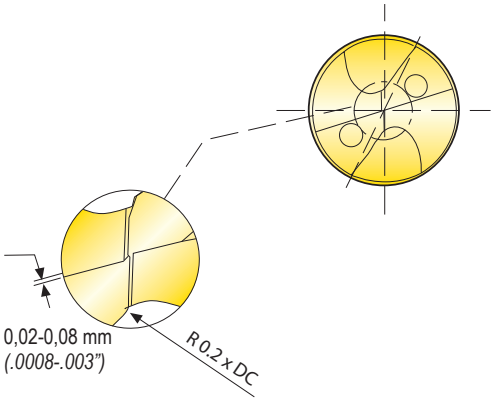
Important:
▪Muchiile aşchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeaşi mărime.
▪Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei aşchietoare.

1. Patru faţete

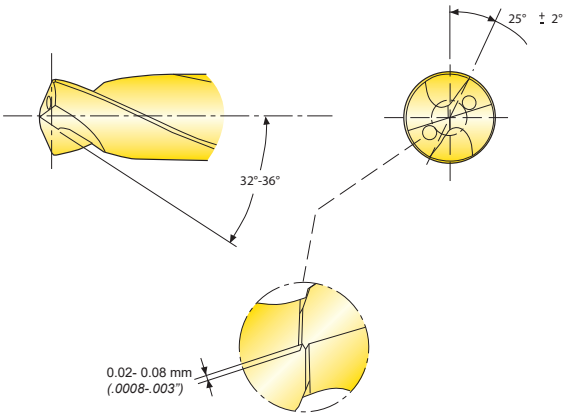


Distanţa înălţimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm *(0,008")*

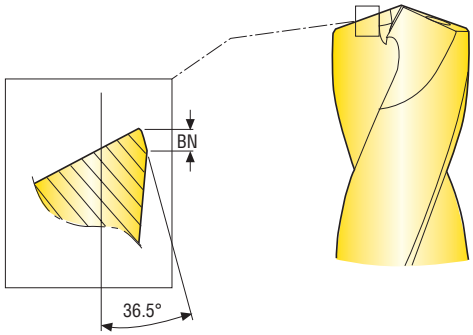
2. Ascuţirea razei R



3. Web thinning



4. Pregătirea muchiei



Burghiu ∅ DC mm	BN mm	Burghiu ∅ 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*

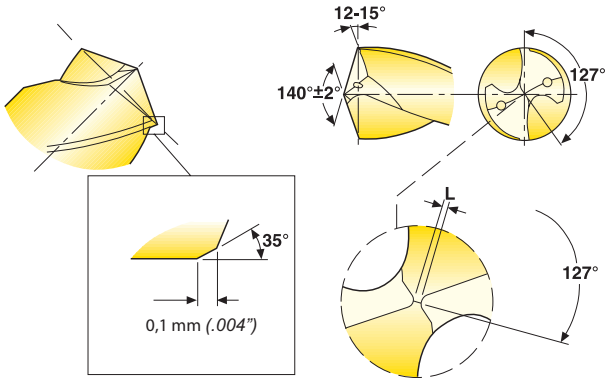
Uzura maximă pe flanc înainte de reascuţire este de 0,1-0,3 mm *(0,004-0,012")* măsurată în zona maximă.

Instrucţiuni de reascuţire pentru geometriile -M și -T

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Ajustaj conic: Forma roţii 12A2 Granulaţia D54 (fig.1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Șanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 4).

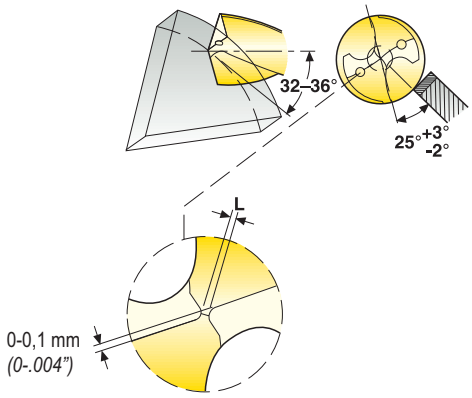
Important:
▪Muchiile aşchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeaşi mărime.
▪Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei aşchietoare.

1. Flanc conic



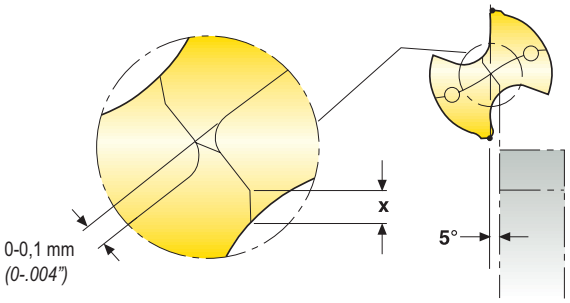
Distanţa înălţimii buzei (bătaia radială) trebuie să fie maxim 0,01 mm *(0,0004")*

2. Web thinning

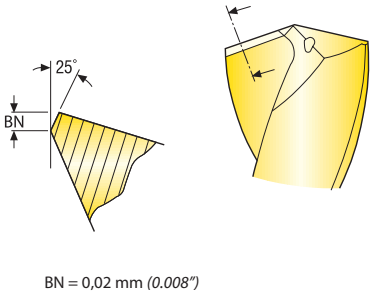


Burghiu ∅ DC mm	L mm	Burghiu ∅ DC *inch*	L *inch*
3-6	0,1-0,2	*0.118-0.236*	*0.004-0.008*
6-10	0,13-0,27	*0.236-0.394*	*0.005-0.011*
10-20	0,2-0,4	*0.394-0.787*	*0.008-0.016*

3. Grinding of flat X



4. Pregătirea muchiei



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

Uzura maximă pe flanc înainte de reascuţire este de 0,1-0,3 mm *(0,004-0,012")* măsurată în zona maximă.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

La găurirea în oțel inoxidabil cu 8xD și 12xD, ar putea fi necesară o operație de pre-găurire

SD1112A – Ø 3-20 mm / *0.118-0.787 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

La găurirea în oțel inoxidabil cu 8xD și 12xD, ar putea fi necesară o operație de pre-găurire

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD207A – Ø 3-20 mm / *0.118-0.787 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

SD2016A-SD2030A – Ø 3-14 mm / *0.118-0.551 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD2040-2060A – Ø 3-8 mm / *0.118-0.315 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

SD265A – Ø 4-16 mm / *0.157-0.630 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

SD205A-M – Ø 2-8 mm / *0.079-0.315 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

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

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

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de așchiere sunt valori de start.

SD22 & SD26 – Ø 0,1-0,3 mm / *0.0039-0.0118 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

SD22 & SD26 – Ø 0,4-0,5 mm / *0.0157-0.0197 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

SD22 & SD26 – Ø 0,9-1,1 mm / *0.0354-0.0433 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD22 & SD26 – Ø 1,2-2,0 mm / *0.0472-0.0787 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.



Burghiu Seco® X-Tip

Burghiul Seco® X-tip este o nouă generaţie de burghie cu vârfuri interschimbabile, cu o nouă interfaţă pre-tensionată, care îmbunătăţeşte securitatea vârfurilor și măreşte durata de viaţă a corpului burghiului.

— Geometriile sunt mai ușor de aplicat cu o fereastră mai largă de parametri de așchiere pe toate grupurile de materiale
— Soluţie robustă și fiabilă, permiţând capacităţi de avans mai mari, oferind o durată de viaţă mai lungă a sculei și un cost mai mic pe gaură, un număr mai mare de modificări ale vârfului de găurire într-un singur corp de găurire

Privire generală

Seco® X-Tip Drill	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD4103 	Pag. 171, 172, 173	Ø 9,49-17,99 mm *(0.3736-0.7083")*	~ 3 x D	n7	H9/H10	Ra 0,6-5 µm *(Ra 24-197 µin)*
SD4105 	Pag. 174, 175, 176	Ø 9,49-17,99 mm *(0.3736-0.7083")*	~ 5 x D	n7	H9/H10	Ra 0,6-5 µm *(Ra 24-197 µin)*
SD4108 	Pag. 177, 178, 179	Ø 9,49-17,99 mm *(0.3736-0.7083")*	~ 8 x D	n7	H9/H10	Ra 0,6-5 µm *(Ra 24-197 µin)*

1) pot apărea variaţii în funcţie de material şi de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire şi materialul pot provoca deteriorarea finisajului suprafeţei.

Codificări



Codificare corpuri de burghiu

Metric

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

Inci

				50	–	0750	–	R	7
				3		4		5	6

1.
Tip burghiu
SD4103: 3 x D
SD4105: 5 x D
SD4108: 8 x D

2.
Diam. coroană min/max

3.
Adâncimea de găurire

4.
Diametru coadă

5.
Sens de rotaţie spre dreapta

6
Tip de coadă
1. Cilindrică
7. ISO 9766

Codificare coroane

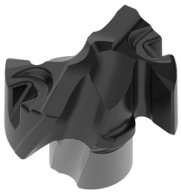
SD4100	–	14.00	–	P
		2		3

2.
Diametru burghiu

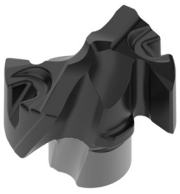
3.
Tipul geometriei
P = oţel
M = oţel inox

Geometrii

Geometria P
– Geometrie universală, prima alegere pentru găurirea în oţel

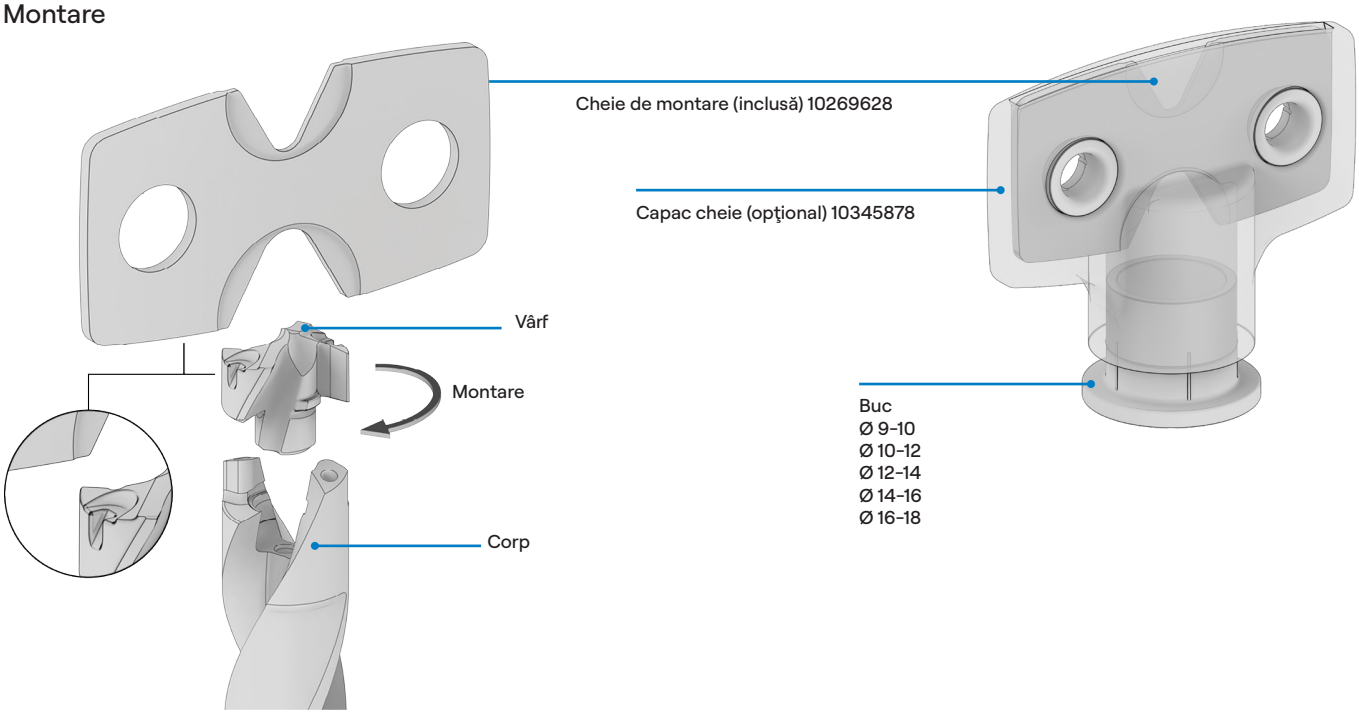


Geometrie M
– Pentru oţel inox și aliaje rezistente la temperaturi înalte



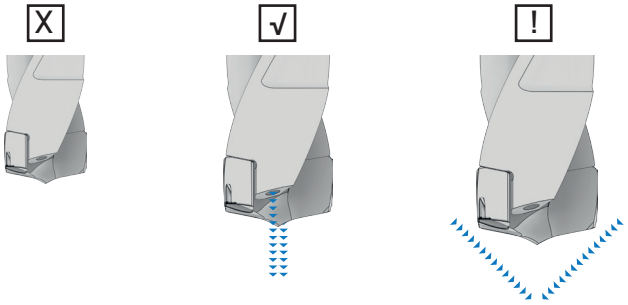
Instrucţiuni de montare

Montare

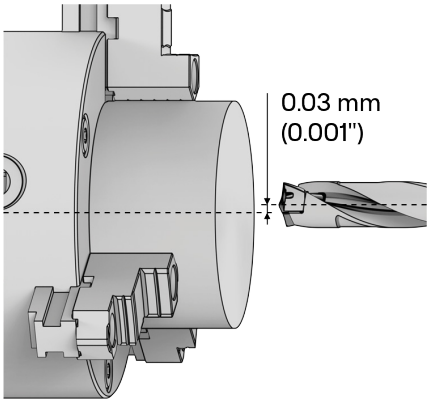


Sfaturi de aplicare

1. Orificii de curgere a agentului de răcire



2. Aplicaţie staţionară



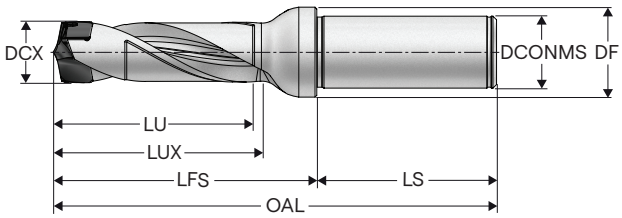
3. Selecţie mandrină

	Corp	
ISO 9766 chuck	■	–
Mandrină hidraulică	■ ■ (cu pensetă)	■ ■
Mandrină Weldon	–	–

SD4103 – R1

Adâncime de găurire ~ 3 x D – Coadă metric/inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Prindere hidraulică sau coadă cilindrică
—Regimuri de așchiere, vezi pagina(paginile) 184

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

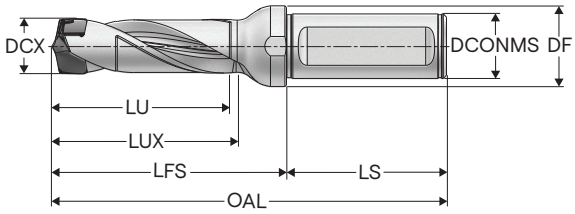
Piese de schimb, Piese incluse la livrare

Pentru	Cheie de blocare
	
SD4103-..	SD4100-0900/1799-BASIC-KEY

SD4103 – R7

Adâncime de găurire ~ 3 x D – Coadă metric/inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 184

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

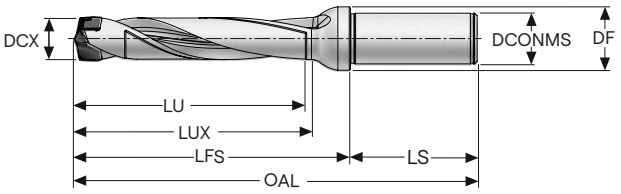
Piese de schimb, Piese incluse la livrare

Pentru	Cheie de blocare
	
SD4103-..	SD4100-0900/1799-BASIC-KEY

SD4105 – R1

Adâncime de găurire ~ 5 x D – Coadă metric/inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Prindere hidraulică sau coadă cilindrică
—Regimuri de așchiere, vezi pagina(paginile) 184

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

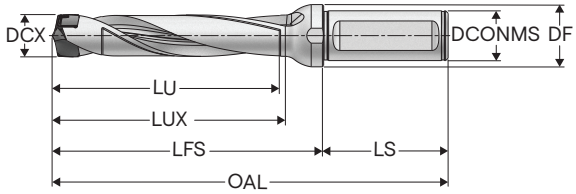
Piese de schimb, Piese incluse la livrare

Pentru	Cheie de blocare
	
SD4105-..	SD4100-0900/1799-BASIC-KEY

SD4105 – R7

Adâncime de găurire ~ 5 x D – Coadă metric/inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 184

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

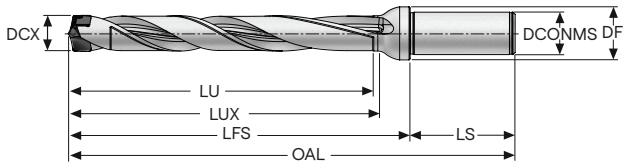
Piese de schimb, Piese incluse la livrare

Pentru	Cheie de blocare
	
SD4105-..	SD4100-0900/1799-BASIC-KEY

SD4108 – R1

Adâncime de găurire ~ 8 x D – Coadă metric/inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Prindere hidraulică sau coadă cilindrică
—Regimuri de așchiere, vezi pagina(paginile) 184

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

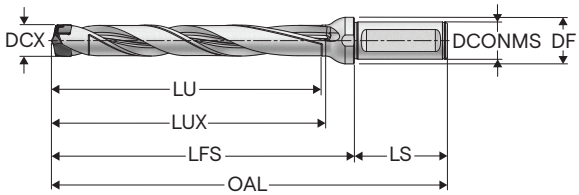
Piese de schimb, Piese incluse la livrare

Pentru	Cheie de blocare
	
SD4108-..	SD4100-0900/1799-BASIC-KEY

SD4108 – R7

Adâncime de găurire ~ 8 x D – Coadă metric/inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 184

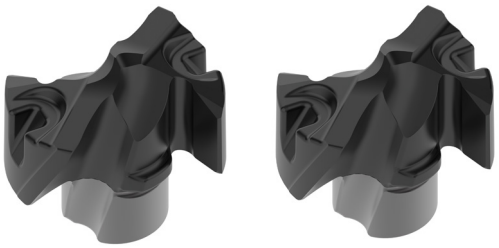
Reper Nr.	Număr reper	DCX	LU	LUX	LFS	OAL	LS	DCONMS	DF
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*
SD4108-1000/1049-084-0625R7	10333521	10,49 *0.413*	84 *3.307*	85,7 *3.374*	98,6 *3.882*	148,1 *5.831*	48,0 *1.890*	15,875 *0.625*	20,0 *0.787*
SD4108-1000/1049-084-16R7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

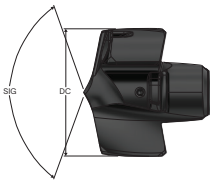
Piese de schimb, Piese incluse la livrare

Pentru	Cheie de blocare
	
SD4108-..	SD4100-0900/1799-BASIC-KEY

Coroane – Geometrie -P și -M

Unghi la vârf 158°





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

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

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

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

■ Stoc standard.

SD4103, SD4105, SD4108 – Ø 9-17,99 mm / *0.354-0.708 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.



Crownloc®

Seco Crownloc® este o gamă de burghie cu vârf schimbabil concepute să ofere găuri de înaltă calitate la un cost mai mic. Oferind aceeași calitate precum burghiele de înaltă precizie, Crownloc utilizează coroane înlocuibile pentru a elimina nevoia și costul reascuţirii.

— Găurile de lichid de răcire care traversează coroana permit unui volum mare de lichid de răcire să ajungă la muchiile așchietoare.
— Crownloc® este disponibilă într-o largă varietate de geometrii de vârf optimizate pentru diferite aplicaţii și materiale ale piesei de prelucrat.

Privire generală

Crownloc®	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD101 	Pag. 189-190	Ø 12,00-25,99 mm *(0.472-1.023")*	1,5 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD103 	Pag. 191-192	Ø 9,52-25,99 mm *(0.375-1.023")*	3 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD105 	Pag. 193-194	Ø 10,00-25,99 mm *(0.394-1.023")*	5 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD107 	Pag. 195-196	Ø 12,00-25,99 mm *(0.472-1.023")*	7 x D	k7	IT 10	Ra 1-4 µm *(Ra 39-157 µin)*
Modul pentru şanfrenat 	Pag. 203	Ø 12.00-19,99 mm *(0.472-0.787")*	–	–	–	–

1) pot apărea variaţii în funcţie de material şi de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire şi materialul pot provoca deteriorarea finisajului suprafeţei.

Codificări



Codificare corpuri de burghiu

Metric

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

Inci

				50	–	0750	–	R	7
				3		4		5	6

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

2.
Diam. coroană min/max

3.
Adâncimea de găurire

4.
Diametru coadă

5.
Sens de rotaţie spre dreapta

6
Tip de coadă
1. Cilindrică
7. ISO 9766

Codificare coroane

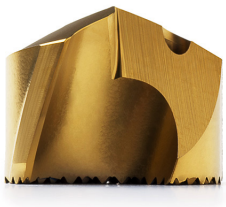
SD100	–	14.00	–	P
		2		3

2.
Diametru burghiu

3.
Tipul geometriei
P = Oţel
M = Oţel inoxidabil
K = Fontă

Geometrii

Geometria P
– Geometrie universală, prima alegere pentru găurirea în oţel



Geometrie M
– Pentru oţel inox și aliaje rezistente la temperaturi înalte



Geometrie K
– Prima alegere pentru găurire în fontă



Kit piese de schimb

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

Instrucţiuni de montare

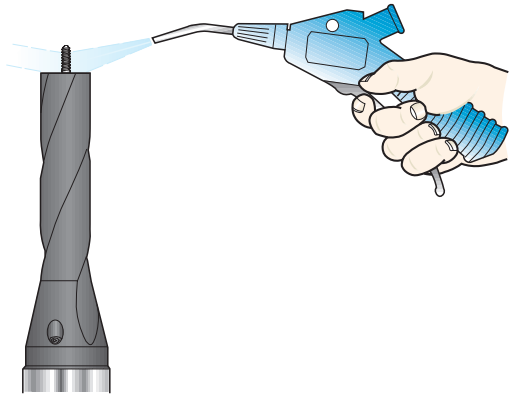
1. Curăţă cu atenţie suprafaţa de blocare a corpului burghiului pentru a îndepărta orice aşchie sau reziduu.
2. Asigură-te că tija centrală este extinsă la maxim.
3. Montează noua coroană în tijă și rotește până se ajunge la capătul filetului.

Rotește ușor coroana în sens antiorar (înapoi) până se fixează pe interfaţa de blocare.
Apasă coroana spre corpul burghiului în timp ce strângi șurubul de prindere.
Ai grijă ca interfaţa să se potrivească.
Strânge șurubul de prindere definitiv cu o cheie dinamometrică.

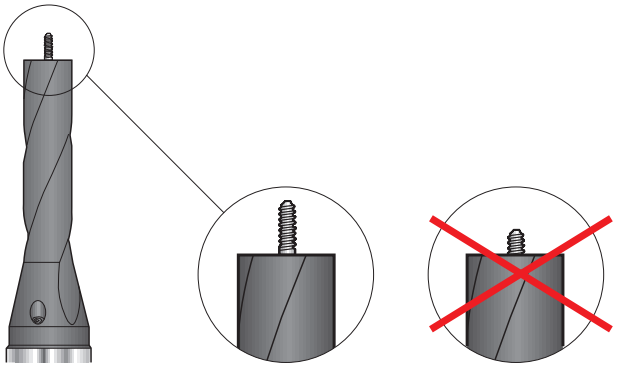
Stabilitate
Stabilitatea aplicaţiei este importantă pentru a obţine cea mai bună durată de viaţă a sculei și precizie a găurii. Verifică starea arborelui maşinii, fixarea și prinderea componentelor pentru a asigura un maxim de stabilitate și rigiditate. Condiţiile instabile pot duce la distrugerea sculei.

Rotative
Bătaia radială indicată totală (TIR) nu trebuie să depășească 0,06 mm *(0,002")* la o aplicaţie rotativă. Măsoară bătaia când burghiul este montat in arborele maşinii.

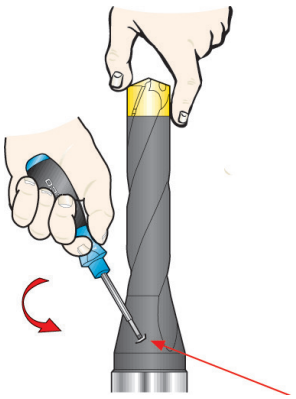
1.



2.

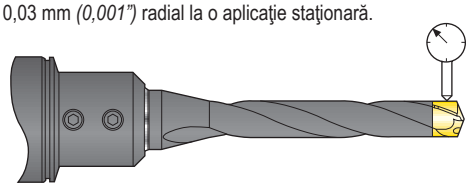


3.



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

Staţionare
Distanţa dintre vârful burghiului și centrul rotativ al piesei de prelucrat nu trebuie să depășească 0,03 mm *(0,001")* radial la o aplicaţie staţionară.



Port-scule recomandate
Pentru cele mai bune rezultate, utilizaţi port-scule tip DIN 1835 B/DIN 6535 HB (Weldon). Pentru informaţii suplimentare, consultaţi catalogul de scule.

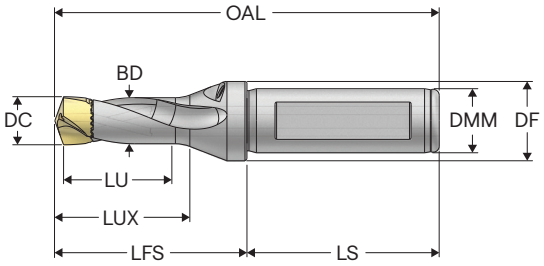


Weldon

SD101 – R7

Adâncime de găurire ~ 1,5 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 206

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Cheie de blocare	Șurub de blocare	Set piese de schimb
			
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

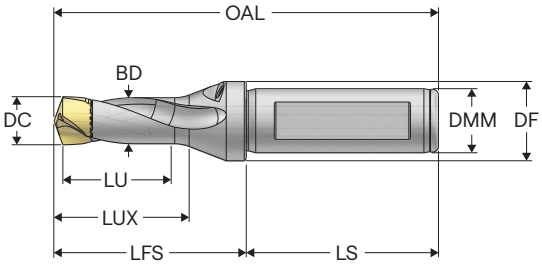
Accesorii

Lamă interschimbabilă	Cheie dinamometrică
	
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD101 – R7

Adâncime de găurire ~ 1,5 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 206

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

Piese de schimb, Piese incluse la livrare

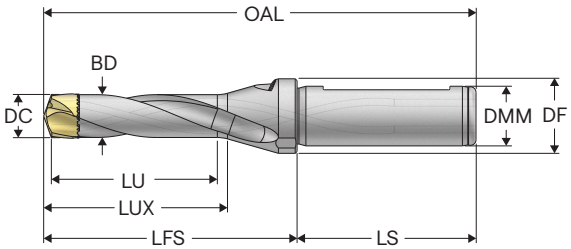
Accesorii

Pentru burghiu dia (inch)	Cheie de blocare	Șurub de blocare	Set piese de schimb	Lamă interschimbabilă	Cheie dinamometrică
					
0.472-0.551	H1.5-2D	MP6SS3X12	SD101-SP-5.0	H00-1.5	H00-1509
0.551-0.669	H2.0-2D	MP6SS4X12	SD101-SP-6.0	H00-2.0	H00-2020
0.669-0.787	H2.5-2D	MP6SS5X16	SD101-SP-7.0	H00-2.5	H00-2530
0.787-1.023	H2.5-2D	MP6SS5X16	SD101-SP-8.0	H00-2.5	H00-2535

SD103 – R7

Adâncime de găurire ~ 3 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 207

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Cheie de blocare	Șurub de blocare	Set piese de schimb
			
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

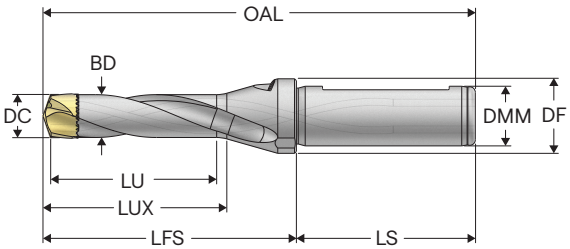
Accesorii

Lamă interschimbabilă	Cheie dinamometrică
	
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

Adâncime de găurire ~ 3 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 207

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Cheie de blocare	Șurub de blocare	Set piese de schimb
			
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

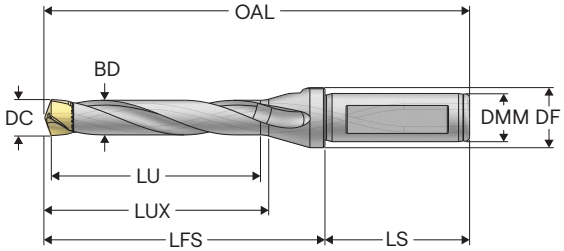
Accesorii

Lamă interschimbabilă	Cheie dinamometrică
	
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD105 – R7

Adâncime de găurire ~ 5 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 208

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Cheie de blocare	Șurub de blocare	Set piese de schimb
			
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

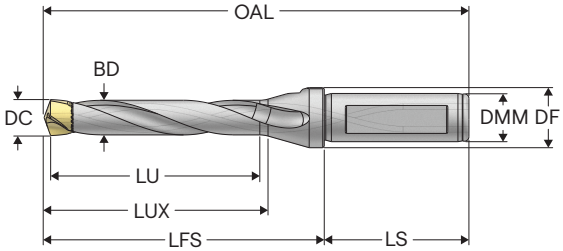
Accesorii

Lamă interschimbabilă	Cheie dinamometrică
	
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

Adâncime de găurire ~ 5 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 208

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Cheie de blocare	Șurub de blocare	Set piese de schimb
			
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

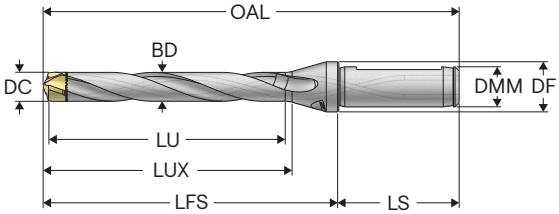
Accesorii

Lamă interschimbabilă	Cheie dinamometrică
	
H00-1.5	H00-1509
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD107 – R7

Adâncime de găurire ~ 7 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 209

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Cheie de blocare	Șurub de blocare	Set piese de schimb
			
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

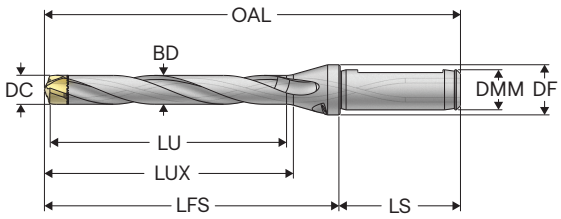
Accesorii

Lamă interschimbabilă	Cheie dinamometrică
	
H00-1.5	H00-1509
H00-2.0	H00-2020
H00-2.5	H00-2530
H00-2.5	H00-2535

SD107 – R7

Adâncime de găurire ~ 7 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 209

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

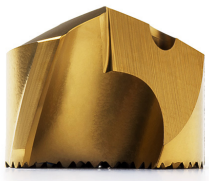
Piese de schimb, Piese incluse la livrare

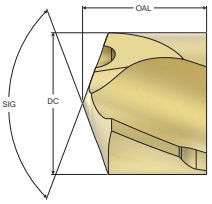
Accesorii

Pentru burghiu dia (inch)	Cheie de blocare	Șurub de blocare	Set piese de schimb	Lamă interschimbabilă	Cheie dinamometrică
					
0.472-0.551	H1.5-2D	MP6SS3X12	SD107-SP-5.0	H00-1.5	H00-1509
0.551-0.669	H2.0-2D	MP6SS4X12	SD107-SP-6.0	H00-2.0	H00-2020
0.669-0.787	H2.5-2D	MP6SS5X16	SD107-SP-7.0	H00-2.5	H00-2530
0.787-1.023	H2.5-2D	MP6SS5X16	SD107-SP-8.0	H00-2.5	H00-2535

Coroane – Geometrie -P, -M și -K

Unghi la vârf 140°



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

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

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

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

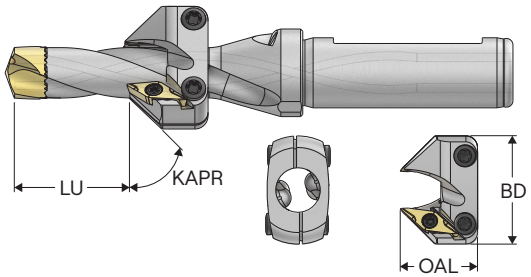
Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	*inci*	mm	*inci*
SD100-19.10-P	00030902	■	–	–	19,1	*0.752*	15,2	*0.598*
SD100-19.20-K	00071566	–	–	■	19,2	*0.756*	15,2	*0.598*
SD100-19.20-M	00071564	–	■	–	19,2	*0.756*	15,2	*0.598*
SD100-19.20-P	00071563	■	–	–	19,2	*0.756*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

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

■ Stoc standard.

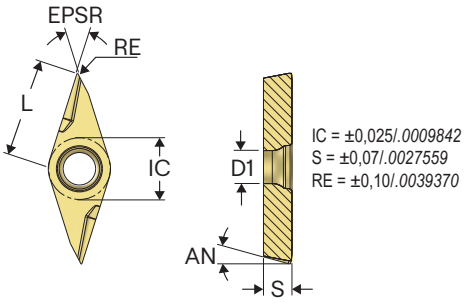
Modul pentru șanfrenat





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

Plăcuţă amovibilă

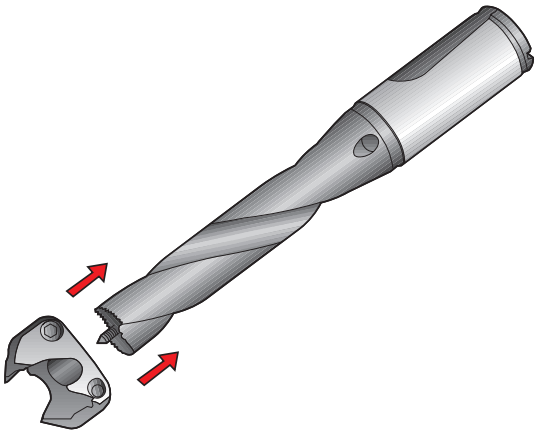


IC = ±0,025/*.0009842*
S = ±0,07/*.0027559*
RE = ±0,10/*.0039370*

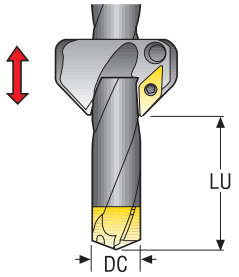
Toleranţe: mm/*inci*	Dimensiune	L mm/*inci*	EPSR	RE mm/*inci*	IC mm/*inci*	D1 mm/*inci*	AN	S mm/*inci*
	09	9,0/*.2187*	35°	0,2/*.0078*	5,556/*.2187*	2,9/*.1141*	7°	2,5/*.0984*
	Calitate: T400D							
	Denumire: VCGX090202-D1							
	Număr reper: 00014948							

Modul pentru șanfrenat – Instrucţiuni de montare/schimbare a modulului

1. Montează modulul pe burghiu fără plăcuţa de șanfrenat sau coroana montată.

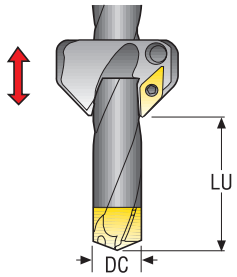


2.1 Dacă este posibil, montează modulul cât mai aproape de coadă.



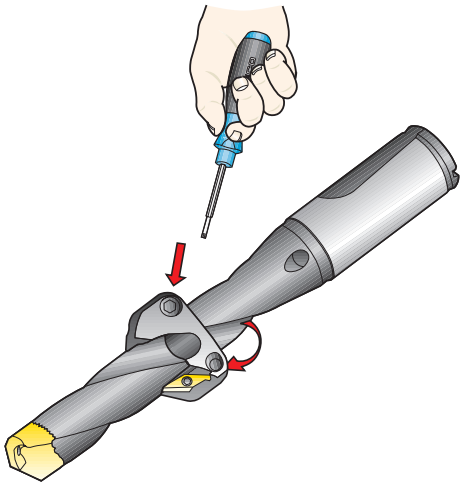
DC		Adâncimea de găurire LU (min-max)			
		SD101		SD103	
mm	inch	mm	inch	mm	inch
12	.472	12-13	.472-.512	12-28	.472-1.102
12,5	.492	12-14	.472-.551	12-29	.472-1.142
13	.512	13-14	.512-.551	13-29	.512-1.142
14	.551	14-20	.551-.787	14-40	.551-1.575
15	.591	14-21	.551-.827	14-41	.551-1.614
16	.630	15-22	.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 Dacă este posibil, montează modulul cât mai aproape de coadă.



DC		Adâncimea de găurire LU (min-max)			
		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

3. Strângeţi ambele șuruburi conform tabelului de mai jos.



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

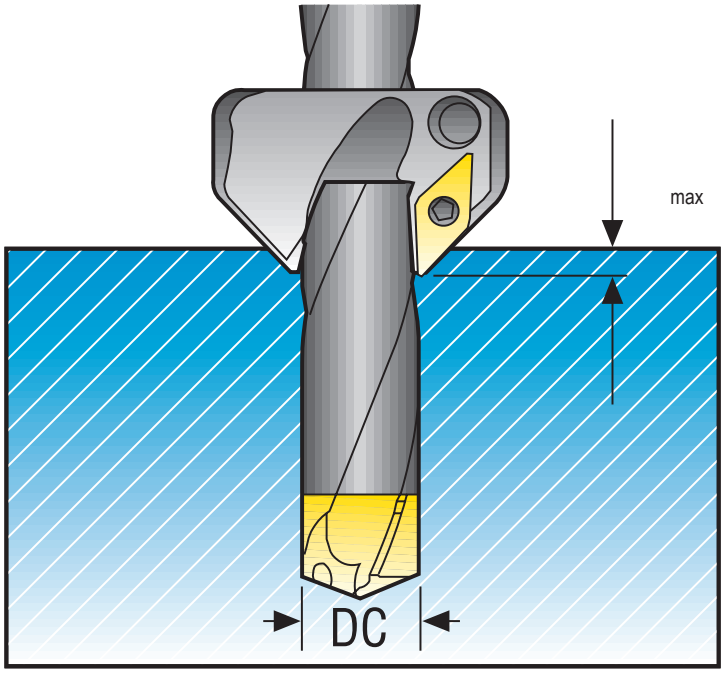
Modul pentru șanfrenat

Vitezele de așchiere și avansurile recomandate pentru Crownloc® de la paginile 206-209 se pot utiliza și în cazul operațiilor de șanfrenare.

Depanare

Vibrații în timpul șanfrenării	• Micșorează viteza de așchiere • Dacă este posibil, montează modulul mai aproape de coada burghiului • Dacă este posibil, utilizează un burghiu mai scurt

Adâncimea maximă a șanfrenului



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

SD101 – Ø 10-26 mm / *0.394-1.024 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

SD103 – Ø 10-26 mm / *0.394-1.024 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD105 – Ø 10-26 mm / *0.394-1.024 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD107 – Ø 10-26 mm / *0.394-1.024 inch*

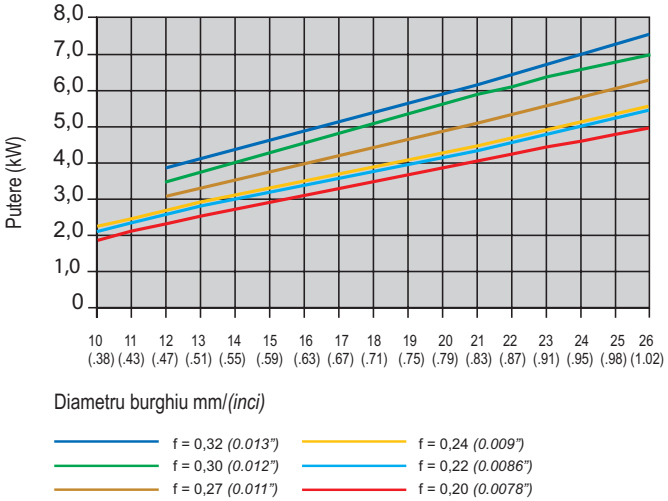
SMG		f								v_c
		Ø 12.00 *Ø 0.472*	Ø 14.00 *Ø 0.551*	Ø 16.00 *Ø 0.630*	Ø 18.00 *Ø 0.709*	Ø 20.00 *Ø 0.787*	Ø 22.00 *Ø 0.866*	Ø 24.00 *Ø 0.945*	Ø 26.00 *Ø 1.024*	
P1	P	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	110
	P	*0.0095*	*0.010*	*0.011*	*0.012*	*0.013*	*0.013*	*0.013*	*0.014*	*360*
P2	P	0,24	0,26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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

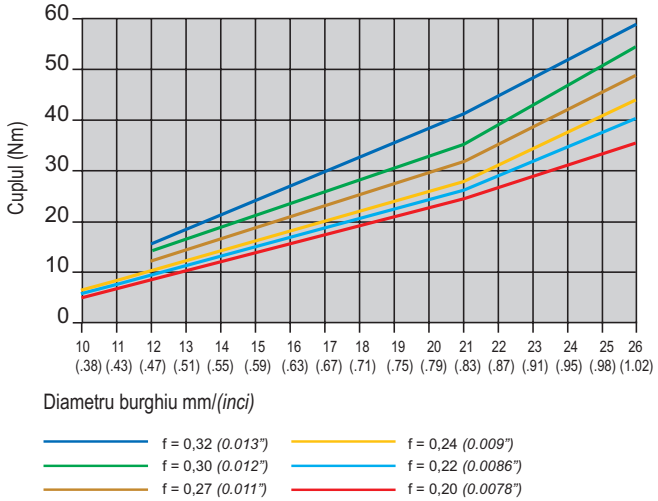
Parametri de prelucrare

Valorile din grafic pot varia în funcţie de ex. regimurile de aşchiere, materialul, eficienţa maşinii şi uzura sculei.
Graficele de mai jos sunt valabile pentru Grupa de materiale Seco (SMG) P5-P6 şi viteza de aşchiere de 90 m/min (*295 sf/m*).

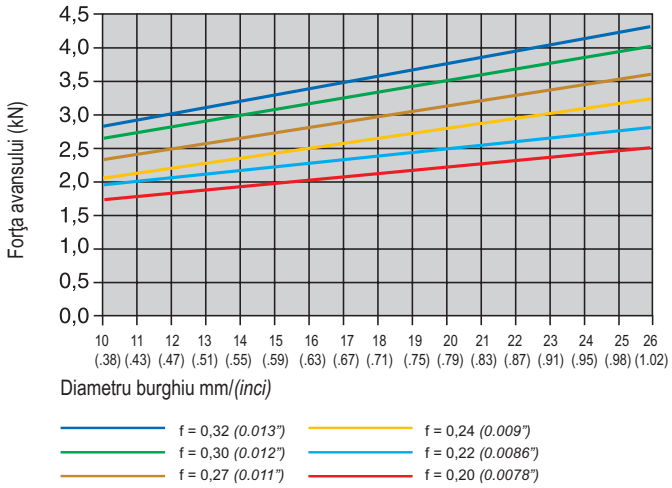
Consumul net de putere



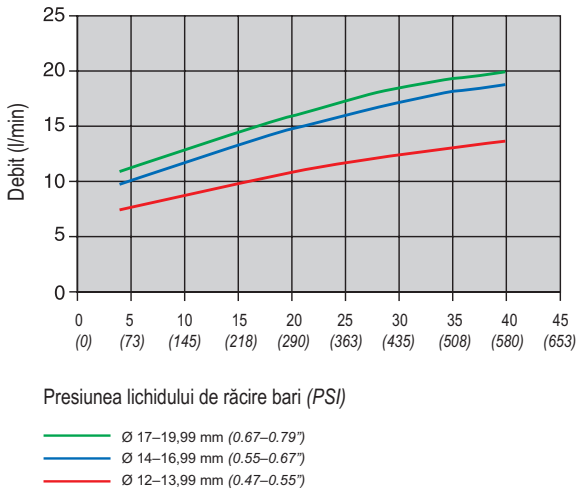
Cuplul la găurire



Forţa avansului



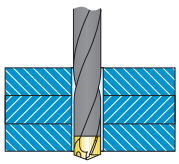
Debitul lichidului de răcire la diferite presiuni



Debit de lichid de răcire recomandat Dx1 l/min
Debit de lichid de răcire minim D/2 l/min
D = diametrul burghiului
Presiune minimă recomandată a lichidului de răcire 10 bari *(145 PSI)* cu < 3 x D
Presiune minimă recomandată a lichidului de răcire 20 bari *(290 PSI)* cu > 3 x D
Presiune minimă recomandată a lichidului de răcire 40 bari *(580 PSI)* cu > 5 x D

Amestec de lichid de răcire
Amestec emulsie recomandat 6-8%.
Când se găureşte în oţel inox, superaliaje şi oţeluri de înaltă rezistenţă se recomandă un amestec de 10%.

Recomandări de prelucrare
Este posibil să găuriţi materiale suprapuse, cât timp piesele sunt bine fixate împreună, astfel încât să nu existe goluri de aer intre ele. Golurile de aer pot influenţa evacuarea aşchiilor, şi pot duce chiar la distrugerea burghiului.



Toleranţa găurii/Finisarea suprafeţei

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

Burghiu ∅ DC (mm)	Toleranţa IT9 (µm)	Toleranţa IT10 (µm)	Burghiu ∅ DC *(inci)*	Toleranţa IT9 *(inci)*	Toleranţa IT10 *(inci)*
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*

*Deteriorarea finisării suprafeţei şi a toleranţei găurii pot apărea când găuriţi în oţel cu conţinut redus de carbon sau în oţel inox. Utilizaţi cel mai scurt burghiu posibil pentru a obţine o calitate maximă a găurii.

Depanare – Condiţii iniţiale:

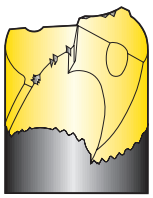
- Stabilitatea prinderii
- Starea arborelui maşinii
- Starea port-sculei

- Prinderea sculei:
  - Bătaie radială max. 0,06 TIR

- Îndepărtarea aşchiilor:
  – regimuri de frezare

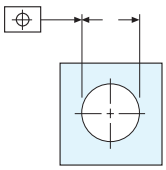
- Lichid de răcire:
  - Presiune
  - Debit
  - Concentraţie

Muchiile aşchietoare sunt ciupite



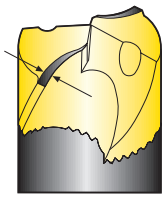
- Reduceţi avansul/rot
- Dacă burghiul vibrează, reduceţi viteza de aşchiere şi măriţi avansul
- La găurirea unor suprafeţe dure şi neregulate, reduceţi avansul cu 30%-50% la intrare şi la ieşire

Toleranţa diametrului nesatisfăcătoare



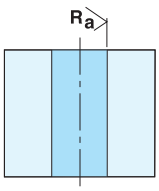
- Măriţi avansul/rotaţia
- Utilizaţi un burghiu din carbură solidă Seco Feedmax, consultaţi paginile 19-22
- Utilizaţi o operaţie de alezare, consultaţi paginile 328
- Utilizaţi o operaţie de alezare adâncă, consultaţi paginile 479-480

Uzură rapidă a flancurilor



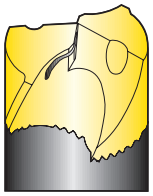
- Verifică dacă se utilizează geometria corectă
- Reduceţi viteza de aşchiere

Finisare slabă a suprafeţei



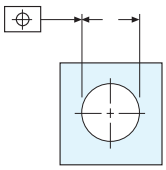
- Reduceţi avansul/rot
- Măriţi viteza de aşchiere
- Verifică dacă se utilizează geometria corectă
- Utilizaţi un burghiu de carbură Feedmax - vezi pag. 19-22
- Utilizaţi o operaţie de alezare cu alezor solid - vezi pag. 328

Uzura canelurii



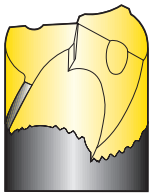
- Reduceţi avansul/rot
- Reduceţi viteza de aşchiere
- Măriţi concentraţia lichidului de răcire

Poziţionarea găurii nesatisfăcătoare



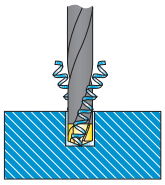
- Reduceţi avansul/rotaţie
- La găurirea prin suprafeţe neregulate, tari şi înclinate – reduceţi avansul cu 30-50% la intrare şi la ieşire
- Pregăurire cu un burghiu cu unghi la vârf de 140°
- Utilizaţi un burghiu din carbură solidă Feedmax, consultaţi paginile despre Feedmax 19-22
- Utilizaţi o operaţie de alezare adâncă, consultaţi paginile 479-480

Uzură a marginilor laterale periferice



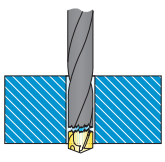
- Verificaţi dacă se utilizează geometria corectă
- Reduceţi viteza de aşchiere
- Măriţi concentraţia lichidului de răcire
- La găurirea prin suprafeţe neregulate, tari sau înclinate, reduceţi rata de avans cu 30-50% la intrare şi la ieşire

Probleme cu blocarea aşchiilor din cauza aşchiilor lungi



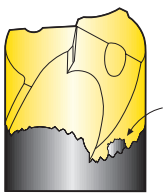
- Măriţi avansul
- La materiale care produc aşchii lungi SMG P1-P4, SMG M1-M2:
  - Măriţi viteza de aşchiere şi reduceţi avansul/rotaţie
  - Utilizaţi geometria L (model personalizat)

Spargere la ieşirea din material



- Dacă conexiunea coroanei se rupe atunci când coroana este pe cale să iasă din material. Defectul este cauzat de:
  - Interfaţa nu a fost curăţată temeinic şi există murdărie sau aşchii rămase între coroană şi corpul de burghiu
  - Coroana nu a fost bine prinsă. Utilizaţi cheia dinamometrică
  - Coroana este fixată cu prea puţin filet

Ciupituri ale suprafeţei de aşezare



- Ciupiturile minore nu sunt periculoase pentru sistemul de prindere. Nu vor afecte rezultatul găuririi
- Dacă apar ciupituri majore la utilizarea unui avans mare sau când se găureşte printr-o suprafaţă înclinată - reduceţi rata avansului



Crownloc® Plus

Seco Crownloc® Plus este o nouă generaţie de burghie Seco cu coroane interschimbabile. Dispunând de o nouă interfaţă de blocare, Crownloc Plus îmbunătăţeşte îndepărtarea aşchiilor şi rezistenţa la uzură pentru o varietate de materiale.

- Un model de corp de burghiu robust, interfaţă de blocare de mare putere cu caneluri adânci şi late şi corp lustruit.
- Alegerea numărul unu pentru aplicaţii generale, geometria P reprezintă o soluţie robustă şi versatilă.
- Geometria M oferă performanţe excelente în aliaje de temperatură ridicată, titan, aliaje de titan şi oţel inox

Privire generală

Crownloc® Plus	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurilor (1)	Finisarea suprafeţei (2)
SD403 	Pag. 216-219	Ø 12,00-19,99 mm *(0.472-0.787")*	~ 3 x D	k7	IT 9-10	Ra 1-3 µm *(Ra 39-118 µin)*
SD405 	Pag. 220-223	Ø 12,00-19,99 mm *(0.472-0.787")*	~ 5 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*
SD408 	Pag. 224-227	Ø 12,00-19,99 mm *(0.472-0.787")*	~ 8 x D	k7	IT 10	Ra 1-3 µm *(Ra 39-118 µin)*

1) pot apărea variaţii în funcţie de material şi de parametrii de aşchiere utilizaţi.
2) adâncimea de găurire, parametrii de aşchiere, presiunea lichidului de răcire şi materialul pot provoca deteriorarea finisajului suprafeţei.

Codificări



Corpuri de burghiu Crownloc® Plus

Metric

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

Inci

45	–	0750	–	R	7
3		4		5	6

1.
Tip burghiu
SD403: 3 x D
SD405: 5 x D
SD408: 8 x D

2.
Diam. coroană
min/max

3.
Adâncimea de găurire

4.
Diametru coadă

5.
Sens de rotaţie spre dreapta

6
Tip de coadă
1. Cilindrică
7. ISO 9766

Codificare coroane

SD400	–	14.00	–	P
		2		3

2.
Diametru burghiu

3.
Tipul geometriei
P = oţel
M = oţel inox



Geometrii

Geometria P
– Geometrie universală, prima alegere pentru găurirea în oţel



Geometrie M
– Pentru oţel inox și aliaje rezistente la temperaturi înalte



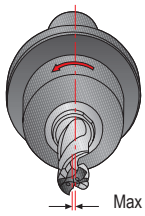
Instrucţiuni de montare

1. Stabilitate

Stabilitatea aplicaţiei este importantă pentru a obţine cea mai bună durată de viaţă a sculei şi toleranţa găurii. Verifică starea arborelui maşinii, fixarea şi prinderea componentelor pentru a asigura un maxim de stabilitate şi rigiditate.
Condiţiile instabile pot duce la distrugerea sculei.

2. Aplicaţii dinamice

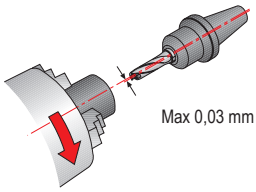
Bătaia radială indicată totală (TIR) nu trebuie să depăşească 0,06 mm *(0,002")* la o aplicaţie rotativă.
Măsoară bătaia burghiul la rotirea cu 360° în arborele maşinii.



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

3. Staţionare

Distanţa dintre vârful burghiului şi centrul rotativ al piesei de prelucrat nu trebuie să depăşească 0,03 mm *(0,001")* radial la o aplicaţie staţionară.



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

4. Port-scule recomandate

Seco Tools oferă o gamă largă de port-scule (mandrine cu pensete, port-scule Shrinkfit, mandrine hidraulice Weldon etc.), disponibile pentru o varietate de tipuri de capete de alezare.
Pentru cele mai bune rezultate, utilizaţi conuri ERHP 5672, Mandrină de înaltă precizie.
Pentru informaţii suplimentare, consultaţi catalogul de port-scule.



Mandrină cu pensete de înaltă precizie
(Doar pentru coadă cilindrică, -R1)



Prindere hidraulică
(Doar pentru coadă cilindrică, -R1)

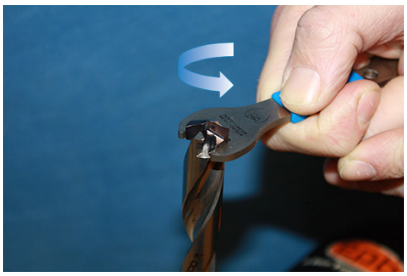


Weldon

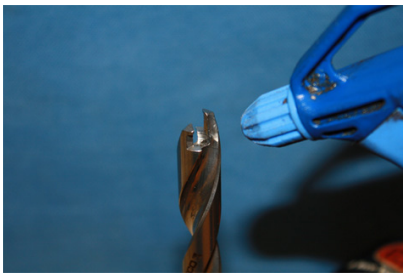
1. Pentru desfacerea coroanei, găseşte cele două aplatizări de pe Coroană pentru cheie.



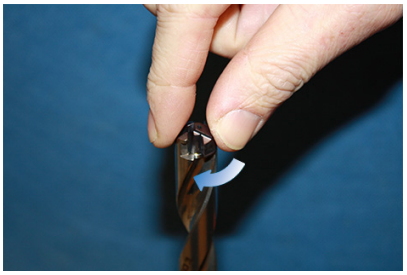
2. Roteşte cheia în sens antiorar pentru a debloca coroana cu un sfert de tură.



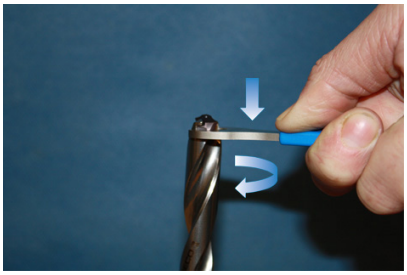
3. Curăţă conexiunea înainte de montarea coroanei.



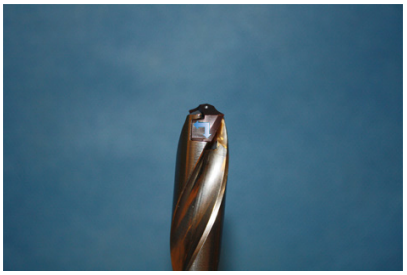
4. Strânge coroana la mână înainte de a utiliza cheia de strângere.



5. Strânge un sfert de tură cu ajutorul cheii în sensul acelor de ceasornic apăsând simultan coroana ţinând cheia perpendicular pe corpul burghiului.



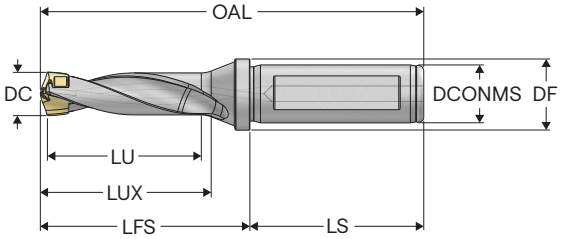
6. Atunci când coroana este montată în corpul burghiului, trebuie să existe un contact perfect între suprafaţa de contact a coroanei şi corpul burghiului, vezi figura.



SD403 – R7

Adâncime de găurire ~ 3 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 232

Reper Nr.	Număr reper	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

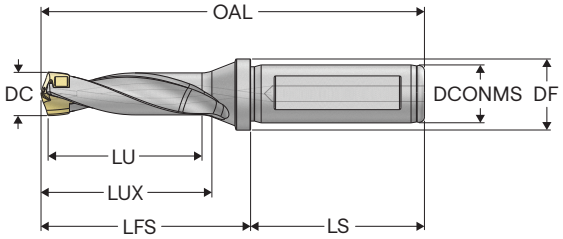
Accesorii

Pentru burghiu dia (mm)	Cheie
	
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

Adâncime de găurire ~ 3 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 232

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

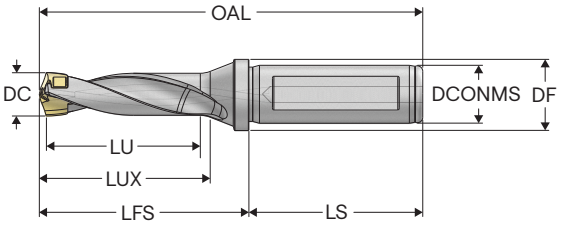
Accesorii

Pentru burghiu dia (inch)	Cheie
	
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

Adâncime de găurire ~ 3 x D – Coadă metric





—Agent de răcire intern
—Coada cilindrică (R1) se potrivește cu portsculele: 5834/HC/HCR/HCS și 5672
—Regimuri de așchiere, vezi pagina(paginile) 232

Reper Nr.	Număr reper	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

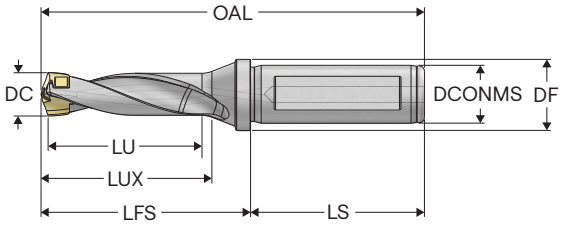
Accesorii

Pentru burghiu dia (mm)	Cheie
	
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

Adâncime de găurire ~ 3 x D – Coadă inci





—Agent de răcire intern
—Coada cilindrică (R1) se potrivește cu portsculele: 5834/HC/HCR/HCS și 5672
—Regimuri de așchiere, vezi pagina(paginile) 232

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

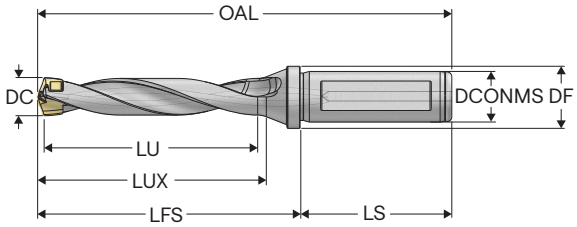
Accesorii

Pentru burghiu dia (inch)	Cheie
	
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

Adâncime de găurire ~ 5 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 233

Reper Nr.	Număr reper	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

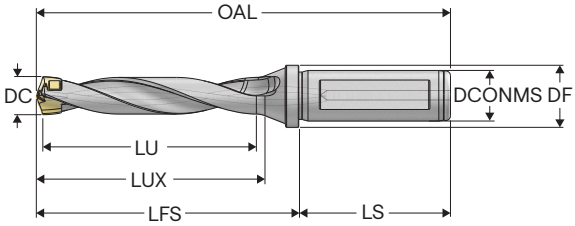
Accesorii

Pentru burghiu dia (mm)	Cheie
	
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

Adâncime de găurire ~ 5 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 233

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

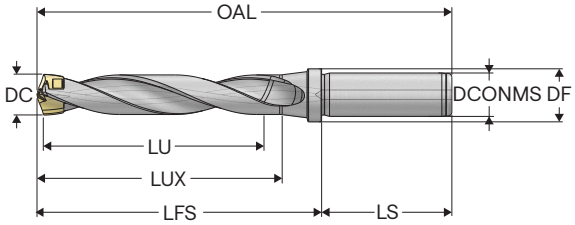
Accesorii

Pentru burghiu dia (inch)	Cheie
	
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

Adâncime de găurire ~ 5 x D – Coadă metric





—Agent de răcire intern
—Coada cilindrică (R1) se potrivește cu portsculele: 5834/HC/HCR/HCS și 5672
—Regimuri de așchiere, vezi pagina(paginile) 233

Reper Nr.	Număr reper	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

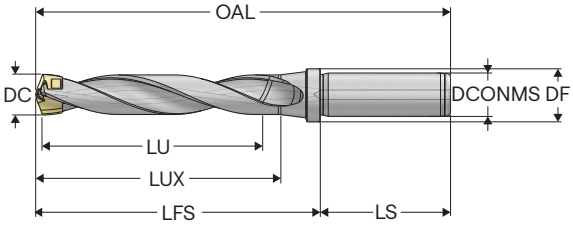
Accesorii

Pentru burghiu dia (mm)	Cheie
	
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

SD405 – R1

Adâncime de găurire ~ 5 x D – Coadă inci





—Agent de răcire intern
—Coada cilindrică (R1) se potrivește cu portsculele: 5834/HC/HCR/HCS și 5672
—Regimuri de așchiere, vezi pagina(paginile) 233

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

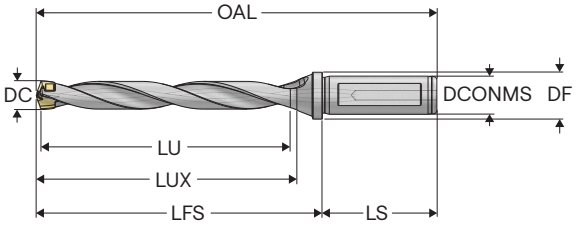
Accesorii

Pentru burghiu dia (inch)	Cheie
	
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

Adâncime de găurire ~ 8 x D – Coadă metric





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 234

Reper Nr.	Număr reper	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

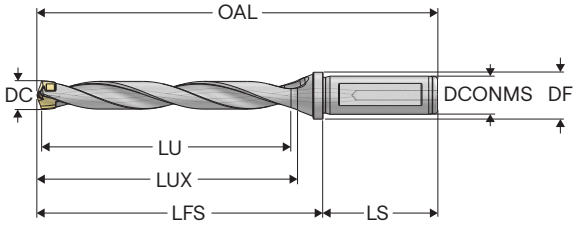
Accesorii

Pentru burghiu dia (mm)	Cheie
	
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

Adâncime de găurire ~ 8 x D – Coadă inci





—Agent de răcire intern
—ISO9766 se potrivește suporturilor: Weldon 1835B, ISO 5414, DIN 60880
—Regimuri de așchiere, vezi pagina(paginile) 234

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

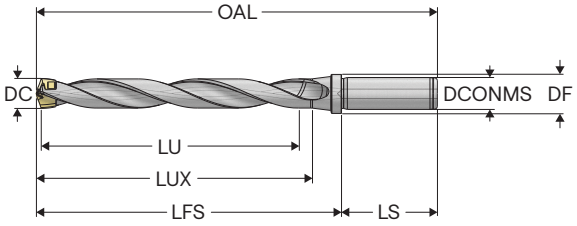
Accesorii

Pentru burghiu dia (inch)	Cheie
	
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

Adâncime de găurire ~ 8 x D – Coadă metric





—Agent de răcire intern
—Coada cilindrică (R1) se potrivește cu portsculele: 5834/HC/HCR/HCS și 5672
—Regimuri de așchiere, vezi pagina(paginile) 234

Reper Nr.	Număr reper	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

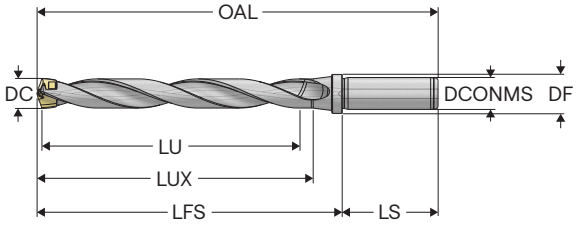
Accesorii

Pentru burghiu dia (mm)	Cheie
	
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

Adâncime de găurire ~ 8 x D – Coadă inci





—Agent de răcire intern
—Coada cilindrică (R1) se potrivește cu portsculele: 5834/HC/HCR/HCS și 5672
—Regimuri de așchiere, vezi pagina(paginile) 234

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

Accesorii

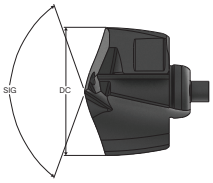
Pentru burghiu dia (inch)	Cheie
	
0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

Coroane – Geometrie -P și -M

Unghi la vârf 140°







Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	DC	
				mm	*inci*
SD400-12.00-M	02826210	–	■	12,0	*0.472*
SD400-12.00-P	02630908	■	–	12,0	*0.472*
SD400-12.10-P	02630910	■	–	12,1	*0.476*
SD400-12.20-P	02630911	■	–	12,2	*0.480*
SD400-12.30-M	02826211	–	■	12,3	*0.484*
SD400-12.30-P	02630912	■	–	12,3	*0.484*
SD400-12.41-P	02630913	■	–	12,41	*0.489*
SD400-12.50-M	02826213	–	■	12,5	*0.492*
SD400-12.50-P	02630915	■	–	12,5	*0.492*
SD400-12.60-P	02630916	■	–	12,6	*0.496*
SD400-12.70-M	02826214	–	■	12,7	*0.500*
SD400-12.70-P	02630917	■	–	12,7	*0.500*
SD400-12.80-M	02826215	–	■	12,8	*0.504*
SD400-12.80-P	02630918	■	–	12,8	*0.504*
SD400-12.90-P	02630919	■	–	12,9	*0.508*
SD400-13.00-M	02826217	–	■	13,0	*0.512*
SD400-13.00-P	02634577	■	–	13,0	*0.512*
SD400-13.10-M	02826218	–	■	13,1	*0.516*
SD400-13.10-P	02634578	■	–	13,1	*0.516*
SD400-13.20-P	02634579	■	–	13,2	*0.520*
SD400-13.30-M	02826219	–	■	13,3	*0.524*
SD400-13.30-P	02634580	■	–	13,3	*0.524*
SD400-13.50-M	02826220	–	■	13,5	*0.531*
SD400-13.50-P	02634581	■	–	13,5	*0.531*
SD400-13.70-P	02634582	■	–	13,7	*0.539*
SD400-13.80-M	02826222	–	■	13,8	*0.543*
SD400-13.80-P	02634583	■	–	13,8	*0.543*
SD400-13.89-M	02826223	–	■	13,89	*0.547*
SD400-13.89-P	02634584	■	–	13,89	*0.547*
SD400-14.00-M	02826224	–	■	14,0	*0.551*
SD400-14.00-P	02634589	■	–	14,0	*0.551*
SD400-14.10-P	02634590	■	–	14,1	*0.555*
SD400-14.20-M	02826225	–	■	14,2	*0.559*
SD400-14.20-P	02634591	■	–	14,2	*0.559*
SD400-14.288-M	02826226	–	■	14,29	*0.563*
SD400-14.288-P	02634592	■	–	14,288	*0.563*
SD400-14.40-P	02634593	■	–	14,4	*0.567*
SD400-14.50-M	02826227	–	■	14,5	*0.571*
SD400-14.50-P	02634594	■	–	14,5	*0.571*
SD400-14.70-M	02826229	–	■	14,7	*0.579*
SD400-14.80-M	02826230	–	■	14,8	*0.583*
SD400-14.80-P	02634597	■	–	14,8	*0.583*
SD400-14.90-P	02634598	■	–	14,9	*0.587*
SD400-15.00-M	02826232	–	■	15,0	*0.591*

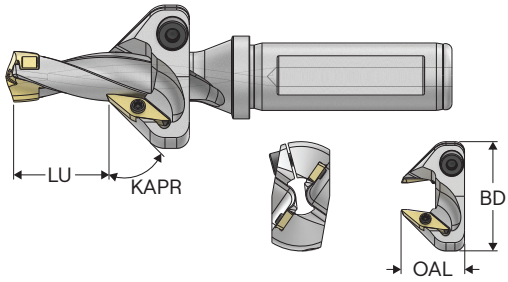
Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	DC	
				mm	*inci*
SD400-15.00-P	02634599	■	–	15,0	*0.591*
SD400-15.08-M	02826233	–	■	15,08	*0.594*
SD400-15.08-P	02634600	■	–	15,08	*0.594*
SD400-15.10-P	02634601	■	–	15,1	*0.594*
SD400-15.20-P	02634602	■	–	15,2	*0.598*
SD400-15.25-M	02826234	–	■	15,25	*0.600*
SD400-15.25-P	02634603	■	–	15,25	*0.600*
SD400-15.478-M	02826235	–	■	15,48	*0.609*
SD400-15.478-P	02634604	■	–	15,478	*0.609*
SD400-15.50-M	02826236	–	■	15,5	*0.610*
SD400-15.50-P	02634605	■	–	15,5	*0.610*
SD400-15.70-M	02826237	–	■	15,7	*0.618*
SD400-15.70-P	02634607	■	–	15,7	*0.618*
SD400-15.80-P	02634608	■	–	15,8	*0.622*
SD400-15.875-M	02826239	–	■	15,88	*0.625*
SD400-15.875-P	02634609	■	–	15,875	*0.625*
SD400-16.00-M	02826240	–	■	16,0	*0.630*
SD400-16.00-P	02635956	■	–	16,0	*0.630*
SD400-16.10-P	02635957	■	–	16,1	*0.634*
SD400-16.20-P	02635958	■	–	16,2	*0.638*
SD400-16.25-P	02635959	■	–	16,25	*0.640*
SD400-16.27-M	02826241	–	■	16,27	*0.641*
SD400-16.50-M	02826242	–	■	16,5	*0.650*
SD400-16.50-P	02635963	■	–	16,5	*0.650*
SD400-16.669-M	02826243	–	■	16,67	*0.656*
SD400-16.669-P	02635964	■	–	16,669	*0.656*
SD400-16.70-M	02826244	–	■	16,7	*0.657*
SD400-16.70-P	02635966	■	–	16,7	*0.657*
SD400-16.80-P	02635968	■	–	16,8	*0.661*
SD400-16.90-P	02635969	■	–	16,9	*0.665*
SD400-17.00-M	02826246	–	■	17,0	*0.669*
SD400-17.00-P	02635970	■	–	17,0	*0.669*
SD400-17.065-M	02826247	–	■	17,07	*0.672*
SD400-17.10-P	02635973	■	–	17,1	*0.673*
SD400-17.20-P	02635974	■	–	17,2	*0.677*
SD400-17.35-P	02888828	■	–	17,35	*0.683*
SD400-17.463-M	02826248	–	■	17,46	*0.687*
SD400-17.463-P	02635975	■	–	17,463	*0.688*
SD400-17.50-M	02826249	–	■	17,5	*0.689*
SD400-17.50-P	02635976	■	–	17,5	*0.689*
SD400-17.70-M	02826250	–	■	17,7	*0.697*
SD400-17.70-P	02635977	■	–	17,7	*0.697*
SD400-17.80-M	02826251	–	■	17,8	*0.701*
SD400-17.90-M	02826253	–	■	17,9	*0.705*
SD400-17.90-P	02635980	■	–	17,9	*0.705*
SD400-18.00-M	02826254	–	■	18,0	*0.709*
SD400-18.00-P	02635981	■	–	18,0	*0.709*
SD400-18.10-P	02635982	■	–	18,1	*0.713*
SD400-18.20-P	02635983	■	–	18,2	*0.717*
SD400-18.256-M	02826255	–	■	18,26	*0.719*
SD400-18.50-M	02826256	–	■	18,5	*0.728*
SD400-18.50-P	02635985	■	–	18,5	*0.728*
SD400-18.70-P	02635987	■	–	18,7	*0.736*
SD400-18.80-P	02635988	■	–	18,8	*0.740*

Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	DC	
				mm	*inci*
SD400-18.90-M	02826260	–	■	18,9	*0.744*
SD400-19.00-M	02826261	–	■	19,0	*0.748*
SD400-19.00-P	02635991	■	–	19,0	*0.748*
SD400-19.05-M	02826262	–	■	19,05	*0.750*
SD400-19.05-P	02635992	■	–	19,05	*0.750*
SD400-19.10-P	02635993	■	–	19,1	*0.752*
SD400-19.20-M	02826263	–	■	19,2	*0.756*
SD400-19.20-P	02635995	■	–	19,2	*0.756*
SD400-19.447-P	02635997	■	–	19,447	*0.766*
SD400-19.50-M	02826265	–	■	19,5	*0.768*
SD400-19.50-P	02635998	■	–	19,5	*0.768*
SD400-19.70-P	02635999	■	–	19,7	*0.776*
SD400-19.80-M	02826267	–	■	19,8	*0.780*
SD400-19.80-P	02636000	■	–	19,8	*0.780*
SD400-19.844-M	02826268	–	■	19,84	*0.781*
SD400-19.844-P	02636001	■	–	19,844	*0.781*
SD400-19.90-M	02826269	–	■	19,9	*0.783*
SD400-19.90-P	02636002	■	–	19,9	*0.783*

■ Stoc standard.

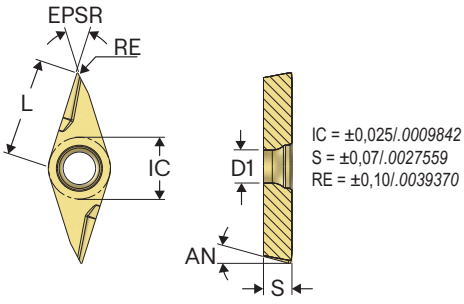
Modul pentru șanfrenat





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

Plăcuţă amovibilă



Dimensiune	Toleranţe: mm/*inci* L mm/*inci*	EPSR	RE mm/*inci*	IC mm/*inci*	D1 mm/*inci*	AN	S mm/*inci*
09	**9,0**/*.2187*	**35°**	**0,2**/*.0078*	**5,556**/*.2187*	**2,9**/*.1141*	**7°**	**2,5**/*.0984*
Calitate: T400D							
Denumire: VCGX090202-D1							
Număr reper: 00014948							

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

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

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

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

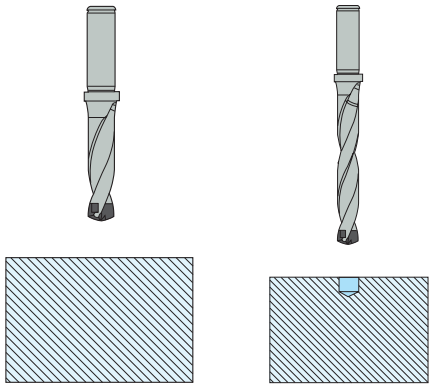
SMG		f					v_c
		Ø 12,00 *Ø 0.472*	Ø 14,00 *Ø 0.551*	Ø 16,00 *Ø 0.630*	Ø 18,00 *Ø 0.709*	Ø 20,00 *Ø 0.787*	
P1	P	0,30	0,32	0,34	0,36	0,36	100
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.014*	*330*
P2	P	0,30	0,32	0,34	0,36	0,38	100
	P	*0.012*	*0.013*	*0.013*	*0.014*	*0.015*	*330*
P3	P	0,28	0,30	0,32	0,34	0,36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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toți parametri de așchiere sunt valori de start.

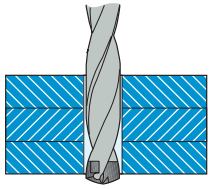
Informaţii despre aplicaţie

Informaţii despre aplicaţie

Suprafaţa prelucrată
Nu este necesară pre-găurirea sau avansul la intrare când se utilizează SD403 sau SD405. Când se utilizează SD408 se recomandă pre-găurirea. (La utilizarea SD405 în oţel inox poate fi necesară o operaţie de pregăurire).



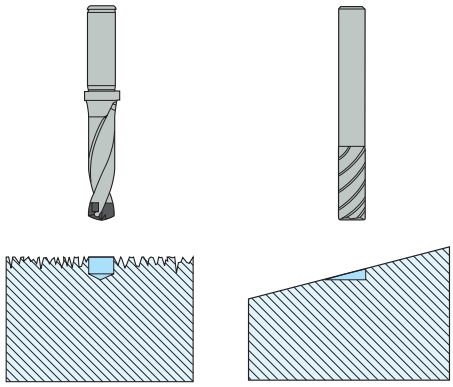
Materiale suprapuse
Este posibil să găuriţi materiale suprapuse, cât timp piesele sunt bine fixate împreună, astfel încât să nu existe goluri de aer intre ele. Golurile de aer pot influenţa evacuarea aşchiilor, şi pot duce chiar la distrugerea burghiului.



Intrare neregulată/înclinată în gaură

La intrarea în gaură neregulată sau înclinată utilizaţi operaţii pregătitoare corespunzătoare. La utilizarea unui burghiu >3 x D executaţi o pre-găurire cu o scula standard ex. SD403 este recomandat.

Operaţie alternativă de pre-găurire



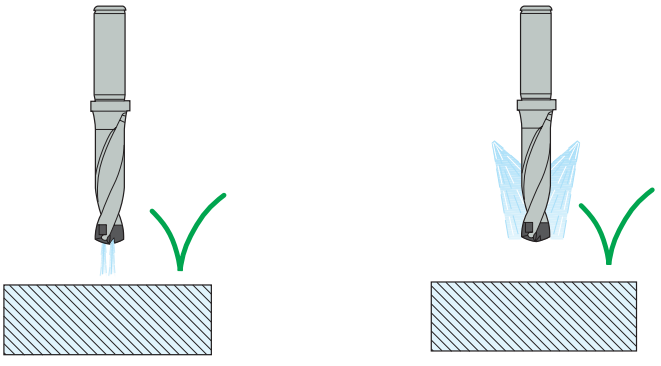
Intrarea neregulată în gaură

Intrarea înclinată în gaură

Prelucraţi o suprafaţă plană cu o freză din gama Seco.

Recomandări de lichid de răcire

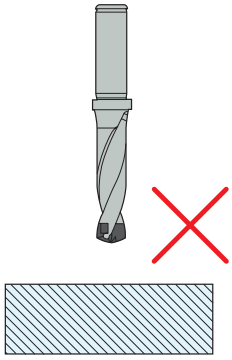
Presiune lichid de răcire
Presiunea minimă recomandată a lichidului de răcire 10 bari (145 PSI) cu ≤ 3 x D
Presiunea minimă recomandată a lichidului de răcire 30 bari (435 PSI) cu > 3 x D



Prima alegere

< 3 x D

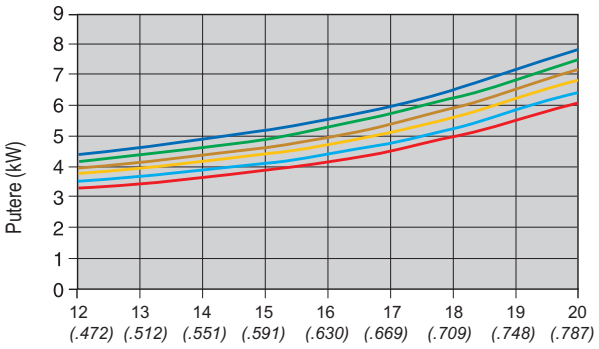
Concentraţia emulsiei
Amestec emulsie recomandat 6-8%. Când se găureşte în oţel inox, superaliaje şi oţeluri de înaltă rezistenţă se recomandă un amestec de 10%



Parametri de prelucrare

Valorile din grafic pot varia în funcţie de ex. regimurile de aşchiere, materialul, eficienţa maşinii şi uzura sculei.
Graficele de mai jos sunt valabile pentru Grupa de materiale Seco (SMG) P5-P6 şi viteza de aşchiere de 90 m/min (*295 sf/m*).

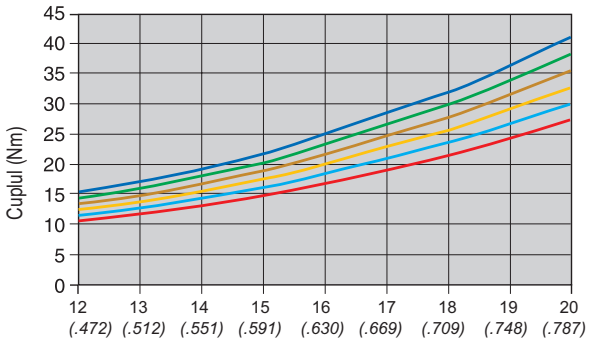
Consumul net de putere



Diametru burghiu mm/*(inci)*

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

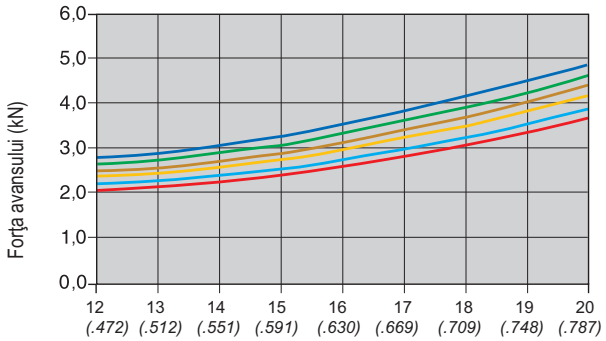
Cuplul la găurire



Diametru burghiu mm/*(inci)*

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

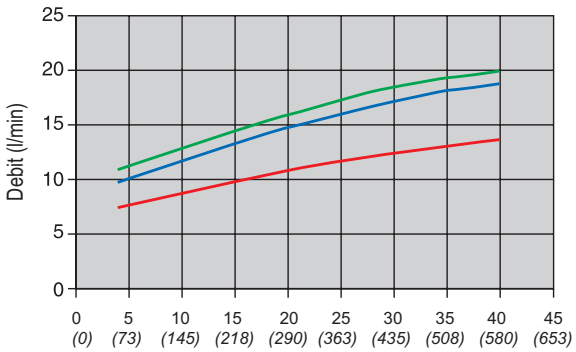
Forţa avansului



Diametru burghiu mm/*(inci)*

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

Debitul lichidului de răcire la diferite presiuni



Presiunea lichidului de răcire bari *(PSI)*

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

Debit de lichid de răcire recomandat Dx1 l/min
Debit de lichid de răcire minim D/2 l/min
D = diametrul burghiului
Presiune minimă recomandată a lichidului de răcire 10 bari *(145 PSI)* cu ≤ 3 x D
Presiune minimă recomandată a lichidului de răcire 20 bari *(290 PSI)* cu ≤ 5 x D
Presiune minimă recomandată a lichidului de răcire 40 bari *(580 PSI)* cu > 5 x D

Amestec de lichid de răcire
Amestec emulsie recomandat 6-8%.
Când se găureşte în oţel inox, superaliaje şi oţeluri de înaltă rezistenţă se recomandă un amestec de 10%.

Toleranţa găurii/Finisarea suprafeţei

SD403, SD405 şi SD408 IT9-10 / R_a 1-4*, *R_a 39-157 µin**					
Burghiu ∅ DC (mm)	**Toleranţa IT9 (µm)**	**Toleranţa IT10 (µm)**	**Burghiu ∅ DC** *(inci)*	**Toleranţa IT9** *(inci)*	**Toleranţa IT10** *(inci)*
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*

*Deteriorarea finisării suprafeţei şi a toleranţei găurii pot apărea când găuriţi în oţel cu conţinut redus de carbon sau în oţel inox. Utilizaţi cel mai scurt burghiu posibil pentru a obţine o calitate maximă a găurii.

Depanare – Condiţii iniţiale:

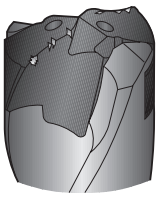
- Stabilitatea prinderii
- Starea arborelui maşinii
- Starea port-sculei

- Prinderea sculei:
  - Bătaie radială max. 0,06 TIR

- Îndepărtarea aşchiilor:
  – regimuri de frezare

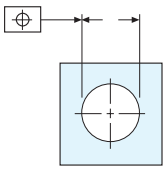
- Lichid de răcire:
  - Presiune
  - Debit
  - Concentraţie

Muchiile aşchietoare sunt ciupite



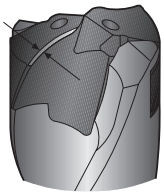
- Reduceţi avansul/rot
- Dacă burghiul vibrează, reduceţi viteza de aşchiere şi măriţi avansul
- La găurirea unor suprafeţe dure şi neregulate, reduceţi avansul cu 30%-50% la intrare şi la ieşire

Toleranţa diametrului nesatisfăcătoare



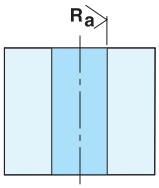
- Măriţi avansul/rotaţia
- Utilizaţi un burghiu din carbură solidă Seco Feedmax, consultaţi paginile 19-22
- Utilizaţi o operaţie de alezare, consultaţi paginile 328
- Utilizaţi o operaţie de alezare adâncă, consultaţi paginile 479-480

Uzură rapidă a flancurilor



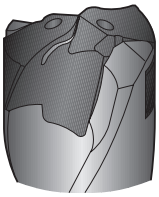
- Verifică dacă se utilizează geometria corectă
- Reduceţi viteza de aşchiere

Finisare slabă a suprafeţei



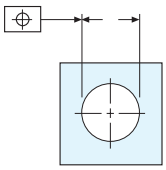
- Reduceţi avansul/rot
- Măriţi viteza de aşchiere
- Verifică dacă se utilizează geometria corectă
- Utilizaţi un burghiu de carbură Feedmax - vezi pag. 19-22
- Utilizaţi o operaţie de alezare cu alezor solid - vezi pag. 328

Uzura canelurii



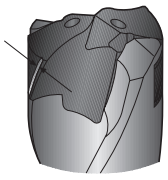
- Reduceţi avansul/rot
- Reduceţi viteza de aşchiere
- Măriţi concentraţia lichidului de răcire

Poziţionarea găurii nesatisfăcătoare



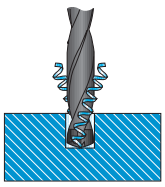
- Reduceţi avansul/rotaţie
- La găurirea prin suprafeţe neregulate, tari şi înclinate – reduceţi avansul cu 30-50% la intrare şi la ieşire
- Pregăurire cu un burghiu cu unghi la vârf de 140°
- Utilizaţi un burghiu din carbură solidă Feedmax, consultaţi paginile despre Feedmax 19-22
- Utilizaţi o operaţie de alezare adâncă, consultaţi paginile 479-480

Uzură a marginilor laterale periferice



- Verificaţi dacă se utilizează geometria corectă
- Reduceţi viteza de aşchiere
- Măriţi concentraţia lichidului de răcire
- La găurirea prin suprafeţe neregulate, tari sau înclinate, reduceţi rata de avans cu 30-50% la intrare şi la ieşire

Probleme cu blocarea aşchiilor din cauza aşchiilor lungi



- Măriţi avansul
- La materiale care produc aşchii lungi SMG P1-P4, SMG M1-M2:
  - Măriţi viteza de aşchiere şi reduceţi avansul/rotaţie
  - Utilizaţi geometria L



Perfomax®

Perfomax® este o gamă de tradiţie, dovedită de burghie cu plăcuţe amovibile care oferă o soluţie economică atunci când vine vorba de găurirea productivă a găurilor.

- Fiabile și de încredere, plăcuţele amovibile pătrate oferă fiecare patru muchii aşchietoare.
- Cele mai moderne clase de plăcuţă și geometrii pentru diferite materiale ale piesei de prelucrat
- Modelul corpului de burghiu dispune de un model unic de caneluri pentru aşchii și găuri de răcire prin interior la toate dimensiunile, pentru optimizarea îndepărtării aşchiilor.

Privire generală

Perfomax®	Tip	Pag.	∅ Gamă	Adâncimea de găurire	Toleranţă ∅ burghiu	Toleranţa găurii
	SD522	Pag. 244, 245, 246-250, 251	Ø 15-59 mm *(0.594-2.375“)*	~ 2 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD523	Pag. 252, 253, 254, 255-266, 267	Ø 15-59 mm *(0.594-2.375“)*	~ 3 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,3 mm *(+0/+ 0.012”)*
	SD524	Pag. 268, 269-279, 280	Ø 17-59 mm *(0.594-2.375“)*	~ 4 x D	+/- 0,1 mm *(+/- 0.004”)*	+ 0,4 mm *(+0/+ 0.016”)*
	SD525	Pag. 281, 282-283	Ø 19-45 mm *(0.750-2.000“)*	~ 5 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,5 mm *(+0/+ 0.020”)*
	SD5301	Pag. 284-285	Ø 64-84 mm *(2.250-3.500“)*	Ø 84 mm *(3.307“)*	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD5402	Pag. 286-287	Ø 60-85 mm *(2.250-3.500“)*	~ 2.5 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD5702	Pag. 288-290	Ø 15-47 mm *(0.591“-1.850”)*	~ 2 x D	+/- 0,1 mm *(+/- 0.004”)*	+0/+ 0,2 mm *(+0/+ 0.008”)*
	SD602	Pag. 291-295	Ø 60-160 mm *(2.362“-4.000“)*	~ 1-10 x D	+/- 0,2 mm *(+/- 0.008”)*	–

Codificare – burghiu cu plăcuţe amovibile



Metric

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

1.
Tip burghiu
SD522: 2 x D
SD523: 3 x D
SD524: 4 x D
SD525: 5 x D
SD5301: 84 mm (3.307")
SD5402: 2,5 x D
SD5702: 2 x D

2.
Diametru burghiu

3.
Adâncimea de găurire

4.
Diametru coadă

5.
Sens de rotaţie spre dreapta

6
Tip de coadă
2. ABS-compatibil
7. ISO 9766
8. VDI-compatible
G. Graflex

Inci

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

1.
Tip burghiu
SD522: 2 x D
SD523: 3 x D
SD524: 4 x D
SD525: 5 x D
SD5301: 84 mm (3.307")
SD5402: 2,5 x D
SD5702: 2 x D

2.
Diametru burghiu

3.
Adâncimea de găurire

4.
Diametru coadă

5.
Sens de rotaţie spre dreapta

6
Tip de coadă
2. ABS-compatibil
7. ISO 9766
8. VDI-compatible
G. Graflex

7
Aplicaţie
C. staţionară

Capto™

SD523	–	20	–	60	–	C5
1		2		3		4

1.
Tip burghiu
SD5702: 2 x D
SD523: 3 x D
SD524: 4 x D

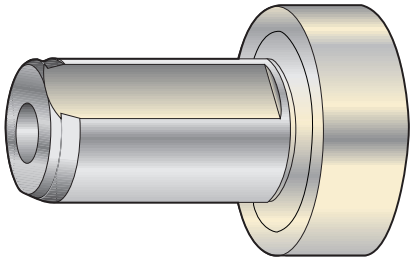
2.
Diametru burghiu

3.
Adâncimea de găurire

4.
Conexiune pentru Capto:
C4, C5, C6

Cozi

-R7

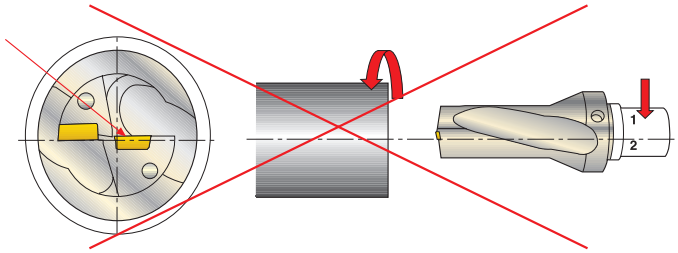


ISO 9766
Opţiunea Universal se potrivește în majoritatea port-sculelor de pe piaţă, cum ar fi:

- Weldon 1835B
- ISO 5414
- DIN 69880

Cu răcire interioară și la partea din spate a burghiului.

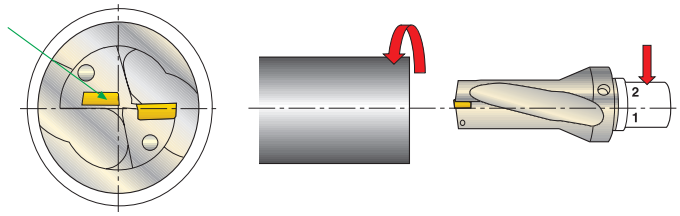
R7 și R7-C



Cozi cu două sau patru aplatizări
Muchia aşchietoare a plăcuţei centrale deasupra axei centrale a piesei de prelucrat.

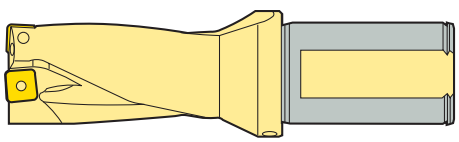
Pentru aplicaţii statice:

- Este adăugată o aplatizare suplimentară la coadă pentru mărirea stabilităţii la aplicaţiile pe stung.
- În cazul acestor aplicaţii axa centrală a piesei de prelucrat trebuie aliniată cu axa centrală a burghiului.
- În caz contrar, plăcuţa centrală ar putea fi poziţionată deasupra axei centrale a piesei de prelucrat, ceea ce va duce la performanţe slabe ale burghiului.



Cozi cu patru aplatizări
Muchia aşchietoare a plăcuţei centrale deasupra axei centrale a piesei de prelucrat.

Prin rotirea burghiului cu 180 grade, a doua aplatizare oferă posibilitatea de a compensa această nealiniere printr-o metodă rapidă și simplă.

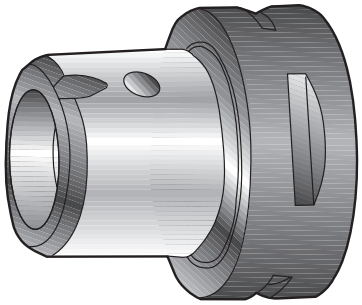


NOTĂ!

- Dacă un burghiu cu coadă -7 este utilizat într-o aplicaţie rotativă împreună cu port-scula noastră reglabilă, trebuie utilizată aplatizarea de pe aceeași parte cu plăcuţa centrală.
- În caz contrar diametrul găurii va fi poziţionat greșit.

Cozi

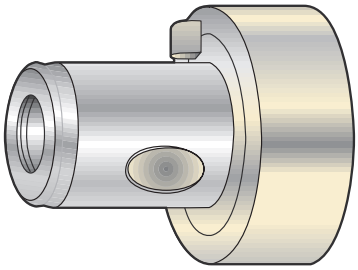
Seco Capto™



Seco Capto™ C4, C5, C6

- Flexibilitate - Aceeași port-sculă poate fi utilizată la diferite mașini.
- Modular – Posibilitatea de a alcătui scule cu ajutorul adaptoarelor de extensie.
- Transmiterea cuplului maxim - Cuplul este distribuit simetric.
- Rigiditate mare - Prinderile strânse garantează lipsa jocului în cuplaj.
- Acurateţe - Cupla conico-poligonală asigură o articulaţie auto-centrată în plaja a 2 microni.

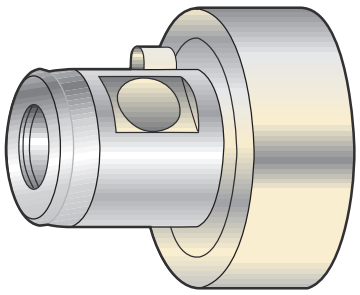
Graflex



- G

- Se fixează direct în port-sculele Graflex și se blochează cu două șuruburi de blocare cu cap sferic poziţionate la 120°.
- Ansambluri modulare care oferă rigiditate și bătaie radială bună.
- Conectare cilindrică/frontală – precizie excelentă.
- Asamblare/dezasamblare rapidă și ușoară a modulelor, pentru flexibilitate ridicată.
- Cu răcire interioară și la partea din spate a burghiului.

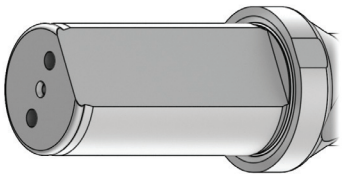
ABS 50(compatibil)



- 2

- O coadă compatibilă ABS 50.
- Se fixează direct în port-scula ABS 50 cu un șurub de blocare.
- Cu răcire interioară și la partea din spate a burghiului.

VDI 30 și VDI 40 (compatibil)



- 8

- Coadă compatibilă VDI.
- Se fixează direct în port-sculă pentru:
  – VDI 3425 bl.2
  – DIN 69880

NOTĂ!
Garnitura pentru lichidul de răcire trebuie comandată separat.

Cozi – garnitură de lichid de răcire

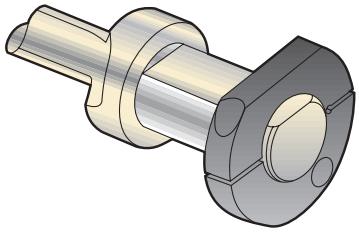
VDI 30

Adâncimea de găurire	Diametru burghiu mm	Diametru burghiu *inch*	Accessorii Inel lichid răcire
			
2 x D	15-31	*0,591-1,220*	SDA5-30R8
3 x D	15-31	*0,591-1,220*	SDA5-30R8
4 x D	17-31	*0,669-1,220*	SDA5-30R8
5 x D	19-31	*0,748-1,220*	SDA5-30R8

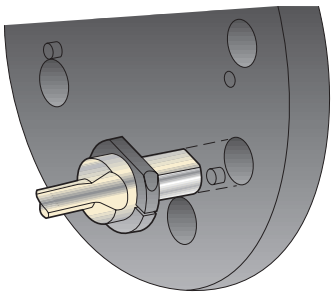
VDI 40

Adâncimea de găurire	Diametru burghiu mm	Diametru burghiu *inch*	Dop	Șurub de blocare	Accessorii Inel lichid răcire
					
2 x D	15-31	*0,591-1,220*			SDA5-40R8
3 x D	15-31	*0,591-1,220*			SDA5-40R8
4 x D	17-31	*0,669-1,220*			SDA5-40R8
5 x D	19-31	*0,748-1,220*			SDA5-40R8
2 x D	41-59	*1,614-2,323*	R1/4”	P6SS8x8	SDA5-40R8
3 x D	41-59	*1,614-2,323*	R1/4”	P6SS8x8	SDA5-40R8

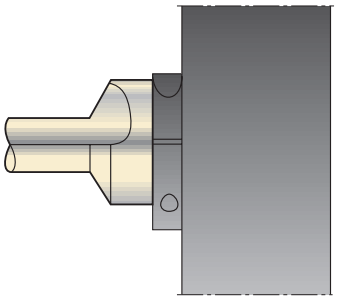
1. Potriviţi garnitura în jurul burghiului dar nu strângeţi șurubul de blocare.



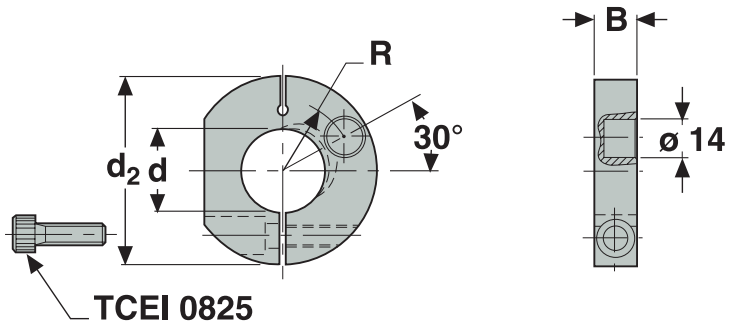
2. Blocaţi burghiul în pensetă.



3. Strângeţi șurubul de blocare în inelul lichidului de răcire.



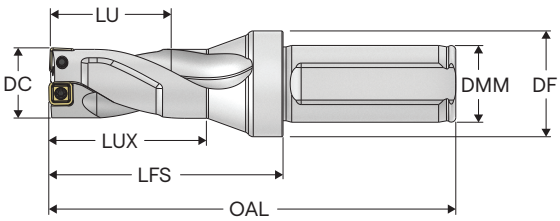
Inel lichid răcire



SD522

Adâncime de găurire ~ 2 x D – Metric/Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 305, 306
- Pentru diametre intermediare, consultaţi software-ul My Design

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

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

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,5-19,00	C02205-T07P	C02245-T07P	T07P-2
19,5-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
29,00-31,00	C03007-T09P	C03009-T09P	T09P-2
32,00-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
42,00-59,00	C04011-T15P	C05012-T15P	T15P-2D

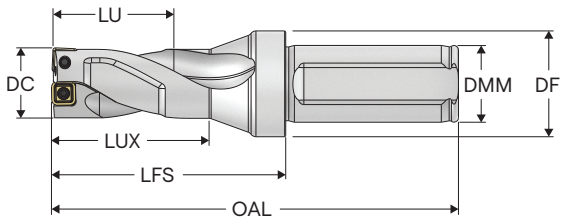
Accesorii

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

SD522

Adâncime de găurire ~ 2 x D – Inci





—Coadă ISO 9766, -7
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 305, 306
—Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă		Intern	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică	*Inci -*	*Inci +*
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*

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie
			
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.875	C02205-T07P	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.062	–	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.500	–	C03508-T15P	T15P-2D
1.625	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

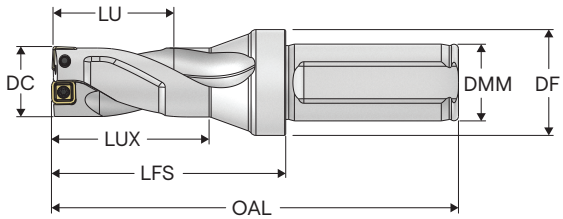
Accesorii

Pentru burghiu dia (inch)	Cheie dinamometrică
	
0.594-0.687	T00-07P09
0.709-0.766	T00-07P09
0.787-0.827	T00-07P09
0.875	T00-08P12
0.906-1.000	T00-08P12
1.032-1.062	T00-09P20
1.125-1.187	T00-09P20
1.250-1.500	T00-15P30
1.625	T00-15P30
1.750-2.375	T00-15P35

SD522

Adâncime de găurire ~ 2 x D – Inci





- Coadă ISO 9766, R-7C
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 305-306
- Pentru diametre intermediare, consultaţi software-ul My Design
- Pentru aplicaţii staţionare

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă		Intern	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plcuţa centrală	Plăcuţa periferică	Inci -	Inci +
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

Piese de schimb, Piese incluse la livrare

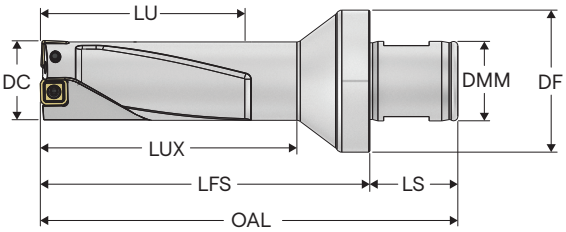
Accesorii

Pentru burghiu dia (inch)	Adaptor furtun	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie	Dop	Adaptor furtun	Cheie dinamometrică
0.625	C02245-T07P	C02245-T07P	C02245-T07P	T07P-2	R1/4	1310	T00-07P09
0.687	–	–	C02245-T07P	T07P-2	R1/4	1310	T00-07P09
0.750	C02205-T07P	C02205-T07P	C02245-T07P	T07P-2	R1/4	1310	T00-07P09
0.812	C02506-T08P	C02506-T08P	C02205-T07P	T07P-2	R1/4	1310	T00-07P09
0.875	–	–	C02506-T08P	T08P-2	R1/4	1310	T00-08P12
0.937	C03007-T09P	C02507-T08P	C03007-T08P	T08P-2	R1/4	1310	T00-08P12
1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4	–	T00-08P12
1.062	C03508-T15P	C03508-T15P	C03007-T09P	T09P-2	R1/4	1310	T00-09P20
1.125-1.187	–	C03007-T09P	C03009-T09P	T09P-2	R1/4	1310	T00-09P20
1.250-1.500	–	–	C03508-T15P	T15P-2D	R1/4	1310	T00-15P30
1.750-2.375	–	C04011-T15P	C05012-T15P	T15P-2D	R1/4	1310	T00-15P35

SD522

Adâncime de găurire ~ 2 x D – Metric/Inci





—Coadă compatibilă ABS 50, R2
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 305, 306
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

Piese de schimb, Piese incluse la livrare

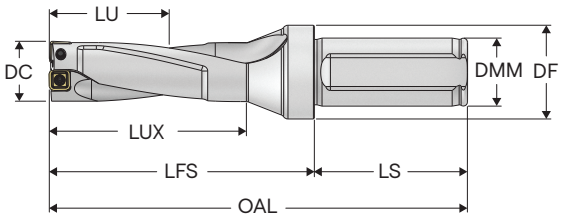
Accesorii

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie	Cheie dinamometrică
				
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2	T00-07P09
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2	T00-07P09
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2	T00-07P09
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2	T00-08P12
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2	T00-08P12
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2	T00-09P20
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2	T00-09P20
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D	T00-15P30
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D	T00-15P30
44,45	C04011-T15P	C05012-T15P	T15P-2D	T00-15P35

SD523

Adâncime de găurire ~ 3 x D – Metric/Inci





–Coadă ISO 9766, -7
–Agent de răcire intern
–Pentru gama de plăcuţe, vezi pag. 301-304
–Regimuri de aşchiere, vezi pagina(paginile) 307-308
–Pentru diametre intermediare, consultaţi software-ul My Design

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

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

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
19,50-21,00	C02205-T07P	C02205-T07P	T07P-2
21,50-22,00	C02506-T08P	C02506-T08P	T08P-2
22,50-25,00	C02507-T08P	C03007-T08P	T08P-2
25,50-28,00	C03007-T09P	C03007-T09P	T09P-2
28,50-31,00	C03007-T09P	C03009-T09P	T09P-2
31,50-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,50-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,00-59,00	C04011-T15P	C05012-T15P	T15P-2D

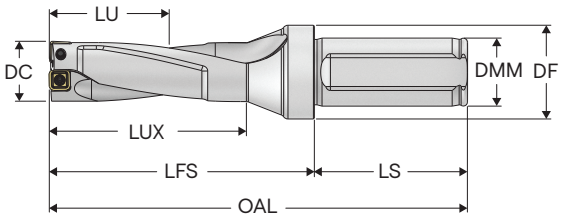
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
15,00-17,00	T00-07P09
17,50-19,00	T00-07P09
19,50-21,00	T00-07P09
21,50-22,00	T00-08P12
22,50-25,00	T00-08P12
25,50-28,00	T00-09P20
28,50-31,00	T00-09P20
31,50-40,00	T00-15P30
41,50-43,00	T00-15P30
44,00-59,00	T00-15P35

SD523

Adâncime de găurire ~ 3 x D – Inci





—Coadă ISO 9766, -7
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 307-308
—Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă		Intern	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică	*Inci -*	*Inci +*
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*

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
0.562	C02245-T07P	C02245-T07P	T07P-2
0.594-0.687	–	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787-0.827	C02506-T08P	C02205-T07P	T07P-2
0.875	–	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.109	–	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.562	–	C03508-T15P	T15P-2D
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

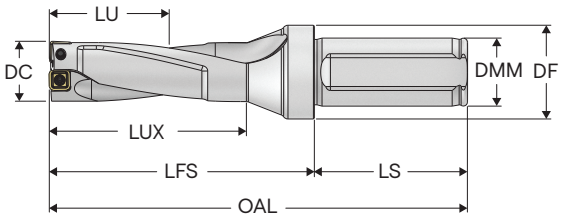
Accesorii

Pentru burghiu dia (inch)	Lamă interschimbabilă	Cheie dinamometrică
		
0.562	T00-07P	T00-07P09
0.594-0.687	–	T00-07P09
0.709-0.766	–	T00-07P09
0.787-0.827	–	T00-07P09
0.875	–	T00-08P12
0.906-1.000	–	T00-08P12
1.032-1.109	–	T00-09P20
1.125-1.187	–	T00-09P20
1.250-1.562	–	T00-15P30
1.625-1.687	–	T00-15P30
1.750-2.375	–	T00-15P35

SD523

Adâncime de găurire ~ 3 x D – Inci





—Coadă ISO 9766, R-7C
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 307-308
—Pentru diametre intermediare, consultaţi software-ul My Design
—Pentru aplicaţii staţionare

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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă		Intern	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică	*Inci -*	*Inci +*
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*

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie	Dop
				
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2	R1/4
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2	R1/4
0.787-0.827	C02205-T07P	C02205-T07P	T07P-2	R1/4
0.875	C02506-T08P	C02506-T08P	T08P-2	R1/4
0.906	C02507-T08P	C03007-T08P	T08P-2	R1/4
0.922	C02506-T08P	C03007-T08P	T08P-2	R1/4
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.032-1.109	C03007-T09P	C03007-T09P	T09P-2	R1/4
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2	R1/4
1.250-1.562	C03508-T15P	C03508-T15P	T15P-2D	R1/4
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D	R1/4
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D	R1/4

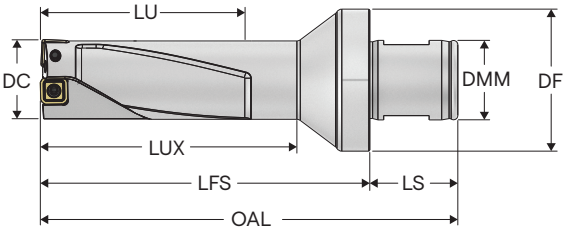
Accesorii

Pentru burghiu dia (inch)	Adaptor furtun	Cheie dinamometrică
		
0.594-0.687	1310	T00-07P09
0.709-0.766	1310	T00-07P09
0.787-0.827	1310	T00-07P09
0.875	1310	T00-08P12
0.906	1310	T00-08P12
0.922	1310	T00-08P12
0.937-1.000	1310	T00-08P12
1.032-1.109	1310	T00-09P20
1.125-1.187	1310	T00-09P20
1.250-1.562	1310	T00-15P30
1.625-1.687	1310	T00-15P30
1.750-2.375	1310	T00-15P35

SD523

Adâncime de găurire ~ 3 x D – Metric/Inci





—Coadă compatibilă ABS 50, -2
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 307-308
—Pentru diametre intermediare, consultaţi software-ul My Design

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

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00	C02506-T08P	C03007-T08P	T08P-2
24,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,00-44,45	C04011-T15P	C05012-T15P	T15P-2D

Accesorii

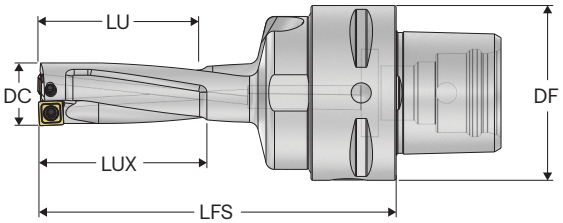
Cheie dinamometrică

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

SD523

Adâncime de găurire ~ 3 x D – Metric/Inci





- Seco Capto™ prindere C4
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 307-308
- Pentru diametre intermediare, consultaţi software-ul My Design

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
15,00-16,50	C02245-T07P	C02245-T07P	T07P-2
17,50	C02205-T07P	C02245-T07P	T07P-2
17,51	C02245-T07P	C02245-T07P	T07P-2
18,00-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-30,00	C03007-T09P	C03009-T09P	T09P-2

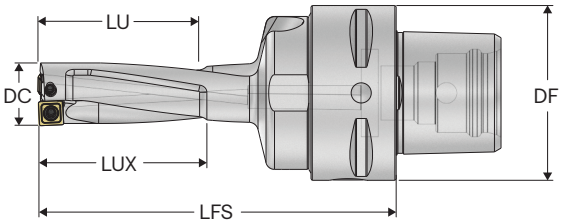
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
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17,50	T00-07P09
17,51	T00-07P09
18,00-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-30,00	T00-09P20

SD523

Adâncime de găurire ~ 3 x D – Metric/Inci





- Seco Capto™ prindere C5
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 307-308
- Pentru diametre intermediare, consultaţi software-ul My Design

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

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Șurub plăcuţă centru	Șurub plăcuţă periferie	Cheie
			
15,00-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

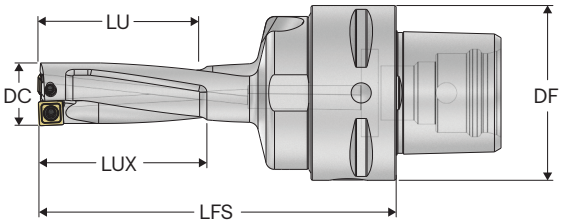
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
15,00-17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD523

Adâncime de găurire ~ 3 x D – Metric/Inci





- Seco Capto™ prindere C6
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 307-308
- Pentru diametre intermediare, consultaţi software-ul My Design

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

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
15,50-17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

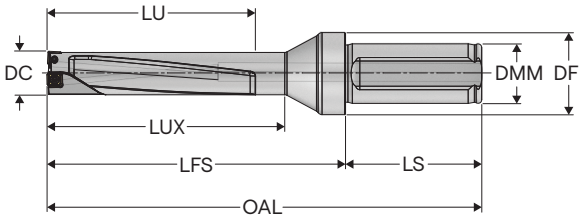
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
15,50-17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,00	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD524

Adâncime de găurire ~ 4 x D – Metric/Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 309, 310
- Pentru diametre intermediare, consultaţi software-ul My Design

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

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,76	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
29,00-31,00	C03007-T09P	C03009-T09P	T09P-2
32,00-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-43,00	C03508-T15P	C05012-T15P	T15P-2D
44,00-59,00	C04011-T15P	C05012-T15P	T15P-2D

Accesorii

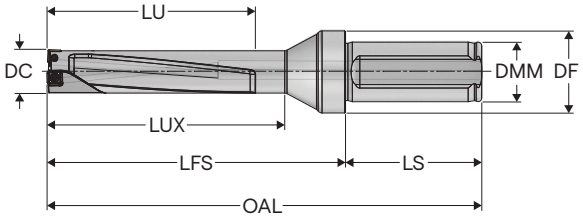
Cheie dinamometrică

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

SD524

Adâncime de găurire ~ 4 x D – Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 309, 310
- Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică
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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
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

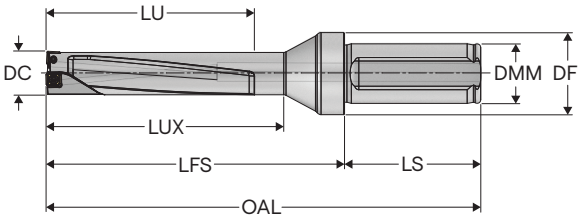
Accesorii

Pentru burghiu dia (inch)	Cheie dinamometrică
	
0.594-0.687	T00-07P09
0.709-0.766	T00-07P09
0.787-0.827	T00-07P09
0.875-0.905	T00-08P12
0.906-1.000	T00-08P12
1.032-1.109	T00-09P20
1.125-1.187	T00-09P20
1.250-1.562	T00-15P30
1.625-1.687	T00-15P30
1.750-2.375	T00-15P35

SD524

Adâncime de găurire ~ 4 x D – Inci





- Coadă ISO 9766, R-7C
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 309, 310
- Pentru diametre intermediare, consultaţi software-ul My Design
- Pentru aplicaţii staţionare

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică
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

Piese de schimb, Piese incluse la livrare

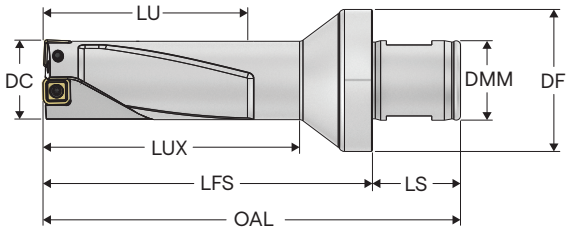
Accesorii

Pentru burghiu dia (inch)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie	Dop	Adaptor furtun	Cheie dinamometrică
						
0.625-0.687	C02245-T07P	C02245-T07P	T07P-2	R1/4	1310	T00-07P09
0.750	C02205-T07P	C02245-T07P	T07P-2	R1/4	1310	T00-07P09
0.812	C02205-T07P	C02205-T07P	T07P-2	R1/4	1310	T00-07P09
0.875	C02506-T08P	C02506-T08P	T08P-2	R1/4	1310	T00-08P12
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2	R1/4	1310	T00-08P12
1.062	C03007-T09P	C03007-T09P	T09P-2	R1/4	1310	T00-09P20
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2	R1/4	1310	T00-09P20
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D	R1/4	1310	T00-15P30
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D	R1/4	1310	T00-15P35

SD524

Adâncime de găurire ~ 4 x D – Metric/Inci





—Coadă compatibilă ABS 50, -2
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 309, 310
—Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă	
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	Plcuţa centrală	Plăcuţa periferică
SD524-36-144-50R2	03080203	36,0 *1.417*	144,0 *5.669*	205,0 *8.071*	149,0 *5.866*	174,0 *6.850*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-37-148-50R2	03080204	37,0 *1.457*	148,0 *5.827*	209,0 *8.228*	153,0 *6.024*	178,0 *7.008*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-38-152-50R2	03080426	38,0 *1.496*	152,0 *5.984*	213,0 *8.386*	157,0 *6.181*	182,0 *7.165*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-39-156-50R2	03080205	39,0 *1.535*	156,0 *6.142*	217,0 *8.543*	161,0 *6.339*	186,0 *7.323*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-40-160-50R2	03080206	40,0 *1.575*	160,0 *6.299*	221,0 *8.701*	165,0 *6.496*	190,0 *7.480*	31,0 *1.220*	28,0 *1.102*	50,0 *1.969*	SPGX12T3	SCGX11T308

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

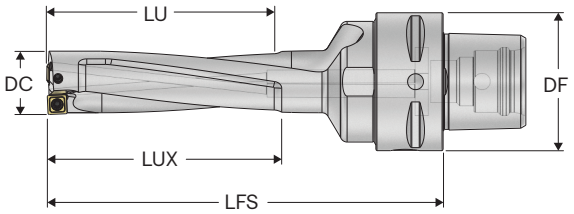
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD524

Adâncime de găurire ~ 4 x D – Metric/Inci





—Seco Capto™ prindere C4
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 309, 310
—Pentru diametre intermediare, consultaţi software-ul My Design

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie
			
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-30,00	C03007-T09P	C03009-T09P	T09P-2

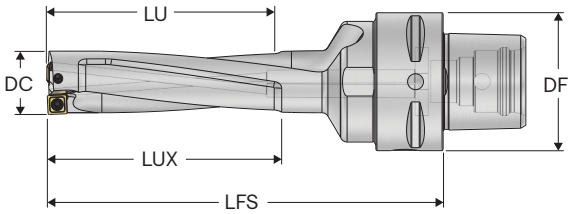
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-30,00	T00-09P20

SD524

Adâncime de găurire ~ 4 x D – Metric/Inci





–Seco Capto™ prindere C5
–Agent de răcire intern
–Pentru gama de plăcuţe, vezi pag. 301-304
–Regimuri de aşchiere, vezi pagina(paginile) 309, 310
–Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	LUX	LFS	DF	Plăcuţă amovibilă	
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	Plcuţa centrală	Plăcuţa periferică
SD524-35-140-C5	03080256	35,0 *1.378*	140,0 *5.512*	145,0 *5.709*	186,0 *7.323*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-36-144-C5	03080257	36,0 *1.417*	144,0 *5.669*	149,0 *5.866*	190,0 *7.480*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-37-148-C5	03080258	37,0 *1.457*	148,0 *5.827*	153,0 *6.024*	194,0 *7.638*	50,0 *1.969*	SPGX11T3	SCGX11T308
SD524-38-152-C5	03080259	38,0 *1.496*	152,0 *5.984*	157,0 *6.181*	198,0 *7.795*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-39-156-C5	03080260	39,0 *1.535*	156,0 *6.142*	161,0 *6.339*	202,0 *7.953*	50,0 *1.969*	SPGX12T3	SCGX11T308
SD524-40-160-C5	03080261	40,0 *1.575*	160,0 *6.299*	165,0 *6.496*	206,0 *8.110*	50,0 *1.969*	SPGX12T3	SCGX11T308

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

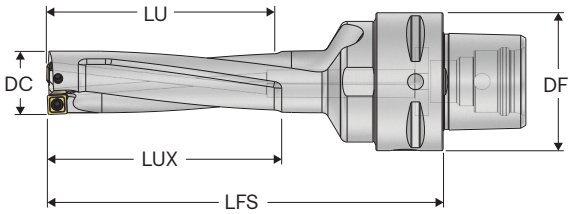
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD524

Adâncime de găurire ~ 4 x D – Metric/Inci





–Seco Capto™ prindere C6
–Agent de răcire intern
–Pentru gama de plăcuţe, vezi pag. 301-304
–Regimuri de aşchiere, vezi pagina(paginile) 309, 310
–Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	LUX	LFS	DF	Plăcuţă amovibilă	
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	Plcuţa centrală	Plăcuţa periferică
SD524-35-140-C6	03080402	35,0 *1.378*	140,0 *5.512*	145,0 *5.709*	188,0 *7.402*	63,0 *2.480*	SPGX11T3	SCGX11T308
SD524-36-144-C6	03080403	36,0 *1.417*	144,0 *5.669*	149,0 *5.866*	192,0 *7.559*	63,0 *2.480*	SPGX11T3	SCGX11T308
SD524-37-148-C6	03080404	37,0 *1.457*	148,0 *5.827*	153,0 *6.024*	196,0 *7.717*	63,0 *2.480*	SPGX11T3	SCGX11T308
SD524-38-152-C6	03080405	38,0 *1.496*	152,0 *5.984*	157,0 *6.181*	200,0 *7.874*	63,0 *2.480*	SPGX12T3	SCGX11T308
SD524-39-156-C6	03080406	39,0 *1.535*	156,0 *6.142*	161,0 *6.339*	204,0 *8.031*	63,0 *2.480*	SPGX12T3	SCGX11T308
SD524-40-160-C6	03080407	40,0 *1.575*	160,0 *6.299*	165,0 *6.496*	208,0 *8.189*	63,0 *2.480*	SPGX12T3	SCGX11T308

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
17,00	C02245-T07P	C02245-T07P	T07P-2
17,50-19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00-22,23	C02506-T08P	C02506-T08P	T08P-2
23,00-25,40	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
28,59-31,00	C03007-T09P	C03009-T09P	T09P-2
31,75-40,00	C03508-T15P	C03508-T15P	T15P-2D

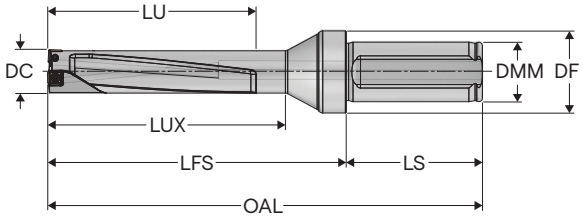
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
17,00	T00-07P09
17,50-19,00	T00-07P09
20,00-21,00	T00-07P09
22,00-22,23	T00-08P12
23,00-25,40	T00-08P12
26,00-28,00	T00-09P20
28,59-31,00	T00-09P20
31,75-40,00	T00-15P30

SD525

Adâncime de găurire ~ 5 x D – Metric/Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 311, 312
- Pentru diametre intermediare, consultaţi software-ul My Design

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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă	
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	Plcuţa centrală	Plăcuţa periferică
SD525-44-220-40R7	03079607	44,0 *1.732*	220,0 *8.661*	318,0 *12.520*	225,0 *8.858*	250,0 *9.843*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX120408
SD525-45-225-40R7	03079608	45,0 *1.772*	225,0 *8.858*	323,0 *12.717*	230,0 *9.055*	255,0 *10.039*	68,0 *2.677*	40,0 *1.575*	50,0 *1.969*	SPGX1504	SCGX150512

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
19,00	C02205-T07P	C02245-T07P	T07P-2
20,00-21,00	C02205-T07P	C02205-T07P	T07P-2
22,00	C02506-T08P	C02506-T08P	T08P-2
23,00-25,00	C02507-T08P	C03007-T08P	T08P-2
26,00-28,00	C03007-T09P	C03007-T09P	T09P-2
29,00-31,00	C03007-T09P	C03009-T09P	T09P-2
32,00-40,00	C03508-T15P	C03508-T15P	T15P-2D
41,00-42,00	C03508-T15P	C05012-T15P	T15P-2D
43,00-45,00	C04011-T15P	C05012-T15P	T15P-2D

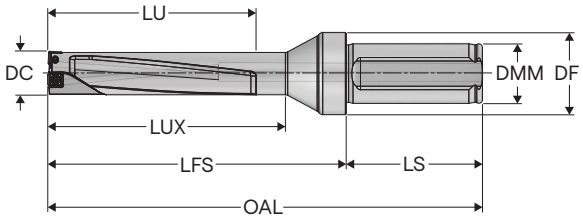
Accesorii

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

SD525

Adâncime de găurire ~ 5 x D – Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 311, 312
- Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuţă amovibilă	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică
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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)	Şurub plăcuţă centru	Şurub plăcuţă periferie	Cheie
			
0.750	C02205-T07P	C02245-T07P	T07P-2
0.812	C02205-T07P	C02205-T07P	T07P-2
0.875	C02506-T08P	C02506-T08P	T08P-2
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2
1.062	C03007-T09P	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D
1.625	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.000	C04011-T15P	C05012-T15P	T15P-2D

Accesorii

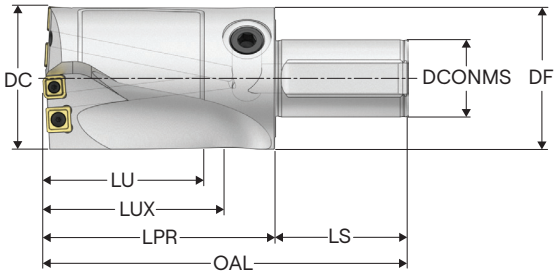
Cheie dinamometrică

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

SD5301

Adâncimea de găurire = 84 mm (3.307") – Metric/Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 313, 314
- Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper	DC	LU	LUX	LPR	OAL	LS	DCONMS	DF	Plăcuţă amovibilă	
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	Plcuţa centrală	Plăcuţa periferică
SD5301-64-84-40R7	10137541	64,0 *2.520*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	63,0 *2.480*	SPGX 0903-CI	SCGX09T308...
SD5301-69-84-40R7	10137542	69,0 *2.717*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	68,0 *2.677*	SPGX 11T3-C1	SCGX120408...
SD5301-74-84-40R7	10137543	74,0 *2.913*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	73,0 *2.874*	SPGX 11T3-C1	SCGX 120408...
SD5301-79-84-40R7	10137544	79,0 *3.110*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	78,0 *3.071*	SPGX 12T3-C1	SCGX 120408...
SD5301-84-84-40R7	10137545	84,0 *3.307*	84 *3.307*	86,5 *3.406*	120,0 *4.724*	188,0 *7.402*	68,0 *2.677*	40,0 *1.575*	83,0 *3.268*	SPGX 12T3-C1	SCGX 120408...

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Adaptor furtun	Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie	Dop
					
64,0	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
69,0-84,0	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8

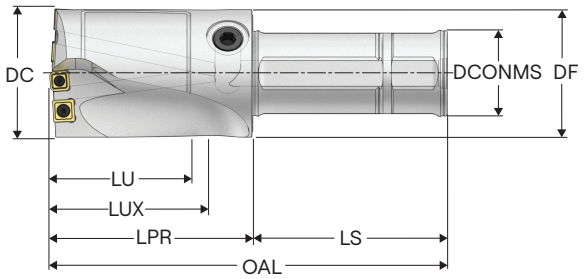
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
64,0	T00-09P20
69,0-84,0	T00-15P30

SD5301

Adâncimea de găurire = 84 mm (3.307") – Metric/Inci





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 313, 314
- Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper									Plăcuţă amovibilă	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică
SD5301-2500-330-2000R7	10137546	2.500	3.307	3.406	4.724	9.224	4.500	2.000	2.461	SPGX 0903-CI	SCGX09T308...
SD5301-2750-330-2000R7	10137547	2.750	3.307	3.406	4.724	9.224	4.500	2.000	2.711	SPGX 11T3-C1	SCGX120408...
SD5301-3000-330-2000R7	10137548	3.000	3.307	3.406	4.724	9.224	4.500	2.000	2.961	SPGX 11T3-C1	SCGX 120408...
SD5301-3250-330-2000R7	10137549	3.250	3.307	3.406	4.724	9.224	4.500	2.000	3.211	SPGX 12T3-C1	SCGX 120408...
SD5301-3500-330-2000R7	10137550	3.500	3.307	3.406	4.724	9.224	4.500	2.000	3.461	SPGX 1504-C1	SCGX 120408...

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Adaptor furtun	Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie	Dop
					
63,5	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
69,85-82,55	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8
88,9	R3/8-HA	T15P-2D	C04011-T15P	C05012-T15P	R3/8

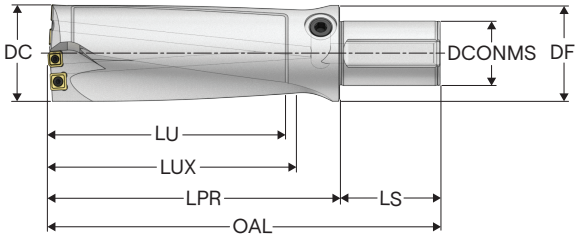
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
63,5	T00-09P20
69,85-82,55	T00-15P30
88,9	T00-15P30

SD5402

Adâncimea de găurire ~ 2.5 X D





—Coadă ISO 9766, -7
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 313, 314
—Pentru diametre intermediare, consultaţi software-ul My Design

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Adaptor furtun	Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie	Dop
					
60,0	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
65,0	R3/8-HA	T15P-2D	CO3508-T15P	C03508-T15P	R3/8
70,0-85,0	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8

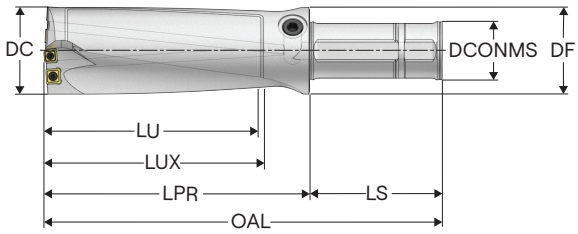
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
60,0	T00-09P20
65,0	T00-15P30
70,0-85,0	T00-15P30

SD5402

Adâncimea de găurire ~ 2.5 X D





—Coadă ISO 9766, -7
—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 313, 314
—Pentru diametre intermediare, consultaţi software-ul My Design

Reper Nr.	Număr reper									Plăcuţă amovibilă	
		Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	Plcuţa centrală	Plăcuţa periferică
SD5402-2250-563-1500R7	10137535	2.250	5.630	5.866	7.185	11.685	4.500	1.500	2.211	SPGX 0903-C1	SCGX 09T308...
SD5402-2500-625-1500R7	10137536	2.500	6.250	6.486	7.805	12.305	4.500	1.500	2.461	SPGX 0903-C1	SCGX 09T308...
SD5402-2750-688-1500R7	10137537	2.750	6.880	7.116	8.435	12.935	4.500	1.500	2.711	SPGX 11T3-C1	SCGX 120408...
SD5402-3000-750-2000R7	10137538	3.000	7.500	7.736	9.055	13.555	4.500	2.000	2.961	SPGX 11T3-C1	SCGX 120408...
SD5402-3250-813-2500R7	10137539	3.250	8.130	8.366	9.685	14.185	4.500	2.500	3.211	SPGX 12T3-C1	SCGX 120408...
SD5402-3500-875-2500R7	10137540	3.500	8.750	8.986	10.305	14.805	4.500	2.500	3.461	SPGX 1504-C1	SCGX 120408...

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)	Adaptor furtun	Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie	Dop
					
57,15-63,5	R3/8-HA	T09P-2	C03007-T09P	C03009-T09P	R3/8
69,85-82,55	R3/8-HA	T15P-2D	C03508-T15P	C05012-T15P	R3/8
88,9	R3/8-HA	T15P-2D	C04011-T15P	C05012-T15P	R3/8

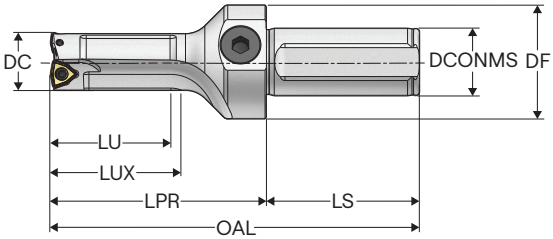
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică
	
57,15-63,5	T00-09P20
69,85-82,55	T00-15P30
88,9	T00-15P30

SD5702

Adâncime de găurire ~ 2 x D





- Coadă ISO 9766, -7
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 315-316
- Pentru diametre intermediare, consultaţi software-ul My Design

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)		Adaptor furtun	Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie	Şurub
						
15.00-20.59	C02205-T07P	1310	T07P-2	C02205-T07P	C02205-T07P	R1/4
20.60-24.59	T08P-2	1310	T09P-2	C03007-T09P	C02506-T08P	R1/4
24.60-32.59	T09P-2	1310	T15P-2D	C03508-T15P	C03007-T09P	R1/4
32.60-36.59	C03508-T15P	1310	T15P-2D	C03508-T15P	C03508-T15P	R1/4
36.60-59.00	C04011-T15P	1310	T15P-2D	C04011-T15P	C04011-T15P	R1/4

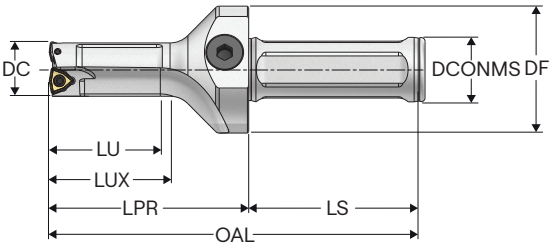
Accesorii

Pentru burghiu dia (mm)	Valoare cuplu	Valoare cuplu 2	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică	Cheie dinamometrică 2
						
15.00-20.59	0,9 Nm		T00-07P	–	T00-07P09	–
20.60-24.59	1,2 Nm		T00-09P	T00-08P	T00-09P12	T00-08P12
24.60-32.59	3,0 Nm		T00-15P	T00-09P	T00-15P30	T00-09P20
32.60-36.59	3,0 Nm		T00-15P	–	T00-15P30	–
36.60-59.00	3,0 Nm		T00-15P	–	T00-15P30	–

SD5702

Adâncime de găurire ~ 2 x D – Inci





–Coadă ISO 9766, -7
–Agent de răcire intern
–Pentru gama de plăcuţe, vezi pag. 301-304
–Regimuri de aşchiere, vezi pagina(paginile) 315-316
–Pentru diametre intermediare, consultaţi software-ul My Design

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (inch)		Adaptor furtun	Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie	Şurub
						
0.591-0.811	C02205-T07P	1310	T07P-2	C02205-T07P	C02205-T07P	R1/4
0.812-0.968	T08P-2	1310	T09P-2	C03007-T09P	C02506-T08P	R1/4
0.969-1.283	T09P-2	1310	T15P-2D	C03508-T15P	C03007-T09P	R1/4
1.283-1.440	C03508-T15P	1310	T15P-2D	C03508-T15P	C03508-T15P	R1/4
1.441-2.323	C04011-T15P	1310	T15P-2D	C04011-T15P	C04011-T15P	R1/4

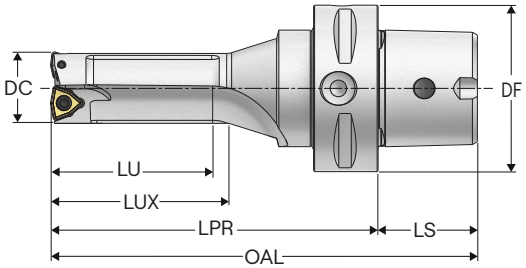
Accesorii

Pentru burghiu dia (mm)	Valoare cuplu	Valoare cuplu 2	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică	Cheie dinamometrică 2
						
0.591-0.811	0,9 Nm		T00-07P	–	T00-07P09	–
0.812-0.968	1,2 Nm		T00-09P	T00-08P	T00-09P12	T00-08P12
0.969-1.283	0,9 Nm		T00-15P	T00-09P	T00-15P30	T00-09P20
1.283-1.440	3,0 Nm		T00-15P	–	T00-15P30	–
1.441-2.323	3,0 Nm		T00-15P	–	T00-15P30	–

SD5702

Adâncime de găurire ~ 2 x D





- Seco Capto™ prindere C5
- Agent de răcire intern
- Pentru gama de plăcuţe, vezi pag. 301-304
- Regimuri de aşchiere, vezi pagina(paginile) 315-316
- Pentru diametre intermediare, consultaţi software-ul My Design

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

Piese de schimb, Piese incluse la livrare

Pentru burghiu dia (mm)		Cheie plăcuţă	Şurub plăcuţă centru	Şurub plăcuţă periferie
				
15.00-20.59	C02205-T07P	T07P-2	C02205-T07P	C02205-T07P
20.60-24.59	T08P-2	T09P-2	C03007-T09P	C02506-T08P
24.60-32.59	T09P-2	T15P-2D	C03508-T15P	C03007-T09P
32.60-36.59	C03508-T15P	T15P-2D	C03508-T15P	C03508-T15P
36.60-59.00	C04011-T15P	T15P-2D	C04011-T15P	C04011-T15P

Accesorii

Pentru burghiu dia (mm)	Valoare cuplu	Valoare cuplu 2	Lamă interschimbabilă	Lamă interschimbabilă 1	Cheie dinamometrică	Cheie dinamometrică 2
						
15.00-20.59	0,9 Nm		T00-07P	–	T00-07P09	–
20.60-24.59	1,2 Nm		T00-09P	T00-08P	T00-09P12	T00-08P12
24.60-32.59	3,0 Nm		T00-15P	T00-09P	T00-15P30	T00-09P20
32.60-36.59	3,0 Nm		T00-15P	–	T00-15P30	–
36.60-59.00	3,0 Nm		T00-15P	–	T00-15P30	–



Perfomax® SD602

Perfomax® SD602 de la Seco este un sistem modular de cap de burghiu conceput special pentru aplicaţii cu găuri adânci care necesită găurirea de diametre mari în siguranţă și eficient.

— Clasa de plăcuţe DP2501 oferă duritatea necesară optimizării Perfomax® SD602.
— Clasa permite avansuri și viteze mari.
— Flexibilitate ridicată prin utilizarea extensiilor pentru a ajunge la adâncimea de găurire necesară.

Codificări

Corpuri de burghiu



SD602	–	89/90	–	50	RG
1		2		3	4

1.
Tip burghiu
SD602: Burghiu de ghidare și cartuș

2.
Diametru de burghiu posibil
89 – diametru inferior
90 – diametru superior

3.
Diametrul flanșei

4.
Tip de coadă

Inci

SD602	–	3500	RG

Burghiu de ghidare



(Burghiul de ghidare trebuie achiziţionat separat)

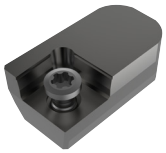
SD601	1	–	10	–	R
	2		3		4

2.
0 = carbură solidă
1 = HSS

3.
Diametru burghiu

4.
Rotaţie în sens orar

Casetă



-N



-U

SD600	C	–	07	–	N
	2		3		4

2.
C = centru
*P = periferie

3.
Mărimea plăcuţei
SCGX07
SCGX09
SCGX12
SCGX15

***4.**
N – diametru nominal
U – diametru inferior

Kit



-N



-U

SD602	1	–	P	–	07	–	N
	2		3		4		5

2.
0 = incl 2 ghidaje (< ∅ 135 mm)
1 = incl 4 ghidaje (> ∅ 135 mm)

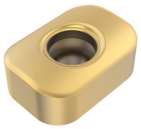
3.
Periferie

4.
Mărimea plăcuţei
SCGX07
SCGX09
SCGX12
SCGX15

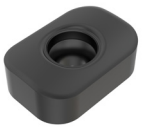
5.
N – diametru nominal
U – diametru inferior

Notă: Selectaţi kitul „D” de piese de schimb pentru diametru nominal (-N) sau inferior (-U) de la pagina 295 pentru a completa ansamblul corpului de burghiu. Kitul „D” trebuie comandat separat.

Ghidaj



-N



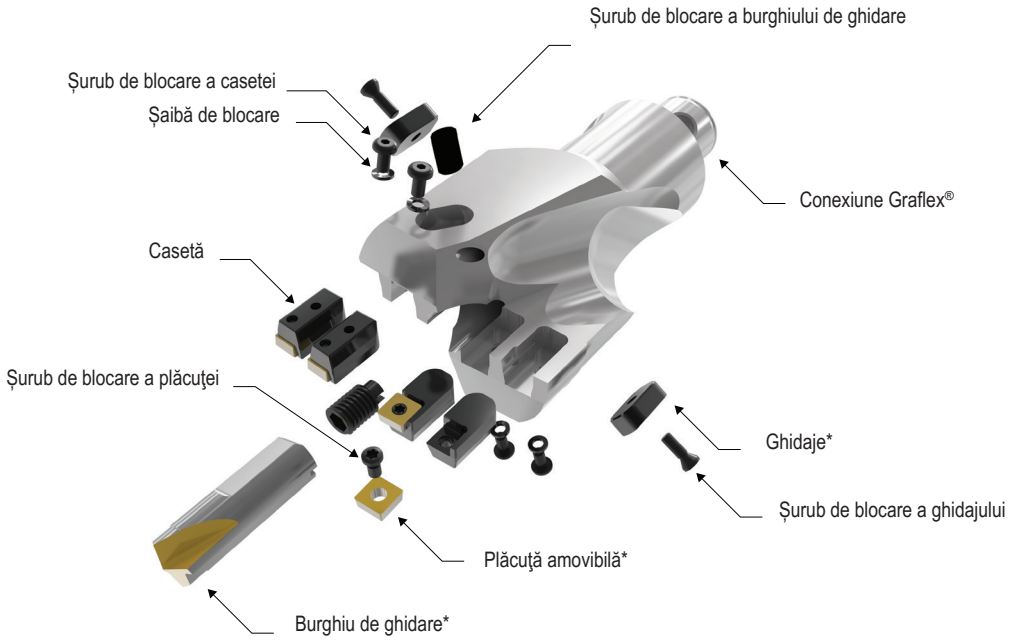
-U

PAD	–	L20R25	-N
			3

***3.**
N - Diametru nominal
U - Diametru mai mic

Asamblare burghiu cu cap modular

SD602-59/60-40RG





Exemplu: Diametru 59; SD602-59-40RG
Utilizaţi kitul: SD6020-P07*



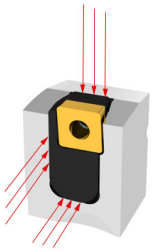
Exemplu: Diametru 60; SD602-60-40RG
Utilizaţi kitul: SD6020-P07-N*

Instrucţiuni de montare

- Strânge șurubul de blocare a casetei
- Montează plăcuţa
- Montează burghiul de ghidaj și fixează-l în gaură, dacă este necesară extinderea burghiului de ghidaj folosește șurubul de reglaj
- Montează extensiile

Montarea cartușelor și a ghidajelor

- Montează caseta
- Verifică să nu fie loc între casetă și pereţi
- Strânge șurubul de blocare a casetei cu cheia dinamometrică:
  SD600-x-07: 3 Nm
  SD600-x-09: 3 Nm
  SD600-x-12: 8 Nm
  SD600-x-15: 8 Nm
- Montează ghidajele
- Strânge șurubul de blocare a ghidajului

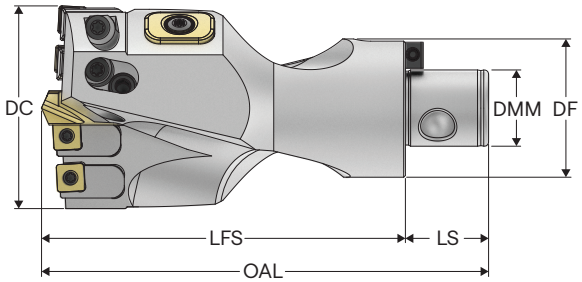


*** Nu este inclus în pachetul de livrare** Pachetul periferic, burghiul pilot și plăcuţele necesare se vor comanda separat.

SD602

Capete de burghie modulare – Metric/Inci





—Agent de răcire intern
—Pentru gama de plăcuţe, vezi pag. 301-304
—Regimuri de aşchiere, vezi pagina(paginile) 317-318
—Burghiu de ghidare reglabil

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

Piese de schimb, Piese incluse la livrare

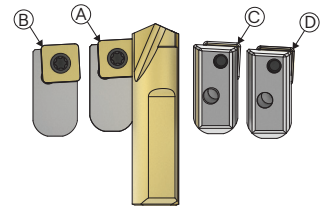
Casetă	Casetă	Şurubul casetei	Şaibă	Şurub de blocare a plăcuţei	Cheie plăcuţă	Ghidaje*	Ghidaje*	Şurub pad
								
SD600-C-07	SD600-P-07-N	K6S4x8	LW0408	C03007-T09P	T09P-2, T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-09	SD600-P-09-N	K6S4x8	LW0408	C03508-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
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

* Nu este inclus în pachetul de livrare

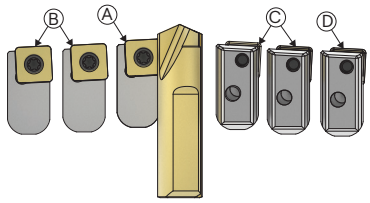
SD602

Capete de burghie modulare

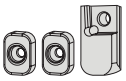
60 ≤ Ø ≤ 134.99



135 ≤ Ø ≤ 160



Piese de schimb, Piese incluse la livrare

Reper Nr.	Pentru burghiu dia (mm)	Pentru burghiu dia (inch)	Șurub pilot	Șurub reglaj	Casetă (A)	Casetă (B)	Casetă (C)	Kit periferic* (D)	Burghiu de ghidare* x=0 Carbură solidă 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

* Nu este inclus în pachetul de livrare. Kit periferic, U-subdimensiune, N-nominal.

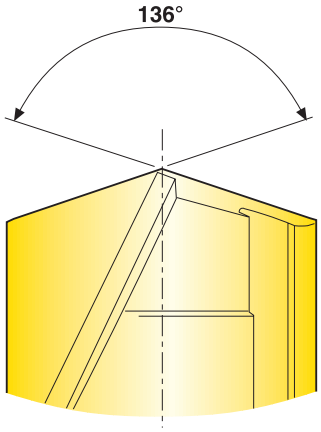
Pentru gama de plăcuţe, vezi pag. 301-304

Instrucţiuni de reascuţire pentru SD602

Specificaţii:
Specificaţiile propuse pentru discul de diamant:
Ajustaj conic: Forma roţii 12A2 Granulaţia D54 (fig.1).
Tăietura: Forma roţii 1A1 sau 1V1 granulaţia D64-D46 (fig. 2-3).
Şanfrenul la colţ: Forma roţii 1A1 sau 12A2 (fig. 1).
Tratamentul muchiei: ascuţire K-land sau rectificare (figura 2).

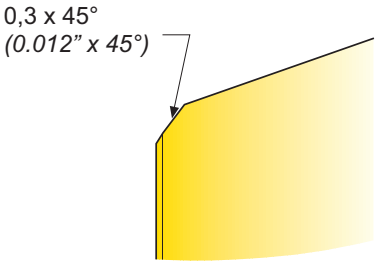
Important:
▪Muchiile aşchietoare trebuie să fie uniforme şi să aibă pregătirea muchiei de aceeaşi mărime.
▪Pregătirea muchiei trebuie extinsă pe toată lungimea muchiei aşchietoare.

1. Unghi la vârf

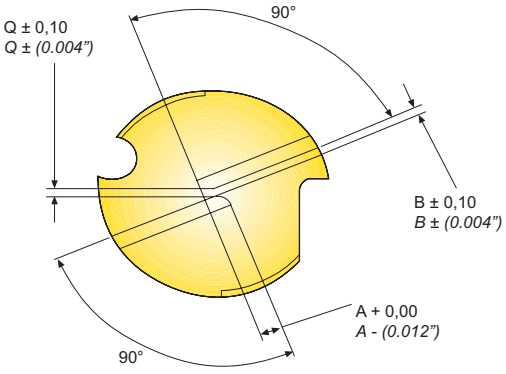


Pregătirea muchiei 0-0,1 mm *(0-0,004")* x 20°. Degajarea conică a vârfului burghiului 10°.

2. Şanfrenul la colţ



3.

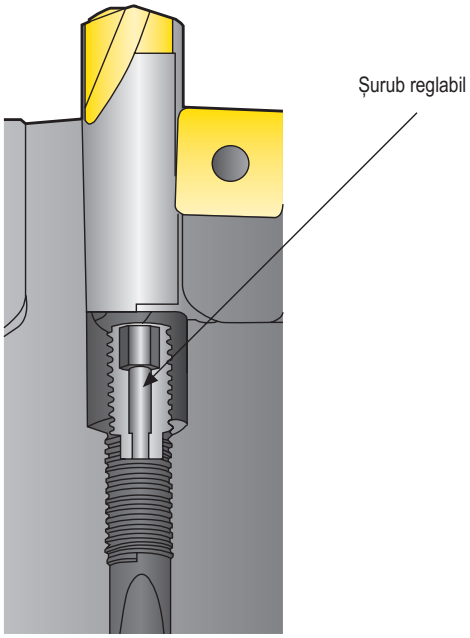


4.

Dimensiuni în mm (*inch*)				
Diametru	**A**	**B**	**C**	**Lungime minimă**
10 mm	1,5 *(0.059)*	0,5 *(0.020)*	0,57 *(0.022)*	38 *(1.496)*
15 mm	1,5 *(0.059)*	0,6 *(0.024)*	0,68 *(0.027)*	45 *(1.772)*
25 mm	1,5 *(0.059)*	1,4 *(0.055)*	1,6 *(0.063)*	57 *(2.244)*

Asamblare burghiu cu cap modular

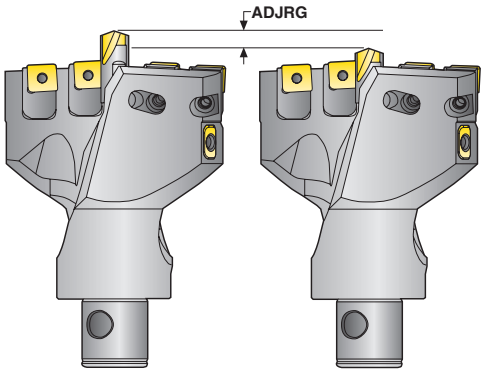
Caracteristici: Burghiu de ghidare reglabil



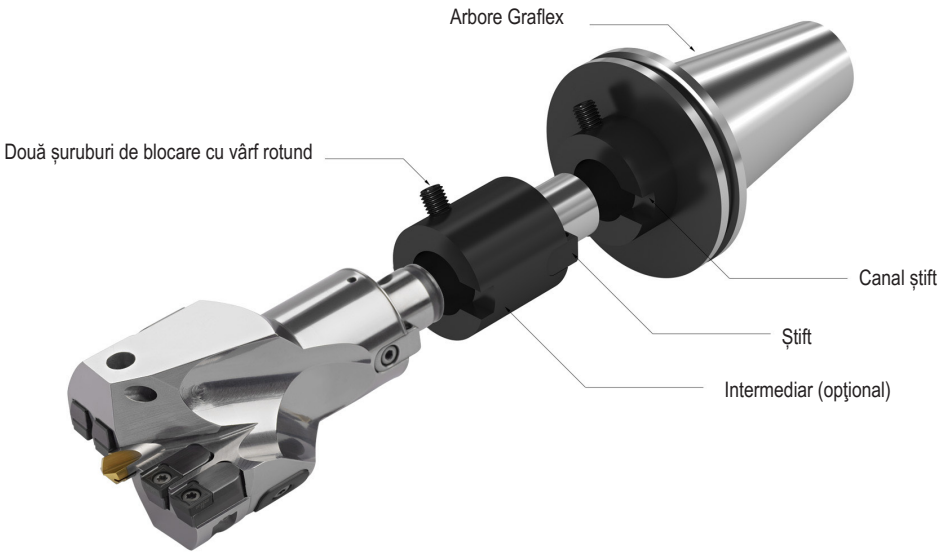
Burghiu	Lungime reglabilă ADJRG mm	*inch*
SD602-59/60-40RG	3,0	*0.118*
SD602-69/70-40RG	3,0	*0.118*
SD602-79/80-50RG	5,0	*0.197*
SD602-89/90-50RG	5,0	*0.197*
SD602-99/100-63RG	5,0	*0.197*
SD602-119/120-63RG	5,0	*0.197*
SD602-139/140-90RG	5,0	*0.197*
SD602-159/160-90RG	5,0	*0.197*
SD602-2500-40RG	3,0	*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*

Caracteristici: Lungime reglabilă

Beneficii: Aceeași lungime de reglare după reascuţirea unui burghiu pilot
Posibilitatea de a regla lungimea în consolă a burghiului pilot
Când adâncimea de găurire > 5 x D se recomandă reglarea burghiului cu 5 mm (*0,197*") în plus.
Recomandare: În cazul reintrării în gaură se recomandă reglarea burghiului de ghidare cu 3 mm (*0,118*") în plus faţă de poziţia iniţială pentru a asigura o mai bună centrare.

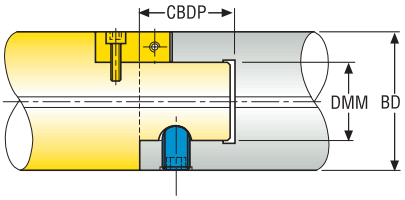


Asamblare burghiu cu cap modular



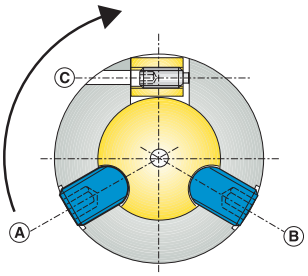
Instrucţiuni de montare

1. Curăţă piesele ce urmează să fie asamblate și aplică un strat subţire de antioxidant.
2. Asamblează piesele și asigură-te că latura stângă a știftului este în contact cu latura stângă a canalului pentru știft.
3. Strângeţi uşor şurubul A (capetele de burghiu trebuie mișcate înainte și înapoi pentru a găsi punctul cel mai de jos pentru șurubul A).
4. Strângeţi uşor şurubul B.
5. Strângeţi la cuplu șurubul de blocare C.
6. Strângeţi la cuplu șurubul A.
7. Strângeţi la cuplu șurubul B.
8. Reverificaţi strângerea șurubului de blocare.



Direcţia de rotaţie

Faţa stângă



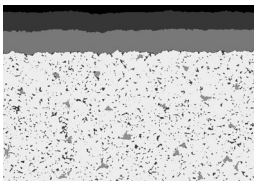
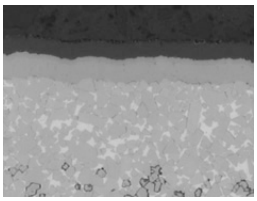
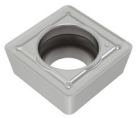
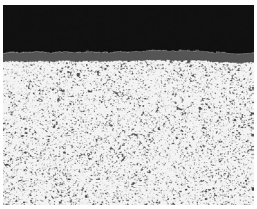
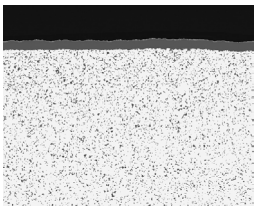
Mărimea Graflex	DMM mm (*inch*)	BD mm (*inch*)	CBDP mm (*inch*)	Cuplul recomandat la prinderea Graflex: Șuruburile cu vârf rotund (A) și (B)	Cuplul recomandat la prinderea Graflex: Șurubul de blocare a știftului (C)
4	22 *(0,866)*	40 *(1,575)*	24 *(0,945)*	20 Nm *(14,7 ft/lbs)*	0,7 Nm *(0,5 ft/lbs)*
5	28 *(1,102)*	50 *(1,969)*	30 *(1,181)*	25 Nm *(18,4 ft/lbs)*	2 Nm *(1,5 ft/lbs)*
6	36 *(1,417)*	63 *(2,480)*	40 *(1,575)*	35 Nm *(25,8 ft/lbs)*	4 Nm *(2,9 ft/lbs)*
7	46 *(1,811)*	90 *(3,543)*	50 *(1,969)*	60 Nm *(44,2 ft/lbs)*	8 Nm *(5,9 ft/lbs)*

Clasa plăcuţei

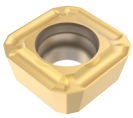
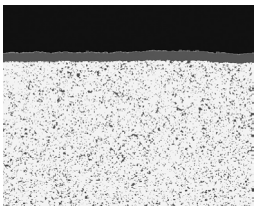
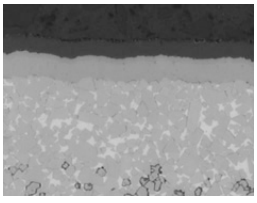
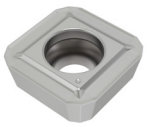
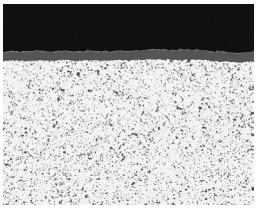
Caracteristici:
— 4 muchii de aşchiere pe plăcuţă
— Plăcuţe pătrate solide

Beneficii:
— Economie
— Siguranţă
— Performanţă
— Preţ mic per gaură

Plcuţa periferică

DP2000			Tehnologia de acoperire DURATOMIC® Clasă optimizată pentru prelucrarea oţelului şi fontei pentru prelucrarea cu viteze de aşchiere foarte mari O combinaţie unică de tenacitate superioară a muchiei şi o acoperire groasă rezistentă la uzură Ti(C,N) + Al_2O_3 DURATOMIC®
DP2501			Tehnologie de acoperire DURATOMIC® Clasă universală Rezistenţă superioară la uzură şi rezilienţă a muchiilor Clasă tenace pentru securitate maximă în aplicaţii Ti(C,N) + Al_2O_3 DURATOMIC® Gradient substrate
DS2050			Calitate optimizată pentru titan, super aliaje şi oţel inoxidabil dificil Acoperire PVD TiAlN + NbN
T250D			Prima alegere în oţel călit şi în Al cu conţinut ridicat de Si, muchie ascuţită de aşchiere şi acoperirea PVD (TiAl)N + TiN

Plcuţa centrală

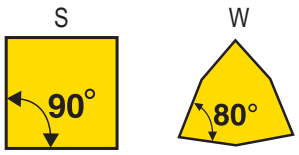
T400D			Prima alegere Clasa rezilientă pentru plăcuţa centrală dură, pentru securitate maximă Acoperire PVD (Ti, Al)N + TiN
DP2501			Tehnologie de acoperire DURATOMIC® Rezistenţă superioară la uzură şi rezilienţă a muchiilor Ti(C,N) + Al_2O_3 DURATOMIC® Gradient substrate
DS4050			Calitate optimizată pentru titan, super aliaje şi oţel inoxidabil dificil Acoperire PVD TiAlN + NbN

Geometrii

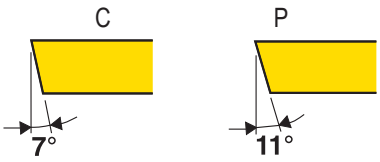


S	C	G	X	06	02	04	-	P1
1	2	3	4	5	6	7		10

1. Formă plăcuţe amovibile



2. Unghiul de degajare laterală al plăcuţei amovibile



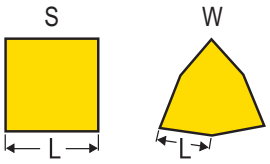
4. Tip

X=Special

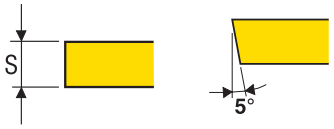
3. Toleranţe

Tol. clasa	Toleranţa +/- mm (*inch*)			Pentru IC, dimensiune în mm/in (*inch*)								
		S		5,556 (0.2187)	6,35 (0.2500)	7,937 (0.3125)	7,94 (0.3126)	9,525 (0.3750)	11,509 (0.4531)	12,7 (0.5000)	15,875 (0.6250)	19,05 (0.7500)
	m		IC									
G	0,025 (0.001)	0,13 (0.005)	0,025 (0.001)	•	•	•		•	•	•	•	•
M	0,013 (0.005)	0,13 (0.005)	0,05 (0.002)	•	•		•	•	•	•	•	•
M	0,013 (0.005)	0,13 (0.005)	0,08 (0.003)							•		

5. Lungimea muchiei aşchietoare



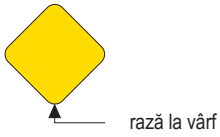
6. Grosimea



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

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

7. Plăcuţă amovibilă cu colţ şanfren/rază la colţ



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

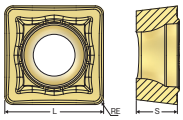
10. Descriere proprie:

ex. denumirea fragmentatorului de aşchii

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

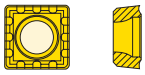
Plăcuţe indexabile – Plăcuţa periferică, tip P1*

pentru SD522, SD523, SD524, SD525, SD542, SD602



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

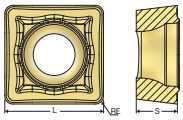
*Fragmentator pentru viteze mici de avans şi pentru o finisare bună a suprafeţei în toate materialele



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

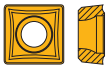
Plăcuţe indexabile – Plăcuţa periferică, tip P2**

pentru SD522, SD523, SD524, SD525, SD542, SD602



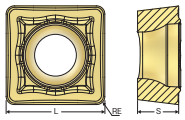
Toleranţe:
L = ±0,025 (0.001")
S = ±0,13 (0.005")
RE = ±0,1 (0.004")

**Fragmentator pentru viteze mari de avans în oţel, oţel inoxidabil şi fontă

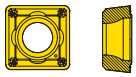


Reper Nr.	Plăcuţe amovibile	L	S	RE	Calităţi		
		mm *Inci*	mm *Inci*	mm *Inci*	T250D	DP2000	DP2501
SCGX050204-P2	SCGX-P2	5,556 *0,219*	2,38 *0,094*	0,4 *0,016*	00059711	02590854	10299502
SCGX060204-P2	SCGX-P2	6,35 *0,25*	2,38 *0,094*	0,4 *0,016*	02526803	02590855	10299503
SCGX070308-P2	SCGX-P2	7,937 *0,312*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

Plăcuţe indexabile – Plăcuţa periferică, tip MP
pentru SD522, SD523, SD524, SD525, SD542

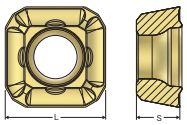


Toleranţe:
L = ±0,025 (0.001")
S = ±0,13 (0.005")
RE = ±0,1 (0.004")

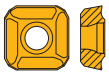


Reper Nr.	Plăcuţe amovibile	L	S	RE	Calităţi
		mm *Inci*	mm *Inci*	mm *Inci*	**DS2050**
SCGX050204-MP	SCGX-MP	5,56 *0,219*	2,38 *0,094*	0,4 *0,016*	03134312
SCGX060204-MP	SCGX-MP	6,35 *0,25*	6,35 *0,25*	0,4 *0,016*	03134313
SCGX070308-MP	SCGX-MP	7,94 *0,313*	3,18 *0,125*	0,8 *0,031*	03134314
SCGX09T308-MP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

Plăcuţe indexabile – Plăcuţa centrală, tip C1
pentru SD522, SD523, SD524, SD525, SD542, SD602

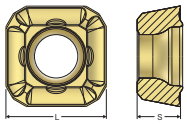


Toleranţe:
L = ±0,025 (0.001")
S = ±0,13 (0.005")

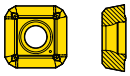


Reper Nr.	Plăcuţe amovibile	L	S	Calităţi	
		mm *Inci*	mm *Inci*	**T400D**	**DP2501**
SPGX0502-C1	SPGX-C1	5,556 *0,219*	2,38 *0,094*	74077370	10299515
SPGX0602-C1	SPGX-C1	6,35 *0,25*	2,38 *0,094*	74077371	10299516
SPGX0703-C1	SPGX-C1	7,937 *0,312*	3,18 *0,125*	74077372	10299517
SPGX0903-C1	SPGX-C1	9,525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

Plăcuţe indexabile – Plăcuţa centrală, tip MC
pentru SD522, SD523, SD524, SD525, SD542

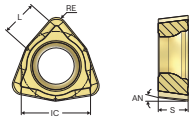


Toleranţe:
L = ±0,025 (0.001")
S = ±0,13 (0.005")



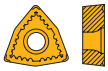
Reper Nr.	Plăcuţe amovibile	L	S	Calităţi
		mm *Inci*	mm *Inci*	**DS4050**
SPGX0502-MC	SPGX-MC	5,56 *0,219*	2,38 *0,094*	03134319
SPGX0602-MC	SPGX-MC	6,35 *0,25*	2,38 *0,094*	03134320
SPGX0703-MC	SPGX-MC	7,94 *0,313*	3,18 *0,125*	03134321
SPGX0903-MC	SPGX-MC	9,525 *0,375*	3,18 *0,125*	03134322
SPGX11T3-MC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

Plăcuţe indexabile – Plăcuţa periferică, tip 85*
pentru SD572



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

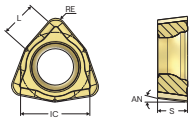
*Fragmentator pentru viteze mici de avans şi pentru o finisare bună a suprafeţei în toate materialele



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

Plăcuţă centrală, Plăcuţă periferică tip 86**

pentru SD572



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

**Fragmentator pentru viteze mari de avans în oţel, oţel inoxidabil şi fontă



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

SD522 Ø 15-60 mm / *0.590-2.375 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD522 Viteza de așchiere

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

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

SD523 Ø 15-60 mm / *0.590-2.375 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD523 Viteza de așchiere

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

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

SD524 Ø 15-60 mm / *0.590-2.375 inch*

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

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD524 Viteza de așchiere

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

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

SD525 Ø 19-45 mm / *0.768-2.000 inch*

SMG		f					v_c
		Ø 19,50-22,49 *Ø 0.768-0.885*	Ø 22,50-28,49 *Ø 0.886-1.121*	Ø 28,50-34,49 *Ø 1.122-1.357*	Ø 34,50-40,49 *Ø1.358-1.593*	Ø 40,49-45,00 *Ø 1.594-2.000*	
P1	P2 DP2501	0,070	0,085	0,095	0,11	0,12	320
	P2 DP2501	*0.0028*	*0.0034*	*0.0038*	*0.0044*	*0.0048*	*1050*
P2	P2 DP2501	0,070	0,085	0,10	0,11	0,12	310
	P2 DP2501	*0.0028*	*0.0034*	*0.0040*	*0.0044*	*0.0048*	*1025*
P3	P2 DP2501	0,14	0,17	0,19	0,22	0,22	265
	P2 DP2501	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*870*
P4	P2 DP2501	0,13	0,16	0,19	0,22	0,22	180
	P2 DP2501	*0.0050*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*590*
P5	P2 DP2501	0,13	0,16	0,18	0,20	0,22	170
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*560*
P6	P2 DP2501	0,13	0,16	0,18	0,20	0,22	190
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*620*
P7	P2 DP2501	0,13	0,16	0,18	0,20	0,22	180
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*590*
P8	P2 DP2501	0,14	0,17	0,19	0,22	0,22	170
	P2 DP2501	*0.0055*	*0.0065*	*0.0075*	*0.0085*	*0.0085*	*560*
P11	P2 DP2501	0,13	0,16	0,18	0,20	0,22	175
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*570*
P12	P2 DP2501	0,090	0,11	0,12	0,14	0,15	105
	P2 DP2501	*0.0036*	*0.0044*	*0.0048*	*0.0055*	*0.0060*	*345*
M1	P2 DP2501	0,10	0,12	0,14	0,16	0,17	210
	P2 DP2501	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*0.0065*	*690*
M2	P2 DP2501	0,090	0,11	0,13	0,14	0,15	170
	P2 DP2501	*0.0036*	*0.0044*	*0.0050*	*0.0055*	*0.0060*	*560*
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 DP2501	0,14	0,17	0,20	0,22	0,24	185
	P2 DP2501	*0.0055*	*0.0065*	*0.0080*	*0.0085*	*0.0095*	*610*
K2	P2 DP2501	0,13	0,16	0,18	0,20	0,22	160
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*520*
K3	P2 DP2501	0,13	0,16	0,18	0,20	0,22	135
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*445*
K4	P2 DP2501	0,13	0,16	0,18	0,20	0,22	130
	P2 DP2501	*0.0050*	*0.0065*	*0.0070*	*0.0080*	*0.0085*	*425*
K5	P2 DP2501	0,11	0,14	0,16	0,18	0,19	80
	P2 DP2501	*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 = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD525 Viteza de așchiere

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	355 *1175*	320 *1050*	320 *1050*	205 *670*	320 *1050*
P2	345 *1125*	310 *1025*	310 *1025*	200 *660*	310 *1025*
P3	295 *970*	265 *870*	265 *870*	170 *560*	265 *870*
P4	165 *540*	180 *590*	170 *560*	90 *295*	— —
P5	155 *510*	170 *560*	165 *540*	90 *295*	— —
P6	175 *570*	190 *620*	180 *590*	100 *330*	— —
P7	165 *540*	180 *590*	170 *560*	95 *310*	— —
P8	155 *510*	170 *560*	165 *540*	90 *295*	— —
P11	160 *520*	175 *570*	165 *540*	90 *295*	— —
P12	95 *310*	105 *345*	100 *330*	55 *180*	— —
M1	— —	210 *690*	225 *740*	105 *345*	— —
M2	— —	170 *560*	180 *590*	85 *280*	— —
M3	— —	140 *460*	140 *460*	65 *215*	140 *460*
M4	— —	105 *345*	105 *345*	49 *160*	95 *310*
M5	— —	85 *280*	85 *280*	41 *135*	80 *260*
K1	195 *640*	185 *610*	185 *610*	— —	— —
K2	170 *560*	160 *520*	160 *520*	— —	— —
K3	145 *475*	135 *445*	135 *445*	— —	— —
K4	140 *460*	130 *425*	130 *425*	— —	— —
K5	80 *260*	80 *260*	80 *260*	— —	— —
N1	— —	285 *940*	285 *940*	240 *790*	240 *790*
N2	— —	185 *610*	185 *610*	155 *510*	155 *510*
N3	— —	120 *395*	120 *395*	100 *330*	100 *330*
N11	— —	235 *770*	235 *770*	200 *660*	200 *660*
S1	— —	— —	— —	26 *85*	44 *145*
S2	— —	— —	— —	20 *65*	36 *120*
S3	— —	— —	— —	20 *65*	31 *100*
S11	— —	— —	— —	50 *165*	65 *215*
S12	— —	— —	— —	39 *130*	49 *160*
S13	— —	— —	— —	30 *100*	38 *125*
H3	— —	25 *80*	48 *155*	46 *150*	— —
H5	— —	47 *155*	90 *295*	85 *280*	— —
H7	— —	25 *80*	48 *155*	46 *150*	— —
H8	— —	47 *155*	90 *295*	85 *280*	— —
H11	— —	60 *195*	115 *375*	110 *360*	— —
H12	— —	55 *180*	60 *195*	100 *330*	— —
H21	— —	90 *295*	90 *295*	85 *280*	— —

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

SD5301 & SD5402 Ø 60-85 mm / *2.250-3.500 inch*

SMG		f		v_c
		Ø60,00-65,00 *Ø 2.250-2.559*	Ø70,00-85,00 *Ø 2.750-3.500*	
P1	P2 DP2501 *P2 DP2501*	0,095 *0.0038*	0,12 *0.0048*	390 *1275*
P2	P2 DP2501 *P2 DP2501*	0,10 *0.0040*	0,12 *0.0048*	380 *1250*
P3	P2 DP2501 *P2 DP2501*	0,19 *0.0075*	0,22 *0.0085*	325 *1075*
P4	P2 DP2501 *P2 DP2501*	0,19 *0.0075*	0,22 *0.0085*	220 *720*
P5	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	210 *690*
P6	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	235 *770*
P7	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	220 *720*
P8	P2 DP2501 *P2 DP2501*	0,19 *0.0075*	0,22 *0.0085*	210 *690*
P11	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	215 *710*
P12	P2 DP2501 *P2 DP2501*	0,12 *0.0048*	0,15 *0.0060*	125 *410*
M1	P2 DP2501 *P2 DP2501*	0,14 *0.0055*	0,17 *0.0065*	235 *770*
M2	P2 DP2501 *P2 DP2501*	0,13 *0.0050*	0,15 *0.0060*	190 *620*
M3	P1 T250D *P1 T250D*	0,10 *0.0040*	0,12 *0.0048*	90 *295*
M4	P1 T250D *P1 T250D*	0,090 *0.0036*	0,11 *0.0044*	70 *230*
M5	P1 T250D *P1 T250D*	0,090 *0.0036*	0,11 *0.0044*	55 *180*
K1	P2 DP2501 *P2 DP2501*	0,20 *0.0080*	0,24 *0.0095*	225 *740*
K2	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	195 *640*
K3	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	165 *540*
K4	P2 DP2501 *P2 DP2501*	0,18 *0.0070*	0,22 *0.0085*	160 *520*
K5	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,19 *0.0075*	95 *310*
N1	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	335 *1100*
N2	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	215 *710*
N3	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	145 *475*
N11	P1 T250D *P1 T250D*	0,20 *0.0080*	0,24 *0.0095*	285 *940*
S1	MP DS2050 *MP DS2050*	0,15 *0.0060*	0,18 *0.0070*	55 *180*
S2	MP DS2050 *MP DS2050*	0,15 *0.0060*	0,18 *0.0070*	45 *150*
S3	MP DS2050 *MP DS2050*	0,14 *0.0055*	0,17 *0.0065*	39 *130*
S11	MP DS2050 *MP DS2050*	0,17 *0.0065*	0,20 *0.0080*	80 *260*
S12	MP DS2050 *MP DS2050*	0,17 *0.0065*	0,20 *0.0080*	60 *195*
S13	MP DS2050 *MP DS2050*	0,15 *0.0060*	0,18 *0.0070*	48 *155*
H3	P1 T250D *P1 T250D*	0,080 *0.0032*	0,10 *0.0040*	65 *215*
H5	P1 T250D *P1 T250D*	0,12 *0.0048*	0,15 *0.0060*	120 *395*
H7	P1 T250D *P1 T250D*	0,080 *0.0032*	0,10 *0.0040*	65 *215*
H8	P1 T250D *P1 T250D*	0,095 *0.0038*	0,11 *0.0044*	120 *395*
H11	P1 T250D *P1 T250D*	0,12 *0.0048*	0,15 *0.0060*	155 *510*
H12	P1 T250D *P1 T250D*	0,095 *0.0038*	0,11 *0.0044*	140 *460*
H21	P1 T250D *P1 T250D*	0,095 *0.0038*	0,11 *0.0044*	120 *395*

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD5301 & SD5402 Viteza de așchiere

SMG	v_c				
	DP2000	DP2501	DP3000	T250D	DS2050
P1	435 *1425*	390 *1275*	390 *1275*	290 *950*	390 *1275*
P2	425 *1400*	380 *1250*	380 *1250*	280 *920*	380 *1250*
P3	365 *1200*	325 *1075*	325 *1075*	240 *790*	325 *1075*
P4	255 *840*	220 *720*	210 *690*	130 *425*	— —
P5	245 *800*	210 *690*	200 *660*	125 *410*	— —
P6	275 *900*	235 *770*	225 *740*	140 *460*	— —
P7	260 *850*	220 *720*	210 *690*	130 *425*	— —
P8	245 *800*	210 *690*	200 *660*	125 *410*	— —
P11	250 *820*	215 *710*	205 *670*	125 *410*	— —
P12	150 *490*	125 *410*	120 *395*	75 *245*	— —
M1	— —	235 *770*	250 *820*	150 *490*	— —
M2	— —	190 *620*	205 *670*	120 *395*	— —
M3	— —	155 *510*	155 *510*	90 *295*	155 *510*
M4	— —	115 *375*	115 *375*	70 *230*	130 *425*
M5	— —	95 *310*	95 *310*	55 *180*	105 *345*
K1	235 *770*	225 *740*	225 *740*	— —	— —
K2	205 *670*	195 *640*	195 *640*	— —	— —
K3	175 *570*	165 *540*	165 *540*	— —	— —
K4	165 *540*	160 *520*	160 *520*	— —	— —
K5	100 *330*	95 *310*	95 *310*	— —	— —
N1	— —	390 *1275*	390 *1275*	335 *1100*	335 *1100*
N2	— —	250 *820*	250 *820*	215 *710*	215 *710*
N3	— —	165 *540*	165 *540*	145 *475*	145 *475*
N11	— —	325 *1075*	325 *1075*	285 *940*	285 *940*
S1	— —	— —	— —	37 *120*	55 *180*
S2	— —	— —	— —	27 *90*	45 *150*
S3	— —	— —	— —	27 *90*	39 *130*
S11	— —	— —	— —	70 *230*	80 *260*
S12	— —	— —	— —	55 *180*	60 *195*
S13	— —	— —	— —	43 *140*	48 *155*
H3	— —	31 *100*	65 *215*	65 *215*	— —
H5	— —	60 *195*	120 *395*	120 *395*	— —
H7	— —	31 *100*	65 *215*	65 *215*	— —
H8	— —	60 *195*	120 *395*	120 *395*	— —
H11	— —	75 *245*	155 *510*	155 *510*	— —
H12	— —	65 *215*	70 *230*	140 *460*	— —
H21	— —	120 *395*	120 *395*	120 *395*	— —

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

SD5702 Ø 15-52 mm / *0.590-2.0472 inch*

SMG		f						v_c
		Ø15,00-17,00 *Ø 0.590-0.669*	Ø18,00-20,00 *Ø 0.670-0.787*	Ø21,00-24,00 *Ø 0.788-0.944*	Ø25,00-32,00 *Ø 0.945-1.259*	Ø33,00-36,00 *Ø 1.260-1.417*	Ø37,00-52,00 *Ø 1.418-1.850*	
P1	85 DP2501	0,042	0,042	0,048	0,060	0,070	0,085	325
	85 DP2501	*0.0017*	*0.0017*	*0.0019*	*0.0024*	*0.0028*	*0.0034*	*1075*
P2	85 DP2501	0,042	0,042	0,050	0,060	0,070	0,085	320
	85 DP2501	*0.0017*	*0.0017*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*1050*
P3	86 DP2501	0,080	0,080	0,090	0,11	0,13	0,16	275
	86 DP2501	*0.0032*	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*900*
P4	86 DP2501	0,080	0,080	0,090	0,11	0,13	0,16	240
	86 DP2501	*0.0032*	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*790*
P5	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	230
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*750*
P6	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	260
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*850*
P7	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	245
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*800*
P8	86 DP2501	0,080	0,080	0,090	0,11	0,13	0,16	230
	86 DP2501	*0.0032*	*0.0032*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*750*
P11	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	235
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*770*
P12	86 DP2501	0,050	0,050	0,060	0,075	0,085	0,10	140
	86 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*460*
M1	86 DP2501	0,048	0,048	0,055	0,065	0,080	0,095	235
	86 DP2501	*0.0019*	*0.0019*	*0.0022*	*0.0026*	*0.0032*	*0.0038*	*770*
M2	86 DP2501	0,042	0,042	0,050	0,060	0,070	0,085	190
	86 DP2501	*0.0017*	*0.0017*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*620*
M3	85 DP2501	0,034	0,034	0,040	0,048	0,055	0,070	145
	85 DP2501	*0.0013*	*0.0013*	*0.0016*	*0.0019*	*0.0022*	*0.0028*	*475*
M4	85 DP2501	0,030	0,030	0,034	0,042	0,050	0,060	110
	85 DP2501	*0.0012*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0024*	*360*
M5	85 DP2501	0,030	0,030	0,034	0,042	0,050	0,060	90
	85 DP2501	*0.0012*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0024*	*295*
K1	86 DP2501	0,075	0,075	0,090	0,11	0,13	0,15	180
	86 DP2501	*0.0030*	*0.0030*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*590*
K2	86 DP2501	0,070	0,070	0,080	0,10	0,12	0,14	155
	86 DP2501	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*510*
K3	86 DP2501	0,070	0,070	0,080	0,10	0,12	0,14	130
	86 DP2501	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*425*
K4	86 DP2501	0,070	0,070	0,080	0,10	0,12	0,14	125
	86 DP2501	*0.0028*	*0.0028*	*0.0032*	*0.0040*	*0.0048*	*0.0055*	*410*
K5	86 DP2501	0,065	0,065	0,075	0,090	0,10	0,12	75
	86 DP2501	*0.0026*	*0.0026*	*0.0030*	*0.0036*	*0.0040*	*0.0048*	*245*
S1	85 DP2501	0,055	0,055	0,060	0,075	0,090	0,11	40
	85 DP2501	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*130*
S2	85 DP2501	0,055	0,055	0,060	0,075	0,090	0,11	30
	85 DP2501	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*100*
S3	85 DP2501	0,050	0,050	0,060	0,070	0,085	0,10	30
	85 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*100*
S11	85 DP2501	0,060	0,060	0,070	0,090	0,10	0,12	80
	85 DP2501	*0.0024*	*0.0024*	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*260*
S12	85 DP2501	0,060	0,060	0,070	0,090	0,10	0,12	60
	85 DP2501	*0.0024*	*0.0024*	*0.0028*	*0.0036*	*0.0040*	*0.0048*	*195*
S13	85 DP2501	0,055	0,055	0,060	0,075	0,090	0,11	47
	85 DP2501	*0.0022*	*0.0022*	*0.0024*	*0.0030*	*0.0036*	*0.0044*	*155*
H3	86 DP2501	0,034	0,034	0,040	0,050	0,055	0,070	80
	86 DP2501	*0.0013*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*0.0028*	*260*
H5	86 DP2501	0,050	0,050	0,060	0,075	0,085	0,10	150
	86 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*490*
H7	86 DP2501	0,034	0,034	0,040	0,050	0,055	0,070	80
	86 DP2501	*0.0013*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*0.0028*	*260*
H8	86 DP2501	0,040	0,040	0,046	0,055	0,065	0,080	150
	86 DP2501	*0.0016*	*0.0016*	*0.0018*	*0.0022*	*0.0026*	*0.0032*	*490*
H11	86 DP2501	0,050	0,050	0,060	0,075	0,085	0,10	195
	86 DP2501	*0.0020*	*0.0020*	*0.0024*	*0.0030*	*0.0034*	*0.0040*	*640*
H12	86 DP2501	0,040	0,040	0,046	0,055	0,065	0,080	85
	86 DP2501	*0.0016*	*0.0016*	*0.0018*	*0.0022*	*0.0026*	*0.0032*	*280*
H21	86 DP2501	0,040	0,040	0,046	0,055	0,065	0,080	150
	86 DP2501	*0.0016*	*0.0016*	*0.0018*	*0.0022*	*0.0026*	*0.0032*	*490*

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de aşchiere sunt valori de start.

SD5702 Viteza de așchiere

SMG	v_c		
	DP2000	DP2501	DP3000
P1	375 *1225*	325 *1075*	310 *1025*
P2	365 *1200*	320 *1050*	305 *1000*
P3	315 *1025*	275 *900*	260 *850*
P4	280 *920*	240 *790*	230 *750*
P5	265 *870*	230 *750*	220 *720*
P6	300 *980*	260 *850*	245 *800*
P7	280 *920*	245 *800*	235 *770*
P8	265 *870*	230 *750*	220 *720*
P11	275 *900*	235 *770*	225 *740*
P12	160 *520*	140 *460*	135 *445*
M1	285 *940*	235 *770*	235 *770*
M2	230 *750*	190 *620*	190 *620*
M3	175 *570*	145 *475*	145 *475*
M4	130 *425*	110 *360*	110 *360*
M5	110 *360*	90 *295*	90 *295*
K1	215 *710*	180 *590*	180 *590*
K2	185 *610*	155 *510*	155 *510*
K3	160 *520*	130 *425*	130 *425*
K4	150 *490*	125 *410*	125 *410*
K5	90 *295*	75 *245*	75 *245*
S1	— —	40 *130*	40 *130*
S2	— —	30 *100*	30 *100*
S3	— —	30 *100*	30 *100*
S11	— —	80 *260*	80 *260*
S12	— —	60 *195*	60 *195*
S13	— —	47 *155*	47 *155*
H3	80 *260*	80 *260*	80 *260*
H5	150 *490*	150 *490*	150 *490*
H7	80 *260*	80 *260*	80 *260*
H8	150 *490*	150 *490*	150 *490*
H11	195 *640*	195 *640*	195 *640*
H12	95 *310*	85 *280*	80 *260*
H21	150 *490*	150 *490*	150 *490*

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

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

SMG		f					v_c
		Ø60,00-69,99 *Ø 2.362-2.755*	Ø70,00-91,99 *Ø 2.756-3.621*	Ø92,00-110,99 *Ø 3.622-4.369*	Ø111,00-134,99 *Ø 4.370-4.314*	Ø135,00-160,00 *Ø 4.315-6.300*	
P1	P2 DP2501 *P2 DP2501*	0,085 *0.0034*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,12 *0.0048*	295 *970*
P2	P2 DP2501 *P2 DP2501*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	0,12 *0.0048*	285 *940*
P3	P2 DP2501 *P2 DP2501*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,26 *0.010*	0,22 *0.0085*	245 *800*
P4	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	0,22 *0.0085*	165 *540*
P5	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,22 *0.0085*	160 *520*
P6	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,22 *0.0085*	175 *570*
P7	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,22 *0.0085*	165 *540*
P8	P2 DP2501 *P2 DP2501*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,26 *0.010*	0,22 *0.0085*	160 *520*
P11	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,22 *0.0085*	160 *520*
P12	P2 DP2501 *P2 DP2501*	0,11 *0.0044*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,15 *0.0060*	95 *310*
M1	P2 DP2501 *P2 DP2501*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	0,17 *0.0065*	200 *660*
M2	P2 DP2501 *P2 DP2501*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,15 *0.0060*	160 *520*
M3	P1 DP2501 *P1 DP2501*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,12 *0.0048*	135 *445*
M4	P1 DP2501 *P1 DP2501*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	0,11 *0.0044*	100 *330*
M5	P1 DP2501 *P1 DP2501*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	0,11 *0.0044*	85 *280*
K1	P2 DP2501 *P2 DP2501*	0,17 *0.0065*	0,20 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,24 *0.0095*	175 *570*
K2	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,24 *0.0095*	0,22 *0.0085*	150 *490*
K3	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,24 *0.0095*	0,22 *0.0085*	130 *425*
K4	P2 DP2501 *P2 DP2501*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,24 *0.0095*	0,22 *0.0085*	120 *395*
K5	P2 DP2501 *P2 DP2501*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,19 *0.0075*	75 *245*
H3	P2 DP2501 *P2 DP2501*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,10 *0.0040*	23 *75*
H5	P2 DP2501 *P2 DP2501*	0,11 *0.0044*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,15 *0.0060*	43 *140*
H7	P2 DP2501 *P2 DP2501*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,10 *0.0040*	23 *75*
H8	P2 DP2501 *P2 DP2501*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,11 *0.0044*	43 *140*
H11	P2 DP2501 *P2 DP2501*	0,11 *0.0044*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,15 *0.0060*	55 *180*
H12	P2 DP2501 *P2 DP2501*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,11 *0.0044*	50 *165*
H21	P2 DP2501 *P2 DP2501*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,11 *0.0044*	80 *260*

SMG = Grupa de material Seco f = mm/rot (IPR) v_c= m/min Toţi parametri de așchiere sunt valori de start.

SD602 Viteza de așchiere

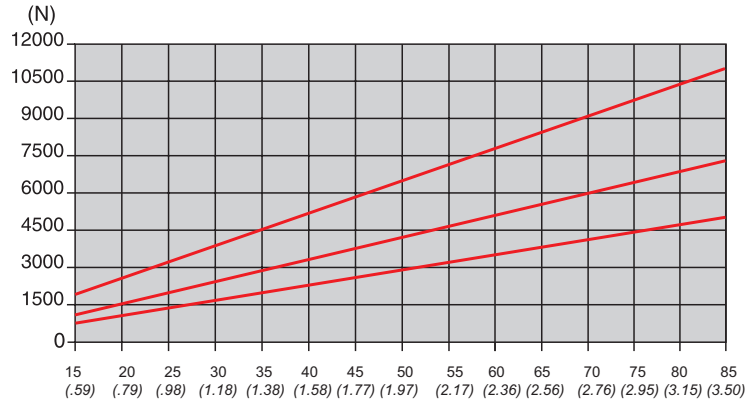
SMG	v_c			
	DP2501	DP3000	T250D	DS2050
P1	295 *970*	295 *970*	180 *590*	295 *970*
P2	285 *940*	285 *940*	175 *570*	285 *940*
P3	245 *800*	245 *800*	150 *490*	245 *800*
P4	165 *540*	160 *520*	80 *260*	— —
P5	160 *520*	150 *490*	75 *245*	— —
P6	175 *570*	170 *560*	85 *280*	— —
P7	165 *540*	160 *520*	80 *260*	— —
P8	160 *520*	150 *490*	75 *245*	— —
P11	160 *520*	155 *510*	80 *260*	— —
P12	95 *310*	90 *295*	46 *150*	— —
M1	200 *660*	215 *710*	90 *295*	— —
M2	160 *520*	175 *570*	75 *245*	— —
M3	135 *445*	135 *445*	55 *180*	135 *445*
M4	100 *330*	100 *330*	43 *140*	85 *280*
M5	85 *280*	85 *280*	36 *120*	70 *230*
K1	175 *570*	175 *570*	— —	— —
K2	150 *490*	150 *490*	— —	— —
K3	130 *425*	130 *425*	— —	— —
K4	120 *395*	120 *395*	— —	— —
K5	75 *245*	75 *245*	— —	— —
H3	23 *75*	42 *140*	40 *130*	— —
H5	43 *140*	80 *260*	75 *245*	— —
H7	23 *75*	42 *140*	40 *130*	— —
H8	43 *140*	80 *260*	75 *245*	— —
H11	55 *180*	100 *330*	95 *310*	— —
H12	50 *165*	55 *180*	85 *280*	— —
H21	80 *260*	80 *260*	75 *245*	— —

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

Parametri de prelucrare SD522, SD523, SD524, SD525, SD5301, SD5402 and SD5702 – Consum de putere, volum de lichid de răcire și grafice cu forţe

Valorile din grafic pot varia în funcţie de ex. regimurile de aşchiere, materialul, eficienţa maşinii şi uzura sculei.
Graficele de mai jos sunt valabile pentru Grupa de materiale Seco (SMG) P5-P6 și viteza de aşchiere de 200 m/min (*655 sf/m*).

Forţa avansului

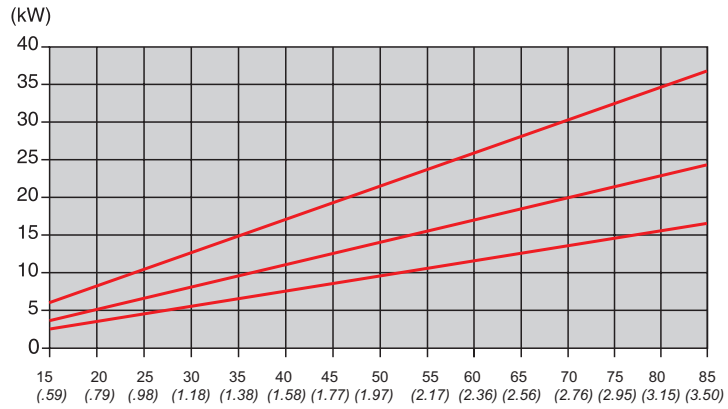


f = 0,18 mm/rot
(f = 0,007 inci/rot)

f = 0,12 mm/rot
(f = 0,005 inci/rot)

f = 0,08 mm/rot
(f = 0,003 inci/rot)

Consumul net de putere

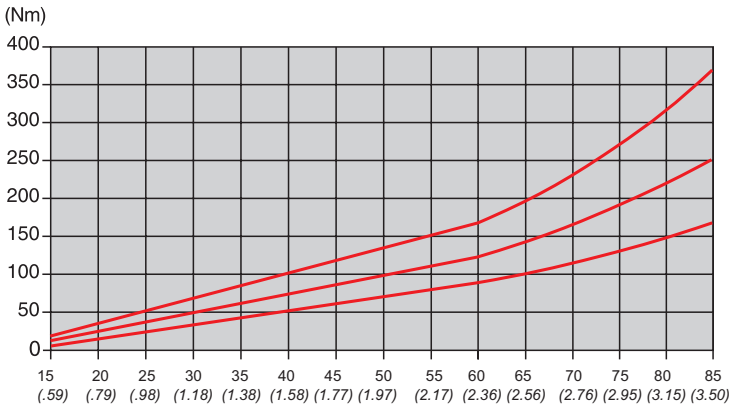


f = 0,18 mm/rot
(f = 0,007 inci/rot)

f = 0,12 mm/rot
(f = 0,005 inci/rot)

f = 0,08 mm/rot
(f = 0,003 inci/rot)

Cuplul la găurire



f = 0,18 mm/rot
(f = 0,007 inci/rot)

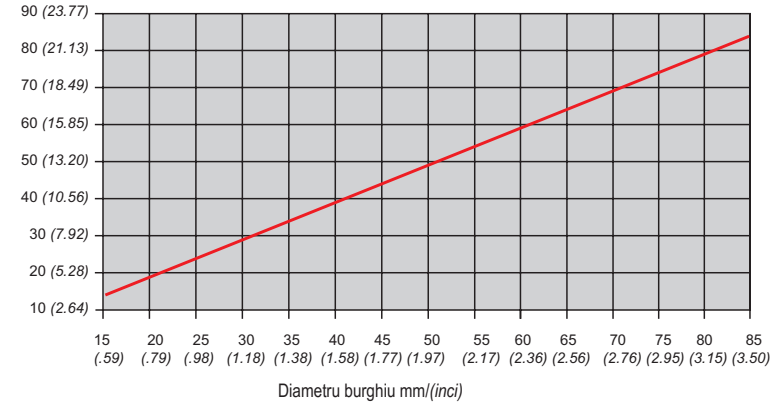
f = 0,12 mm/rot
(f = 0,005 inci/rot)

f = 0,08 mm/rot
(f = 0,003 inci/rot)

Parametri de prelucrare

Necesităţile privind volumul lichidului de răcire

Litri/minut *(galoane/minut)*

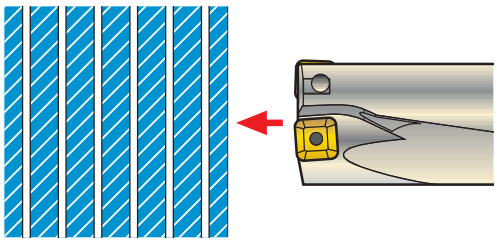


Necesităţile privind presiunea lichidului de răcire

Presiune recomandată bari *(PSI)*

	Diametru burghiu mm (*inch*)		
Adâncimea de găurire	**15-25** *(0,591-0,984)*	**> 25-40** *> 0,984-1,575*	**> 40** *> 1,575*
< 3 x D	6 *(87)*	4,5 *(65)*	3 *(44)*
≥ 3 x D	12 *(174)*	9 *(130)*	6 *(87)*

Găurirea materialelor suprapuse



Găurirea materialelor suprapuse fără goluri de aer între straturi, max. 0,2 mm *(0,008")*, poate fi executată cu burghiele SD522 2 x D, SD523 3 x D și SD542 2.5 x D și SD542 2.5 x D. Materialele trebuie să fie bine fixate și nu trebuie să apară încovoiere la străpungerea fiecărui strat.

Recomandări pentru regimul de aşchiere şi plăcuţe la găurirea materialelor suprapuse.

Geometrii plăcuţe amovibile:	**Geometrii plăcuţe**	**Calităţi de carbură:**
Plăcuţă centrală	SPGX-C1	T400D
Plăcuţa periferică	SCGX-P2	DP2501

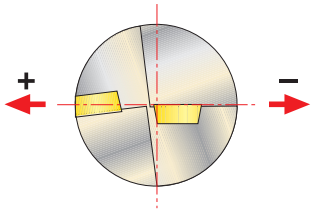
Viteza de aşchiere: Consultaţi recomandările pentru calitatea carburii DP2501
Avans/rotaţie: Consultaţi recomandările pentru geometria P2

Dacă survin probleme la străpungerea fiecărui strat, reduceţi avansul/rotaţie cu 30-50 %.

Atenţie!
Discul produs la ieşirea burghiului poate fi aruncat cu viteză mare la utilizarea burghiului ca scula staţionară, (rotirea semifabricatului).
Este foarte important să vă asiguraţi că maşina este bine protejată pentru a asigura siguranţa operatorului.

Configurare

Reglarea diametrului găurii şi recomandări de configurare Burghiele cu plăcuţe pot fi montate excentric pentru a obţine un diametru al găurii mai mic sau mai mare decât burghiul în sine.
Pentru măsurători, consultaţi „Ajustare radială" în tabelul cu parametrii de sculă din paginile catalogului.



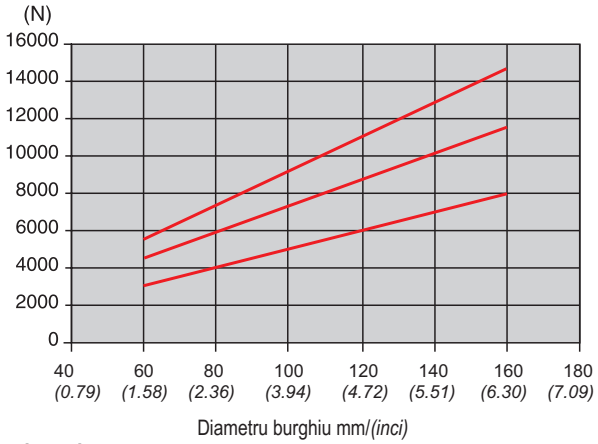
Rotativ
Port-scula reglabilă Seco este recomandată pentru setarea de precizie IT10 a diametrului găurii la utilizarea SD522 și SD523, 3 x D ca burghie rotative.

Staţionar
La montarea burghiului, asiguraţi-vă că muchiile aşchietoare sunt paralele cu ghidajele saniei transversale și că axa centrală a burghiului și a piesei de prelucrat sunt aliniate. Pentru a obţine un diametru mai mare al găurii, poziţionaţi burghiul în aşa fel încât plăcuţa periferică să se îndepărteze de axa centrală a piesei de prelucrat.

Parametri de așchiere SD602 – Consum de putere, necesităţi de volum de lichid de răcire și grafice cu forţe

Valorile din grafic pot varia, de ex. regimurile de așchiere, materialul, cu eficienţa mașinii de 80%.
Graficele de mai jos sunt valabile pentru SMG P5-P6 și viteza de așchiere de 200 m/min *(655 sf/min)*.

Forţa avansului

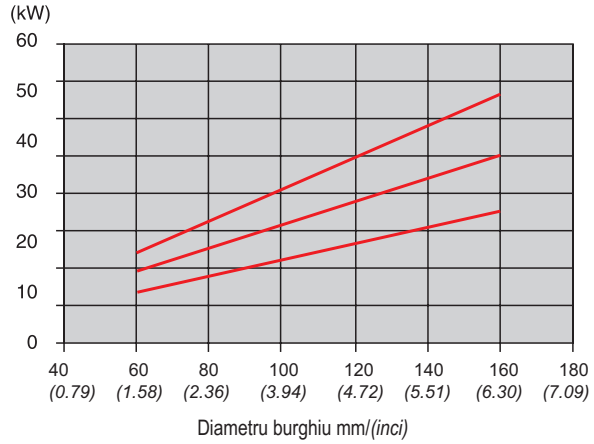


f = 0,18 mm/rot
(f = 0,007 inci/rot)

f = 0,12 mm/rot
(f = 0,005 inci/rot)

f = 0,08 mm/rot
(f = 0,003 inci/rot)

Consumul net de putere

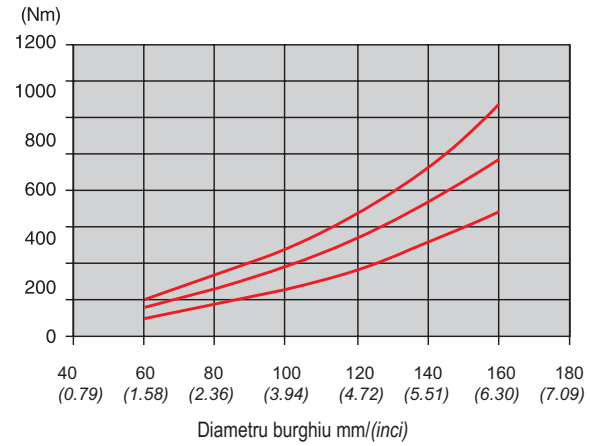


f = 0,18 mm/rot
(f = 0,007 inci/rot)

f = 0,12 mm/rot
(f = 0,005 inci/rot)

f = 0,08 mm/rot
(f = 0,003 inci/rot)

Cuplul la găurire



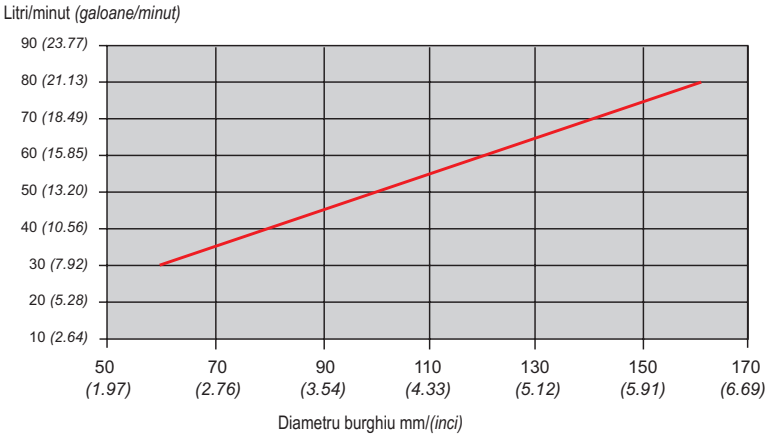
f = 0,18 mm/rot
(f = 0,007 inci/rot)

f = 0,12 mm/rot
(f = 0,005 inci/rot)

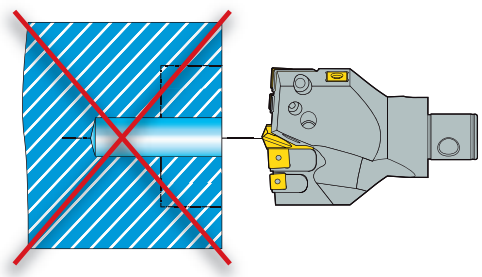
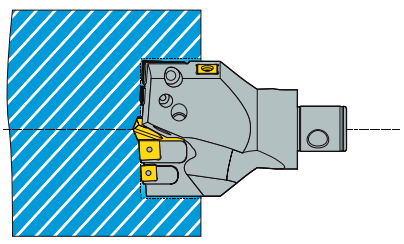
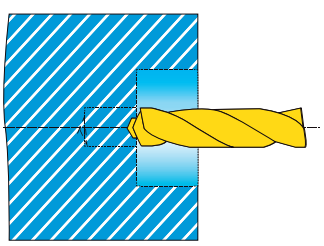
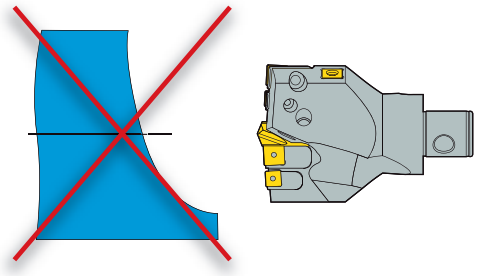
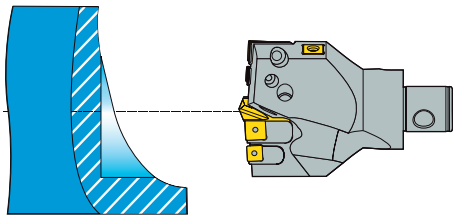
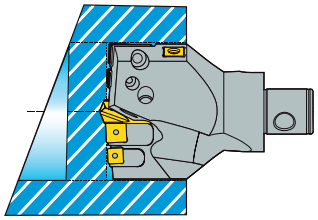
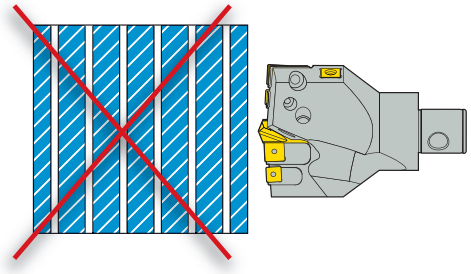
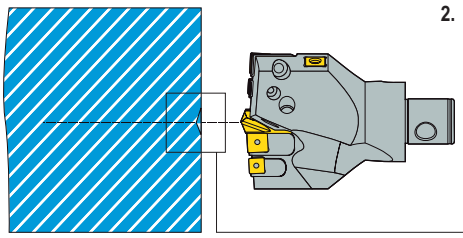
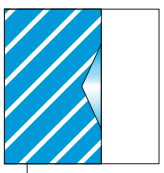
f = 0,08 mm/rot
(f = 0,003 inci/rot)

Parametri de prelucrare SD602

Necesităţile privind volumul lichidului de răcire



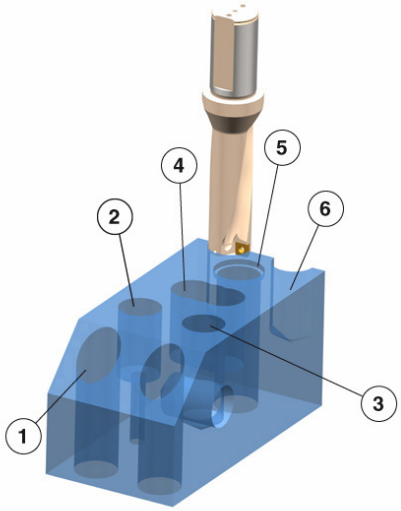
Metode

Nerecomandat	Soluţie
	1.  2. 
	1.  2. 
	1.  2.  > 5xD

Polivalenţă

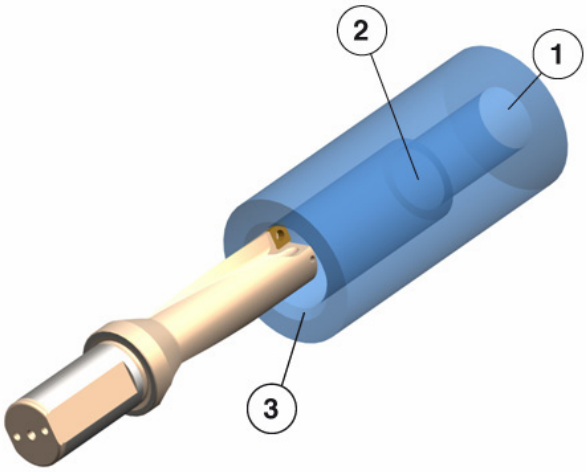
Aplicaţii

1. Găuri cu intrare în unghi
2. Alezare
3. Găurire transversal cu o gaură existentă
4. Găurire și frezare axială
5. Găurire și frezare anti-orară cu interpolare circulară
6. Axial



Mai multe opţiuni pentru operaţii statice

1. Găurire
2. Alezare adâncă / Gaură conică
3. Șanfrenare



Recomandări

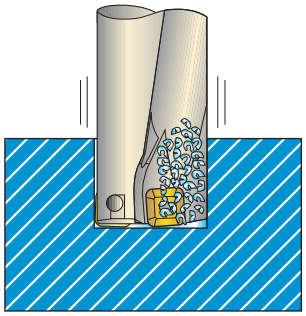
- Burghie 2 x D și 3 x D (SD522, SD523)
- Reduceţi avansul ~ 50% atunci când burghiul nu este complet antrenat
- Utilizaţi calitatea DP2501
- Utilizaţi fragmentatorul de așchii -P2

Depanare

Vibraţii

Aplicaţii

- Verifică prinderea burghiului
- Verifică fixarea piesei de prelucrat
- Mărește avansul. Dacă este un material foarte maleabil, reduceţi avansul și creșteţi viteza
- Mărește viteza de așchiere



Cuplu insuficient

- Reduceţi avansul
- Alege o geometrie cu fragmentator puternic pentru avansuri mai mici.

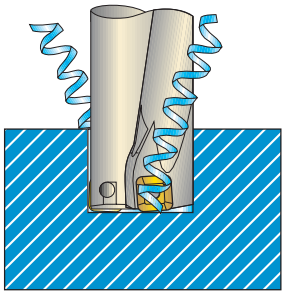
Putere insuficientă

- Reduceţi viteza de așchiere
- Reduceţi avansul
- Alegeţi o geometrie cu un fragmentator de așchii mai puternic pentru avansuri mai mici (SCGX-P1)

Probleme cu blocarea așchiilor

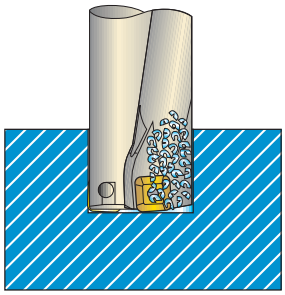
Probleme cu blocarea așchiilor din cauza așchiilor lungi

- Măriţi avansul Dacă este un material foarte moale, reduceţi avansul și creșteţi viteza
- Alegeţi o geometrie cu fragmentator de așchii mai puternic pentru avansuri mai mici (SCGX-P1)



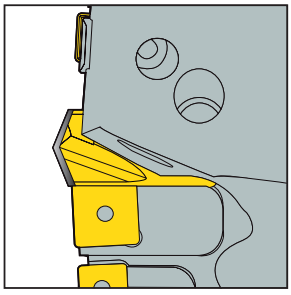
Probleme cu blocarea așchiilor în ciuda așchiilor scurte

- Măriţi presiunea/volumul lichidului de răcire
- Reduceţi viteza de așchiere



Uzura rapidă a flancului pe burghiul de centrare

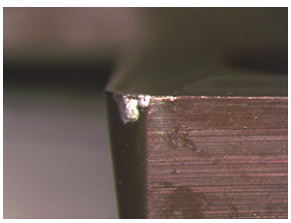
- Reduceţi viteza de așchiere
- Mărește concentraţia lichidului de răcire



Probleme cu durata de viaţă a sculei

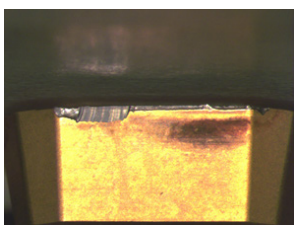
Ciobirea plăcuţei periferice

- Reduceţi avansul la intrare
- Alege o calitate mai dură
- Alege o geometrie cu un fragmentator pentru avansuri mari (SCGX-P2)
- Reduceţi avansul
- Reduceţi viteza de așchiere



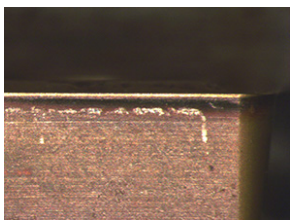
Ciobirea plăcuţei centrale

- Verifică prinderea burghiului
- Verifică fixarea piesei de prelucrat
- Reduceţi avansul la intrare
- Mărește avansul
- Reduceţi viteza de așchiere

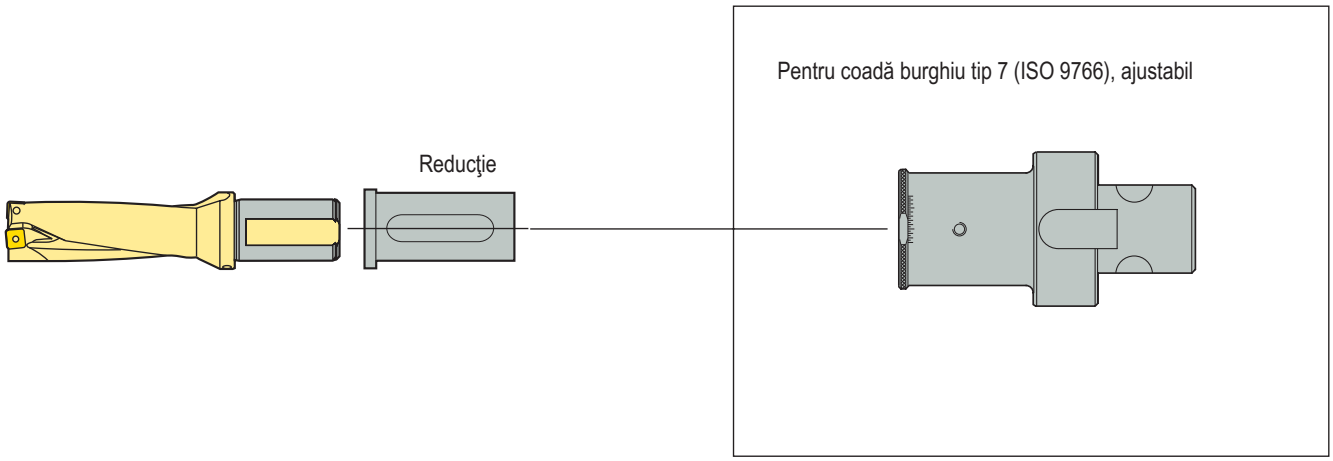


Uzură rapidă a flancului la plăcuţa periferică

- Reduceţi viteza de așchiere
- Mărește presiunea lichidului de răcire
- Alege o calitate mai rezistentă la uzură



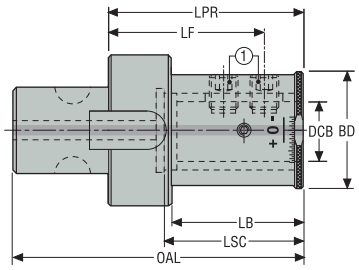
Port-scule ajustabile



ADH 6101 - Suporturi reglabile pentru burghie, pentru burghie cu coadă tip 7

Graflex®





1. Șurub de blocare

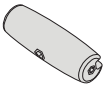
—Pentru burghie Perfomax®
—Ajustabil de la -0,3 mm la + 0,8

		Spre mașină	Spre semifabricat								
Reper Nr.	Număr reper	Dimensiune coadă Graflex	Pentru corput burghiului	DCB	OAL	LPR	BD	LF	LB	LSC	Greutate	Echilibrare
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
BM061610025	02422113	G6	R7	25,0 *0.984*	110,0 *4.331*	70,0 *2.756*	49,0 *1.929*	55,0 *2.165*	54,0 *2.126*	54,0 *2.126*	1,12 *2.470*	PB
BM061610125	02422116	G6	R7	25,4 *1.000*	110,0 *4.331*	70,0 *2.756*	49,0 *1.929*	55,0 *2.165*	54,0 *2.126*	54,5 *2.146*	1,11 *2.450*	PB
BM061610032	02422114	G6	R7	32,0 *1.260*	125,0 *4.921*	85,0 *3.346*	71,0 *2.795*	70,0 *2.756*	66,0 *2.598*	60,5 *2.382*	2,1 *4.630*	PB
BM061610138	02422118	G6	R7	38,1 *1.500*	125,0 *4.921*	85,0 *3.346*	81,0 *3.189*	70,0 *2.756*	66,0 *2.598*	60,5 *2.382*	2,45 *5.400*	PB
BM061610040	02422115	G6	R7	40,0 *1.575*	125,0 *4.921*	85,0 *3.346*	81,0 *3.189*	70,0 *2.756*	66,0 *2.598*	60,5 *2.382*	2,4 *5.290*	PB

Piese de schimb, Piese incluse la livrare

Pentru DCB	Șurub de blocare	Cep
		
25,4/1.000	950AF1210014	90M61
25/0.984	950AF1210014	90M61
32/1.260	–	90M61
38,1/1.500	–	90M61
40/1.575	–	90M61

Accesorii

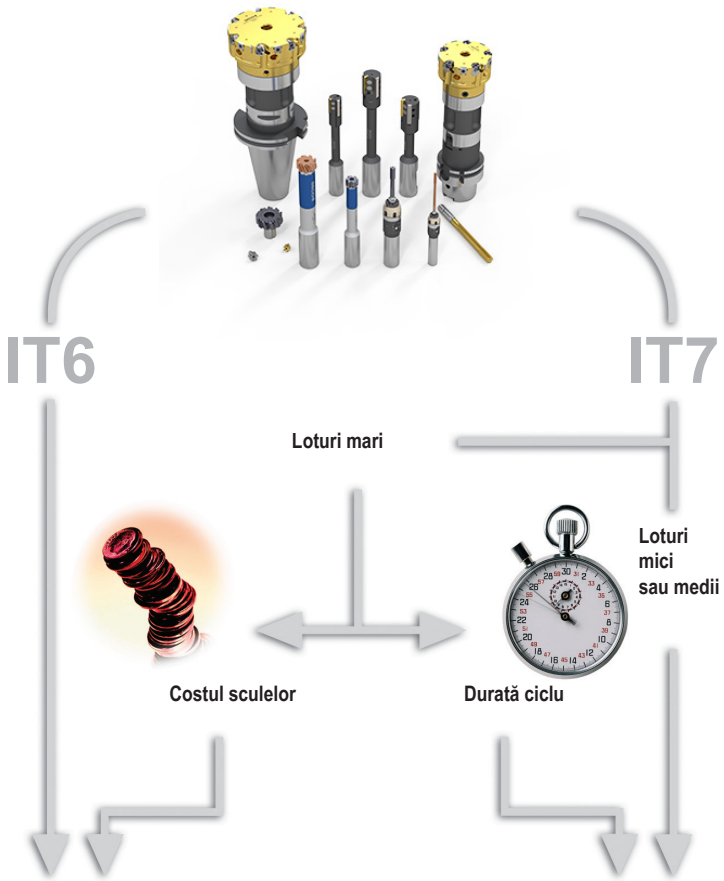
Pentru DCB	Cheie (tip T)	Cheie
		
25,4/1.000	DOUBLE-T	H6B-H6.0L
25/0.984	DOUBLE-T	H6B-H6.0L
32/1.260	DOUBLE-T	H6B-H6.0L
38,1/1.500	–	H06-4
40/1.575	DOUBLE-T	H6B-H6.0L

PB=pre-echilibrat prin design (pentru mai multe detalii, consultaţi pagina Ghidului de echilibrare din catalogul Tooling Systems)

Mai multe muchii sau plăcuţe amovibile – Alegerea celei mai bune soluţii

Calitate, performanţă și costul sculei, toate trei obiectivele pot fi atinse. Alegerea alezorului depinde de toleranţa găurii, cantitatea de producţie și durata unui ciclu. Sistemele de prelucrare a alezajelor Seco pot atinge aceste cerinţe.
Cu alezoarele Precimaster, Bifix, Xfix și Nanojet, Seco poate rezolva toate problemele legate de operaţiile de alezare.

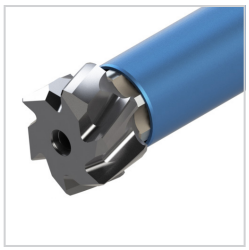
Tabelul de mai jos vă ajută să alegeţi scula de alezare ideală.



Bifix®



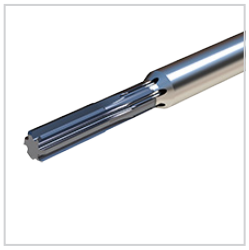
Precimaster™ Plus



Xfix™



Nanojet



Privire generală

	Pag.	∅ Gamă	Adâncime de alezare	Toleranţa ∅ găurii	Diametru intermediar	Finisarea suprafeţei
Precimaster™ Plus 	Pag. 329-366	Ø 7,75-60,500 mm *(0.3051-2.3818")*	~ 2-10 x D	IT 6-7-8	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Nanojet 	Pag. 367-392	Ø 1,461-9,960 mm *(0.057-0.392")*	~ 4-15 x D	IT 7	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Bifix® 	Pag. 393-419	Ø 5,900-60,500 mm *(0.2323-2.3819")*	~ 2-7 x D	IT 6-7	Da, disponibil prin My Design	R_a 0,2-0,8 µm *(R_a 7.87-31.5 µin)*
Xfix™ 	Pag. 420-459	Ø 39,500-154,500 mm *(1.5551-6.0827")*	~ 2,5-6,5 x D	IT 6	Da, disponibil prin My Design	R_a 0,8-1,6 µm *(R_a 31-63 µin)*



Precimaster™ Plus

Precimaster™ Plus este un sistem de alezor modular care crește viteza de alezare, stabilitatea și versatilitatea pentru realizare de găuri mai precisă și mai rentabilă.

— Sistemul dispune de conexiune inovatoare de înaltă precizie, capete de unică folosinţă din carbură solidă, precum și port-scule comune pentru aplicaţii de găuri înfundate și străpunse
— Permite toleranţe între 15 și 25 microni și finisări de suprafeţe de R_a 0,4 până la R_a 0,8 µm (RMS 15 până la 35 micro/inci)

Precimaster™ Plus – Privire generală

	∅ Gamă	Adâncime de alezare	Toleranţa ∅ găurii	Diametru intermediar	Finisarea suprafeţei
PMX5 / PMX6 / PMX8 	7,75-60 mm *(0.3051-2.3622")*	~ 2-3 x D	IT 6-7-8	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
PMX5 / PMX6 / PMX8 	7,75-60 mm *(0.3051-2.3622")*	~ 4-5 x D	IT 6-7-8	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
PMX5 / PMX6 / PMX8 	7,75-60 mm *(0.3051-2.3622")*	~ 8-10 x D	IT 6-7-8	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*

Codificări

Cozile Precimaster Plus se pot folosi atât la găuri înfundate cât și la cele străpunse.

Coada sculei

PMX08	–	08200	–	20	–	N	1
1		2		3		4	5

1. Mărimea corpului alezorului

2. Adâncimea maximă de alezare

3. Diametru coadă circulară

4. Neutru

5. Tip de coadă
1. Cilindrică
DIN1835



Cap

PMX6	–	18H7	–	EB45	–	RX2000
1		2		3		4



PMX6

1. Tip Cap

2. Diametrul găurii și toleranţa găurii

3. Geometria de intrare

4. Calităţi de carbură:

Diametru intermediar cap

PMX5	–	15.515 P7	–	EB845	–	RX2000
1		2		3		4

0.6108”/0.6115”
2

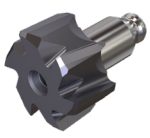
1. Tip Cap

2. Diametrul găurii și toleranţa găurii

3. Geometria de intrare

4. Calităţi de carbură:

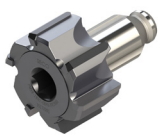
PMX4: Design cu caneluri elicoidale RH, doar pentru găuri înfundate.
PMX5: Design cu caneluri drepte, pentru găuri înfundate sau străpunse.
PMX6: Design cu caneluri elicoidale LH, doar pentru găuri străpunse.
PMX8: Caneluri drepte, expandabil, pentru găuri înfundate sau străpunse.
Designul cu caneluri pe stânga asigură împingerea aşchiilor spre înainte.
Designul cu caneluri pe dreapta îmbunătăţeşte acţiunea de evacuare a aşchiilor.
Consultaţi pagina cu opţiunile de cap Precimaster Plus 338.



PMX4



PMX5



PMX8

Codificări

Cozile Precimaster Plus se pot folosi atât la găuri înfundate cât și la cele străpunse.

PMX08 B HM	–	14500	–	20	–	N	1
1 2 3		4		5		6	7

1. Mărimea corpului alezorului

2. Ieșire lichid de răcire pentru alezaje înfundate

3. Corp din carbură

4 Adâncimea maximă de alezare

5 Diametru coadă circulară

6. Neutru

7. Tip de coadă 1. Cilindrică DIN1835



PMX08 T	–	AD	–	08200	–	20	–	N	1
1 2		3		4		5		6	7

1. Mărimea corpului alezorului

2. Ieșire lichid de răcire pentru alezaje străpunse

3. Port-scule ajustabile

4 Adâncimea maximă de alezare

5 Diametru coadă circulară

6. Neutru

7. Tip de coadă 1. Cilindrică DIN1835



PMX08 T	–	FL	–	08200	–	20	–	N	1
1 2		3		4		5		6	7

1. Mărimea corpului alezorului

2. Ieșire lichid de răcire pentru alezaje străpunse

3. Port-sculă cu auto-centrare

4 Adâncimea maximă de alezare

5 Diametru coadă circulară

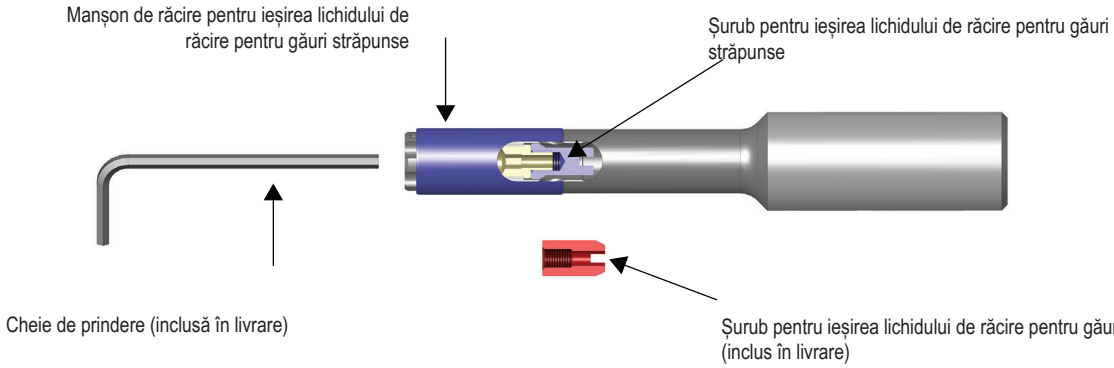
6. Neutru

7. Tip de coadă 1. Cilindrică DIN1835



Reglarea lichidului de răcire

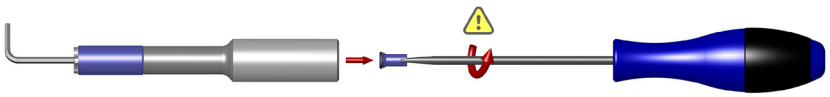
Procedura de reglare a ieșirii lichidului de răcire: Descrierea pieselor de schimb



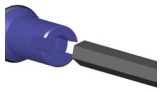
Procedura de reglare a ieșirii lichidului de răcire: Reglarea pentru găuri înfundate

1.

Scoateți șurubul pentru alezare străpunsă (albastru)
Notă: șuruburile sunt șuruburi de stânga

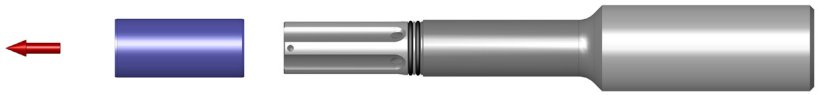


Folosiţi o șurubelniță lată SAU o cheie Allen, recomandări de mărime conform tabelului

Mărimea corpului	Mărimea șurubelniţei late mm	Mărimea șurubelniţei late *inci*	Mărimea cheii Allen mm	Mărimea cheii Allen *inci*
				
PMX05	1,2 x 4 x 120	*0,05 x 0,16 x 4,72*	2 x 120	*0,08 x 4,72*
PMX06	1,0 x 5,5 x 150	*0,04 x 0,22 x 5,9*	2,5 x 150	*0,10 x 5,9*
PMX08	1,2 x 6,5 x 200	*0,05 x 0,26 x 7,87*	3 x 200	*0,12 x 7,87*
PMX12	1,2 x 8 x 200	*0,05 x 0,31 x 6,89*	5 x 200	*0,2 x 6,89*

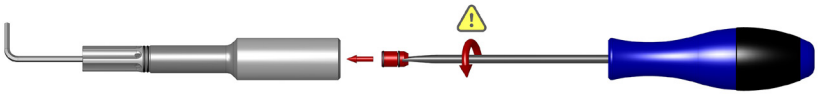
2.

Scoateţi manșonul de lichid de răcire



3.

Instalaţi șurubul pentru alezări înfundate (roșu)
Notă: șuruburile sunt șuruburi de stânga



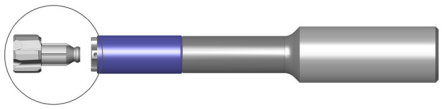
Montarea capului

1.

Asigurați-vă că geometria capului este adecvată pentru tipul de lichid de răcire


PMX5/PMX8


PMX6

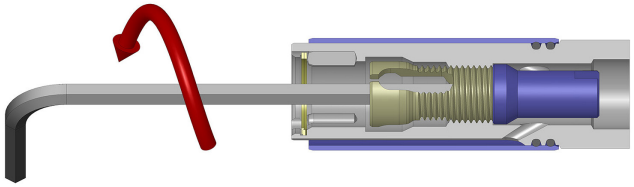

Găuri străpunse


PMX5/PMX8


Găuri înfundate

2.

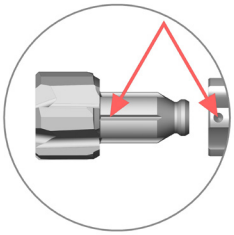
Poziționați clema înainte de montarea capului

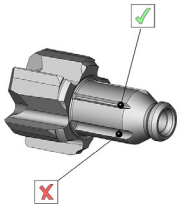


3.

Aliniați canalul de rotire cu punctul roșu de pe corp

Canal mic

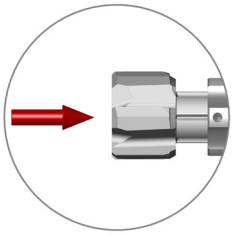




Canale mari

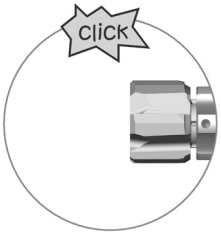
4.

Amplasați capul în corp



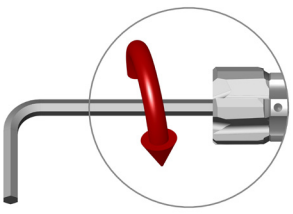
5.

Apăsați capul în corp până se aude un „clic”



6.

Strângeți capul cu ajutorul cheii Allen

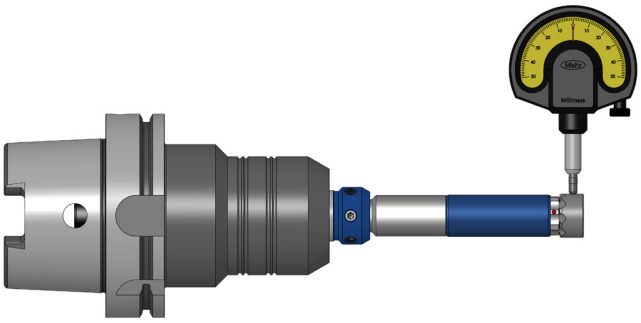


PMX Mărimea cozii	Cuplu de strângere recomandat
PMX05	0,5 Nm
PMX06	0,9 Nm
PMX08	1,2 Nm
PMX12	2,0 Nm
PMX16	5,0 Nm

Reglare – Bătaia radială

Aplicaţii dinamice

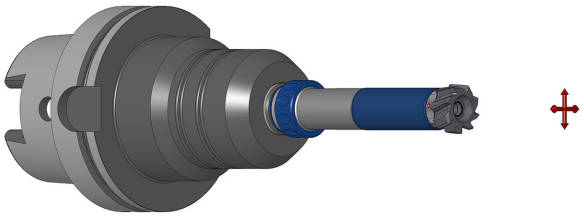
Bătaia radială maximă recomandată: 10-15 µm *(393,7008-590,5512 µin)*.
Se recomandă prinderea în mandrină hidraulică, Shrinkfit, port-sculă sau mandrină cu pensete de precizie.
Pentru un control cât mai bun al bătăii radiale, se recomandă utilizarea adaptoarelor reglabile Precimaster Plus PMX-AD, consultaţi paginile 350-351.



Aplicaţii statice

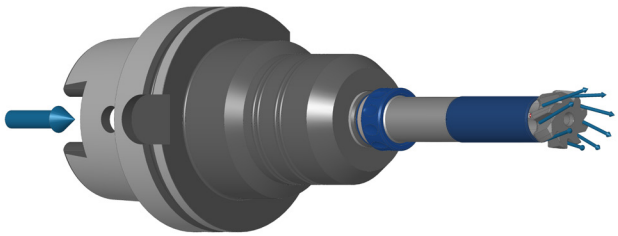
Utilizaţi port-sculele flotante Precimaster Plus PMX - FL, consultaţi paginile 352-353.

Port-sculele cu autocentrare permit autocentrarea alezorului în gaura prelucrată.



Cerinţele lichidului de răcire

Pentru a obţine o viaţă lungă a sculei şi o calitate ridicată a găurii, trebuie ţinut cont de următoarele caracteristici ale lichidului de răcire.
Se recomandă răcirea interioară.
Se poate utiliza alimentare externă cu lichid de răcire pentru adâncime de alezare < 2 x D.
Ulei solubil de calitate cu minim 40% ulei mineral.
Se recomandă ulei curat pentru oţel inoxidabil.
Concentraţia minimă 6-8 %.
Filtrare 30–50 µm *(1200-2000 µin)*.
Volum min. 0,5 l/min/mm *(3,35 gal/min/inci)* din diametrul sculei.
(Ex: Alezor ∅ 10, volum min. este 5 l/min *(1,3 gal/min)*.
Presiunea recomandată a lichidului de răcire: min. 8-10 bari, max. 30 bari.

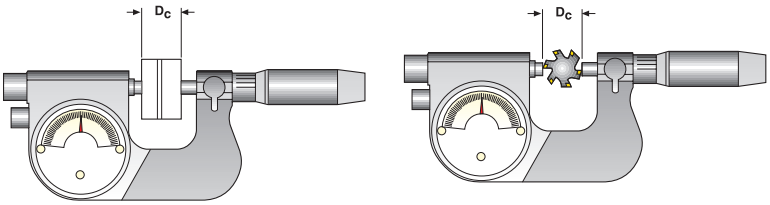


Măsurarea diametrului

Calibraţi ceasul micrometrului înainte de măsurătoare.

Important
Alezoarele Precimaster au pas diferenţial al dinţilor.
La măsurarea diametrului se utilizează 2 dinţi opuşi la 180°.

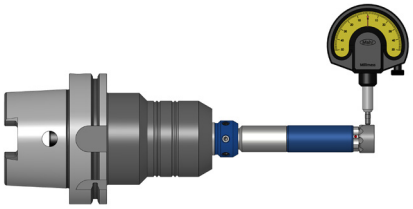
La calibrare utilizaţi un comparator micrometric şi o cală de calibrare.



Reglarea configurării cozilor:

1.
Instalaţi masterul de setare (furnizat cu port-sculă reglabilă).

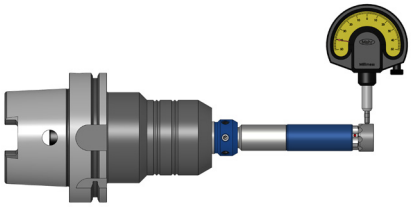
Instalaţi scula în capul de alezare.





2.
Setaţi comparatorul după cum este indicat.

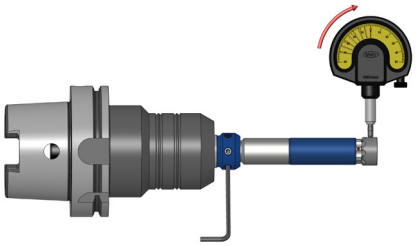
3.
Rotiţi manual scula până se atinge punctul cel mai de jos.





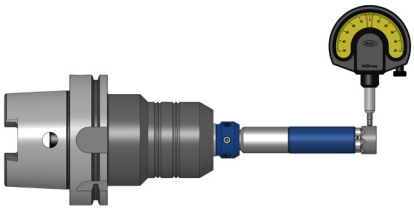
4.
Compensează bătaia radială folosind șuruburile de reglaj. Direcţia așa cum este indicată prin săgeţi.

5.
Verificaţi bătaia radială și repetaţi compensarea, dacă este necesar.





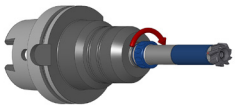
6.
Dacă bătaia radială este mai mică de 5 µm *(197µin)*, asiguraţi strângerea șuruburilor de reglare pentru a nu pierde reglarea



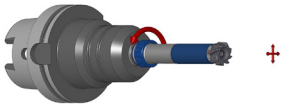


Configurare cozi flotante:

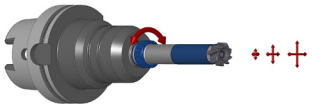
1.
Blocaţi complet coada flotantă prin rotirea în sensul acelor de ceasornic a inelului de reglare.



2.
Deschideţi coada flotantă 2 sau 3 clicuri rotind inelul de reglare în sens invers acelor de ceasornic.

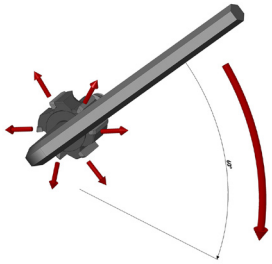


3.
Continuaţi cu reglarea suplimentară a valorii flotante, dacă este necesar. O valoarea flotantă prea mare poate crea condiţii instabile la intrarea alezajului. O valoarea prea mică duce la apariţia vibraţiilor și poate produce o gaură conică.

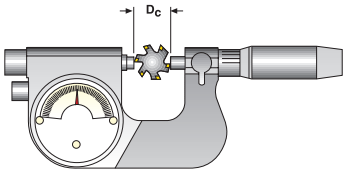


Compensare uzură alezor expandabil

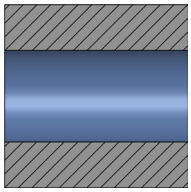
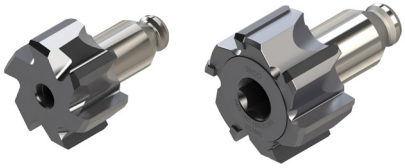
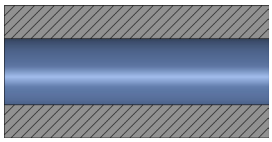
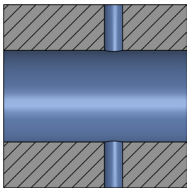
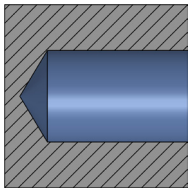
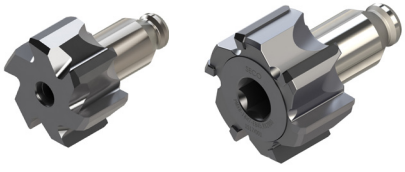
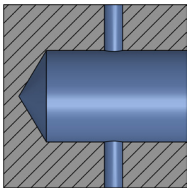
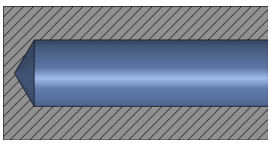
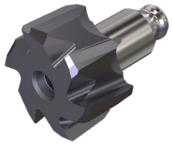
1.
Folosiţi o cheie Allen hexagonală pentru a compensa uzura Ø sculei (trepte de 60° = aproximativ 0,005 µm *(0,197µin)* compensare a Ø)



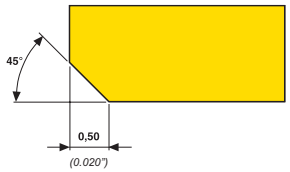
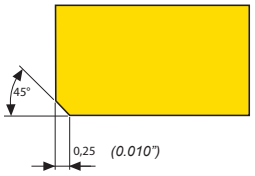
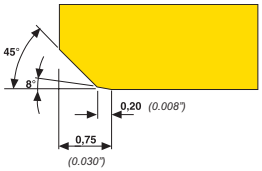
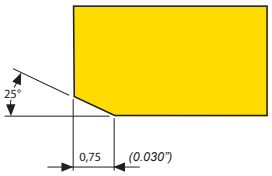
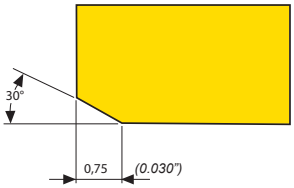
2.
Verifică dimensiunea Ø după expansiune utilizând un comparator



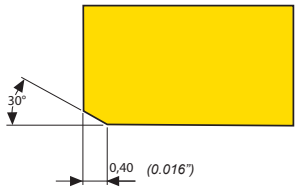
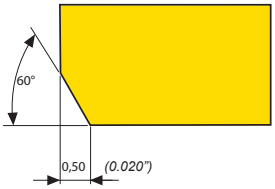
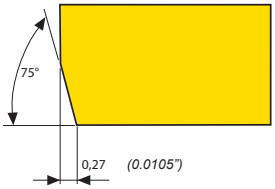
Opţiune de cap

Piesă de prelucrat	Diametru de alezat ∅ **8-60 mm** *(0,3150-2,3622")*	
Găuri străpunse scurte < 3 x D 	**PMX5 / PMX8** 	
Găuri străpunse lungi > 3 x D 	**PMX6** Pentru aplicaţii de alezaje străpunse, ieșirea lichidului de răcire al port-sculei trebuie setată pentru găuri străpunse: consultaţi paginile referitoare la configurarea agentului de răcire. 	
Găuri încrucișate 		
Găuri înfundate 	**PMX5/PMX8** Pentru aplicaţii de alezaje străpunse, ieșirea lichidului de răcire al port-sculei trebuie setată pentru găuri străpunse: consultaţi paginile referitoare la configurarea agentului de răcire 	
Găuri înfundate și încrucișate 		
Gaură înfundată > 3x D 	**PMX4** Pentru aplicaţii de alezaje străpunse, ieșirea lichidului de răcire al portsculei trebuie setată pentru găuri străpunse: consultaţi paginile referitoare la configurarea agentului de răcire. 	

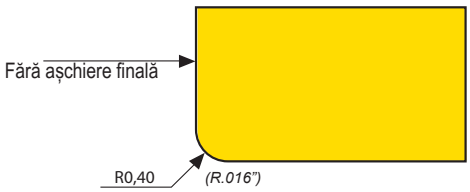
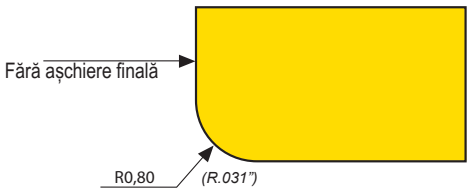
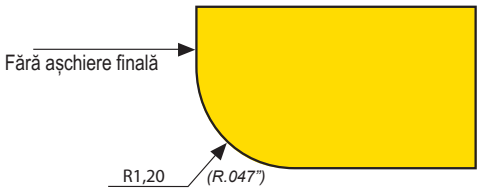
Alegerea geometriei – Aplicaţii

Geometria vârfului - EB45 Controlul asupra formării aşchiilor ++ Finisarea suprafeţei +++ R_a 0,8 - 1,2 µm *(Finisarea suprafeţei +++ R_a 31 - 47 µin)* Versatil	
Geometria vârfului - EBS45 Controlul asupra formării aşchiilor +++ Finisarea suprafeţei + R_a 0,8- 1,2 *(Finisarea suprafeţei + R_a 31- 47 µin)* Scurt EB45	
Geometria vârfului - EB845 Controlul asupra formării aşchiilor ++ Finisarea suprafeţei +++ R_a 0,2 - 0,8 µm *(Finisarea suprafeţei +++ R_a 8 - 31 µin)*	
Geometria vârfului - EB25 Performanţa avansului +++ Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm *(Finisarea suprafeţei ++ R_a 16 - 31 µin)* Controlul asupra formării aşchiilor +	
Geometria vârfului - EB30 Performanţa avansului +++ Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm *(Finisarea suprafeţei ++ R_a 16 - 31 µin)* Controlul asupra formării aşchiilor +	

Alegerea geometriei – Aplicaţii

Geometria vârfului - EBS30 Performanţa avansului +++ Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm *(Finisarea suprafeţei ++ R_a 16 - 31 µin)* Controlul asupra formării aşchiilor + Scurt EB30	
Geometria vârfului - EB60 Performanţa avansului + Finisarea suprafeţei ++ R_a 0,8 - 1,2 µm *(Finisarea suprafeţei ++ R_a 31 - 47 µin)* Controlul asupra formării aşchiilor ++	
Geometria vârfului - EB75 Performanţa avansului + Finisarea suprafeţei ++ R_a 0,8 - 1,2 µm *(Finisarea suprafeţei ++ R_a 31 - 47 µin)* Controlul asupra formării aşchiilor ++	

Alegerea geometriei – Aplicaţii

Geometria vârfului - RE040 Performanţa avansului ++ Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm *(Finisarea suprafeţei ++ R_a 16 - 31 µin)* Controlul asupra formării aşchiilor +	
Geometria vârfului - RE080 Performanţa avansului ++ Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm *(Finisarea suprafeţei ++ R_a 16 - 31 µin)* Controlul asupra formării aşchiilor +	
Geometria vârfului - RE120 Performanţa avansului ++ Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm *(Finisarea suprafeţei ++ R_a 16 - 31 µin)* Controlul asupra formării aşchiilor + Disponibil de la Ø 14 mm *(0,551")*	

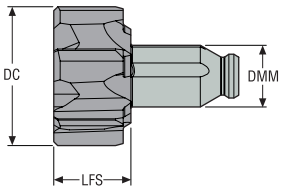
Calităţi

	**RX2000**	**Acoperire** De înaltă performanţă, potrivită pentru toate materialele.
	**CP20**	**Acoperite** O clasă de carbură acoperită, versatilă, potrivită pentru majoritatea materialelor, cu excepţia aluminiului. TiN
	**H15**	**Neacoperită** O clasă tenace de carbură pentru toate materialele. Potrivită pentru alezare fină datorită muchiei ascuţite.
	**CF**	**Cermet** O clasă rezistentă la uzură pentru optimizarea performanţei în oţel.
	**RX1500**	**Cermet acoperit** O clasă rezistentă la uzură pentru optimizarea performanţei în oţel şi fontă.
	**RN2010**	**Neacoperit** O calitate neacoperită cu geometrii optimizate pentru N-materiale (neferoase).
	**RM2020**	**Acoperită** O calitate acoperită tenace, adecvată pentru operaţiuni de alezare fină, cu geometrii optimizate pentru materiale M.
	**RM2090**	**Acoperită** O calitate acoperită rezistentă la uzură cu geometrii specifice pentru materialele M. Optimizarea materialelor M.
	**RK2050**	**Acoperită** O calitate acoperită tenace, adecvată pentru operaţiuni de alezare fină, cu geometrii optimizate pentru materiale K.
	**RK1550**	**Cermet acoperit** O calitate acoperită rezistentă la uzură cu geometrii specifice pentru materialele K. Optimizarea în materiale K.
	**RS2090**	**Acoperită** O calitate acoperită rezistentă la uzură cu geometrii specifice pentru materialele S. Optimizarea în materiale S.

Capete pentru găuri străpunse și înfundate

Ø 8–32 mm / 0.315–1.260"





—Pentru alegerea geometriei, consultați pagina (paginile) 339–341
—Regimuri de așchiere, vezi pagina(paginile) 360–366

Reper Nr.	Număr reper	DC	Mărimea burghiului*		LFS	DMM	Mărimea corpului	Geometrii			Calități				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX5-8H7-EB45	03123158	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX5-9H7-EB45	03123159	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX5-10H7-EB30	10020602	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-11H7-EB45	02925754	11,0	10,8/10,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-12H7-EB30	10019482	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-12H7-EB45	02925755	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-13H7-EB30	10019483	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-13H7-EB45	02925756	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-14H7-EB30	10019484	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-14H7-EB45	02925757	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-15H7-EB30	10019485	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-15H7-EB45	02925758	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-16H7-EB30	10019486	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-16H7-EB45	02925759	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-17H7-EB30	10019487	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-17H7-EB45	02925760	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-18H7-EB30	10019488	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-18H7-EB45	02925761	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-19H7-EB30	10019489	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-19H7-EB45	02925762	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-20H7-EB30	10020603	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-20H7-EB45	02925763	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-21H7-EB45	02925764	21,0	20,8/20,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-22H7-EB30	10020604	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-22H7-EB45	02925765	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-23H7-EB30	10019490	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-23H7-EB45	02925766	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-24H7-EB30	10019491	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-24H7-EB45	02925767	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-25H7-EB30	10019492	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-25H7-EB45	02925768	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-26H7-EB30	10019493	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-26H7-EB45	02925769	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-27H7-EB45	02925770	27,0	26,8/26,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-28H7-EB30	10019494	28,0	26,8/26,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-28H7-EB45	02925771	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-29H7-EB45	02925772	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-30H7-EB30	10019495	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-30H7-EB45	02925773	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

Reper Nr.	Număr reper	DC	Mărimea burghiului*		LFS	DMM	Mărimea corpului	Geometrii			Calităţi				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX5-32H7-EB30	10019496	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-32H7-EB45	02925775	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

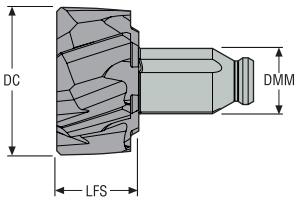
*Pentru informaţii suplimentare despre ce burghiusă utilizaţi și cum să îl utilizaţi, consultaţi pagina . 11
■ **Stoc standard.**□ **Standard fără stoc.**

<STEPTABLE O="A4 test PMX5 annan tabell" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

Capete pentru găuri străpunse

Ø 8-32 mm / 0.315-1.260"





—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de aşchiere, vezi pagina(paginile) 360-366

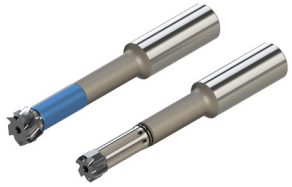
Reper Nr.	Număr reper	DC	Mărimea burghiului*		LFS	DMM	Mărimea corpului	Geometrii			Calităţi				
		mm	mm		mm	mm		EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX6-8H7-EB45	03123161	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX6-9H7-EB45	03123162	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	–	–
PMX6-10H7-EB45	02965863	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-11H7-EB45	02925776	11,0	10,8/10,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-12H7-EB45	02925777	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-13H7-EB45	02925778	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-14H7-EB45	02925779	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-15H7-EB45	02925780	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-16H7-EB45	02925781	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-17H7-EB45	02925782	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-18H7-EB45	02925783	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-19H7-EB45	02925784	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-20H7-EB45	02925785	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-21H7-EB45	02925786	21,0	20,8/20,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-22H7-EB45	02925030	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-23H7-EB45	02925031	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-24H7-EB45	02925032	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-25H7-EB45	02925033	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-26H7-EB45	02925034	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-27H7-EB45	02925035	27,0	26,8/26,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-28H7-EB45	02925036	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-29H7-EB45	02925037	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-30H7-EB45	02925038	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-31H7-EB45	02925039	31,0	30,8/30,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-32H7-EB45	02925040	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

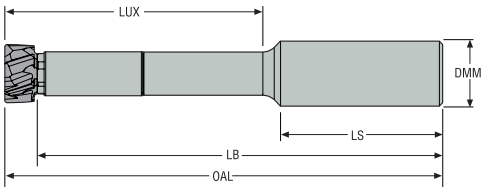
*Pentru informaţii suplimentare despre ce burghiusă utilizaţi și cum să îl utilizaţi, consultaţi pagina . 11
■ Stoc standard.□ Standard fără stoc.

<STEPTABLE O="New A4_Precimaster_PMX6" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

Cozi identice pentru găuri străpunse și înfundate

Ø 7,75-60,500 mm / 0.305-2.381"

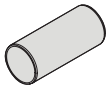
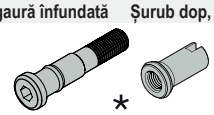




—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

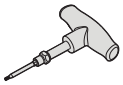
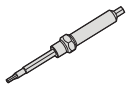
Reper Nr.	Număr reper	Materialul portsculei	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05-02800-10N1	03123012	Oţel	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05-04100-10N1	02929923	Oţel	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05-10000-10N1	03123013	Oţel	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06-03700-12N1	02925828	Oţel	9,901 - 14,499	84,0	77,0	45,0	37,0	12,0
PMX06-05700-12N1	02925829	Oţel	9,901 - 14,499	104,0	97,0	45,0	57,0	12,0
PMX06-12000-12N1	02925830	Oţel	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX06HM-12000-12N1	02925831	Carbură	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX08-04600-20N1	02925832	Oţel	14,5 - 21,499	99,0	89,0	50,0	46,0	20,0
PMX08-08200-20N1	02925833	Oţel	14,5 - 21,499	135,0	125,0	50,0	82,0	20,0
PMX08-14500-20N1	02925834	Oţel	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX08HM-14500-20N1	02925835	Carbură	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX12-06800-25N1	02925836	Oţel	21,5 - 32,499	127,0	115,0	56,0	68,0	25,0
PMX12-10400-25N1	02925837	Oţel	21,5 - 32,499	163,0	151,0	56,0	104,0	25,0
PMX12-17000-25N1	02925838	Oţel	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX12HM-17000-25N1	02925839	Carbură	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX16-06300-32N1	02925840	Oţel	32,5 - 60,5	124,0	110,0	60,0	63,0	32,0
PMX16-12700-32N1	02925841	Oţel	32,5 - 60,5	188,0	174,0	60,0	127,0	32,0
PMX16-17000-32N1	02925842	Oţel	32,5 - 60,5	231,0	217,0	60,0	170,0	32,0
PMX16HM-17000-32N1	02925843	Carbură	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

Piese de schimb, Piese incluse la livrare

Pentru coadă	Pentru ∅ (mm)	Cheie clemă	Set clemă	Set răcire	Șurub dop, gaură înfundată	Șurub dop, gaură străpunsă
						
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

* Piese de schimb numai pentru corpuri PMX16. Pentru PMX16, șuruburile dop sunt utilizate și pentru fixare.

Accesorii

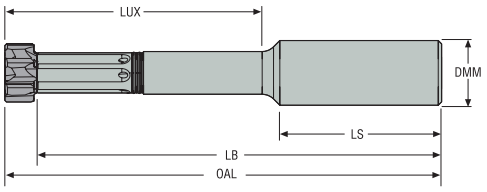
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Valoare cuplu
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

Pentru ∅ (mm)	Mărimea cozii	Număr reper	Extractor universal	Număr reper	Inel de extracţie	Număr reper	Corp extractor	Număr reper	Kit extracţie
									
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Cozi pentru găuri înfundate

Ø 7,75-60,500 mm / 0.305-2.381"

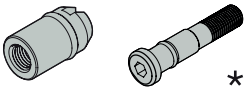




—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

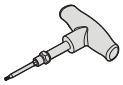
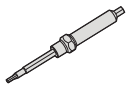
Reper Nr.	Număr reper	Materialul portsculei	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05B-02800-10N1	03144322	Oţel	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05B-04100-10N1	03144323	Oţel	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05B-10000-10N1	03144324	Oţel	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06B-03700-12N1	03075433	Oţel	9,901 - 14,499	84,0	77,0	45,0	37,0	12,0
PMX06B-05700-12N1	03075434	Oţel	9,901 - 14,499	104,0	97,0	45,0	57,0	12,0
PMX06B-12000-12N1	03075435	Oţel	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX06BHM-12000-12N1	03075436	Carbură	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX08B-04600-20N1	03075437	Oţel	14,5 - 21,499	99,0	89,0	50,0	46,0	20,0
PMX08B-08200-20N1	03075438	Oţel	14,5 - 21,499	135,0	125,0	50,0	82,0	20,0
PMX08B-14500-20N1	03075439	Oţel	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX08BHM-14500-20N1	03075440	Carbură	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX12B-06800-25N1	03075441	Oţel	21,5 - 32,499	127,0	115,0	56,0	68,0	25,0
PMX12B-10400-25N1	03075442	Oţel	21,5 - 32,499	163,0	151,0	56,0	104,0	25,0
PMX12B-17000-25N1	03075443	Oţel	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX12BHM-17000-25N1	03075444	Carbură	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX16B-06300-32N1	03075445	Oţel	32,5 - 60,5	124,0	110,0	61,0	63,0	32,0
PMX16B-12700-32N1	03075446	Oţel	32,5 - 60,5	188,0	174,0	61,0	127,0	32,0
PMX16B-17000-32N1	03075447	Oţel	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0
PMX16BHM-17000-32N1	03075448	Carbură	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

Piese de schimb, Piese incluse la livrare

Pentru coadă	Pentru ∅ (mm)	Cheie clemă	Set clemă	Șurub dop, gaură înfundată
			 *	 *
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

* Piese de schimb numai pentru corpuri PMX16. Pentru PMX16, șuruburile dop sunt utilizate și pentru fixare.

Accesorii

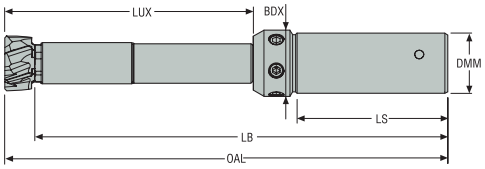
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Valoare cuplu
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

Pentru ∅ (mm)	Mărimea cozii	Număr reper	Extractor universal	Număr reper	Inel de extracţie	Număr reper	Corp extractor	Număr reper	Kit extracţie
									
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Cozi reglabile pentru găuri străpunse

Ø 7,75–60,500 mm / 0.305–2.381”

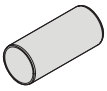




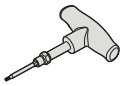
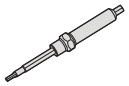
—Pentru alegerea geometriei, consultaţi pagina (paginile) 339–341
—Regimuri de aşchiere, vezi pagina(paginile) 360–366

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru coadă	Pentru ∅ (mm)	Cheie clemă	Inel răcire	Cheie de reglare	Calibru de reglare	Șurub de reglare
						
PMX05T	7,750-9,900	1.5SMS795	RT05-KI	2SMS795	PMX05-MSTR	HCM4X4X0.5/ISO4026
PMX06T	9,901-14,499	–	RT06-KI	2SMS795	PMX06-MSTR	HCM4X4X0.5/ISO4026
PMX08T	14,50-21,499	–	RT08-KI	2.5SMS795	PMX08-MSTR	HCM5X5X0.5/ISO4026
PMX12T	21,50-32,499	4SMS795	RT12-KI	3SMS795	PMX12-MSTR	HCM6X6X0.75/ISO4026
PMX16T	32,50-60,000	5SMS795	–	3SMS795	–	HCM6X6X0.75/ISO4026

Accesorii

Pentru ∅ (mm)	Mărimea cozii	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Valoare cuplu
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

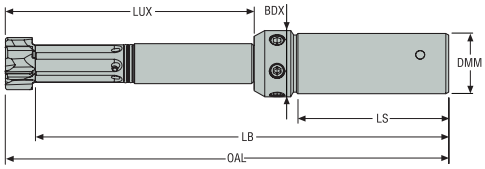
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Extractor universal	Număr reper	Inel de extracţie	Număr reper	Corp extractor	Număr reper	Kit extracţie
									
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Notă: Setul de cleme de reparaţie PMxx-CLKI nu este potrivit pentru tipul PMX FL & AD

Cozi reglabile pentru găuri înfundate

Ø 7,75-60,500 mm / 0.305-2.381”





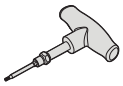
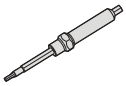
—Pentru alegerea geometriei, consultați pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru coadă	Pentru ∅ (mm)	Cheie clemă	Cheie de reglare	Calibru de reglare	Șurub de reglare
					
PMX05B	7,750-9,900	1.5SMS795	2SMS795	PMX05-MSTR	HCM4X4X0.5/ISO4026
PMX06B	9,901-14,499	2SMS795	–	PMX06-MSTR	HCM4X4X0.5/ISO4026
PMX08B	14,50-21,499	–	2.5SMS795	PMX08-MSTR	HCM5X5X0.5/ISO4026
PMX12B	21,50-32,499	4SMS795	3SMS795	PMX12-MSTR	HCM6X6X0.75/ISO4026
PMX16B	32,50-60,000	5SMS795	3SMS795	–	HCM6X6X0.75/ISO4026

Accesorii

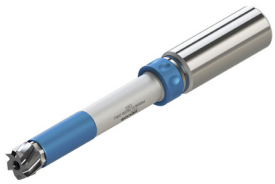
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Valoare cuplu
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

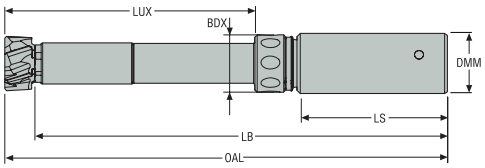
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Extractor universal	Număr reper	Inel de extracție	Număr reper	Corp extractor	Număr reper	Kit extracție
									
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Notă: Setul de cleme de reparație PMxx-CLKI nu este potrivit pentru tipul PMX FL & AD

Cozi flotante pentru găuri străpunse

Ø 7,75-60,500 mm / 0.305-2.381"

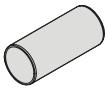




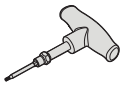
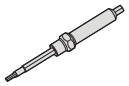
—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de aşchiere, vezi pagina(paginile) 360-366

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru coadă	Pentru ∅ (mm)	Cheie clemă	Inel răcire	Cheie de reglare
				
PMX05T	7,750-9,900	1.5SMS795	RT05-KI	–
PMX06T	9,901-14,499	–	RT06-KI	2SMS795
PMX08T	14,50-21,499	–	RT08-KI	2.5SMS795
PMX12T	21,50-32,499	4SMS795	RT12-KI	–
PMX16T	32,50-60,000	5SMS795	–	–

Accesorii

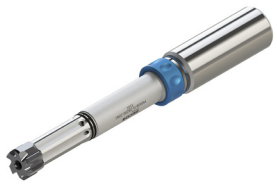
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Valoare cuplu
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

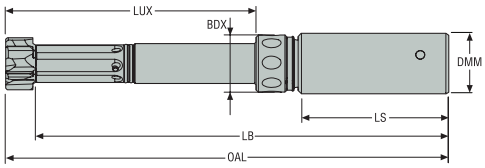
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Extractor universal	Număr reper	Inel de extracţie	Număr reper	Corp extractor	Număr reper	Kit extracţie
									
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Notă: Setul de cleme de reparaţie PMxx-CLKI nu este potrivit pentru tipul PMX FL & AD

Cozi flotante pentru găuri înfundate

Ø 7,75-60,500 mm / 0.305-2.381”





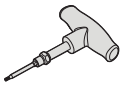
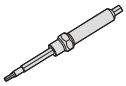
—Pentru alegerea geometriei, consultați pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

Reper Nr.	Număr reper	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

Piese de schimb, Piese incluse la livrare

Pentru coadă	Pentru ∅ (mm)	Cheie clemă
		
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

Accesorii

Pentru ∅ (mm)	Mărimea cozii	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Număr reper	Cheie dinamometrică*	Număr reper	Lamă interschimbabilă	Valoare cuplu
										
7,750-9,900	PMX05	03178196	H00-1505-27	03178237	H00-1.5-27	–	–	–	–	0,5 Nm
9,901-14,499	PMX06	03178197	H00-2009-33	03178238	H00-2.0-33	–	–	–	–	0,9 Nm
14,500-21,499	PMX08	03178199	H00-2512-40	03178240	H00-2.5-40	–	–	–	–	1,2 Nm
21,500-32,499	PMX12	03178201	H00-4020-60	03178242	H00-4.0-60	–	–	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	–	–	03271887	H00T-5050	02506761	H00T-5.0	5,0 Nm

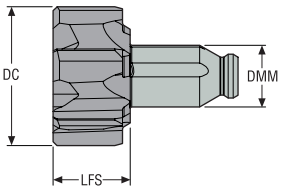
Pentru ∅ (mm)	Mărimea cozii	Număr reper	Extractor universal	Număr reper	Inel de extracție	Număr reper	Corp extractor	Număr reper	Kit extracție
									
7,750-9,900	PMX05	10185807	PMX-EXTR05	10185811	PMX-EXTR-RING05	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
9,901-14,499	PMX06	10185808	PMX-EXTR06	10185812	PMX-EXTR-RING06	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
14,500-21,499	PMX08	10185809	PMX-EXTR08	10185813	PMX-EXTR-RING08	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
21,500-32,499	PMX12	10185810	PMX-EXTR12	10185814	PMX-EXTR-RING012	10185815	PMX-EXTR-BDY	10185816	PMX-EXTR-KIT
32,500-60,500	PMX16	–	–	–	–	–	–	–	–

Notă: Setul de cleme de reparație PMxx-CLKI nu este potrivit pentru tipul PMX FL & AD

Capete pentru găuri străpunse și înfundate, Design personalizat

Ø 7,75-60,500 mm / 0.305-2.381"





—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

Reper Nr.	DCN	DCX	LFS	DMM		Mărimea corpului	Geometrii	Calităţi										
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX5-7.75-XX-XXXX	7,75 *0.305*	9,9 *0.390*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB845 EB30	□	□	□	□	□	–	–	□	□	□	□
PMX5-10.0-XX-XXXX	9,901 *0.390*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX5-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX5-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-XX	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX5-32.5-XX-XXXX	32,5 *1.280*	60,5 *2.382*	14,0 *0.551*	16,0 *0.630*	10	PMX16-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□

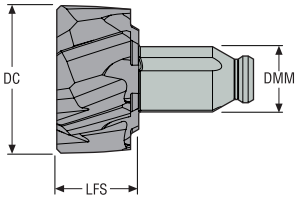
□ **= Standard fără stoc.**
Notă: Când comandaţi alezoarele Nanofix pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: PMX5-16.515 P7-EB45 RM2020.

<STEPTABLE O="A4_Precimaster_custom_1" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

Capete pentru găuri străpunse, Design personalizat

Ø 7,75-60,500 mm / 0.305-2.381”





—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

Reper Nr.	DCN	DCX	LFS	DMM		Mărimea corpului	Geometrii	Calităţi										
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX6-7.75-XX-XXXX	7,75 *0.305*	9,9 *0.390*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB845 EB30	□	□	□	□	□	–	–	□	□	□	□
PMX6-10.0-XX-XXXX	9,901 *0.390*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX6-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX6-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-XX	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX6-32.5-XX-XXXX	32,5 *1.280*	60,5 *2.382*	14,0 *0.551*	16,0 *0.630*	10	PMX16-xx	EB45 EB845 EB30	□	□	□	□	□	□	□	□	□	□	□

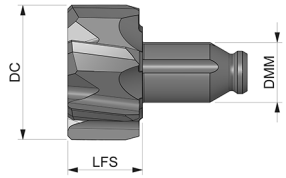
□ **= Standard fără stoc.**
Notă: Când comandaţi alezoarele Nanofix pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: PMX6-16.515 P7-EB45 RM2020.

<STEPTABLE O=”A4_ Precimaster custom PMX6” OT=”Product” TT=”stibo.91791239” VC=”ROro” VO=”6710820” W=”Main” />

Cozi pentru găuri înfundate, Design personalizat

Ø 7,75-60,500 mm / 0.305-2.381"





—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de așchiere, vezi pagina(paginile) 360-366

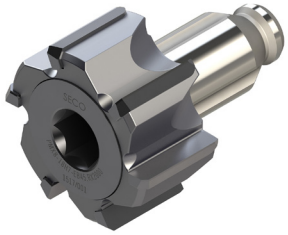
Reper Nr.	DCN	DCX	LFS	DMM		Mărimea corpului	Geometrii	Calităţi										
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX4-7.75-XX-XXXX	7,75 *0.305*	9,9 *0.390*	6,0 *0.236*	4,5 *0.177*	6	PMX05-xx	EB45 EB84 EB30	□	□	□	□	□	–	–	□	□	□	□
PMX4-10.0-XX-XXXX	9,901 *0.390*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX4-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX4-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□
PMX4-32.5-XX-XXXX	32,5 *1.280*	60,5 *2.382*	14,0 *0.551*	16,0 *0.630*	10	PMX16-xx	EB45 EB84 EB30	□	□	□	□	□	□	□	□	□	□	□

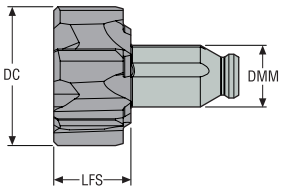
□ **= Standard fără stoc.**
Notă: Când comandaţi alezoarele Nanofix pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: PMX4-16.515 P7-EB45 RM2020.

<STEPTABLE O="A4 PMX4 right hand helical" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

Capete expandabile pentru găuri străpunse și înfundate

Ø 10,00-32,500 mm / 0.393-1.279"





—Pentru alegerea geometriei, consultaţi pagina (paginile) 339-341
—Regimuri de aşchiere, vezi pagina(paginile) 360-366

Reper Nr.	DCN	DCX	LFS	DMM		Mărimea corpului	Geometrii	Calităţi										
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX8-10.0-XX-XXXX	10,0 *0.394*	14,499 *0.571*	7,0 *0.276*	6,0 *0.236*	6	PMX06-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
PMX8-14.5-XX-XXXX	14,5 *0.571*	21,499 *0.846*	10,0 *0.394*	8,0 *0.315*	6	PMX08-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐
PMX8-21.5-XX-XXXX	21,5 *0.846*	32,499 *1.279*	12,0 *0.472*	12,0 *0.472*	8	PMX12-xx	EB45 EB845 EB30	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐	☐

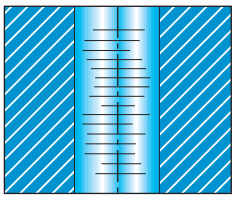
☐ **= Standard fără stoc.**
Notă: Când comandaţi alezoarele Nanofix pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: PMX8-16.515 P7-EB45 RM2020.

<STEPTABLE O="A4_Precimaster_custom_3" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

Depanare

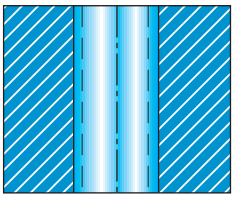
Finisare slabă a suprafeţei

– Verifică adaosul de material
– Îmbunătățește condiţiile de răcire (tipul difuzorului, presiunea, calitatea)
– Reduceţi avansul



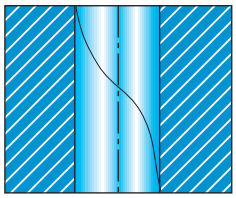
Diametru prea mare

– Îmbunătăţiţi centrarea (piesă/sculă)



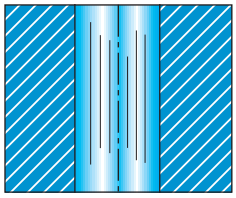
Urme de retragere

– Îmbunătăţiţi condiţiile de răcire (tipul ieșirii, presiunea, calitatea)
– Îmbunătăţiţi centrarea (piesă/sculă)
– Reduceţi viteza la retragere



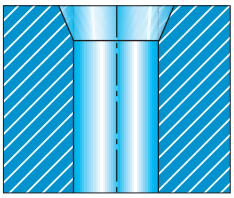
Faţete

– Îmbunătăţiţi centrarea (piesă/sculă)
– Verificaţi toleranţa materialului



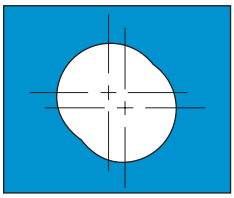
Intrare conică

– Micșorează avansul
– Îmbunătățește centrarea (piesă/sculă)
– Micșorează bătaia radială



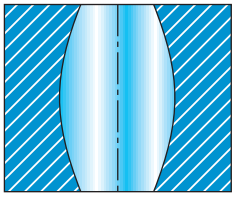
Excentricitate/Ovalitate

– Îmbunătăţiţi prinderea (deformarea piesei de prelucrat)
– Verificaţi toleranţa materialului
– Îmbunătăţiţi centrarea (piesă/sculă)



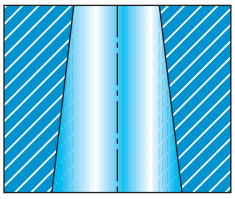
Gaură deformată

– Îmbunătăţiţi prinderea (deformarea piesei de lucru)



Gaură conică

– Îmbunătăţiţi centrarea (piesă/sculă)



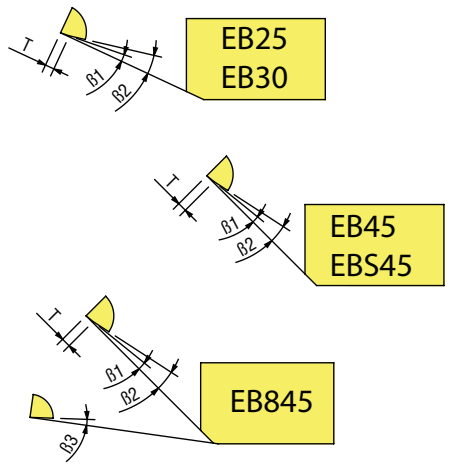
Instrucţiuni pentru reascuţire

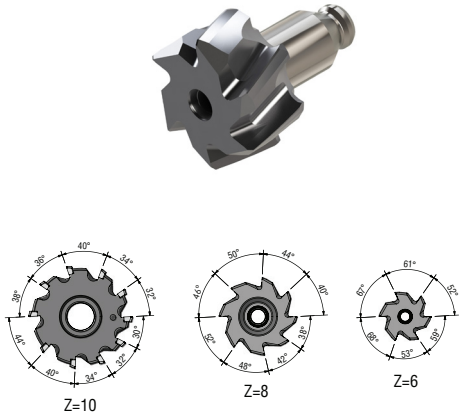
Specificaţii

Roată diamantată pentru ascuţire
Granulaţia:
D6 – Pentru primul unghi de degajare (β1 - β3)
D64 – Pentru al doilea unghi de degajare (β2)

Important:

Reascuţirea reduce diametrul alezorului
Reacoperirea poate duce la mărirea diametrului
Bătaia radială max. pe şanfrenări de intrare 10 µm *(394 µin)*





Ø Precimaster Plus mm *(inci)*	β_1	β_2	β_3	T mm *(inci)*
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)*

Parametri de așchiere – PM Plus... -EB45 metric

SMG		a_p (Ø)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
P1	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–	–
P2	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–	–
P3	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–	–
P4	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P5	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P6	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P7	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–	–
P8	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–	–
P11	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–	–
P12	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	12 (8-15)	25 (15-45)	30 (15-65)	–	65 (45-95)	95 (65-145)	–	–	–	–	–
M1	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	12 (9-15)	25 (15-45)	35 (20-70)	–	–	–	–	–	25 (15-40)	40 (25-80)	–
M2	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	–	25 (15-40)	40 (25-80)	–
M3	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	–	25 (15-40)	40 (25-80)	–
M4	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	–	20 (10-30)	30 (20-60)	–
M5	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	–	20 (10-30)	30 (20-60)	–
K1	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
K2	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	25 (20-40)	40 (30-70)	45 (35-80)	–	80 (50-100)	90 (55-110)	–	–	–	–
K3	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
K4	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–	–
K5	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–	–
K6	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
K7	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–	–
N1	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
N2	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
N3	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
N11	PMXxx ..6 ..8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	–	80 (30-150)	–	–	–	–	50 (30-100)	–	–	–
S1	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	-	–	–	25 (12-30)
S2	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	-	–	–	25 (12-30)
S3	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	-	–	–	25 (12-30)
S11	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	–	50 (25-65)
S12	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	–	50 (25-65)
S13	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	–	50 (25-65)

Tabelul continuă pe pagina următoare.

Parametri de așchiere – PM Plus... -EB45 metric

SMG		a_p (Ø)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
H3	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H5	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H7	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H8	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H11	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H12	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H21	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
H31	PMXxx ..6 ..8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB45	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–	–
PM2	PMXxx ..6 ..8 -EB45	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–	–
PM3	PMXxx ..6 ..8 -EB45	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–	–
TS1	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	–
TS2	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	–
TS3	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	–
TS4	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	25 (12-30)
TP1	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	25 (12-30)
TP2	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	25 (12-30)
TP3	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	50 (25-65)
TP4	PMXxx ..6 ..8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	–	40 (20-60)	–	–	–	–	–	–	–	50 (25-65)
GR1	PMXxx ..6 ..8 -EB45	0,10 -0,30	0,10 -0,40	0,30 -0,90	0,40 -1,20	0,50 -1,50	40 (80-20)	–	60 (30-120)	–	–	–	–	–	–	–	50 (25-65)

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – PM Plus...-EB45 *inch*

SMG		a_p (Ø)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
P1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–	–
P2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–	–
P3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–	–
P4	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P5	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P6	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P7	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–	–
P8	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–	–
P11	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–	–
P12	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.008	.008 -.028	.012 -.039	.016 -.047	40 (25-50)	80 (50-130)	100 (50-215)	–	215 (150-315)	315 (215-480)	–	–	–	–	–
M1	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	40 (30-50)	80 (50-130)	115 (65-230)	–	–	–	–	–	80 (50-130)	130 (80-260)	–
M2	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	–	80 (50-130)	130 (80-260)	–
M3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	–	80 (50-130)	130 (80-260)	–
M4	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	–	65 (35-100)	100 (65-195)	–
M5	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	–	65 (35-100)	100 (65-195)	–
K1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
K2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	80 (65-130)	130 (100-230)	145 (110-260)	–	260 (165-330)	290 (185-370)	–	–	–	–
K3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
K4	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–	–
K5	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–	–
K6	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
K7	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–	–
N1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
N11	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	–	260 (100-490)	–	–	–	–	165 (100-330)	–	–	–
S1	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S2	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	–	80 (40-100)
S11	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	–	165 (80-215)
S12	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	–	165 (80-215)
S13	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	–	165 (80-215)

Tabelul continuă pe pagina următoare.

Parametri de așchiere – PM Plus...-EB45 *inch*

SMG		a_p (Ø)		f			v_c										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
H5	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H7	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H8	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H11	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H12	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H21	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
H31	*PMXxx ..6 ..8 -EB45*	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–	–
PM1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .012	.012- .035	.016- .047	.020- .059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–	–
PM2	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .012	.012- .035	.016- .047	.020- .059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–	–
PM3	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .012	.012- .035	.016- .047	.020- .059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–	–
TS1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TS2	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TS3	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TS4	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP2	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP3	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
TP4	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .008	.012- .035	.016- .047	.020- .059	65 (50-80)	–	130 (65-195)	–	–	–	–	–	–	–	–
GR1	*PMXxx ..6 ..8 -EB45*	.004- .008	.004- .016	.012- .035	.016- .047	.020- .059	130 (260-65)	–	195 (100-395)	–	–	–	–	–	–	–	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c = sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – PM Plus...-EB845 metric

SMG		a_p (Ø)		f			v_c									
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RM2020	RM2090	RS2090
P3	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–	–	–	–
P4	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P5	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P6	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P7	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–	–	–	–
P8	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–
P11	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	–	80 (60-120)	120 (80-180)	–	–	–	–
P12	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	12 (8-15)	25 (15-45)	30 (15-65)	–	65 (45-95)	95 (65-145)	–	–	–	–
M1	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	12 (9-15)	25 (15-45)	35 (20-70)	–	–	–	–	25 (15-40)	35 (20-70)	–
M2	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	25 (15-40)	35 (20-70)	–
M3	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	25 (15-45)	35 (20-70)	–	–	–	–	25 (15-40)	35 (20-70)	–
M4	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	20 (10-30)	25 (15-50)	–
M5	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-30)	25 (15-50)	–	–	–	–	20 (10-30)	25 (15-50)	–
K1	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
K2	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	25 (20-40)	40 (30-70)	45 (35-80)	–	80 (50-100)	90 (55-110)	–	–	–
K3	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
K4	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–
K5	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	–	–	–
K6	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
K7	PMXxx ..6 ..8 -EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)	–	–	–
S1	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	–	–	25 (12-30)
S2	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	–	–	25 (12-30)
S3	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	–	20 (10-25)	20 (10-25)	–	–	–	–	–	–	25 (12-30)
S11	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	50 (25-65)
S12	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	50 (25-65)
S13	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	–	–	–	50 (25-65)
H3	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H5	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H7	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H8	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H11	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H12	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H21	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
H31	PMXxx ..6 ..8 -EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	–	–	10 (8-15)	–	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB845	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–
PM2	PMXxx ..6 ..8 -EB845	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–
PM3	PMXxx ..6 ..8 -EB845	0,10- 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	–	50 (30-80)	70 (40-100)	–	–	–	–	–	–	–

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – PM Plus...-EB845 *inch*

SMG		a_p (Ø)		f			v_c									
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RM2020	RM2090	RS2090
P3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	–	590 (295-655)	720 (395-985)	–	–	–	–
P4	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P5	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P6	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P7	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	–	395 (260-490)	590 (295-655)	–	–	–	–
P8	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–
P11	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	–	260 (195-395)	395 (260-590)	–	–	–	–
P12	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	40 (25-50)	80 (50-130)	100 (50-215)	–	215 (150-315)	315 (215-480)	–	–		
M1	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	40 (30-50)	80 (50-130)	115 (65-230)	–	–	–	–	80 (50-130)	115 (65-230)	–
M2	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	80 (50-130)	115 (65-230)	–
M3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	80 (50-130)	115 (65-230)	–	–	–	–	80 (50-130)	115 (65-230)	–
M4	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	65 (35-100)	80 (50-165)	–
M5	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	–	65 (35-100)	80 (50-165)	–	–	–	–	65 (35-100)	80 (50-165)	–
K1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–
K2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	80 (65-130)	130 (100-230)	145 (110-260)	–	260 (165-330)	290 (185-370)	–	–	–
K3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–
K4	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–
K5	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	–	–	–
K6	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	–
K7	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	–	195 (130-330)	260 (100-490)	290 (110-550)	–	720 (395-985)	805 (440-1105)	–	–	-
S1	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S2	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	–	65 (35-80)	65 (35-80)	–	–	–	–	–	–	80 (40-100)
S11	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	165 (80-215)
S12	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	165 (80-215)
S13	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	–	–	165 (80-215)
H3	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H5	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H7	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H8	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H11	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H12	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H21	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
H31	PMXxx ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	–	–	35 (25-50)	–	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–
PM2	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–
PM3	PMXxx ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	–	165 (100-260)	230 (130-330)	–	–	–	–	–	–	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – Plus... -EB25/EB30 metric

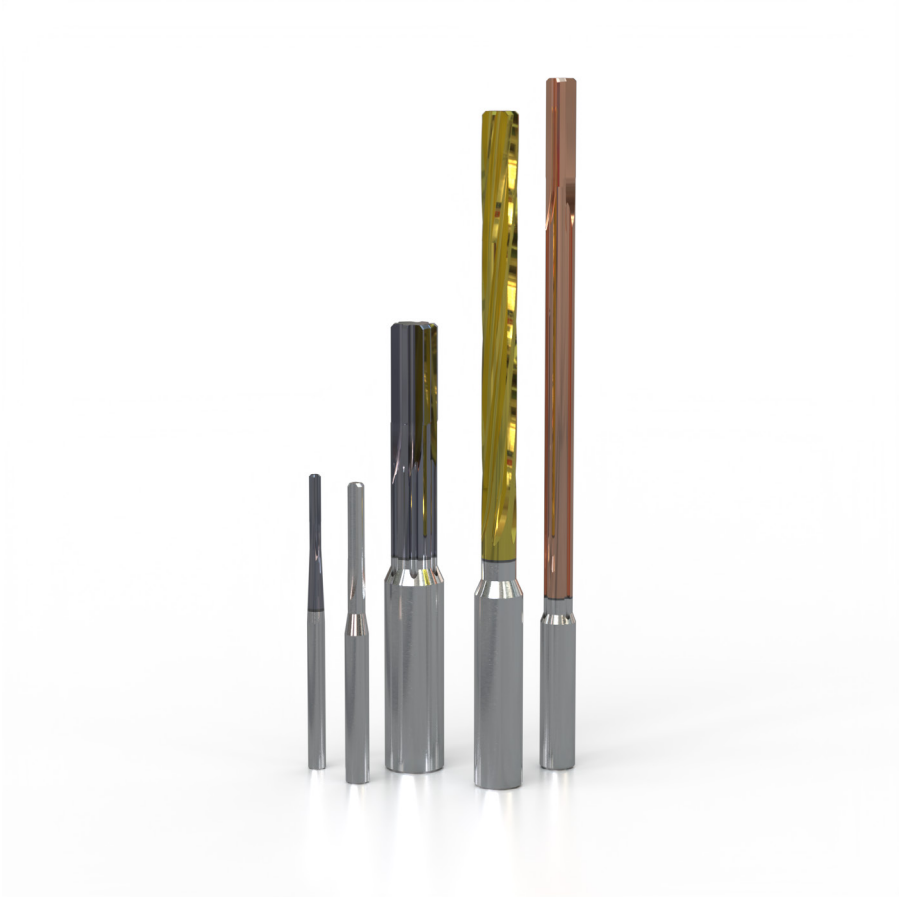
SMG		a_p (Ø)		f			v_c						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–
P2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–
P3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	–	180 (90-200)	220 (120-300)	–
P4	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
P5	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
P6	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
P7	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	–	120 (80-150)	180 (90-200)	–
M1	PMXxx ..6 ..8 -EB25/EB30	0,08-0,15	0,10-0,20	0,80-1,20	1,00-2,00	1,20-2,50	–	25 (15-40)	35 (20-70)	–	–	–	–
K1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
K2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	–	25 (20-40)	40 (30-70)	45 (35-80)	–	80 (50-100)	90 (55-110)
K3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
K4	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)
K5	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)
K6	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
K7	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	–	60 (40-100)	80 (30-150)	90 (35-170)	–	220 (120-300)	245 (135-335)
N1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
N2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
N3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
N11	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	–	–	–	–	–	–
PM1	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM2	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM3	PMXxx ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	–	50 (30-80)	70 (40-100)	–	–	–	–

SMG = Grupa de material Seco. a_p = mm. f = mm/rev. v_c= m/min.
Toţi parametri de așchiere sunt valori de start

Parametri de așchiere – PM Plus... -EB25/EB30 *inch*

SMG		a_p (Ø)		f			v_c						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–	*590 (295-655)*	*720 (395-985)*	–
P2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–	*590 (295-655)*	*720 (395-985)*	–
P3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–	*590 (295-655)*	*720 (395-985)*	–
P4	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
P5	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
P6	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
P7	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.071*	*.039 –.094*	*.047-.118*	*65 (35-80)*	*165 (100-260)*	*195 (100-395)*	–	*395 (260-490)*	*590 (295-655)*	–
M1	*PMXxx ..6 ..8 -EB25/EB30*	*.003 –.006*	*.004 –.008*	*.031 –.047*	*.039 –.079*	*.039-.098*	–	*80 (50-130)*	*115 (65-230)*	–	–	–	–
K1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.087*	*.039 –.110*	*.047-.138*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
K2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.071*	*.039 –.094*	*.047-.118*	–	*80 (65-130)*	*130 (100-230)*	*145 (110-260)*	–	*260 (165-330)*	*290 (185-370)*
K3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.087*	*.039 –.110*	*.047-.138*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
K4	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.087*	*.039 –.110*	*.047-.138*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*	*330 (230-490)*	*490 (260-655)*	*550 (290-735)*
K5	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.087*	*.039 –.110*	*.047-.138*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*	*330 (230-490)*	*490 (260-655)*	*550 (290-735)*
K6	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.071*	*.039 –.094*	*.047-.118*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
K7	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.010*	*.031 –.071*	*.039 –.094*	*.047-.118*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*	–	*720 (395-985)*	*805 (440-1105)*
N1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
N11	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.031 –.087*	*.039 –.110*	*.047-.138*	*165 (100-330)*	–	–	–	–	–	–
PM1	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.020 –.071*	*.031 –.079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–
PM2	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.020 –.071*	*.031 –.079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–
PM3	*PMXxx ..6 ..8 -EB25/EB30*	*.004 –.008*	*.004 –.012*	*.020 –.071*	*.031 –.079*	*.039-.098*	–	*165 (100-260)*	*230 (130-330)*	–	–	–	–

SMG = Grupa de material Seco. a_p = *inch*. f = in/rev. v_c= sf/min. Toţi parametri de așchiere sunt valori de start.

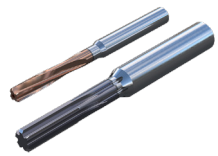
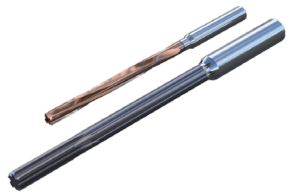
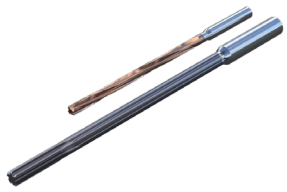


Nanojet

Alezoarele din carbură solidă Nanojet sunt concepute pentru diametre mici de la 1,461 până la 11,960 mm (.057'' - .470").

— Ieșirea puternică și inovatoare a lichidului de răcire
— Permite toleranţe cuprinse între 10 și 15 µm (.0004' – .0006'')
— Opt geometrii disponibile: EB45, EBS45, EB845, EB25, EB30, EBS30, EB60 și EB75
— Trei lungimi diferite: scurt, mediu și lung

Privire generală

Nanojet	∅ Gamă	Adâncime de alezare	Toleranţa ∅ găurii	Diametru intermediar	Finisarea suprafeţei
Scurt 	1,461- 11,960 mm *(0.057-0.470")*	~ 4-7 x D	IT 7	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Mediu 	1,461- 11,960 mm *(0.057-0.470")*	~ 7-12 x D	IT 7	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*
Lung 	1,461- 11,960 mm *(0.057-0.470")*	~ 12-15 x D	IT 7	Da, disponibil prin My Design	R_a 0,2-1,2 µm *(R_a 7.87-47.2 µin)*

Alezoarele din carbură solidă Nanojet sunt concepute pentru diametre mici de la 1.461 până la 9.960 mm (.057" - .392").
Designul include o ieșire periferică inovatoare a lichidului de răcire care furnizează lichid de răcire direct în caneluri într-o manieră optimizată și puternică.

Codificări

Alezoare

N5TS	–	4H7	–	EB45	–	RX2000
1		2		3		4

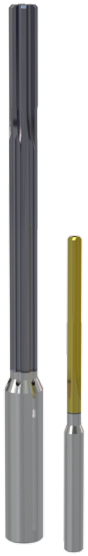


1.	2.	3.	4
Tipul alezorului	Diametrul găurii și toleranţa	Geometria vârfului	Calitate

Diametru intermediar alezoare

N4BM	–	2.5 P7	–	EB30	–	RK2050
1		2		3		4

0.0984”–0.0989”
2



1.	2.	3.	4
Tipul alezorului	Diametrul găurii și toleranţa	Geometria vârfului	Calitate

Diametru intermediar alezoare

N5TL	–	9.525 H7	–	EB60	–	RN2010
1		2		3		4

0.3750”–0.3751”
2



1.	2.	3.	4
Tipul alezorului	Diametrul găurii și toleranţa	Geometria vârfului	Calitate

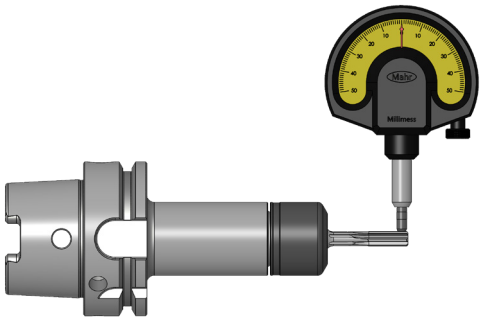
N5TS / N5TM / N5TL: Caneluri drepte. Potrivit pentru găuri străpunse, versiunea scurtă, medie și lungă.
N5BS / N5BM / N5BL: Caneluri drepte. Potrivit pentru găuri înfundate, versiunea scurtă, medie și lungă.
N4BS / N4BM / N4BTL: Caneluri pe dreapta. Potrivit pentru găuri înfundate, versiunea scurtă, medie și lungă.
Canelurile pe dreapta îmbunătăţesc evacuarea aşchiilor, recomandat pentru găuri adânci infundate.

Consultaţi alegerea geometriilor canelurilor Nanofix de la pagina (paginile) 371.

Bătaie radială

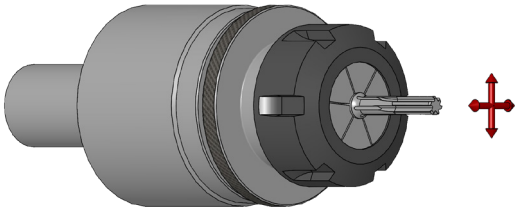
Aplicaţii dinamice

Bătaia radială recomandată max.: 5 µm (*197 µin*).
Se recomandă o portsculă de precizie: Mandrină hidraulică, mandrină cu pensetă de]nalt[precizie ERHP sau portsculă cu fretare.



Aplicaţii statice

Port-sculele flotante permit autocentrarea la pregăurire.



Cerinţele lichidului de răcire

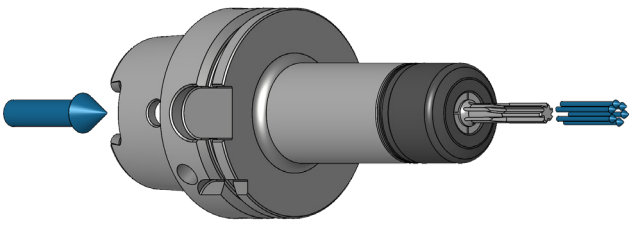
Pentru a obţine o viaţă lungă a sculei şi o calitate ridicată a găurii, trebuie ţinut cont de următoarele caracteristici ale lichidului de răcire.

Se recomandă răcirea interioară.
Se poate utiliza răcire exterioară cu reducerea parametrilor de aşchiere la 75%.

Ulei solubil cu minim 40% ulei mineral.
Se recomandă ulei curat pentru oţel inoxidabil.

Concentraţia minimă 6-8%.
Filtrare 30–50 µm *(1181-1969 µin)*.
Volum min. 0,5 l/min/mm *(0,13 gal/min/inci)* din diametrul sculei (de ex: Alezor ∅ 10, volum min. este 5 l/min *(1,3 gal/min)*.

Presiunea recomandată a lichidului de răcire: min. 8-10 bari, max. 30 bari.

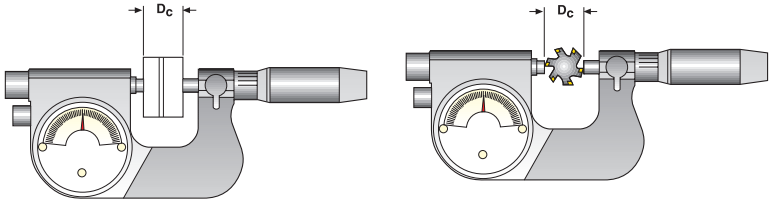


Măsurarea diametrului

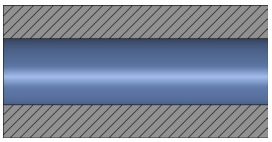
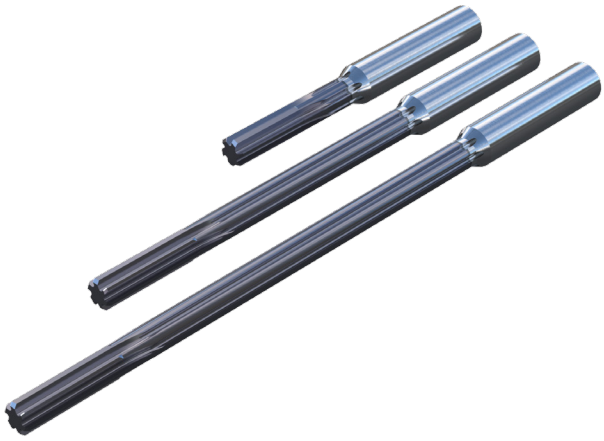
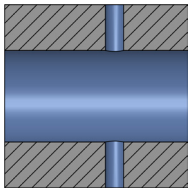
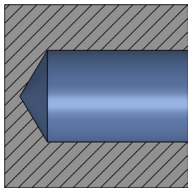
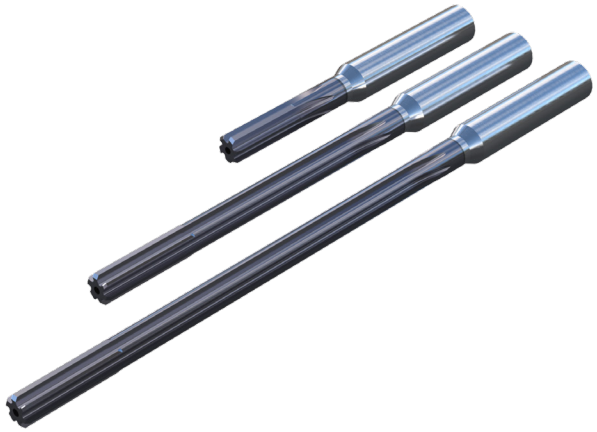
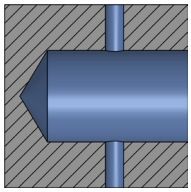
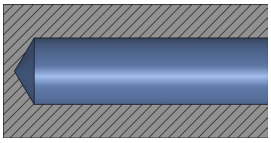
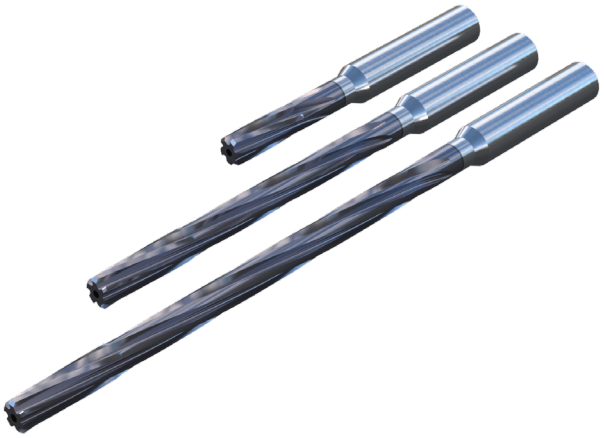
Calibraţi ceasul micrometrului înainte de măsurătoare.

Important!
Alezoarele Nanojet au pas diferenţial al dinţilor.
La măsurarea diametrului se utilizează 2 dinţi opuşi la 180°.

La calibrare utilizaţi un comparator micrometric şi o cală de calibrare.



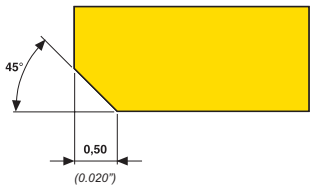
Alegerea geometriei canelurii

Piesă de prelucrat	Diametru de alezat ∅ 1,461-11,960 mm *(0.057-0.470")*	
Găuri străpunse 	**Caneluri drepte** N5T	
Găuri înfundate și încrucișate 		
Găuri înfundate 	**Caneluri drepte** N5B	
Găuri înfundate și încrucișate 		
Gaură înfundată > 3 x D 	**Caneluri elicoidale RH** N4B	

Alegerea geometriei – Aplicaţii

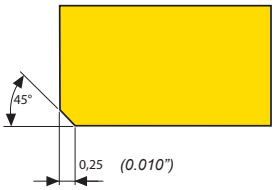
Geometria vârfului - EB45

Controlul asupra formării aşchiilor ++
Finisarea suprafeţei +++ R_a 0,8 - 1,2 µm
(Finisarea suprafeţei +++ R_a 31 - 47 µin)
Versatil



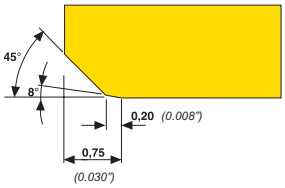
Geometria vârfului - EBS45

Controlul asupra formării aşchiilor +++
Finisarea suprafeţei + R_a 0,8- 1,2
(Finisarea suprafeţei + R_a 31- 47 µin)
Scurt EB45



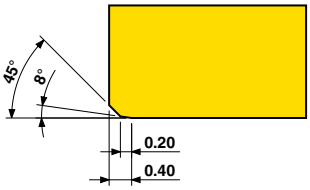
Geometria vârfului - EB845

Controlul asupra formării aşchiilor ++
Finisarea suprafeţei +++ R_a 0,2 - 0,8 µm
(Finisarea suprafeţei +++ R_a 8 - 31 µin)



Geometria vârfului - EBS845

Controlul asupra formării aşchiilor ++
Finisarea suprafeţei +++ R_a 0,2 - 0,8 µm
(Finisarea suprafeţei +++ R_a 8 - 31 µin)

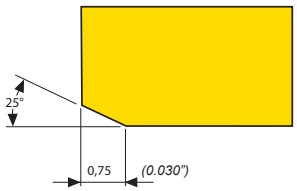


Notă: pentru diametre mici dimensiunile geometriei lungimii sanfrenului pot fi ceva mai mici.

Alegerea geometriei – Aplicaţii

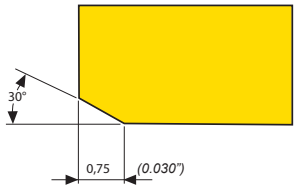
Geometria vârfului - EB25

Performanţa avansului +++
Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm
(Finisarea suprafeţei ++ R_a 16 - 31 µin)
Controlul asupra formării aşchiilor +



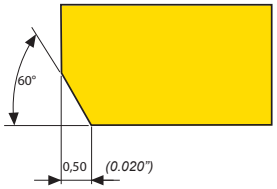
Geometria vârfului - EB30

Performanţa avansului +++
Finisarea suprafeţei ++ R_a 0,4 - 0,8 µm
(Finisarea suprafeţei ++ R_a 16 - 31 µin)
Controlul asupra formării aşchiilor +



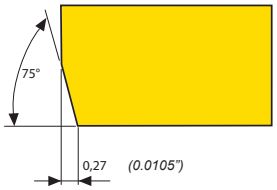
Geometria vârfului - EB60

Performanţa avansului +
Finisarea suprafeţei ++ R_a 0,8 - 1,2 µm
(Finisarea suprafeţei ++ R_a 31 - 47 µin)
Controlul asupra formării aşchiilor ++



Geometria vârfului - EB75

Performanţa avansului +
Finisarea suprafeţei ++ R_a 0,8 - 1,2 µm
(Finisarea suprafeţei ++ R_a 31 - 47 µin)
Controlul asupra formării aşchiilor ++



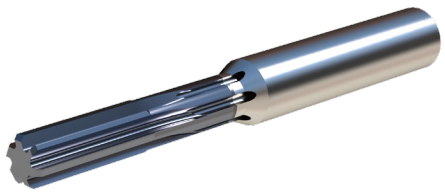
Notă: pentru diametre mici dimensiunile geometriei lungimii sanfrenului pot fi ceva mai mici.

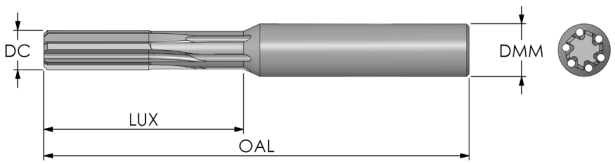
Calităţi

	**RX2000**	**Acoperire** De înaltă performanţă, potrivită pentru toate materialele.
	**CP20**	**Acoperite** O clasă de carbură acoperită, versatilă, potrivită pentru majoritatea materialelor, cu excepţia aluminiului. TiN
	**H15**	**Neacoperită** O clasă tenace de carbură pentru toate materialele. Potrivită pentru alezare fină datorită muchiei ascuţite.
	**RN2010**	**Neacoperit** O calitate neacoperită cu geometrii optimizate pentru N-materiale (neferoase).
	**RM2020**	**Acoperită** O calitate acoperită tenace, adecvată pentru operaţiuni de alezare fină, cu geometrii optimizate pentru materiale M.
	**RM2090**	**Acoperită** O calitate acoperită rezistentă la uzură cu geometrii specifice pentru materialele M. Optimizarea materialelor M.
	**RK2050**	**Acoperită** O calitate acoperită tenace, adecvată pentru operaţiuni de alezare fină, cu geometrii optimizate pentru materiale K.
	**RS2090**	**Acoperită** O calitate acoperită rezistentă la uzură cu geometrii specifice pentru materialele S. Optimizarea în materiale S.

Alezor pentru găuri străpunse

Ø 1,98–11,113 mm / 0.0779–0.4375”





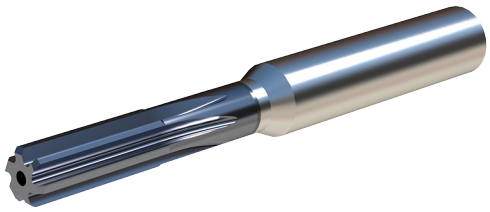
Reper Nr.	Număr reper	DC	Hole dia min-max		LUX	OAL	DMM		Geometrii			Calităţi		
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		EB45	EB845	EB30	RX2000	H15	H15
N5TS-1.98H7-EB45	10289732	1,98 *0.0780*	1,98 *0.0780*	1,99 *0.0783*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-1.99H7-EB45	10289733	1,99 *0.0783*	1,99 *0.0783*	2,0 *0.0787*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2H7-EB45	10238500	2,0 *0.0787*	2,0 *0.0787*	2,01 *0.0791*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2.01H7-EB45	10289734	2,01 *0.0791*	2,01 *0.0791*	2,02 *0.0795*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2.02H7-EB45	10289735	2,02 *0.0795*	2,02 *0.0795*	2,03 *0.0799*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5TS-2.98H7-EB45	10289736	2,98 *0.1173*	2,98 *0.1173*	2,99 *0.1177*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-2.99H7-EB45	10289737	2,99 *0.1177*	2,99 *0.1177*	3,0 *0.1181*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3H7-EB45	10238501	3,0 *0.1181*	3,0 *0.1181*	3,01 *0.1185*	21,0 *0.8270*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.01H7-EB45	10289738	3,01 *0.1185*	3,01 *0.1185*	3,022 *0.1190*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.02H7-EB45	10289739	3,02 *0.1189*	3,02 *0.1189*	3,032 *0.1194*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.175H7-EB45	10289740	3,175 *0.1250*	3,175 *0.1250*	3,187 *0.1255*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5TS-3.98H7-EB45	10289741	3,98 *0.1567*	3,98 *0.1567*	3,992 *0.1572*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-3.99H7-EB45	10289742	3,99 *0.1571*	3,99 *0.1571*	4,002 *0.1576*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4H7-EB45	10238502	4,0 *0.1575*	4,0 *0.1575*	4,012 *0.1580*	28,0 *1.1020*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4.01H7-EB45	10289743	4,01 *0.1579*	4,01 *0.1579*	4,022 *0.1583*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4.02H7-EB45	10289744	4,02 *0.1583*	4,02 *0.1583*	4,032 *0.1587*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5TS-4.98H7-EB45	10289745	4,98 *0.1961*	4,98 *0.1961*	4,992 *0.1965*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-4.99H7-EB45	10289746	4,99 *0.1965*	4,99 *0.1965*	5,002 *0.1969*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5H7-EB45	10238503	5,0 *0.1969*	5,0 *0.1969*	5,012 *0.1973*	28,0 *1.1020*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5.01H7-EB45	10289747	5,01 *0.1972*	5,01 *0.1972*	5,022 *0.1977*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5.02H7-EB45	10290135	5,02 *0.1976*	5,02 *0.1976*	5,032 *0.1981*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5TS-5.98H7-EB45	10289748	5,98 *0.2354*	5,98 *0.2354*	5,992 *0.2359*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-5.99H7-EB45	10289749	5,99 *0.2358*	5,99 *0.2358*	6,002 *0.2363*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-6H7-EB45	10238504	6,0 *0.2362*	6,0 *0.2362*	6,015 *0.2368*	30,0 *1.1810*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-6.01H7-EB45	10290075	6,01 *0.2366*	6,01 *0.2366*	6,025 *0.2372*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-6.02H7-EB45	10289750	6,02 *0.2370*	6,02 *0.2370*	6,035 *0.2376*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□

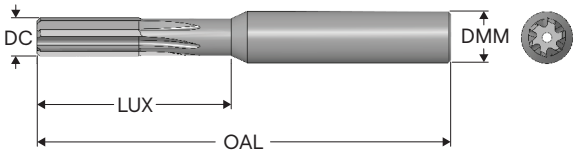
Reper Nr.	Număr reper	DC	Hole dia min-max		LUX	OAL	DMM		Geometrii			Calităţi		
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		EB45	EB845	EB30	RX2000	H15	H15
N5TS-6.35H7-EB45	10238506	6,35 *0.2500*	6,35 *0.2500*	6,365 *0.2506*	30,0 *1.1810*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-7H7-EB45	10289625	7,0 *0.2756*	7,0 *0.2756*	7,015 *0.2762*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-7.937H7-EB45	10289626	7,937 *0.3125*	7,937 *0.3125*	7,952 *0.3131*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5TS-7.98H7-EB45	10289751	7,98 *0.3142*	7,98 *0.3142*	7,995 *0.3148*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-7.99H7-EB45	10289752	7,99 *0.3146*	7,99 *0.3146*	8,005 *0.3152*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-8H7-EB45	10238505	8,0 *0.3150*	8,0 *0.3150*	8,015 *0.3156*	40,0 *1.5750*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-8.01H7-EB45	10289753	8,01 *0.3154*	8,01 *0.3154*	8,025 *0.3159*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-8.02H7-EB45	10289754	8,02 *0.3157*	8,02 *0.3157*	8,035 *0.3163*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5TS-9.525H7-EB45	10289627	9,525 *0.3750*	9,525 *0.3750*	9,54 *0.3756*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□

■ Stoc standard. □ Standard fără stoc.

Alezor pentru găuri înfundate

Ø 1,98–11,113 mm / 0.0779–0.4375”





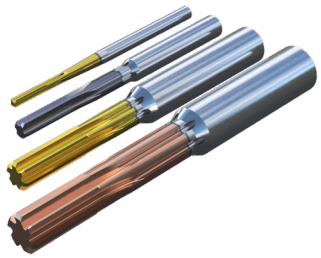
Reper Nr.	Număr reper	DC	Hole dia min-max		LUX	OAL	DMM		Geometrii			Calităţi		
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		EB45	EB845	EB30	RX2000	H15	H15
N5BS-1.98H7-EB45	10289755	1,98 *0.0780*	1,98 *0.0780*	1,99 *0.0783*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-1.99H7-EB45	10289756	1,99 *0.0783*	1,99 *0.0783*	2,0 *0.0787*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-2.01H7-EB45	10289757	2,01 *0.0791*	2,01 *0.0791*	2,02 *0.0795*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-2.02H7-EB45	10289758	2,02 *0.0795*	2,02 *0.0795*	2,03 *0.0799*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-2.98H7-EB45	10289759	2,98 *0.1173*	2,98 *0.1173*	2,99 *0.1177*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-2.99H7-EB45	10289760	2,99 *0.1177*	2,99 *0.1177*	3,0 *0.1181*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-2H7-EB45	10284828	2,0 *0.0787*	2,0 *0.0787*	2,01 *0.0791*	12,0 *0.4720*	50,0 *1.9690*	3,0 *0.1180*	4	■	□	□	■	□	□
N5BS-3.01H7-EB45	10289761	3,01 *0.1185*	3,01 *0.1185*	3,022 *0.1190*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-3.02H7-EB45	10289762	3,02 *0.1189*	3,02 *0.1189*	3,032 *0.1194*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-3.175H7-EB45	10289628	3,175 *0.1250*	3,175 *0.1250*	3,187 *0.1255*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-3.98H7-EB45	10289764	3,98 *0.1567*	3,98 *0.1567*	3,992 *0.1572*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-3.99H7-EB45	10289765	3,99 *0.1571*	3,99 *0.1571*	4,002 *0.1576*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-3H7-EB45	10284829	3,0 *0.1181*	3,0 *0.1181*	3,01 *0.1185*	21,5 *0.8460*	50,0 *1.9690*	4,0 *0.1570*	4	■	□	□	■	□	□
N5BS-4.01H7-EB45	10289766	4,01 *0.1579*	4,01 *0.1579*	4,022 *0.1583*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-4.02H7-EB45	10289767	4,02 *0.1583*	4,02 *0.1583*	4,032 *0.1587*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-4.98H7-EB45	10289768	4,98 *0.1961*	4,98 *0.1961*	4,992 *0.1965*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-4.99H7-EB45	10289769	4,99 *0.1965*	4,99 *0.1965*	5,002 *0.1969*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-4H7-EB45	10284830	4,0 *0.1575*	4,0 *0.1575*	4,012 *0.1580*	28,5 *1.1220*	55,0 *2.1650*	5,0 *0.1970*	4	■	□	□	■	□	□
N5BS-5.01H7-EB45	10289770	5,01 *0.1972*	5,01 *0.1972*	5,022 *0.1977*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-5.02H7-EB45	10290138	5,02 *0.1976*	5,02 *0.1976*	5,032 *0.1981*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-5.98H7-EB45	10289771	5,98 *0.2354*	5,98 *0.2354*	5,992 *0.2359*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-5.99H7-EB45	10289772	5,99 *0.2358*	5,99 *0.2358*	6,002 *0.2363*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-5H7-EB45	10284831	5,0 *0.1969*	5,0 *0.1969*	5,012 *0.1973*	28,5 *1.1220*	55,0 *2.1650*	6,0 *0.2360*	4	■	□	□	■	□	□
N5BS-6.01H7-EB45	10289773	6,01 *0.2366*	6,01 *0.2366*	6,025 *0.2372*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-6.02H7-EB45	10289774	6,02 *0.2370*	6,02 *0.2370*	6,035 *0.2376*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-6.35H7-EB45	10284836	6,35 *0.2500*	6,35 *0.2500*	6,365 *0.2506*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□

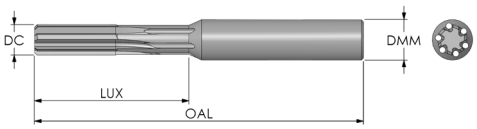
Reper Nr.	Număr reper	DC	Hole dia min-max		LUX	OAL	DMM		Geometrii			Calităţi		
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*		EB45	EB845	EB30	RX2000	H15	H15
N5BS-6H7-EB45	10284832	6,0 *0.2362*	6,0 *0.2362*	6,015 *0.2368*	30,5 *1.2010*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-7.937H7-EB45	10289630	7,937 *0.3125*	7,937 *0.3125*	7,952 *0.3131*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-7.98H7-EB45	10289775	7,98 *0.3142*	7,98 *0.3142*	7,995 *0.3148*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-7.99H7-EB45	10289776	7,99 *0.3146*	7,99 *0.3146*	8,005 *0.3152*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-7H7-EB45	10289629	7,0 *0.2756*	7,0 *0.2756*	7,015 *0.2762*	31,5 *1.2400*	65,0 *2.5590*	8,0 *0.3150*	6	■	□	□	■	□	□
N5BS-8.01H7-EB45	10289777	8,01 *0.3154*	8,01 *0.3154*	8,025 *0.3159*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-8.02H7-EB45	10289778	8,02 *0.3157*	8,02 *0.3157*	8,035 *0.3163*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-8H7-EB45	10284833	8,0 *0.3150*	8,0 *0.3150*	8,015 *0.3156*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□
N5BS-9.525H7-EB45	10289631	9,525 *0.3750*	9,525 *0.3750*	9,54 *0.3756*	40,5 *1.5940*	75,0 *2.9530*	10,0 *0.3940*	6	■	□	□	■	□	□

■ Stoc standard. □ Standard fără stoc.

Alezor pentru găuri străpunse – Diametru intermediar

Canelură dreaptă, versiune scurtă – Ø 1,461-11,960 mm / 0.057- 0.470”





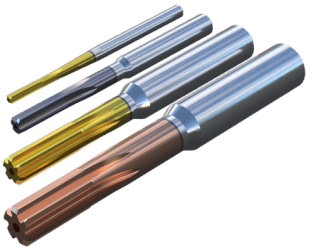
—Pentru alegerea geometriei, consultaţi pagina (paginile) 372-373
—Regimuri de așchiere, vezi pagina(paginile) 385-391

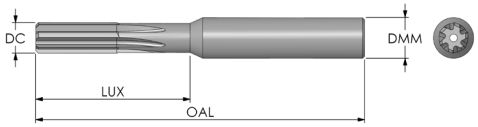
Reper Nr.	DCN	DCX	LUX	DMM	OAL		Geometrii	Calităţi						
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5TS-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	12,0 *0.472*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	17,0 *0.669*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	21,0 *0.827*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	23,0 *0.906*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	28,0 *1.102*	5,0 *0.197*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	28,0 *1.102*	6,0 *0.236*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	30,0 *1.181*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	31,0 *1.220*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	40,0 *1.575*	10,0 *0.394*	75,0 *2.953*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TS-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	50,0 *1.969*	12,0 *0.472*	100,0 *3.937*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = Standard fără stoc.
Notă: Când comandaţi alezoarele Nanojet pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: N5TS-2,5 R7-EBS45, RS2090

Alezor pentru găuri înfundate – Diametru intermediar

Canelură dreaptă, versiune scurtă – Ø 1,461-11,960 mm / 0.057- 0.470"





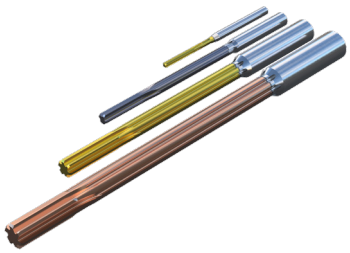
—Pentru alegerea geometriei, consultaţi pagina (paginile) 372–373
—Regimuri de așchiere, vezi pagina(paginile) 385–391

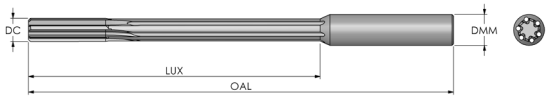
Reper Nr.	DCN	DCX	LUX	DMM	OAL		Geometrii	Calităţi						
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5BS-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	12,0 *0.472*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	17,0 *0.669*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	21,0 *0.827*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	23,0 *0.906*	4,0 *0.157*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	28,0 *1.102*	5,0 *0.197*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	28,0 *1.102*	6,0 *0.236*	55,0 *2.165*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	30,0 *1.181*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	31,0 *1.220*	8,0 *0.315*	65,0 *2.559*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	40,0 *1.575*	10,0 *0.394*	75,0 *2.953*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BS-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	50,0 *1.969*	12,0 *0.472*	100,0 *3.937*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = Standard fără stoc.
Notă: Când comandaţi alezoarele Nanojet pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: N5BS-8,084/8, 100-EB30, RK2050

Alezor pentru găuri străpunse – Diametru intermediar

Canelură dreaptă, versiune medie – Ø 1,461-11,960 mm / 0.057- 0.470"





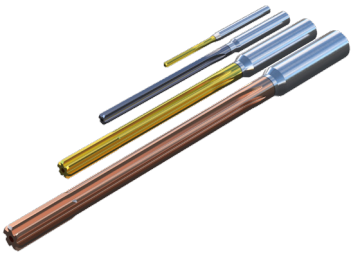
—Pentru alegerea geometriei, consultaţi pagina (paginile) 372-373
—Regimuri de așchiere, vezi pagina(paginile) 385-391

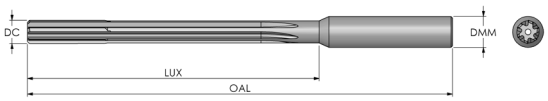
Reper Nr.	DCN	DCX	LUX	DMM	OAL		Geometrii	Calităţi						
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5TM-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	21,5 *0.846*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	32,5 *1.280*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	38,5 *1.516*	4,0 *0.157*	65,0 *2.559*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	48,5 *1.909*	4,0 *0.157*	75,0 *2.953*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	58,5 *2.303*	5,0 *0.197*	85,0 *3.346*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	68,5 *2.697*	6,0 *0.236*	95,0 *3.740*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	75,5 *2.972*	8,0 *0.315*	110,0 *4.331*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	86,5 *3.406*	8,0 *0.315*	120,0 *4.724*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	105,5 *4.154*	10,0 *0.394*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TM-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	117,0 *4.606*	12,0 *0.472*	165,0 *6.496*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = Standard fără stoc.
Notă: Când comandaţi alezoarele Nanojet pentru diametre intermediare, indicaţi diametrul și toleranța găurii de alezat.
Exemplu comandă: N5TM-2,5 R7-EBS45, RS2090

Alezor pentru găuri înfundate – Diametru intermediar

Canelură dreaptă, versiune medie – Ø 1,461-11,960 mm / 0.057- 0.470"





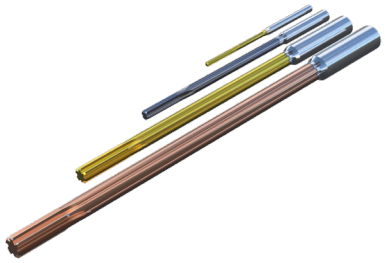
—Pentru alegerea geometriei, consultaţi pagina (paginile) 372-373
—Regimuri de aşchiere, vezi pagina(paginile) 385-391

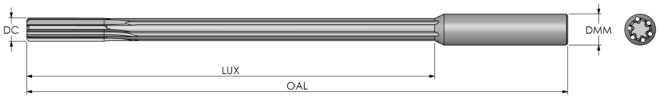
Reper Nr.	DCN	DCX	LUX	DMM	OAL		Geometrii	Calităţi						
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5BM-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	21,5 *0.846*	3,0 *0.118*	50,0 *1.969*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	32,5 *1.280*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	38,5 *1.516*	4,0 *0.157*	65,0 *2.559*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	48,5 *1.909*	4,0 *0.157*	75,0 *2.953*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	58,5 *2.303*	5,0 *0.197*	85,0 *3.346*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TBM-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	68,5 *2.697*	6,0 *0.236*	95,0 *3.740*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	75,5 *2.972*	8,0 *0.315*	110,0 *4.331*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	86,5 *3.406*	8,0 *0.315*	120,0 *4.724*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	105,5 *4.154*	10,0 *0.394*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BM-9.961-XX.XXX	9,961 *0.392*	11,96 *0.471*	117,0 *4.606*	12,0 *0.472*	165,0 *6.496*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

☐ = Standard fără stoc.
Notă: Când comandaţi alezoarele Nanojet pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: N5BM-8,084/8, 100-EB30, RK2050

Alezor pentru găuri străpunse – Diametru intermediar

Canelură dreaptă, versiune lungă – Ø 1,461-9,960 mm / 0.057- 0.392"





—Pentru alegerea geometriei, consultaţi pagina (paginile) 372-373
—Regimuri de aşchiere, vezi pagina(paginile) 385-391

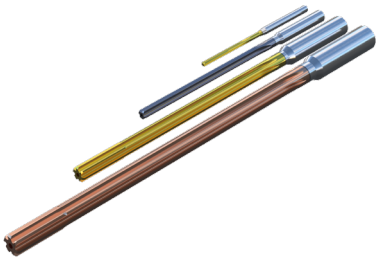
Reper Nr.	DCN	DCX	LUX	DMM	OAL		Geometrii	Calităţi						
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5TL-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	31,5 *1.240*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	42,5 *1.673*	3,0 *0.118*	70,0 *2.756*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	53,5 *2.106*	4,0 *0.157*	80,0 *3.150*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	61,5 *2.421*	4,0 *0.157*	88,0 *3.465*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	73,5 *2.894*	5,0 *0.197*	100,0 *3.937*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	88,5 *3.484*	6,0 *0.236*	115,0 *4.528*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	105,5 *4.154*	8,0 *0.315*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	121,5 *4.783*	8,0 *0.315*	155,0 *6.102*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5TL-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	145,5 *5.728*	10,0 *0.394*	180,0 *7.087*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

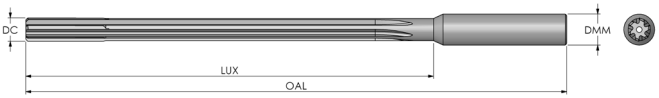
<STEPTABLE O="Nanojet N5TL thro-long" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

☐ = Standard fără stoc.
Notă: Când comandaţi alezoarele Nanojet pentru diametre intermediare, indicaţi diametrul și toleranţa găurii de alezat.
Exemplu comandă: N5TL-2,5 R7-EBS45, RS2090

Alezor pentru găuri înfundate – Diametru intermediar

Canelură dreaptă, versiune lungă – Ø 1,461-9,960 mm / 0.057- 0.392"





—Pentru alegerea geometriei, consultaţi pagina (paginile) 372-373
—Regimuri de așchiere, vezi pagina(paginile) 385-391

Reper Nr.	DCN	DCX	LUX	DMM	OAL		Geometrii	Calităţi						
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090
N5BL-1.461-XX.XXX	1,461 *0.058*	2,2 *0.087*	31,5 *1.240*	3,0 *0.118*	60,0 *2.362*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-2.201-XX.XXX	2,201 *0.087*	2,96 *0.117*	42,5 *1.673*	3,0 *0.118*	70,0 *2.756*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-2.961-XX.XXX	2,961 *0.117*	3,46 *0.136*	53,5 *2.106*	4,0 *0.157*	80,0 *3.150*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-3.461-XX.XXX	3,461 *0.136*	3,96 *0.156*	61,5 *2.421*	4,0 *0.157*	88,0 *3.465*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-3.961-XX.XXX	3,961 *0.156*	4,96 *0.195*	73,5 *2.894*	5,0 *0.197*	100,0 *3.937*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-4.961-XX.XXX	4,961 *0.195*	5,96 *0.235*	88,5 *3.484*	6,0 *0.236*	115,0 *4.528*	4	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-5.961-XX.XXX	5,961 *0.235*	6,96 *0.274*	105,5 *4.154*	8,0 *0.315*	140,0 *5.512*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-6.961-XX.XXX	6,961 *0.274*	7,96 *0.313*	121,5 *4.783*	8,0 *0.315*	155,0 *6.102*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐
N5BL-7.961-XX.XXX	7,961 *0.313*	9,96 *0.392*	145,5 *5.728*	10,0 *0.394*	180,0 *7.087*	6	EB45 EB845 EB30 EB60 ...	☐	☐	☐	☐	☐	☐	☐

<STEPTABLE O="Nanojet N5BL blind-long" OT="Product" TT="stibo.91791239" VC="ROro" VO="6710820" W="Main" />

☐ = Standard fără stoc.
Notă: Când comandaţi alezoarele Nanojet pentru diametre intermediare, indicaţi diametrul şi toleranţa găurii de alezat.
Exemplu comandă: N5BL-8,084/8, 100-EB30, RK2050

Parametri de așchiere – Nanojet -EB45 metric

SMG		a_p (Ø)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
P1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	–	–	–	–
P2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	–	–	–	–
P3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	–	–	–	–
P4	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P5	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P6	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P7	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	–	–	–	–
P8	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	–	–	–	–
P11	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	–	–	–	–
P12	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	12 (8-15)	25 (15-45)	30 (15-65)	-	–	–	–	–
M1	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	12 (9-15)	25 (15-40)	35 (20-60)	-	–	25 (15-40)	40 (20-60)	–
M2	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	25 (15-40)	35 (20-60)	-	–	25 (15-40)	40 (20-60)	–
M3	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	25 (15-40)	35 (20-60)	-	–	25 (15-40)	40 (20-60)	–
M4	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	20 (10-30)	25 (15-40)	-	–	25 (10-30)	30 (15-40)	–
M5	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	–	20 (10-30)	25 (15-40)	-	–	25 (10-30)	30 (15-40)	–
K1	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
K2	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	25 (20-40)	40 (30-70)	45 (35-80)	–	–	–	–
K3	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
K4	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	–	–	–	–
K5	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	–	–	–	–
K6	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
K7	N5T/N5B-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–	–
N1	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
N2	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
N3	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
N4	N5T/N5B-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	-	50 (20-80)	–	–	–
S1	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	15 (8-20)	20 (10-25)	-	–	–	–	20 (10-25)
S2	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	15 (8-20)	20 (10-25)	-	–	–	–	20 (10-25)
S3	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	15 (8-20)	20 (10-25)	-	–	–	–	25 (10-25)
S11	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	–	–	–	30 (20-50)
S12	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	–	–	–	30 (20-50)
S13	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	–	–	–	30 (20-50)

Tabelul continuă pe pagina următoare.

Parametri de așchiere – Nanojet -EB45 metric

SMG		a_p (Ø)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
H3	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H5	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H7	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H8	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H11	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H12	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H21	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
H31	N5T/N5B-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	–	–	10 (8-15)	-	–	–	–	–
PM1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	-	–	–	–	–
PM2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	-	–	–	–	–
PM3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	–	50 (30-80)	70 (40-100)	-	–	–	–	–
TS1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TS2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TS3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TS4	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP2	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP3	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
TP4	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	20 (15-25)	–	40 (20-60)	-	–	–	–	–
GR1	N5T/N5B-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	40 (80-20)	–	60 (30-120)	-	–	–	–	–

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Nanojet -EB45 *inch*

SMG		a_p (Ø)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
P1	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	–	–	–	–	–
P2	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	–	–	–	–	–
P3	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	–	–	–	–	–
P4	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P5	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P6	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P7	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–	–
P8	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–	–
P11	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–	–
P12	N5T/N5B-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	40 (25-50)	80 (50-150)	100 (50-215)	–	–	–	–	–
M1	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	40 (30-50)	80 (50-130)	115 (65-195)	–	–	80 (50-130)	130 (65-195)	–
M2	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	80 (50-130)	115 (65-195)	–	–	80 (50-130)	130 (65-195)	–
M3	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	80 (50-130)	115 (65-195)	–	–	80 (50-130)	130 (65-195)	–
M4	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	65 (35-100)	80 (50-130)	–	–	65 (35-100)	100 (50-130)	–
M5	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	–	65 (35-100)	80 (50-130)	–	–	65 (35-100)	100 (50-130)	–
K1	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
K2	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	80 (65-130)	130 (100-230)	145 (110-260)	–	–	–	–
K3	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
K4	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	–	–	–	–
K5	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	–	–	–	–
K6	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
K7	N5T/N5B-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–	–
N1	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
N2	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
N3	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
N4	N5T/N5B-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	–	260 (100-490)	–	165 (65-260)	–	–	–
S1	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	–	50 (25-65)	65 (35-80)	–	–	–	–	65 (35-80)
S2	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	–	50 (25-65)	65 (35-80)	–	–	–	–	65 (35-80)
S3	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	–	50 (25-65)	65 (35-80)	–	–	–	–	80 (35-80)
S11	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	100 (65-165)
S12	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	100 (65-165)
S13	N5T/N5B-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	–	100 (65-165)

Tabelul continuă pe pagina următoare.

Parametri de așchiere – Nanojet -EB45 *inch*

SMG		a_p (Ø)		f		v_c							
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RN2010	RM2020	RM2090	RS2090
H3	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H5	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H7	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H8	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H11	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H12	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H21	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
H31	*N5T/N5B-EB45*	*0.003-0.006*	*0.004-0.006*	*0.004-0.008*	*0.008-0.012*	–	–	*35 (25-50)*	–	–	–	–	–
PM1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–	–
PM2	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–	–
PM3	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.008*	*0.008-0.020*	–	*165 (100-260)*	*230 (130-350)*	–	–	–	–	–
TS1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TS2	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TS3	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TS4	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP2	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP3	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
TP4	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*65 (50-80)*	–	*130 (65-195)*	–	–	–	–	–
GR1	*N5T/N5B-EB45*	*0.004-0.006*	*0.004-0.008*	*0.004-0.012*	*0.008-0.024*	*130 (65-260)*	–	*195 (100-395)*	–	–	–	–	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – Nanojet -EB845 metric

SMG		a_p (Ø)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,30	0,20 -0,60	–	60 (30-100)	80 (30-150)	–	–	–	–
P4	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	60 (30-120)	–	–	–	–
P5	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	–	–	–	–
P6	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	–	–	–	–
P7	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	–	–	–	–
P8	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	15 (10-20)	35 (20-60)	40 (20-80)	–	–	–	–
P11	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	15 (10-20)	35 (20-60)	40 (20-80)	–	–	–	–
P12	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	12 (8-15)	25 (15-45)	30 (15-65)	–	–	–	–
M1	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	12 (9-15)	25 (15-45)	35 (20-60)	–	25 (15-40)	40 (20-60)	–
M2	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	25 (15-45)	35 (20-60)	–	25 (15-40)	40 (20-60)	–
M3	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	25 (15-45)	35 (20-60)	–	25 (15-40)	40 (20-60)	–
M4	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	20 (10-30)	25 (15-40)	–	25 (10-30)	30 (15-40)	–
M5	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	–	20 (10-30)	25 (15-40)	–	25 (10-30)	30 (15-40)	–
K1	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
K2	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	–	25 (20-40)	40 (30-70)	45 (35-80)	–	–	–
K3	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
K4	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (30-150)	–	–	–
K5	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	–	–	–
K6	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
K7	N5T/N5B-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	–	60 (40-100)	80 (30-150)	90 (35-170)	–	–	–
S1	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	15 (8-20)	20 (10-25)	–	–	–	20 (10-25)
S2	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	15 (8-20)	20 (10-25)	–	–	–	20 (10-25)
S3	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	15 (8-20)	20 (10-25)	–	–	–	25 (10-25)
S11	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	30 (20-50)
S12	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	30 (20-50)
S13	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	–	–	–	30 (20-50)
H3	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H5	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H7	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H8	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H11	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H12	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H21	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
H31	N5T/N5B-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	–	–	10 (8-15)	–	–	–	–
PM1	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM2	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	–
PM3	N5T/N5B-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	–	50 (30-80)	70 (40-100)	–	–	–	–

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Nanojet -EB845 *inch*

SMG		a_p (Ø)		f		v_c						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.012	0.008 –0.024	–	195 (100-330)	260 (100-490)	–	–	–	–
P4	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	195 (100-395)	–	–	–	–
P5	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–
P6	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–
P7	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	65 (35-80)	165 (100-260)	195 (100-395)	–	–	–	–
P8	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–
P11	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	50 (35-65)	115 (65-195)	130 (65-260)	–	–	–	–
P12	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	40 (25-50)	80 (50-150)	100 (50-125)	–	–	–	–
M1	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	40 (30-50)	80 (50-150)	115 (65-200)	–	80 (50-130)	130 (65-195)	–
M2	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	80 (50-150)	115 (65-200)	–	80 (50-130)	130 (65-195)	–
M3	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	80 (50-150)	115 (65-200)	–	80 (50-130)	130 (65-195)	–
M4	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	65 (30-100)	80 (50-135)	–	80 (35-100)	100 (50-130)	–
M5	N5T/N5B-EB845	0.003 -0.006	0.004 –0.006	0.004 –0.008	0.008 -0.02	–	65 (30-100)	80 (50-135)	–	80 (35-100)	100 (50-130)	–
K1	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
K2	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	–	80 (65-130)	130 (100-230)	145 (110-260)	–	–	–
K3	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
K4	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	150 (100-330)	230 (130-395)	260 (145-440)	–	–	–
K5	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	80 (50-100)	150 (100-330)	230 (130-395)	260 (145-440)	–	–	–
K6	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
K7	N5T/N5B-EB845	0.004 –0.008	0.004 –0.010	0.004 –0.012	0.008 –0.024	–	195 (130-330)	260 (100-490)	290 (110-550)	–	–	–
S1	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	50 (25-65)	65 (35-80)	–	–	–	65 (35-80)
S2	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	50 (25-65)	65 (35-80)	–	–	–	65 (35-80)
S3	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	50 (25-65)	65 (35-80)	–	–	–	65 (35-80)
S11	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	100 (65-165)
S12	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	100 (65-165)
S13	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	65 (50-100)	100 (50-130)	130 (65-165)	–	–	–	100 (65-165)
H3	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H5	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H7	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H8	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H11	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H12	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H21	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
H31	N5T/N5B-EB845	0.003 –0.006	0.004 –0.006	0.004 –0.008	0.008 –0.012	–	–	35 (25-50)	–	–	–	–
PM1	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	230 (130-350)	–	–	–	–
PM2	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	230 (130-350)	–	–	–	–
PM3	N5T/N5B-EB845	0.004 –0.006	0.004 –0.008	0.004 –0.008	0.008 –0.020	–	165 (100-260)	230 (130-350)	–	–	–	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – Nanojet -EB25/EB30 metric

SMG		a_p (Ø)		f		v_c			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	–
P2	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	–
P3	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	–
P4	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
P5	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
P6	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
P7	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	–
M1	N5T/N5B-EB25/EB30	0,08-0,15	0,10-0,15	0,3-0,7	0,5-1	–	25 (15-40)	35 (20-60)	–
K1	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)
K2	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	–	25 (20-40)	40 (30-70)	45 (35-80)
K3	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)
K4	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)
K5	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)
K6	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	–	60 (40-100)	80 (30-150)	90 (35-170)
K7	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	–	60 (40-100)	80 (30-150)	90 (35-170)
N1	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N2	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N3	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
N11	N5T/N5B-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	–	–	–
PM1	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	–	50 (30-80)	70 (40-100)	–
PM2	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	–	50 (30-80)	70 (40-100)	–
PM3	N5T/N5B-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	–	50 (30-80)	70 (40-100)	–

SMG = Grupa de material Seco. a_p = mm. f = mm/rev. v_c= m/min.
Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Nanojet -EB25/EB30 *inch*

SMG		a_p (Ø)		f		v_c			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–
P2	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–
P3	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (100-330)*	*260 (100-490)*	–
P4	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
P5	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
P6	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
P7	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.028*	*0.020–0.039*	*65 (35-80)*	*165 (100-265)*	*195 (100-395)*	–
M1	*N5T/N5B-EB25/EB30*	*0.003–0.006*	*0.004–0.006*	*0.012–0.028*	*0.020–0.039*	–	*80 (50-130)*	*115 (65-195)*	–
K1	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
K2	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	–	*80 (65-130)*	*130 (100-230)*	*145 (110-260)*
K3	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
K4	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*
K5	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	*80 (50-100)*	*150 (100-230)*	*230 (130-395)*	*260 (145-440)*
K6	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
K7	*N5T/N5B-EB25/EB30*	*0.004–0.008*	*0.004–0.010*	*0.012–0.035*	*0.020–0.047*	–	*195 (130-330)*	*260 (100-490)*	*290 (110-550)*
N1	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N2	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N3	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
N11	*N5T/N5B-EB25/EB30*	*0.004–0.787*	*0.004–0.012*	*0.012–0.035*	*0.020–0.047*	*165 (65-265)*	–	–	–
PM1	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	–	*165 (100-265)*	*230 (130-330)*	–
PM2	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	–	*165 (100-265)*	*230 (130-330)*	–
PM3	*N5T/N5B-EB25/EB30*	*0.004–0.006*	*0.004–0.008*	*0.012–0.035*	*0.020–0.047*	–	*165 (100-265)*	*230 (130-330)*	–

SMG = Grupa de material Seco. a_p = *inch*. f = in/rev. v_c= sf/min. Toți parametri de așchiere sunt valori de start.

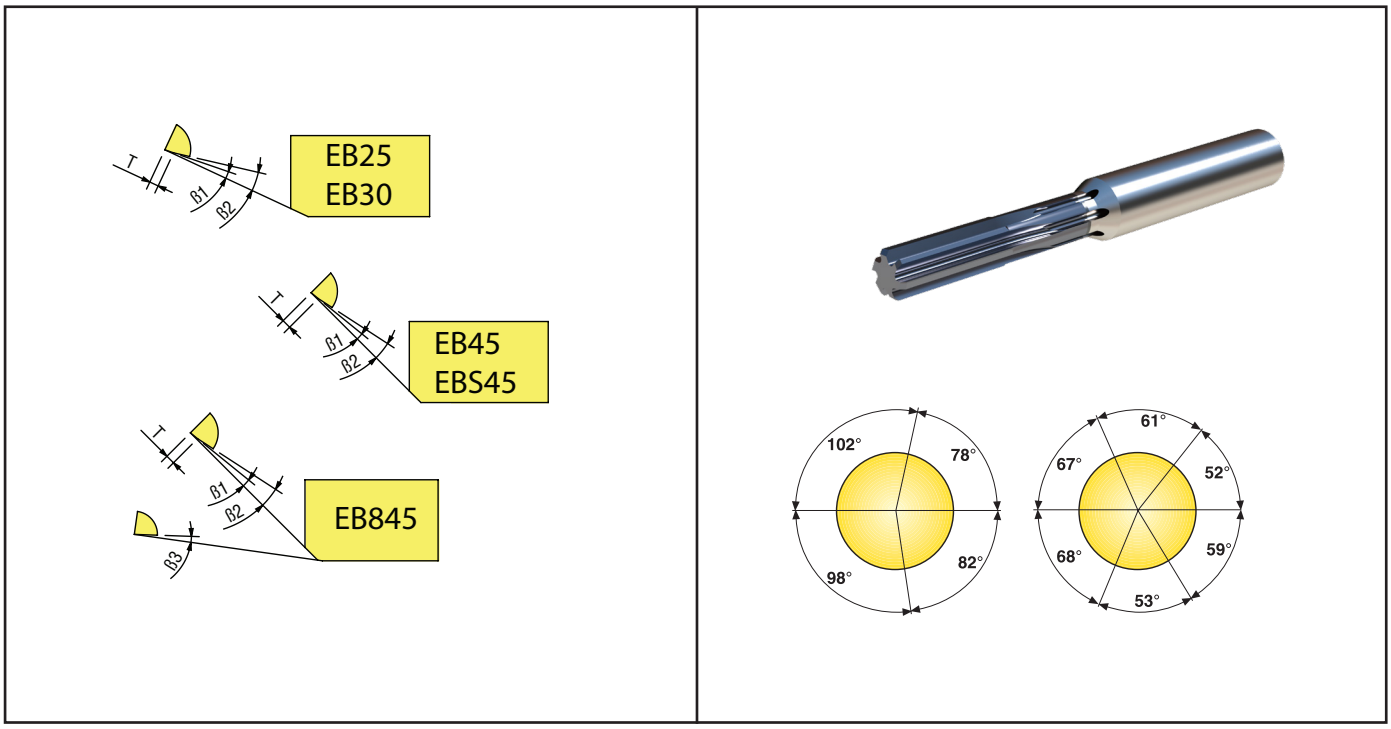
Instrucţiuni pentru reascuţire

Specificaţii

Roată diamantată pentru ascuţire
Granulaţia:
D6 pentru primul unghi de degajare (β1 - β3)
D64 pentru al doilea unghi de degajare (β2)

Important:

Reascuţirea reduce diametrul alezorului.
Reacoperirea poate duce la mărirea diametrului.
Bătaie radială la şanfrenări de intrare 10 µm *(394 µin)*.



Nanojet Ø mm *(inci)*	β_1	β_2	β_3	T mm *(inci)*
1,461-2,460 *(0.0575-0.0968")*	8°	21°	8°	0,10 *(0.004")*
2,461-2,960 *(0.0969-0.1165")*	8°	18°	8°	0,10 *(0.004")*
2,961-9,960 *(0.1166-0.3921")*	8°	18°	8°	0,15 *(0.006")*
9,961-11,960 *(0.3922-0.470")*	8°	18°	8°	0,20 *(0.008")*



Bifix®

Alezoarele cu lame amovibile Bifix® aduc performanţe de înaltă precizie pentru toate grupele de materiale de prelucrat

— Permit toleranţe între 8 și 16 µm și o finisare a suprafeţei de Ra 0,25 (RMS 12 micro/inci)
— Lamele amovibile dispun de două muchii aşchietoare per lamă
— Trei plăcuţe de ghidare cermet și un sistem de reglare precis

Privire generală

	∅ Gamă	Adâncime de alezare	Toleranţa ∅ găurii	Diametru intermediar	Finisarea suprafeţei
SR80 Pentru găuri străpunse 	6,875-60,500 mm *(0.2707-2.3819")*	5-7 x D	IT 6	Da, disponibil prin My Design	R_a 0,2-0,8 µm *(R_a 8-31 µin)*
SR81 Pentru găuri înfundate 	7,875-60,500 mm *(0.3100-2.3819")*	5-7 x D	IT 6-7	Da, disponibil prin My Design	R_a 0,2-0,8 µm *(R_a 8-31 µin)*
SR82 Gaură înfundată, versiunea scurtă 	7,875-60,500 mm *(0.3100-2.3819")*	3-5 x D	IT 6-7	Da, disponibil prin My Design	R_a 0,2-0,8 µm *(R_a 8-31 µin)*

Codificări

Alezoare

Dacă nu se cere altceva, alezoarele sunt create să producă diametrul din mijlocul toleranţei dorite.

SR80	–	16.85 P6	–	EN1	–	R	9
1		2		3		4	

0.6624”–0.6628”
2



1.
Tipul alezorului:
Tip 80: Gaură străpunsă
Tip 81: Gaură înfundată
Tip 82: Gaură înfundată, versiunea scurtă

2.
Diametrul găurii și toleranţa

3.
Tipul geometriei vârfului
EN1, EN2, EN3

4
Tip coadă prindere: (va fi precizat dacă nu este tip standard)
SR80 și SR81: R1 fără aplatizare este standard
SR82: R9 cu aplatizare este standard

Lame

Important:
Alezorul și lama trebuie să aibă aceeași geometrie.

P2	–	EN1	–	06	–	CP20
1		2		3		4

1.
Mărime alamei:
P0, P1, P2, P4

2.
Tipul geometriei vârfului
EN1, EN2, EN3

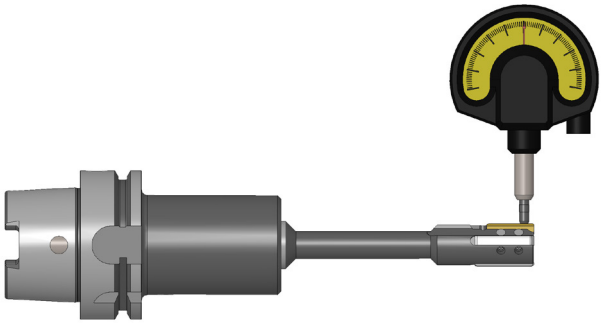
3.
Unghi de degajare:
0°, 6°, 12°

4
Calităţi de carbură:
CP20, H15

Setare și regimuri de așchiere

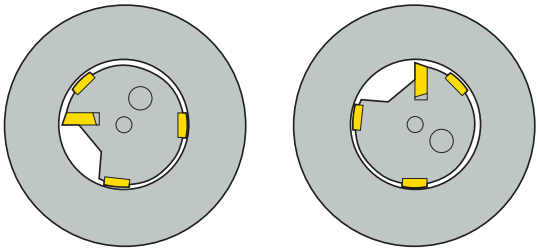
Aplicaţii dinamice

Bătaia radială maximă recomandată: 0,02 mm *(0,0008")*.
Se recomandă o portsculă de precizie: Prindere hidraulică, Mandrină cu pensete tip D, mandrină cu pensete 5672 sau fretare.



Pentru o evacuare optimă a așchiilor

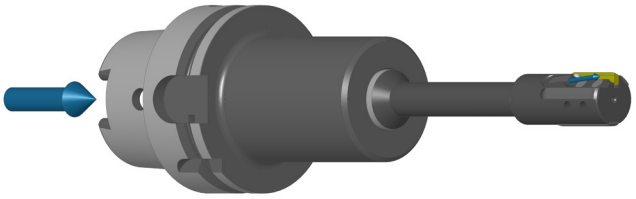
Orientarea recomandată a lamelor pentru aplicaţii statice (vezi desenul, vedere frontală a sculei).



Cerinţele lichidului de răcire

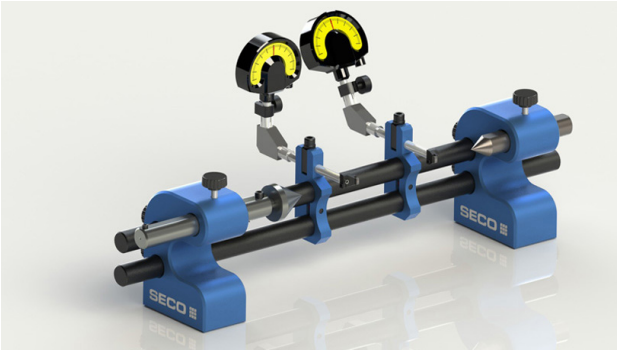
Pentru a obţine o viaţă lungă a sculei și o calitate ridicată a găurii, trebuie ţinut cont de următoarele caracteristici ale lichidului de răcire.
Se recomandă răcirea interioară. Se poate utiliza răcire externă pentru adâncimea alezajului < 2 x D. Ulei solubil de calitate cu minim 40% ulei mineral. Se recomandă ulei curat pentru oţel inoxidabil.
Filtrare 30–50 µm *(1200-2000 µin)*.
Volum min. 0,5 l/min/mm *(3,35 gal/min/inci)* din diametrul sculei.
(Ex: Alezor ∅ 10, volum min. este 5 l/min *(1,3 gal/min)*.

Presiunea recomandată a lichidului de răcire: min. 8-10 bari, max. 30 bari.



Dispozitive de reglare

SF-60200-C160C190: Nr. piesă 02885396
- Stand orizontal
- Prima alegere pentru diametru mai mic de 60 mm *(2.362")*
- 2 comparatoare
- Ø maxim al sculei: 60,5 mm *(2.382")*
- Lungime maximă a sculei: 200 mm *(7.784")*



Opţiune de geometrie – lame

Alezorul și lama trebuie să aibă aceeași geometrie.

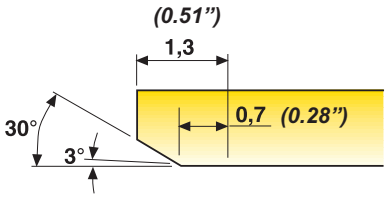
Calitate și unghi de degajare
Utilizaţi tabelele de la paginile 662-668 pentru a clasifica materialul piesei de prelucrat în SMG.

Utilizaţi tabelul de recomandări de regimuri de frezare de la pagina 408416 pentru alegerea calităţii și a unghiului de degajare.

Gama de lame se regăsește la paginile 406, 407.

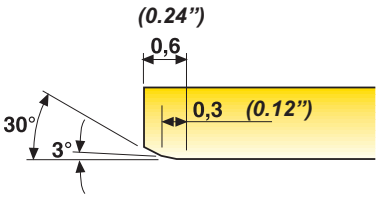
EN1 – Aplicaţie

Toleranţă de prelucrare maximă la ∅ 0,5 mm *(0,020")*
Finisarea suprafeţei + R_a 0,3 - 0,8 µm
(Finisarea suprafeţei + R_a 12 - 31 µin)



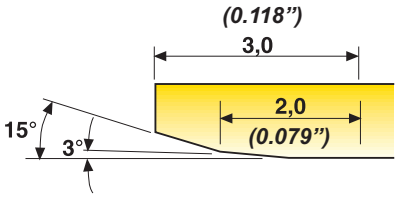
EN2 - Timp scurt de prelucrare

Toleranţă de prelucrare maximă la ∅ 0,3 mm *(0,012")*
Finisarea suprafeţei + R_a 0,4 - 1,2 µm
(Finisarea suprafeţei + R_a 16 - 47 µin)
Rată maximă de avans 0,2 mm/rot *(0,008" in/rot)*.
A se utiliza doar când este necesar un pas mic
Conceput cu așchiere finală



EN3 – Finisare de excepţie a suprafeţei

Toleranţă de prelucrare maximă la ∅ 0,5 mm *(0,020")*
Finisare a suprafeţei + R_a 0,2 - 0,6 µm
(Finisare a suprafeţei + R_a 8 - 24 µin)
Adecvat pentru toate materialele, cu excepţia aluminiului
A se utiliza când R_a trebuie să fie < 0,3-0,4 µm *(12-16 µin)*



Optimizare/Calităţi

Utilizaţi tabelul de selectare a lamelor pentru alegerea lamelor alternative pentru productivitate mai mare sau o mai bună siguranţă

Opţiuni de lame

Mărime lamei	Oţel	Oţel inoxidabil	Fontă	Neferoase	Aluminiu	Rezistenţă la uzură ⟷ Tenacitate			Denumire	
						Productivitate	Polivalenţă	Siguranţă	Lamă	Calitate
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

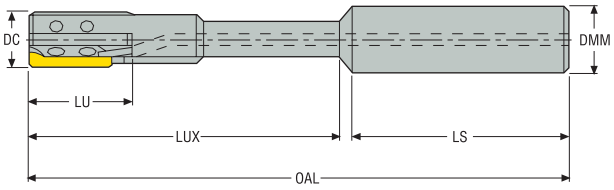
Calităţi

	**CP15**	**Acoperit** O clasă acoperită rezistentă la uzură alternativă la CP20. Pentru optimizare în fonte si oteluri. De asemenea, potrivit pentru neferoase. Ti(C, N)
	**CP20**	**Acoperite** O clasă de carbură acoperită, versatilă, potrivită pentru majoritatea materialelor, cu excepţia aluminiului. TiN
	**H15**	**Neacoperită** O clasă tenace de carbură pentru toate materialele. Potrivită pentru alezare fină datorită muchiei ascuţite.

Pentru găuri străpunse ∅ 7H6-26H6

Tip coadă R1, cilindrică fără aplatizare, SR80





—Informaţii despre lame la pagina (paginile) 406, 407
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 408-416

Denumire	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	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

Piese de schimb, Piese incluse la livrare

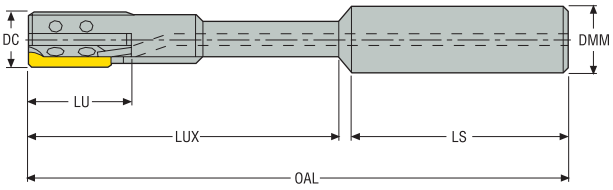
Pentru ∅ (mm)	Şurub reglaj	Bridă	Şuruburi clemă	Cheie de setare	Bilă de sprijin	Cheie dinamometrică*	Valoare cuplu
							
7-8	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–	–
9	SH2025	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
10-12	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
13-19	SH2540	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509	0,9 Nm
20-60	SH3060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Cheia dinamometrică este livrată împreună cu lama de antrenare

Pentru găuri străpunse ∅ 27H6–60H6

Tip coadă R1, cilindrică fără aplatizare, SR80





—Informaţii despre lame la pagina (paginile) 406, 407
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 408–416

Denumire	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	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

Piese de schimb, Piese incluse la livrare

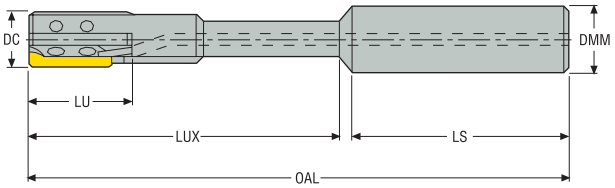
Pentru ∅ (mm)	Şurub reglaj	Bridă	Şuruburi clemă	Cheie de setare	Bilă de sprijin	Cheie dinamometrică*	Valoare cuplu
							
20-60	4060	SR-B5	LH4010	2SMS795	BB3.0	–	2,0 Nm

Cheia dinamometrică este livrată împreună cu lama de antrenare

Pentru găuri străpunse – Diametru intermediar

Tip coadă R1, cilindrică fără aplatizare, SR80





—Informaţii despre lame la pagina (paginile) 406, 407
—Important! Alezorul și lama trebuie să aibă aceeași geometrie
—Pentru alegerea geometriei de atac EN1, EN2 sau EN3 vezi pag. 397
—Regimuri de așchiere, vezi pagina(paginile) 408–416

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	mm	mm	mm	mm	mm	mm	
SR80-6.875-XX-XXXX-EN	6,875 - 7,874	105,0	40,0	63,0	15,0	10,0	P0-EN-xx
SR80-7.875-XX-XXXX-EN	7,875 - 8,749	115,0	40,0	73,0	25,0	10,0	P0-EN-xx
SR80-8.750-XX-XXXX-EN	8,75 - 9,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR80-9.750-XX-XXXX-EN	9,75 - 10,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR80-10.750-XX-XXXX-EN	10,75 - 12,749	133,0	48,0	81,0	25,0	16,0	P1-EN-xx
SR80-12.750-XX-XXXX-EN	12,75 - 16,749	133,0	48,0	81,0	25,0	16,0	P2-EN-xx
SR80-16.750-XX-XXXX-EN	16,75 - 19,499	155,0	50,0	100,0	25,0	20,0	P2-EN-xx
SR80-19.500-XX-XXXX-EN	19,5 - 20,499	155,0	50,0	100,0	30,0	20,0	P4-EN-xx
SR80-20.500-XX-XXXX-EN	20,5 - 26,499	191,0	56,0	129,0	30,0	25,0	P4-EN-xx
SR80-26.500-XX-XXXX-EN	26,5 - 32,499	221,0	56,0	160,0	30,0	25,0	P4-EN-xx
SR80-32.500-XX-XXXX-EN	32,5 - 38,499	226,0	56,0	165,0	30,0	25,0	P4-EN-xx
SR80-38.500-XX-XXXX-EN	38,5 - 40,499	226,0	56,0	166,0	30,0	25,0	P4-EN-xx
SR80-40.500-XX-XXXX-EN	40,5 - 44,499	226,0	56,0	167,0	30,0	25,0	P4-EN-xx
SR80-44.500-XX-XXXX-EN	44,5 - 50,499	226,0	56,0	168,0	30,0	25,0	P4-EN-xx
SR80-50.500-XX-XXXX-EN	50,5 - 60,5	226,0	56,0	169,0	30,0	25,0	P4-EN-xx

Piese de schimb, Piese incluse la livrare

Accesorii

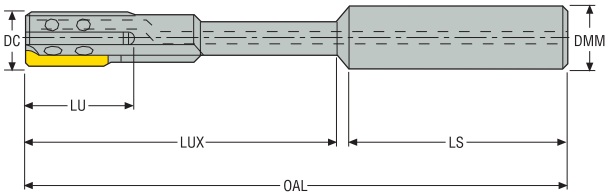
Pentru ∅ (mm)	Șurub reglaj	Clemă	Șurub clemă	Cheie de reglare	Bilă suport	Cheie dinamometrică
						
6,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–
8,750-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305
9,750-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,750-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.0	H00-1509
19,500-60,500	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020

Cheia dinamometrică este livrată împreună cu lama de antrenare
Reţineţi! Când comandaţi alezoare pentru diametru intermediar, vă rugăm să precizaţi: ∅ și toleranţa alezajului de alezat, geometria plăcuţei (EN1, EN2 sau EN3).
Exemplu comandă: SR80-11.50 H7-EN2, P1-EN2-06, CP20.

Pentru găuri înfundate ∅ 8H6-26H6

Tip coadă R1, cilindrică fără aplatizare, SR81





—Informaţii despre lame la pagina (paginile) 406, 407
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 408–416

Denumire	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	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

Piese de schimb, Piese incluse la livrare

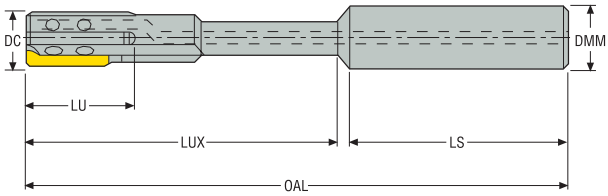
Pentru ∅ (mm)	Şurub reglaj	Bridă	Şuruburi clemă	Cheie de setare	Bilă de sprijin	Cheie dinamometrică*	Valoare cuplu
							
8	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–	–
9	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
10-12	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
13-19	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509	0,9 Nm
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Cheia dinamometrică este livrată împreună cu lama de antrenare

Pentru găuri înfundate ∅ 27H6–60H6

Tip coadă R1, cilindrică fără aplatizare, SR81





—Informaţii despre lame la pagina (paginile) 406, 407
—Agent de răcire intern
—Regimuri de aşchiere, vezi pagina(paginile) 408-416

Denumire	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	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

Piese de schimb, Piese incluse la livrare

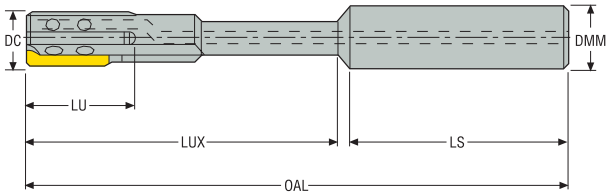
Pentru ∅ (mm)	Şurub reglaj	Bridă	Şuruburi clemă	Cheie de setare	Bilă de sprijin	Cheie dinamometrică*	Valoare cuplu
							
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

Cheia dinamometrică este livrată împreună cu lama de antrenare

Pentru găuri înfundate – Diametru intermediar

Tip coadă R1, cilindrică fără aplatizare, SR81





—Informaţii despre lame la pagina (paginile) 406, 407
—Important! Alezorul și lama trebuie să aibă aceeași geometrie
—Pentru alegerea geometriei de atac EN1, EN2 sau EN3 vezi pag. 397
—Regimuri de așchiere, vezi pagina(paginile) 408–416

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	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

Piese de schimb, Piese incluse la livrare

Accesorii

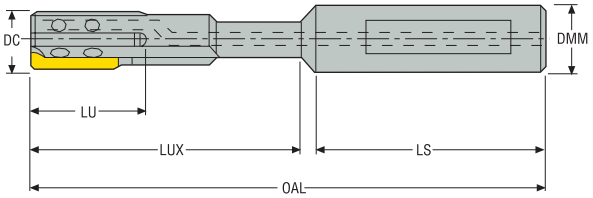
Pentru ∅ (mm)	Șurub reglaj	Clemă	Șurub clemă	Cheie de reglare	Bilă suport	Cheie dinamometrică
						
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	–
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020

Cheia dinamometrică este livrată împreună cu lama de antrenare
Reţineţi! Când comandaţi alezoare pentru diametru intermediar, vă rugăm să precizaţi: ∅ și toleranţa alezajului de alezat, geometria plăcuţei (EN1, EN2 sau EN3).
Exemplu comandă: SR81-11.50 H7-EN2, P1-EN2-06, CP20.

Pentru găuri înfundate – Gama scurtă pentru aplicaţii de strunjire

Tip coadă R9, cilindrică cu aplatizare, SR82





—Informaţii despre lame la pagina (paginile) 406, 407
—Important! Alezorul și lama trebuie să aibă aceeași geometrie
—Pentru alegerea geometriei de atac EN1, EN2 sau EN3 vezi pag. 397
—Regimuri de așchiere, vezi pagina(paginile) 408–416

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Mărime lamei
	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

Piese de schimb, Piese incluse la livrare

Accesorii

Pentru ∅ (mm)	Șurub reglaj	Clemă	Șurub clemă	Cheie de reglare	Bilă suport	Cheie dinamometrică
						
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
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

Cheia dinamometrică este livrată împreună cu lama de antrenare
Reţineţi! Când comandaţi alezoare pentru diametru intermediar, vă rugăm să precizaţi: ∅ și toleranţa alezajului de alezat, geometria plăcuţei (EN1, EN2 sau EN3).
Exemplu comandă: SR82-11.50 H7EN2, P1-EN2-06, CP20.

P0-P4 Lame



Reper Nr.	Plăcuţă amovibilă	L	S	W1	Calităţi	
		mm *Inci*	mm *Inci*	mm *Inci*	H15	CP20
P0-EN1-0	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098229	00098244
P0-EN1-06	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00091786	00091762
P0-EN1-12	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00097299	00091971
P0-EN2-0	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098234	00098249
P0-EN2-06	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098160	00098170
P0-EN2-12	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098165	00098175
P0-EN3-0	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098239	00098254
P0-EN3-06	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098185	00098195
P0-EN3-12	P0	20 *0.787*	1,2 *0.047*	2,5 *0.098*	00098190	00098200
P1-EN1-0	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098230	00098245
P1-EN1-06	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00091787	00091764
P1-EN1-12	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00097300	00091972
P1-EN2-0	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098235	00098250
P1-EN2-06	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098161	00098171
P1-EN2-12	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098166	00098176
P1-EN3-0	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098240	00098255
P1-EN3-06	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098186	00094702
P1-EN3-12	P1	20 *0.787*	1,5 *0.059*	3,0 *0.118*	00098191	00098201
P2-EN1-0	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098231	00098246
P2-EN1-06	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00091788	00091765
P2-EN1-12	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00097301	00091973
P2-EN2-0	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098236	00098251
P2-EN2-06	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098162	00098172
P2-EN2-12	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098167	00098177
P2-EN3-0	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098241	00098256
P2-EN3-06	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098187	00098197
P2-EN3-12	P2	20 *0.787*	2,0 *0.079*	4,5 *0.177*	00098192	00098202
P4-EN1-0	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098232	00098247
P4-EN1-06	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00091789	00091766
P4-EN1-12	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098128	00091974

Reper Nr.	Plăcuţă amovibilă	L	S	W1	Calităţi	
		mm *Inci*	mm *Inci*	mm *Inci*	H15	CP20
P4-EN2-0	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098237	00098252
P4-EN2-06	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098163	00098173
P4-EN2-12	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098168	00098178
P4-EN3-0	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098242	00098257
P4-EN3-06	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098188	00098198
P4-EN3-12	P4	25,0 *0.984*	2,3 *0.091*	7,0 *0.276*	00098193	00098203

Parametri de așchiere – Pxx-EN1/EN2-00 metric

SMG		a_p (Ø)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	–
P6	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	–
P7	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	–
K1	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K2	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	35 (25-50)	50 (25-70)
K3	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K4	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K5	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K6	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K7	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
PM1	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	–
PM2	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	–
PM3	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	–

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Pxx-EN1/EN2-00 *inch*

SMG		a_p (Ø)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	*Pxx-EN1/EN2-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P6	*Pxx-EN1/EN2-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P7	*Pxx-EN1/EN2-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
K1	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K2	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*115 (80-165)*	*165 (80-230)*
K3	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K4	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K5	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K6	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K7	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
PM1	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM2	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM3	*Pxx-EN1/EN2-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – Pxx-EN1/EN2-06 metric

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M4	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
M5	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
K1	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K2	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	35 (25-50)	50 (25-70)
K3	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K4	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K5	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K6	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K7	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
N11	Pxx-EN1/EN2-06	0,10-0,30	0,20-0,50	0,10-0,30	65 (50-150)	90 (70-150)	-
S1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
S2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
S3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
PM1	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Pxx-EN1/EN2-06 *inch*

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P3	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P4	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P5	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P6	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P7	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P8	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P11	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P12	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	*150 (100-180)*
M1	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M2	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M3	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M4	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
M5	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
K1	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	*395 (260-490)*
K2	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*115 (80-165)*	*165 (80-230)*
K3	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	*395 (260-490)*
K4	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	*295 (260-330)*
K5	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	*295 (260-330)*
K6	*Pxx-EN1/EN2-06*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-150)*	*295 (230-490)*	–
K7	*Pxx-EN1/EN2-06*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-150)*	*295 (230-490)*	–
N11	*Pxx-EN1/EN2-06*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-150)*	*295 (230-490)*	–
S1	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S2	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S3	*Pxx-EN1/EN2-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
PM1	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM2	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM3	*Pxx-EN1/EN2-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – Pxx-EN1/EN2-12 metric

SMG		a_p (Ø)		f	v_c		
		– Ø < 9	– Ø ≥ 9		– H15	– CP20	– CP15
P1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M4	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
M5	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
K1	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	90 (80-100)	–
K3	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	90 (80-100)	–
K4	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	70 (60-80)	–
K5	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	70 (60-80)	–
N11	Pxx-EN1/EN2-12	0,10-0,30	0,20-0,50	0,10-0,30	65 (50-150)	90 (70-150)	–
S1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
S2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
S3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
PM1	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–
PM2	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–
PM3	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–

SMG = Grupa de material Seco. a_p = mm. f = mm/rev. v_c= m/min.
Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Pxx-EN1/EN2-12 *inch*

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P3	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P4	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P5	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P6	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P7	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P8	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P11	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P12	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	*150 (100-180)*
M1	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M2	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M3	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*115 (80-130)*	*115 (80-130)*
M4	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
M5	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*65 (50-100)*	*100 (80-130)*	*100 (80-130)*
K1	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K3	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K4	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
K5	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
N11	*Pxx-EN1/EN2-12*	*0.004–0.012*	*0.008–0.020*	*0.004–0.012*	*215 (165-490)*	*295 (230-490)*	–
S1	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S2	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
S3	*Pxx-EN1/EN2-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	*80 (50-100)*	–
PM1	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM2	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM3	*Pxx-EN1/EN2-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–

SMG = Grupa de material Seco. a_p = *inch*. f = in/rev. v_c= sf/min. Toţi parametri de așchiere sunt valori de start.

Parametri de așchiere – Pxx-EN3-00 metric

SMG		a_p (Ø)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P6	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P7	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
K1	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K2	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	35 (25-50)	50 (25-70)
K3	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K4	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K5	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K6	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K7	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
PM1	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM2	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM3	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toţi parametri de aşchiere sunt valori de start

Parametri de aşchiere – Pxx-EN3-00 *inch*

SMG		a_p (Ø)		f	v_c	
		Ø < 9	Ø ≥ 9		CP20	CP15
P5	*Pxx-EN3-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P6	*Pxx-EN3-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
P7	*Pxx-EN3-00*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-165)*	–
K1	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K2	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*115 (80-165)*	*165 (80-230)*
K3	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K4	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K5	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*230 (195-260)*	*295 (260-330)*
K6	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
K7	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*295 (260-330)*	*395 (260-490)*
PM1	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM2	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–
PM3	*Pxx-EN3-00*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	*165 (80-230)*	–

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toţi parametri de aşchiere sunt valori de start.

Parametri de așchiere – Pxx-EN3-06 metric

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M2	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M3	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M4	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	30 (25-40)
M5	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	30 (25-40)
K1	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K2	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	35 (25-50)	50 (25-70)
K3	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K4	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K5	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K6	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K7	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
PM1	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Pxx-E3-06 *inch*

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	**395 (295-490)**
P3	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	**395 (295-490)**
P4	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P5	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P6	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P7	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	**260 (195-330)**
P8	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	**195 (130-230)**
P11	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	**195 (130-230)**
P12	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	**150 (100-180)**
M1	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**115 (80-130)**
M2	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**115 (80-130)**
M3	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**115 (80-130)**
M4	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**100 (80-130)**
M5	*Pxx-EN3-06*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	–	–	**100 (80-130)**
K1	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
K2	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*115 (80-165)*	**165 (80-230)**
K3	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
K4	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	**295 (260-330)**
K5	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	**295 (260-330)**
K6	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
K7	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	**395 (260-490)**
PM1	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	**–**
PM2	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	**–**
PM3	*Pxx-EN3-06*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	**–**

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – Pxx-EN3-12 metric

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
K1	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	-
K3	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	-
K4	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	-
K5	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	-
PM1	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

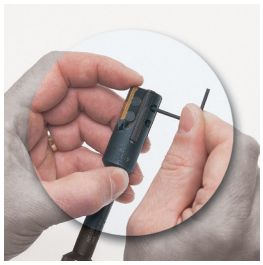
Toți parametri de așchiere sunt valori de start

Parametri de așchiere – Pxx-EN3-12 *inch*

SMG		a_p (Ø)		f	v_c		
		Ø < 9	Ø ≥ 9		H15	CP20	CP15
P1	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P2	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P3	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*130 (100-195)*	*345 (295-395)*	*395 (295-490)*
P4	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P5	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P6	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P7	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*115 (80-130)*	*195 (130-230)*	*260 (195-330)*
P8	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P11	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*100 (80-130)*	*165 (100-195)*	*195 (130-230)*
P12	*Pxx-EN3-12*	*0.004–0.006*	*0.004–0.008*	*0.004–0.012*	*80 (65-100)*	*130 (80-150)*	*150 (100-180)*
K1	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K3	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*295 (260-330)*	–
K4	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
K5	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*230 (195-260)*	–
PM1	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM2	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–
PM3	*Pxx-EN3-12*	*0.004–0.008*	*0.004–0.012*	*0.004–0.012*	–	*165 (80-230)*	–

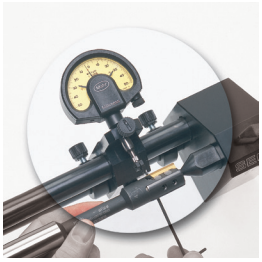
SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Instrucţiuni de reglare

1.		Slăbește cele două șuruburi de reglaj (7) cu 1/4 tură.
2.		Slăbiţi cele două şuruburi (5).
3.		Curăţă bine locașul lamei apoi reașază lama folosită (2) sau înlocuiește-o.
4.		Firmly push the blade against the axial end stopand the adjustment balls (6).
5.		Strânge şurubul de fixare cu grijă. (Ține cheia de partea ei scurtă pentru un cuplu corect).
6.		Reglează micrometrul la zero folosind partea dorsală cilindrică a ghidajelor (3).

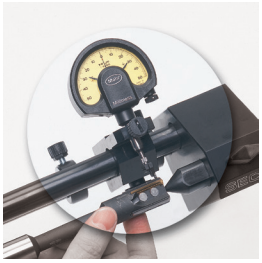
Instrucţiuni de reglare

7.



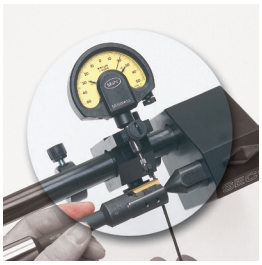
Setaţi capătul posterior a lamei la un diametru astfel încât să obţineţi o conicitate inversă de 0,01 mm/10 mm *(0,0004" la fiecare 0,394")* din lungimea lamei (a se vedea fig. 2).

8.



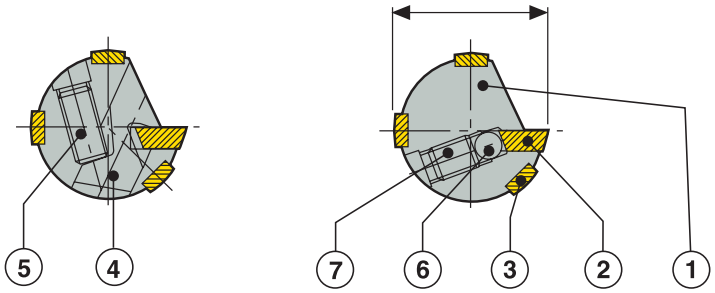
Reglează micrometrul la zero folosind partea frontală cilindrică a ghidajelor (3).

9.



Reglaţi partea frontală a lamei la 0,02 mm sau 0,015 mm *(0,0008" or 0,0006")* deasupra ghidajelor (3) comparator A, a se vedea fig. 1.
Verifică încă o dată valoarea înclinaţiei (pasul 6 și 7) ceas B.

10.



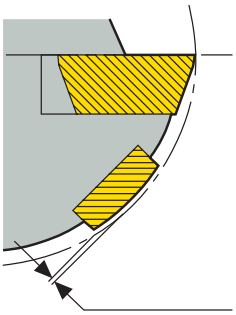


fig. 1

0,015 mm (∅ ≤ 10 mm)
0,020 mm (∅ >10 mm)
Valoarea comparatorului A pentru setarea diametrului
0,0006" (∅ ≤ 0,394")
0,0008" (∅ > 0,394")
Valoarea comparatorului A pentru setarea diametrului

Notă: Dacă diametrul dorit este depășit la reglare, începeţi încă o dată de la început pentru a elimina jocul șurubului de reglare.

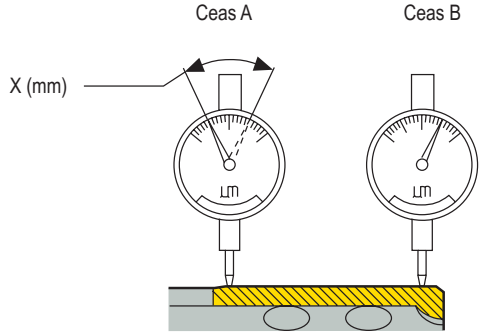


fig. 2

- Unitate comparator = 1 µm *(39 µin)*
- Valorile comparatoarelor faţă și spate valide după reglarea la zero pe un ghidaj adiacent
- Valorile comparatorului spate calculate pentru o conicitate inversă de 1 µm/mm *(0,00004")* de lamă

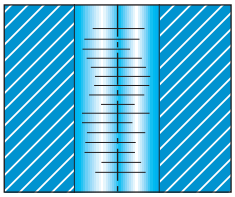
Grafic de setare

Interval de diametre mm *(inci)*	Mărimea lamei	Comparator faţă A	Comparator spate B
6,875-8,749 *(0,271-0,344")*	P0	+15	-5
8,750-10,000 *(0,344-0,394")*	P1	+15	-5
10,001-12,749 *(0,394-0,502")*	P1	+20	0
12,750-19,499 *(0,502-0,768")*	P2	+20	0
19,500-60,500 *(0,768-2,382")*	P4	+20	0

Depanare

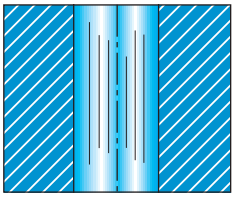
Finisare slabă a suprafeţei

– Verificaţi toleranţele materialului
– Îmbunătăţiţi condiţiile lichidului de răcire (tipul ieşirii, presiunea, calitatea)
– Reduceţi rata avansului
– Schimbaţi lama (geometrie incorectă a vârfului sau unghi de degajare incorect)
– Verificaţi poziţionarea axială a lamei



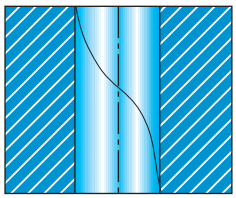
Faţete

– Îmbunătățește centrarea (piesă/sculă)
– Mărește conicitatea inversă



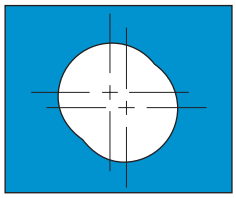
Urme de retragere

– Îmbunătăţiţi condiţiile lichidului de răcire (tipul ieşirii, presiunea, calitatea)
– Îmbunătăţiţi centrarea (piesă/sculă)
– Măriţi conicitatea inversă



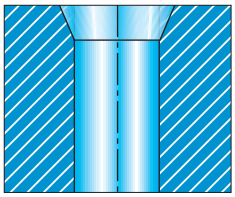
Excentricitate/Ovalitate

– Îmbunătățește prinderea (deformarea piesei de lucru)
– Verifică adaosul de prelucrare
– Îmbunătățește centrarea (piesă/sculă)
– Verifică poziţionarea axială a lamei



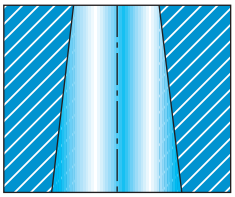
Intrare conică

– Micșorează avansul
– Îmbunătățește centrarea (piesă/sculă)
– Micșorează bătaia radială
– Reduceţi bătaia radială



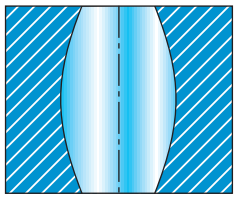
Gaură conică

– Îmbunătățește centrarea (piesă/sculă)
– Verifică conicitatea inversă



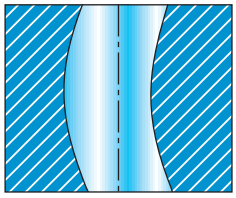
Gaură deformată

– Îmbunătăţiţi prinderea (deformarea piesei de lucru)



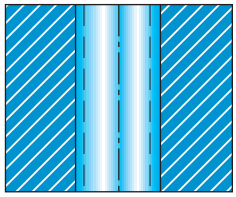
Gaură curbă

– Schimbă lama (geometrie greșită a vârfului)
– Verifică poziţionarea axială a lamei



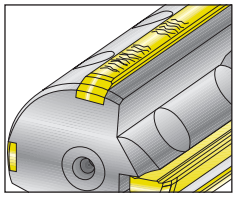
Diametru prea mare

– Îmbunătățește centrarea (piesă/sculă)
– Reglează diametrul (prea mare)



Aderenţe pe ghidaje

– Îmbunătățește condițiile de răcire (tipul ieșirii, presiunea, calitatea)
– Reglează diametrul (prea mic)





Xfix™

Alezoarele Xfix™ de diametru mare, cu mai mulţi dinţi, contribuie la obţinerea celor mai înalte performanţe și precizii posibile în realizarea găurilor.

- Adâncimi de așchiere de până la 6,5xD cu un interval de diametre de la 9,5 până la 154,5 mm (2.03’-6.083’)
- Ușor și rapid de reglat, este necesar un singur șurub per dinte pentru a seta diametrul
- Sistem de reglare precis pentru a obţine toleranţe mici între 16 și 25 µm (0,0006-0,0010’)
- Plăcuţe care au fie patru, fie opt muchii numerotate

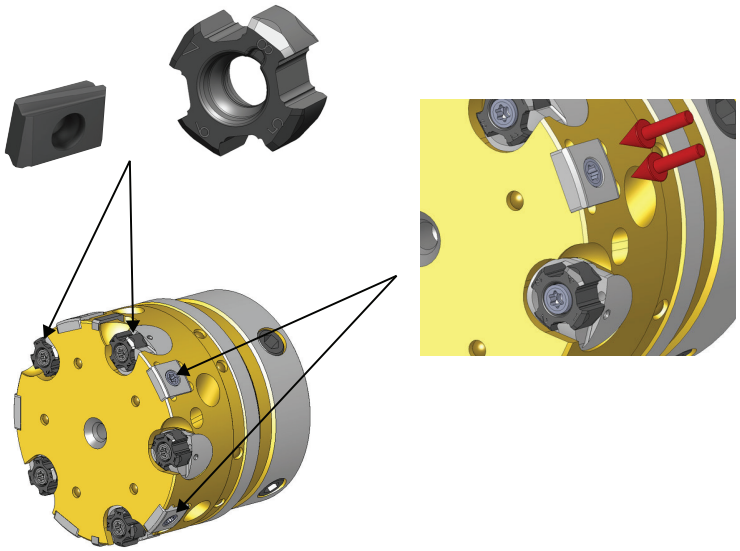
Privire generală

	∅ Gamă	Adâncime de alezare	Toleranţa ∅ găurii	Diametru intermediar	Finisarea suprafeţei
Xfix™ 	39,500-154,500 mm *(1.5551-6.0827")*	2,5-6,5 x D	IT 6	Da, disponibil la cerere	R_a 0,8-1,2 µm *(R_a 31-47 µin)*

Xfix™ este un program de alezare Seco special dezvoltat, dedicat pentru dimensiuni mari de ∅ 39,5 – 154,5 mm *(1.555" – 6.083")*.
Designul include plăcuţe reglabile şi indexabile pentru a obţine o toleranţă IT6, precum şi un adaptor reglabil a bătăii radiale încorporat pentru a garanta calitatea componentelor.
Construcţie cu mai mulţi dinţi şi plăcuţe de ghidare pre-încărcate brevetate, care oferă stabilitate şi productivitate maximă pentru operaţiuni cu ∅ mari de alezare.

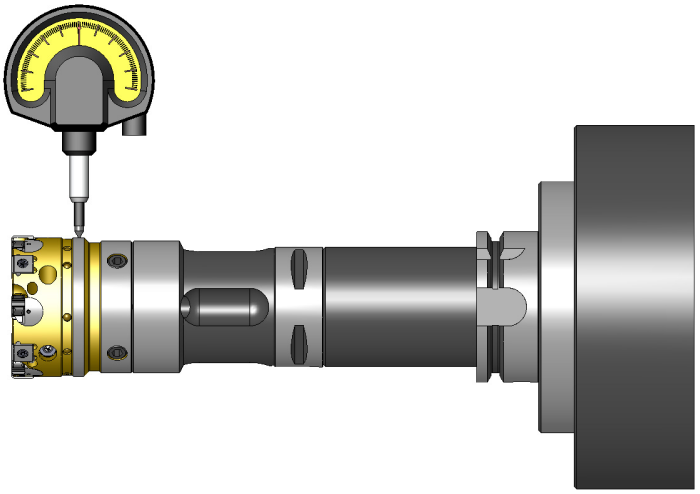
Caracteristici - detalii

- 4 sau 8 muchii de așchiere pentru optimizare pentru toate materialele
- Sistem de prindere stabil
- Ajustare ușoară cu 1 șurub de reglaj pentru ajustare simplă
- Opțiuni de calitate și geometrie pentru aplicații diferite

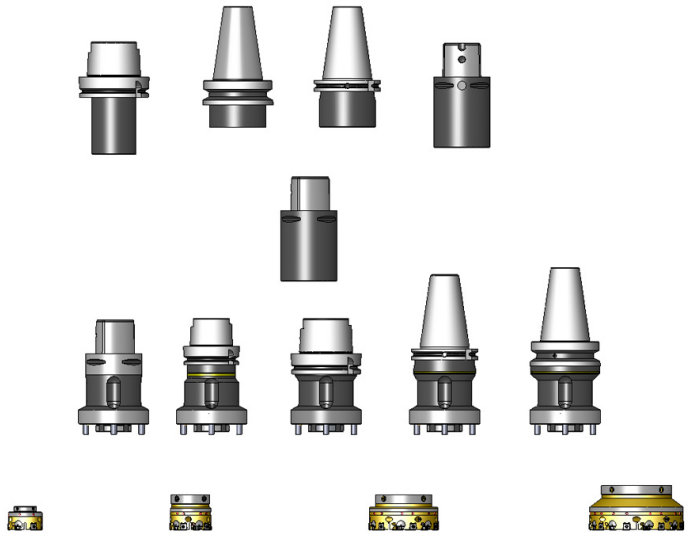


- Mansoane de ghidare pre-reglate brevetate pentru stabilitatea aplicației
- Lubrifierea ghidajelor pentru performanță și siguranță

- Adaptor ajustabil integrat pentru controlul bătăii radiale



- Gama de cozi și extensii din catalogul de port-scule al Seco oferă modularitate maximă



Codificări

Adaptoare

HF55	–	088	–	C5
1		2		3



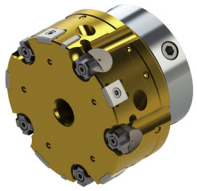
1. Lungimea flanșei

2. Lungimea

3. Tip de coadă

Capete standard

HF85	–	60H6	–	05	–	55
1		2		3		4



1. Tip Cap

2. Diametre și toleranțe

3. Număr de dinți

4. Mărimea flanșei D

Capete intermediare

HF85	–	65.2G7	–	05	–	55
1		2		3		4

1. Tip Cap

2. Diametre și toleranțe

3. Număr de dinți

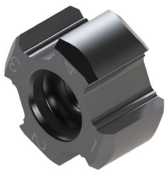
4. Mărimea flanșei D

Informaţii despre tipul capului:

- HF85, alezaj străpuns, materiale cu aşchii scurte
- HF85B, alezaj înfundat, materiale cu aşchii scurte
- HF86, alezaj străpuns, toate materialele
- HF86B, alezaj înfundat, toate materialele

Plăcuţe amovibile

RNAX1005	–	EB45	–	03	–	RX2000
1		2		3		4



Plăcuţă RNAX pentru capete Xfix HF85 și HF 85B

1. Dimens. plăcuţă

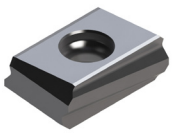
2. Geometria vârfului

3. Unghi de degajare

4. Calitate

Plăcuţe amovibile

LNEG	–	EB45	–	06	–	RX2000
1		2		3		4



Plăcuţe LNEG pentru capete Xfix HF86 și HF86B

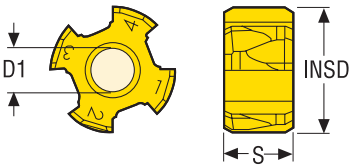
1. Dimens. plăcuţă

2. Geometria vârfului

3. Unghi de degajare

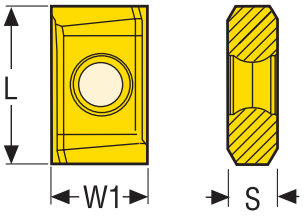
4. Calitate

RNAX



Reper Nr.	Plăcuţe amovibile	INSD	S	D1	Calităţi		Unghi de aşchiere
		mm *Inci*	mm *Inci*	mm *Inci*	RX1500	RX2000	
RNAX1005-EB1570-03	RNAX	10,0 *0,394*	5,5 *0,217*	3,5 *0,138*	02687601	02687603	3 °
RNAX1005-EB45-03	RNAX	10,0 *0,394*	5,5 *0,217*	3,5 *0,138*	02687600	02688608	3 °
RNAX1005-EB845-03	RNAX	10,0 *0,394*	5,5 *0,217*	3,5 *0,138*	02687593	02688606	3 °

LNEG

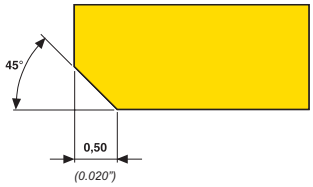


Reper Nr.	Plăcuţe amovibile	L	S	W1	Calităţi			Unghi de aşchiere
		mm *Inci*	mm *Inci*	mm *Inci*	RX1500	RX2000	CF	
LNEG1003-EB45-03	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*		02781311		3 °
LNEG1003-EB45-06	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*	02904277	02781313	02904276	6 °
LNEG1003-EB845-03	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*		02781314		3 °
LNEG1003-EB845-06	LNEG	10,0 *0,394*	3,5 *0,138*	6,35 *0,25*		02781315		6 °

Geometria vârfului

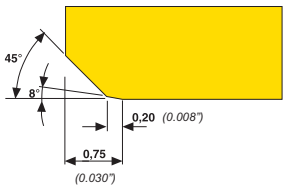
Geometria vârfului EB45 – aplicaţie

Controlul asupra formării aşchiilor +++
Finisarea suprafeţei + R_a 1,2 - 2 µm
(Finisarea suprafeţei + R_a 0,047 - 0,0787 µin)
Prima alegere pentru geometrie



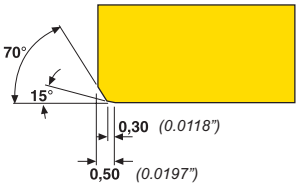
Geometria vârfului EB845 – aplicaţie

Controlul asupra formării aşchiilor ++
Finisarea suprafeţei +++ R_a 0,4 - 1,2 µm
(Finisarea suprafeţei +++ R_a 0,0157 - 0,047 µin)



Geometria vârfului EB1570 – aplicaţie

Controlul asupra formării aşchiilor ++
Finisarea suprafeţei ++ R_a 0,8 - 1,6 µm
(Finisarea suprafeţei ++ R_a 0,031 - 0,0630 µin)
Stabilitate pentru aplicaţii cu rază lungă +++

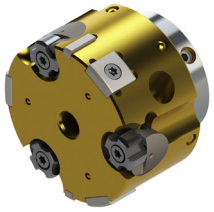


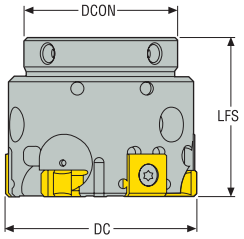
Calităţi

	**RX1500**	**Cermet acoperit** O clasă rezistentă la uzură pentru optimizarea performanţei în oţel şi fontă.
	**RX2000**	**Acoperire** De înaltă performanţă, potrivită pentru toate materialele.
	**CF**	**Cermet** O clasă rezistentă la uzură pentru optimizarea performanţei în oţel.

HF85

Capete pentru plăcuţe RNAX, alezaj străpuns ∅ 39,5-59,499 mm / 1.555-2.342"





—Pentru plăcuţe, calităţi şi geometrii, consultaţi pag. 424-425
—Regimuri de aşchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	RNAX1005...
HF85-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	RNAX1005...
HF85-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	RNAX1005...
HF85-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85 03-32	SH4075S	CARTCYHF16	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

Accesorii

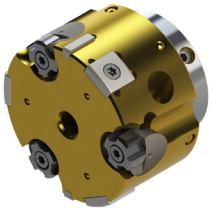
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85 03-32	H00-2020	T00-09P20

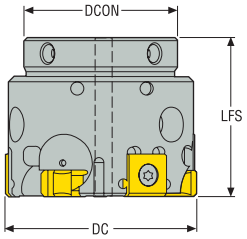
Notă:
Şurubelniţă dinamometrică H00-2020 pentru şuruburile de prindere
Şurubelniţă dinamometrică T00-09P20 pentru şuruburile plăcuţei

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF85B

Capete pentru plăcuţe RNAX, alezaj înfundat ∅ 39,5-59,499 mm / 1.555-2.342”





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85B-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	RNAX1005...
HF85B-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	RNAX1005...
HF85B-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	RNAX1005...
HF85B-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 03-32	SH4075S	CARTCYHF16B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

Accesorii

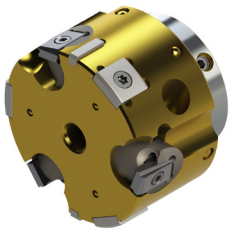
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 03-32	H00-2020	T00-09P20

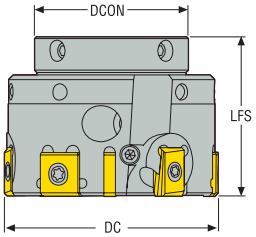
Notă:
Șurubelniță dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniță dinamometrică T00-09P20 pentru șuruburile plăcuței

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86

Capete pentru plăcuţe LNEG, alezaj străpuns ∅ 39,5-59,499 mm / 1.555-2.342"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	LNEG1003...
HF86-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	LNEG1003...
HF86-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	LNEG1003...
HF86-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86 03-32	SH4075S	CARTCYLN16	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

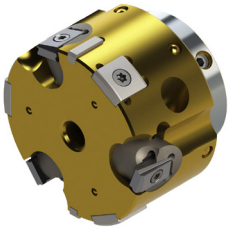
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86 03-32	H00-2020	T00-07P09

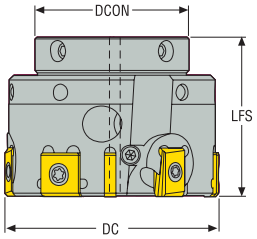
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-07P09 pentru șuruburile plăcuţei

Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86B

Capete pentru plăcuţe LNEG, alezaj înfundat ∅ 39,5-59,499 mm / 1.555-2.342"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86B-39.5/44.499-03-32	39,5 *1.555*	44,499 *1.752*	33,0 *1.299*	32,0 *1.260*	0,41 *0.900*	3	LNEG1003...
HF86B-44.5/49.499-03-32	44,5 *1.752*	49,499 *1.949*	33,0 *1.299*	32,0 *1.260*	0,51 *1.120*	3	LNEG1003...
HF86B-49.5/54.499-03-32	49,5 *1.949*	54,499 *2.146*	33,0 *1.299*	32,0 *1.260*	0,62 *1.370*	3	LNEG1003...
HF86B-54.5/59.499-03-32	54,5 *2.146*	59,499 *2.342*	33,0 *1.299*	32,0 *1.260*	0,74 *1.630*	3	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86B 03-32	SH4075S	CARTCYLN16B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86B 03-32	H00-2020	T00-07P09

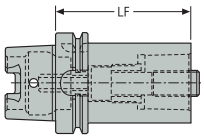
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-07P09 pentru șuruburile plăcuţei

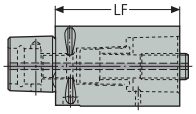
Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF32

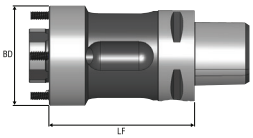
Coadă Seco Capto™ pentru ∅ 39,5-59,499 mm



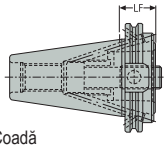




Extensie



Suport alezor



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF32-050-C3	02688610	–	50	C3	32	0,3
HF32...HSKA63	–	65	245	HSK-A63	32	0,0
HF32...HSKA80	–	100	209	HSK-A80	32	0,0
HF32...HSKA100	–	70	245	HSK-A100	32	0,0
HF32...DIN40ADB	–	60	252	DIN40ADB	32	0,0
HF32...DIN50ADB	–	60	317	DIN50ADB	32	0,0
HF32...BT40ADB	–	65	252	BT40ADB	32	0,0
HF32...BT50ADB	–	75	317	BT50ADB	32	0,0

Cozi și extensii pentru HF32-050-C3 (consultați Seco Tooling Systems pentru mai multe detalii).

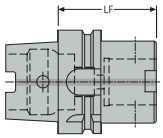
Reper Nr. Coada	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
HA10-C3-032-080	10197961	80	HSK-A100	C3	2,5
HA06-C4-040-080	10197964	80	HSK-A63	C4	1,1
C3-390B.140-40030	02924104	30	DIN40	C3	0,8
C3-390B.55-40030	02925959	30	BT40	C3	1,0
C3-390B.55-40060	02925960	60	BT40	C3	1,1
C3-390B.140-50030	02924106	30	DIN50	C3	2,6
C3-390B.140-50060	02924107	60	DIN50	C3	2,7
C3-390B.58-50040	02925961	40	BT50	C3	3,5
C3-390B.58-50070	02925962	70	BT50	C3	3,7

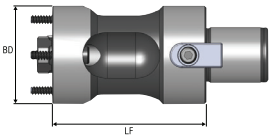
Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
C3-391.01-32060A	75039884	–	C3	C3	0,4
C3-391.01-32080A	00090847	–	C3	C3	0,5
C4-391.02-32055A	75039889	–	C4	C3	0,42
C4-391.02-32070A	02535687	–	C4	C3	0,56
C5-391.02-32060A	75039890	–	C5	C3	0,7
C6-391.02-32070A	75039892	–	C6	C3	1,1

HF32

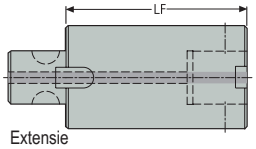
Coadă Graflex® pentru ∅ 39,5-59,499 mm



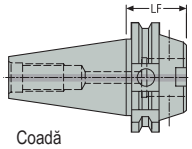




Suport alezor



Extensie



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF32-050-G3	02698870	–	50	G3	32	0,4
HF32...HSKA63	–	65	245	HSK-A63	32	0,0
HF32...HSKA80	–	100	209	HSK-A80	32	0,0
HF32...HSKA100	–	70	245	HSK-A100	32	0,0
HF32...DIN40ADB	–	60	252	DIN40ADB	32	0,0
HF32...DIN50ADB	–	60	317	DIN50ADB	32	0,0
HF32...BT40ADB	–	65	252	BT40ADB	32	0,0
HF32...BT50ADB	–	75	317	BT50ADB	32	0,0

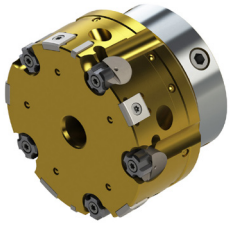
Cozi și extensii pentru HF32-050-G3 (consultaţi Seco Tooling Systems pentru mai multe detalii).

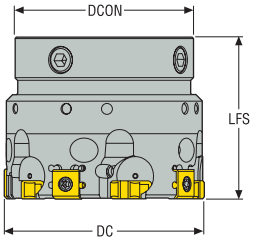
Reper Nr. Coada	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93044011850	00086918	50	HSK-A63	G3	0,8
EM93064011855	00086925	55	HSK-A100	G3	2,2
EM34694011835	02420097	35	DIN40	G3	1,0
EM346940118100	02503298	100	DIN40	G3	1,3
EM34144011840	02503366	40	BT40	G3	1,07
EM341440118100	02503367	100	BT40	G3	1,31
EM34714011835	02503307	35	DIN50	G3	2,67
EM34164011845	02503376	45	BT50	G3	3,6
EM341640118120	02503377	120	BT50	G3	4,0

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402330	00056758	–	G3	G3	0,3
M402331	75056759	–	G3	G3	0,4

HF85

Capete pentru plăcuţe RNAX, alezaj străpuns ∅ 59,5-84,499 mm / 2.343-3.327”





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85-59.5/64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	RNAX1005...
HF85-64.5/69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	RNAX1005...
HF85-69.5/74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	RNAX1005...
HF85-74.5/79.499-05-55	74,5 *2.933*	79,499 *3.130*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	RNAX1005...
HF85-79.5/84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85 05-55	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

Accesorii

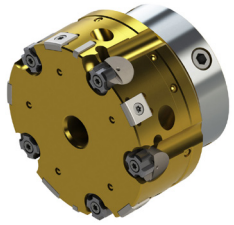
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85 05-55	H00-2020	T00-09P20

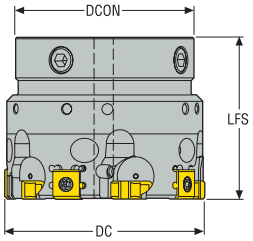
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-09P20 pentru șuruburile plăcuţei

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF85B

Capete pentru plăcuţe RNAX, alezaj înfundat ∅ 59,5-84,499 mm / 2.343-3.327"





—Pentru plăcuţe, calităţi şi geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85B-59.5/64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	RNAX1005...
HF85B-64.5/69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	RNAX1005...
HF85B-69.5/74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	RNAX1005...
HF85B-74.5/79.499-05-55	74,5 *2.933*	79,499 *3.130*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	RNAX1005...
HF85B-79.5/84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 05-55	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

Accesorii

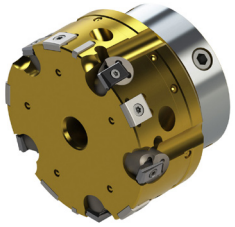
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 05-55	H00-2020	T00-09P20

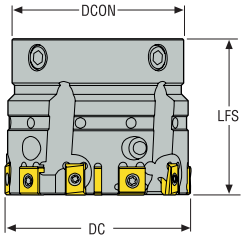
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-09P20 pentru șuruburile plăcuţei

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86

Capete pentru plăcuţe LNEG, alezaj străpuns ∅ 59,5-84,499 mm / 2.343-3.327"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86-59.5-64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	LNEG1003...
HF86-64.5-69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	LNEG1003...
HF86-69.5-74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	LNEG1003...
HF86-74.5-79.499-05-55	74,5 *2.933*	94,499 *3.720*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	LNEG1003...
HF86-79.5-84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86 05-55	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

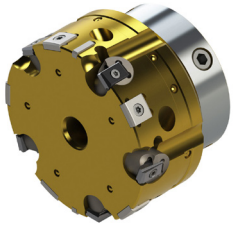
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86 05-55	H00-2020	T00-07P09

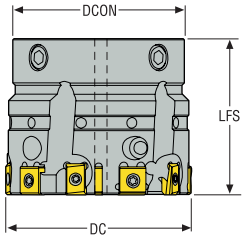
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-07P09 pentru șuruburile plăcuţei

Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86B

Capete pentru plăcuţe LNEG, alezaj înfundat ∅ 59,5-84,499 mm / 2.343-3.327”





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86B-59.5/64.499-05-55	59,5 *2.343*	64,499 *2.539*	50,0 *1.969*	55,0 *2.165*	1,3 *2.870*	5	LNEG1003...
HF86B-64.5/69.499-05-55	64,5 *2.539*	69,499 *2.736*	50,0 *1.969*	55,0 *2.165*	1,5 *3.310*	5	LNEG1003...
HF86B-69.5/74.499-05-55	69,5 *2.736*	74,499 *2.933*	50,0 *1.969*	55,0 *2.165*	1,75 *3.860*	5	LNEG1003...
HF86B-74.5/79.499-05-55	74,5 *2.933*	79,499 *3.130*	50,0 *1.969*	55,0 *2.165*	2,0 *4.410*	5	LNEG1003...
HF86B-79.5/84.499-05-55	79,5 *3.130*	84,499 *3.327*	50,0 *1.969*	55,0 *2.165*	2,2 *4.850*	5	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86B 05-55	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86B 05-55	H00-2020	T00-07P09

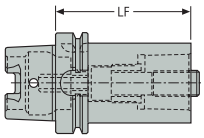
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-07P09 pentru șuruburile plăcuţei

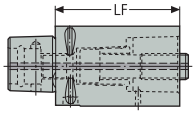
Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF55

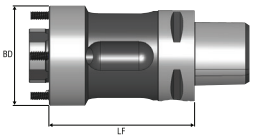
Coadă Seco Capto™ pentru ∅ 59,5-84,499 mm



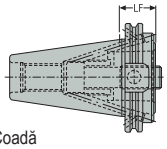




Extensie



Suport alezor



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF55-080-C5	02688647	–	80	C5	55	1,3
HF55...HSKA63	–	80	239	HSK-A63	55	0,0
HF55...HSKA80	–	100	239	HSK-A80	55	0,0
HF55...HSKA100	–	100	239	HSK-A100	55	0,0
HF55...DIN40ADB	–	80	239	DIN40ADB	55	0,0
HF55...DIN50ADB	–	80	304	DIN50ADB	55	0,0
HF55...BT40ADB	–	80	239	BT40ADB	55	0,0
HF55...BT50ADB	–	80	304	BT50ADB	55	0,0

Cozi și extensii pentru HF55-080-C5 (consultați Seco Tooling Systems pentru mai multe detalii).

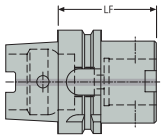
Reper Nr. Coada	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
HA10-C4-040-090	10197963	90	HSK-A100	C4	2,5
HA06-C5-050-090	10197966	90	HSK-A63	C5	1,3
C5-390B.140-40040	02924112	40	DIN40	C5	0,9
C5-390B.140-40080	02924113	80	DIN40	C5	1,5
C5-390B.55-40050	02925967	50	BT40	C5	1,1
C5-390B.55-40090	02925968	90	BT40	C5	1,7
C5-390B.140-50030	02924114	30	DIN50	C5	2,6
C5-390B.140-50070	02924115	70	DIN50	C5	3,1
C5-390B.58-50040	02925969	40	BT50	C5	3,4
C5-390B.58-50080	02925970	80	BT50	C5	3,9

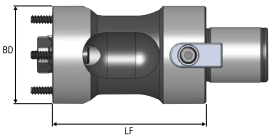
Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
C5-391.01-50080A	75039886	–	C5	C5	1,1
C5-391.01-50100A	00004773	–	C5	C5	1,4
C6-391.02-50080A	75039894	–	C6	C5	1,4
C6-391.02-50110A	02207400	–	C6	C5	2,2
C8-391.02-50080B	03080011	–	C8	C5	2,4

HF55

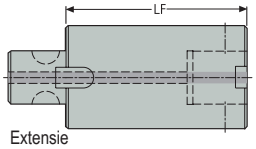
Coadă Graflex® pentru ∅ 59,5-84,499 mm



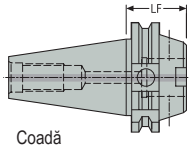




Suport alezor



Extensie



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF55-080-G5	02698871	–	80	G5	55	1,3
HF55...HSKA63	–	80	239	HSK-A63	55	0,0
HF55...HSKA80	–	100	239	HSK-A80	55	0,0
HF55...HSKA100	–	100	239	HSK-A100	55	0,0
HF55...DIN40ADB	–	80	239	DIN40ADB	55	0,0
HF55...DIN50ADB	–	80	304	DIN50ADB	55	0,0
HF55...BT40ADB	–	80	239	BT40ADB	55	0,0
HF55...BT50ADB	–	80	304	BT50ADB	55	0,0

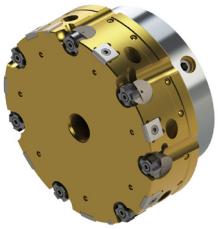
Cozi și extensii pentru HF55-080-G5 (consultaţi Seco Tooling Systems pentru mai multe detalii).

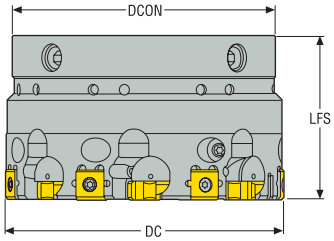
Reper Nr. Coada	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93044012860	00086920	60	HSK-A63	G5	1,0
EM930440128100	00086921	100	HSK-A63	G5	1,6
EM930440128140	00086922	140	HSK-A63	G5	2,18
EM93064012865	00086927	65	HSK-A100	G5	2,4
EM930640128110	00086928	110	HSK-A100	G5	3,1
EM930640128150	00086929	150	HSK-A100	G5	3,7
EM34694012840	02458421	40	DIN40	G5	1,0
EM34694012880	02503301	80	DIN40	G5	1,5
EM346940128120	02503302	120	DIN40	G5	2,1
EM34144012845	02457989	45	BT40	G5	1,2
EM34144012880	02503371	80	BT40	G5	1,6
EM341440128120	02503372	120	BT40	G5	2,2
EM34714012840	02503312	40	DIN50	G5	2,75
EM341640128100	02503381	100	BT50	G5	4,3
EM34164012855	02503380	55	BT50	G5	4,0
EM341640128140	02503382	140	BT50	G5	4,9

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402550	00056762	–	G5	G5	0,8
M402551	00056763	–	G5	G5	1,2
M402552	00056764	–	G5	G5	1,5

HF85

Capete pentru plăcuţe RNAX, alezaj străpuns ∅ 84,5-119,499 mm / 3.327-4.705"





—Pentru plăcuţe, calităţi şi geometrii, consultaţi pag. 424-425
—Regimuri de aşchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	RNAX1005...
HF85-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	RNAX1005...
HF85-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	RNAX1005...
HF85-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	RNAX1005...
HF85-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	RNAX1005...
HF85-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	RNAX1005...
HF85-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85 07-80	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

Accesorii

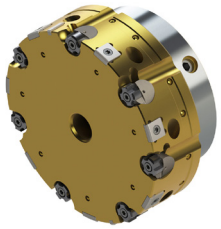
Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85 07-80	H00-2020	T00-09P20

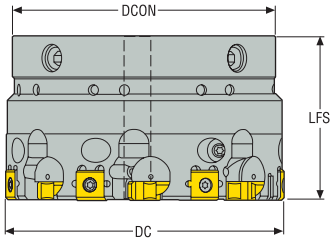
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-09P20 pentru șuruburile plăcuţei

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF85B

Capete pentru plăcuţe RNAX, alezaj înfundat ∅ 84,5-119,499 mm / 3.327-4.705"





—Pentru plăcuţe, calităţi şi geometrii, consultaţi pag. 424-425
—Regimuri de aşchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85B-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	RNAX1005...
HF85B-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	RNAX1005...
HF85B-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	RNAX1005...
HF85B-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	RNAX1005...
HF85B-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	RNAX1005...
HF85B-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	RNAX1005...
HF85B-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 07-80	SH4075S	CARTCYHF20B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

Accesorii

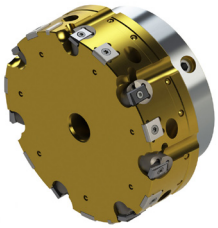
Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 07-80	H00-2020	T00-09P20

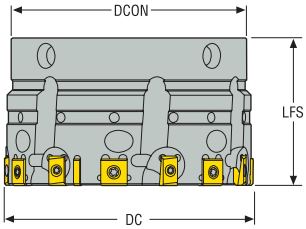
Notă:
Șurubelniță dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniță dinamometrică T00-09P20 pentru șuruburile plăcuței

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86

Capete pentru plăcuţe LNEG, alezaj străpuns ∅ 84,5-119,499 mm / 3.327-4.705”





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	LNEG1003...
HF86-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	LNEG1003...
HF86-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	LNEG1003...
HF86-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	LNEG1003...
HF86-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	LNEG1003...
HF86-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	LNEG1003...
HF86-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86 07-80	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

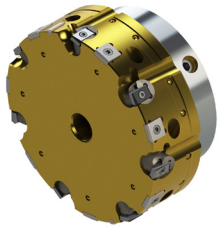
Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86 07-80	H00-2020	T00-07P09

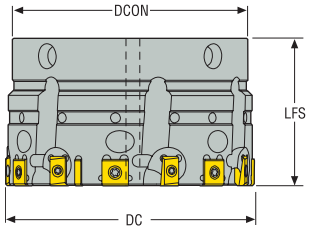
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-07P09 pentru șuruburile plăcuţei

Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86B

Capete pentru plăcuţe LNEG, alezaj înfundat ∅ 84,5-119,499 mm / 3.327-4.705"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86B-84.5/89.499-07-80	84,5 *3.327*	89,499 *3.524*	50,0 *1.969*	80,0 *3.150*	1,68 *3.700*	7	LNEG1003...
HF86B-89.5/94.499-07-80	89,5 *3.524*	94,499 *3.720*	50,0 *1.969*	80,0 *3.150*	1,85 *4.080*	7	LNEG1003...
HF86B-94.5/99.499-07-80	94,5 *3.720*	99,499 *3.917*	50,0 *1.969*	80,0 *3.150*	2,02 *4.450*	7	LNEG1003...
HF86B-99.5/104.499-07-80	99,5 *3.917*	104,499 *4.114*	50,0 *1.969*	80,0 *3.150*	2,2 *4.850*	7	LNEG1003...
HF86B-104.5/109.499-07-80	104,5 *4.114*	109,499 *4.311*	50,0 *1.969*	80,0 *3.150*	2,4 *5.290*	7	LNEG1003...
HF86B-109.5/114.499-07-80	109,5 *4.311*	114,499 *4.508*	50,0 *1.969*	80,0 *3.150*	2,61 *5.750*	7	LNEG1003...
HF86B-114.5/119.499-07-80	114,5 *4.508*	119,499 *4.705*	50,0 *1.969*	80,0 *3.150*	2,82 *6.220*	7	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86B	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86B	H00-2020	T00-07P09

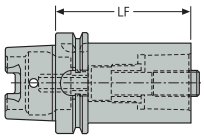
Notă:
Șurubelniță dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniță dinamometrică T00-07P09 pentru șuruburile plăcuţei

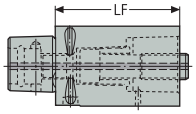
Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF80

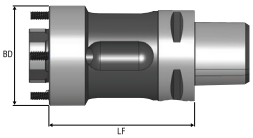
Coadă Seco Capto™ pentru ∅ 84,5-119,499 mm



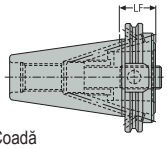




Extensie



Suport alezor



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF80-080-C6	02688648	–	80	C6	80	2,5
HF80...HSKA80	–	100	239	HSK-A80	80	0,0
HF80...HSKA100	–	100	239	HSK-A100	80	0,0
HF80...DIN50ADB	–	80	304	DIN50ADB	80	0,0
HF80...BT50ADB	–	80	304	BT50ADB	80	0,0

Cozi și extensii pentru HF80-080-C6 (consultați Seco Tooling Systems pentru mai multe detalii).

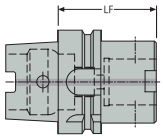
Reper Nr. Coada	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
HA10-C6-063-110	10197967	110	HSK-A100	C6	3,6
C6-390B.140-40085	02924116	85	DIN40	C6	1,8
C6-390B.140-50030	02924117	30	DIN50	C6	2,4
C6-390B.140-50080	02924118	80	DIN50	C6	3,6
C6-390B.55-40075	02925971	75	BT40	C6	1,7
C6-390B.58-50100	02925973	100	BT50	C6	4,6
C6-390B.58-50050	02925972	50	BT50	C6	3,5

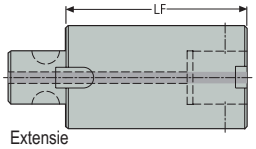
Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
C6-391.01-63100A	75039887	–	C6	C6	2,2
C6-391.01-63140A	00004840	–	C6	C6	3,1
C6-391.01-63060	02300834	–	C6	C6	1,3

HF80

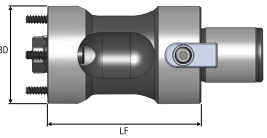
Coadă Graflex® pentru ∅ 84,5-119,499 mm



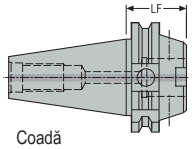




Extensie



Suport alezor



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF80-080-G6	02698873	–	80	G6	80	2,6
HF80...HSKA80	–	100	239	HSK-A80	80	0,0
HF80...HSKA100	–	100	239	HSK-A100	80	0,0
HF80...DIN50ADB	–	80	304	DIN50ADB	80	0,0
HF80...BT50ADB	–	80	304	BT50ADB	80	0,0
	–	–	–	–	–	–

Cozi și extensii pentru HF80-080-G6 (consultaţi Seco Tooling Systems pentru mai multe detalii).

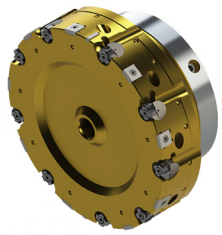
Reper Nr. Coada	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93044013670	00086923	70	HSK-A63	G6	1,3
EM930440136120	00086924	120	HSK-A63	G6	2,38
EM930640136120	00086931	120	HSK-A100	G6	3,9
EM930640136160	00086932	160	HSK-A100	G6	4,8
EM34694013660	02503303	60	DIN40	G6	1,3
EM346940136120	02503304	120	DIN40	G6	2,7
EM34144013650	02503373	50	BT40	G6	1,2
EM341440136120	02503374	120	BT40	G6	2,8
EM34714013645	02503317	45	DIN50	G6	2,9
EM347140136100	02503318	100	DIN50	G6	4,1
EM347140136140	02503319	140	DIN50	G6	5,1
EM34164013663	02503383	63	BT50	G6	4,3
EM341640136100	02503384	100	BT50	G6	4,7
EM341640136140	02503385	140	BT50	G6	5,6

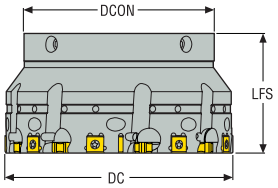
Cozi și extensii pentru HF32-050-G3 (consultaţi Seco Tooling Systems pentru mai multe detalii).

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402660	00056765	–	G6	G6	1,4
M402661	00056766	–	G6	G6	2,2
M402662	00056767	–	G6	G6	2,9

HF85

Capete pentru plăcuţe RNAX, alezaj străpuns ∅ 119,5–154,499 mm / 4.705–6.083"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424–425
—Regimuri de așchiere, vezi pagina(paginile) 450–456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	RNAX1005...
HF85-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	RNAX1005...
HF85-129.5/134.499-09-100	129,5 *5.098*	134,499 *5.295*	63,0 *2.480*	100,0 *3.937*	4,42 *9.740*	9	RNAX1005...
HF85-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	RNAX1005...
HF85-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	RNAX1005...
HF85-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	RNAX1005...
HF85-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85 09-100	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

Accesorii

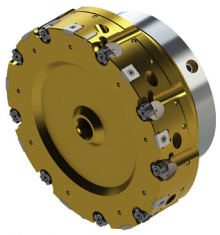
Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85 09-100	H00-2020	T00-09P20

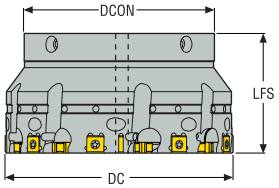
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-09P20 pentru șuruburile plăcuţei

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF85B

Capete pentru plăcuţe RNAX, alezaj înfundat ∅ 119,5-154,499 mm / 4.705-6.083"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF85B-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	RNAX1005...
HF85B-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	RNAX1005...
HF85B-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	RNAX1005...
HF85B-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	RNAX1005...
HF85B-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	RNAX1005...
HF85B-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	RNAX1005...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 09-100	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

Accesorii

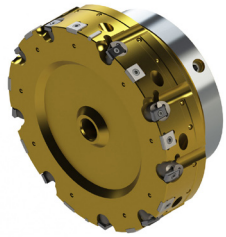
Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 09-100	H00-2020	T00-09P20

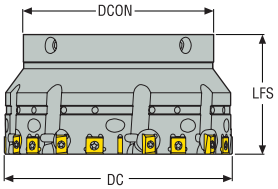
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-09P20 pentru șuruburile plăcuţei

Valoare cuplu T00-09P20: 2 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86

Capete pentru plăcuţe LNEG, alezaj străpuns ∅ 119,5-154,499 mm / 4.705-6.083"





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	LNEG1003...
HF86-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	LNEG1003...
HF86-129.5/134.499-09-100	129,5 *5.098*	134,499 *5.295*	63,0 *2.480*	100,0 *3.937*	4,42 *9.740*	9	LNEG1003...
HF86-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	LNEG1003...
HF86-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	LNEG1003...
HF86-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	LNEG1003...
HF86-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86 09-100	SH4075S	CARTCYHF20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

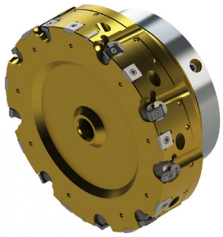
Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86 09-100	H00-2020	T00-07P09

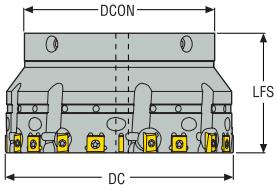
Notă:
Șurubelniţă dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniţă dinamometrică T00-07P09 pentru șuruburile plăcuţei

Valoare cuplu
T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF86B

Capete pentru plăcuţe LNEG, alezaj înfundat ∅ 119,5-154,499 mm / 4.705-6.083”





—Pentru plăcuţe, calităţi și geometrii, consultaţi pag. 424-425
—Regimuri de așchiere, vezi pagina(paginile) 450-456

Reper Nr.	DCN	DCX	LFS	DCON	Greutate		Plăcuţă amovibilă
	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
HF86B-119.5/124.499-09-100	119,5 *4.705*	124,499 *4.902*	63,0 *2.480*	100,0 *3.937*	3,89 *8.580*	9	LNEG1003...
HF86B-124.5/129.499-09-100	124,5 *4.902*	129,499 *5.098*	63,0 *2.480*	100,0 *3.937*	4,15 *9.150*	9	LNEG1003...
HF86B-129.5/134.499-09-100	129,5 *5.098*	134,499 *5.295*	63,0 *2.480*	100,0 *3.937*	4,42 *9.740*	9	LNEG1003...
HF86B-134.5/139.499-09-100	134,5 *5.295*	139,499 *5.492*	63,0 *2.480*	100,0 *3.937*	4,7 *10.360*	9	LNEG1003...
HF86B-139.5/144.499-09-100	139,5 *5.492*	144,499 *5.689*	63,0 *2.480*	100,0 *3.937*	4,99 *11.000*	9	LNEG1003...
HF86B-144.5/149.499-09-100	144,5 *5.689*	149,499 *5.886*	63,0 *2.480*	100,0 *3.937*	5,29 *11.660*	9	LNEG1003...
HF86B-149.5/154.499-09-100	149,5 *5.886*	154,499 *6.083*	63,0 *2.480*	100,0 *3.937*	5,6 *12.350*	9	LNEG1003...

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuţă	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86B 09-100	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

Accesorii

Pentru	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86B 09-100	H00-2020	T00-07P09

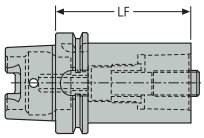
Notă:
Șurubelniță dinamometrică H00-2020 pentru șuruburile de prindere
Șurubelniță dinamometrică T00-07P09 pentru șuruburile plăcuţei

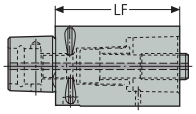
Valoare cuplu T00-07P09: 0,9 Nm.
Valoare cuplu H00-2020: 2 Nm.

HF100

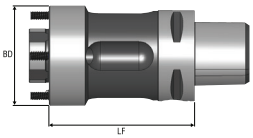
Coadă Seco Capto™ pentru ∅ 119,5–154,499 mm



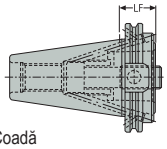




Extensie



Suport alezor



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF100-100-C8	02688649	–	100	C8	100	4,9
HF100...HSKA80	–	100	238	HSK-A80	100	0,0
HF100...HSKA100	–	100	238	HSK-A100	100	0,0
HF100...DIN50ADB	–	100	238	DIN50ADB	100	0,0
HF100...BT50ADB	–	100	238	BT50ADB	100	0,0

Cozi și extensii pentru HF100-100-C8 (consultaţi Seco Tooling Systems pentru mai multe detalii).

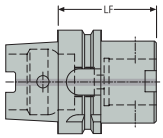
Reper Nr. Coada	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
HA10-C8-080-120	10197968	120	HSK-A100	C8	4,8
C8-390B.140-50070	02924119	70	DIN50	C8	3,7
C8-390B.140-50120	02924120	120	DIN50	C8	5,5
C8-390B.58-50070	02925974	70	BT50	C8	4,0
C8-390B.58-50120	02925975	120	BT50	C8	5,9

Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco Capto™	Greutate
		mm			kg
C8-391.01-80100A	75039888	–	C8	C8	3,7
C8-391.01-80125A	00004841	–	C8	C8	4,6

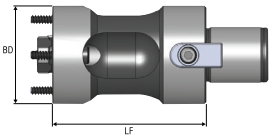
HF100

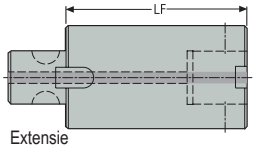
Coadă Graflex® pentru ∅ 119,5-154,499 mm



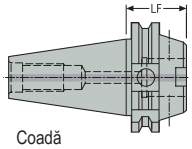


Suport alezor





Extensie



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm	mm	mm	kg
HF100-100-G7	02698874	–	100	G7	100	5,2
HF100...HSKA80	–	100	238	HSK-A80	100	0,0
HF100...HSKA100	–	100	238	HSK-A100	100	0,0
HF100...DIN50ADB	–	100	238	DIN50ADB	100	0,0
HF100...BT50ADB	–	100	238	BT50ADB	100	0,0

Cozi și extensii pentru HF100-100-G7 (consultaţi Seco Tooling Systems pentru mai multe detalii).

Reper Nr. Coada	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93064014685	00074385	85	HSK-A100	G7	4,0
EM930640146160	00086933	160	HSK-A100	G7	7,67
EM34714014650	02503320	50	DIN50	G7	3,3
EM347140146120	02503321	120	DIN50	G7	6,5
EM347140146200	02503324	200	DIN50	G7	10,4
EM34164014665	02503386	65	BT50	G7	4,4
EM341640146120	02503387	120	BT50	G7	6,9
EM341640146200	02503388	200	BT50	G7	10,7

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402770	00056768	–	G7	G7	2,9
M402771	00056769	–	G7	G7	4,4
M402772	00056770	–	G7	G7	5,8

Parametri de așchiere – LNEG...-EB45 metric

SMG		a_p (Ø)	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 = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – LNEG...-EB45 *inch*

SMG		a_p (Ø)	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 = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – LNEG...-EB845 metric

SMG		a_p (Ø)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P1	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P2	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P3	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P4	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P5	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P6	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P7	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P8	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	40 (30-70)
P11	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	40 (30-70)
P12	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	30 (25-55)
M1	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M2	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M3	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M4	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	25 (20-50)
M5	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	25 (20-50)
K1	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K2	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	50 (35-80)
K3	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K4	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)
K5	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)
K6	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K7	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – LNEG...-EB845 *inch*

SMG		a_p (Ø)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P1	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*395 (260-655)*
P2	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*395 (260-655)*
P3	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*395 (260-655)*
P4	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P5	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P6	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P7	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*195 (130-395)*
P8	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*130 (100-230)*
P11	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*130 (100-230)*
P12	*LNEG1003-EB845*	*0.006–0.010*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*100 (85-185)*
M1	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*115 (80-195)*
M2	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*115 (80-195)*
M3	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*115 (80-195)*
M4	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*80 (65-165)*
M5	*LNEG1003-EB845*	*0.004–0.008*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*80 (65-165)*
K1	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*
K2	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*165 (115-260)*
K3	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*
K4	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*230 (165-395)*
K5	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*230 (165-395)*
K6	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*
K7	*LNEG1003-EB845*	*0.008–0.020*	*0.006–0.024*	*0.010–0.039*	*0.014–0.055*	*0.018–0.071*	*330 (195-655)*

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – LNEG...-EB1570 metric

SMG		a_p (Ø)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P4	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P5	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P6	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P7	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P8	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)
P11	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)
P12	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	30 (25-55)
K1	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K2	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)
K3	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K4	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)
K5	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)
K6	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K7	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)

SMG = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – LNEG...-EB1570 *inch*

SMG		a_p (Ø)	f				v_c
			z=3	z=5	z=7	z=9	RX2000
P4	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P5	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P6	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P7	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*195 (130–395)*
P8	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*130 (100–230)*
P11	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*130 (100–230)*
P12	*LNEG1005-EB1570*	*0.006–0.010*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*100 (85–185)*
K1	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*
K2	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*165 (115–260)*
K3	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*
K4	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165–395)*
K5	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*230 (165–395)*
K6	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*
K7	*LNEG1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195–655)*

SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – RNAX...-EB45 metric

SMG		a_p (Ø)	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 = Grupa de material Seco. a_p = mm. f = mm/rev. v_c= m/min.
Toți parametri de așchiere sunt valori de start

Parametri de așchiere – RNAX...-EB45 *inch*

SMG		a_p (Ø)	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 = Grupa de material Seco. a_p = *inch*. f = in/rev. v_c= sf/min. Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – RNAX...-EB845 metric

SMG		a_p (Ø)	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 = Grupa de material Seco. a_p = *inch*. f = in/rev. v_c= sf/min. Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – RNAX...-EB845 *inch*

SMG		a_p (Ø)	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 = Grupa de material Seco. a_p = *inch*. f = in/rev. v_c= sf/min. Toți parametri de așchiere sunt valori de start.

Parametri de așchiere – RNAX...-EB1570 metric

SMG		a_p (Ø)	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 = Grupa de material Seco
a_p = mm
f = mm/rev
v_c= m/min

Toți parametri de așchiere sunt valori de start

Parametri de așchiere – RNAX...-EB1570 *inch*

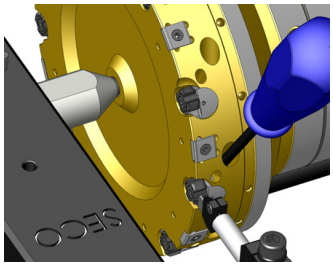
SMG		a_p (Ø)	f				v_c	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*330 (195-655)*	*720 (490- 985)*
K2	*RNAX1005-EB1570*	*0.008–0.020*	*0.006–0.018*	*0.010–0.030*	*0.010–0.041*	*0.018–0.053*	*165 (115-260)*	*230 (165- 395)*
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)*

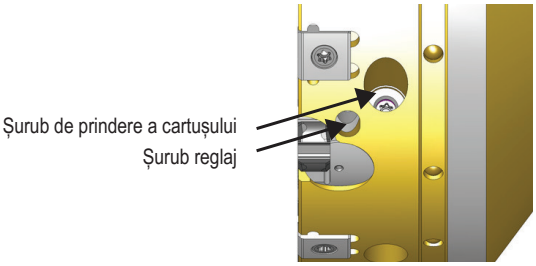
SMG = Grupa de material Seco
a_p = *inch*
f = in/rev
v_c= sf/min
Toți parametri de așchiere sunt valori de start.

Instrucţiuni de reglare

1.

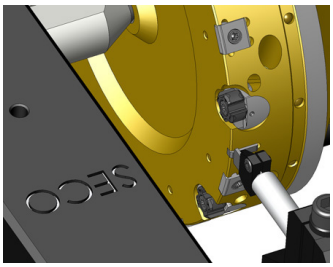
- Slăbiţi şurubul de prindere al cartuşului.
- Rotiţi sau înlocuiţi plăcuţa.
- Desfaceţi şurubul de reglare un sfert de tură şi împingeţi cartuşul înapoi.
- Strângeţi la loc cu grijă şurubul de prindere al cartuşului la 0,5 Nm aprox. *(4,4 in/lbs)*.

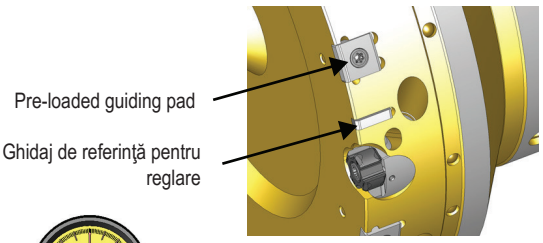


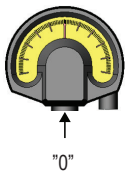


2.

- Setaţi comparatorul la zero pe ghidajul de referinţă.
- Asiguraţi-vă că punctul de măsurare se află după unghiul de avans.

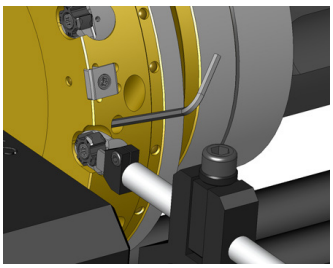


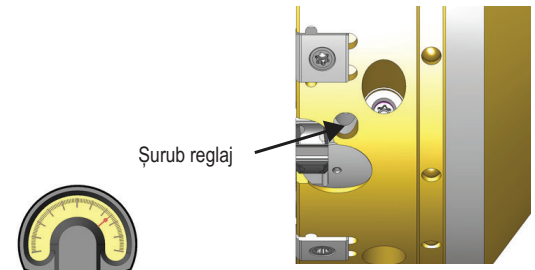




3.

- Setaţi plăcuţa 0,025 mm *(0,001")* deasupra ghidajului de referinţă utilizând şurubul de reglare.
- Repetaţi procesul de reglarea pentru toate plăcuţele.

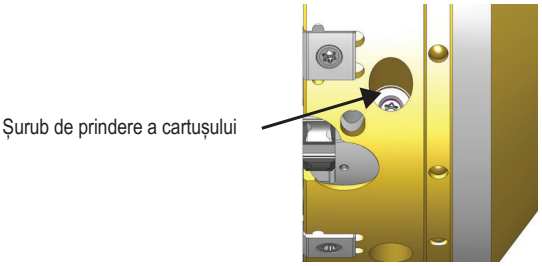




+ 0,025 mm *(+ 0,001")* deasupra ghidajului de referinţă

4.

- Strângeţi şurubul de prindere al cartuşului la 2 Nm *(17.7 in/lbs)*.



Notă: Dacă diametrul dorit este depăşit la reglare, începeţi încă o dată de la început pentru a elimina jocul şurubului de reglare.

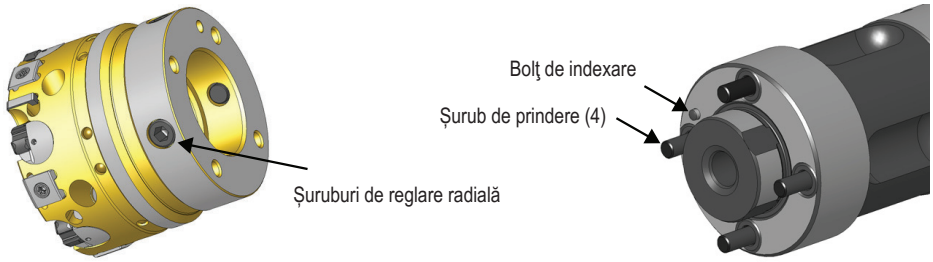
Instrucţiuni de reglare, adaptor

1.

Asamblare

- Curăţaţi temeinic suprafaţa de contact a flanşei.
- Slăbiţi cele 4 şuruburi de reglare radială în aşa fel încât să nu încurce asamblarea.
- Amplasaţi capul alezorului în adaptor (pin de rotaţie) şi strângeţi cele 4 şuruburi de prindere.

Asamblare (schiţa 1)

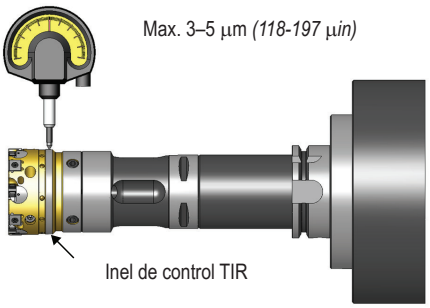


2.

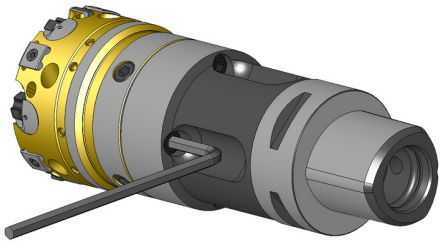
Setare

- Montaţi scula în capul de alezare al utilajului.
- Plasaţi comparatorul µm după cum este indicat în (schiţa 2).
- Deblocaţi capul de alezare pentru a putea fi rotit liber cu mâna.
- Începeţi corectarea bătăii radiale utilizând cele 4 şuruburi de reglare (schiţa 3).
- Bătaie radială max. 5 µm *(197 µin)*.
- Când valorile bătăii radiale coboară sub 10 µm *(394 µin)*, treceţi la strângerea finală (schiţa 1), consultaţi tabelul cu cuplul de strângere pentru valorile recomandate de cuplu.

Setarea operaţiei pe capul de alezare al utilajului (schiţa 2)



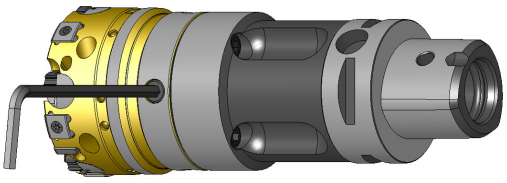
Şuruburi de prindere (schiţa 3)



3.

- Finalizaţi reglarea bătăii radiale, max. 5 µm *(max. 197 µin)*.

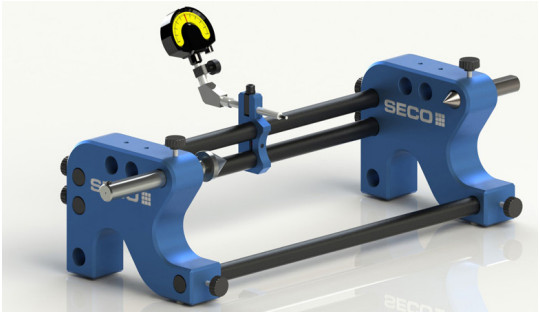
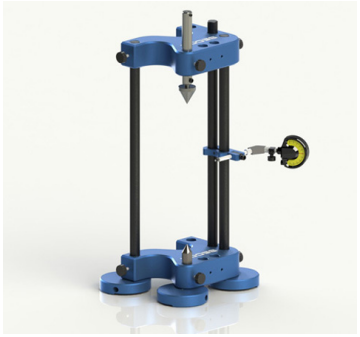
Şuruburi de reglare radială (schiţa 4)



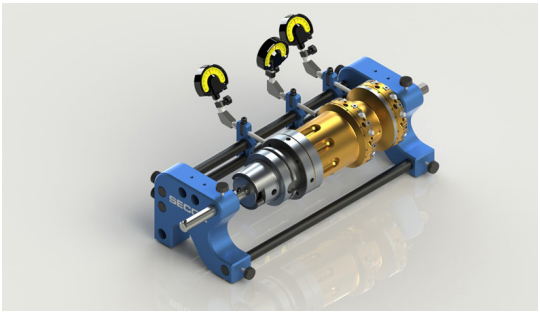
Cuplul de strângere

Diametru mm	*Diametru inci*	**Mărimea adaptorului**	**Şurub de prindere**	**Cuplu de strângere Nm**	*Cuplu de strângere 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*

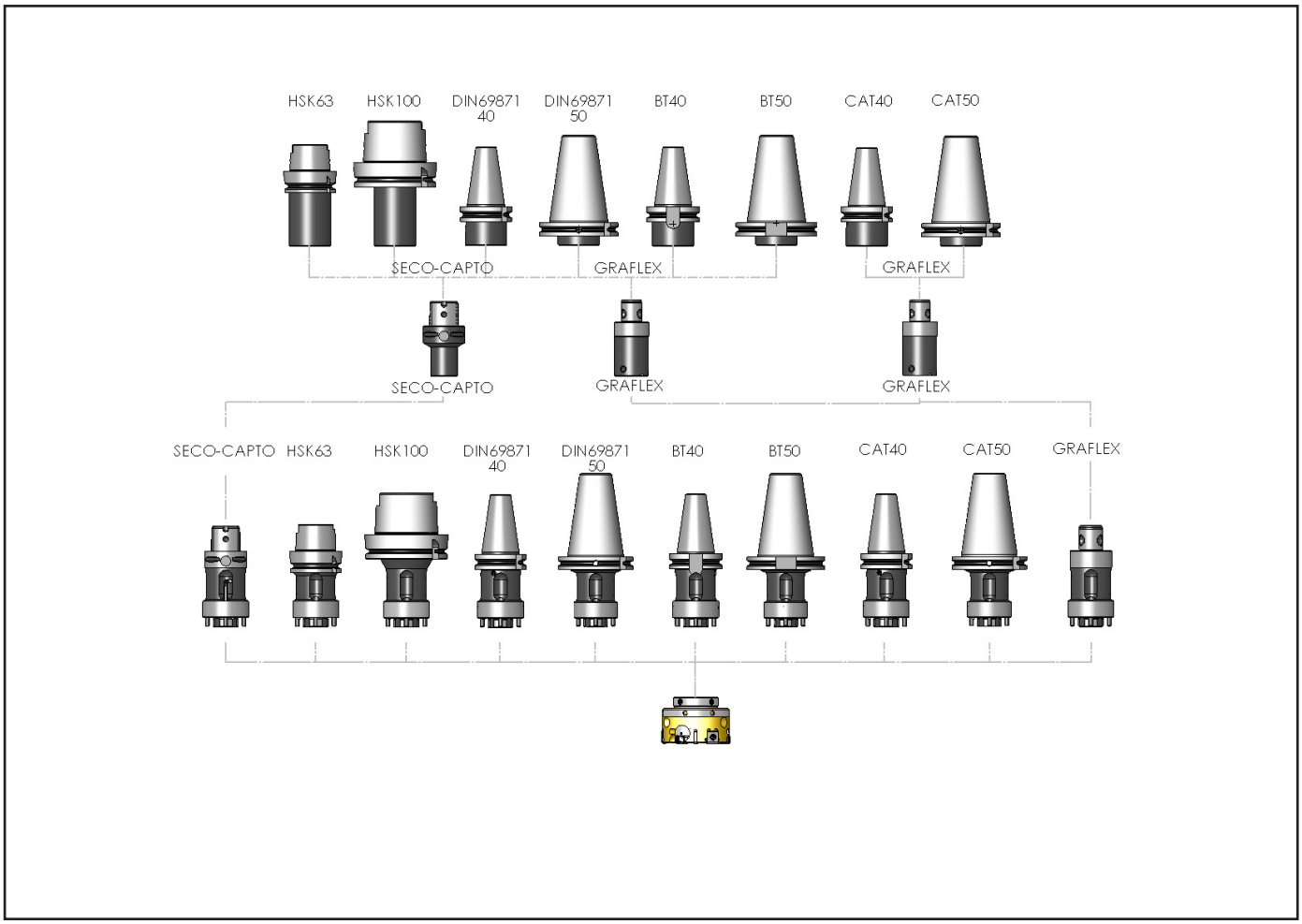
Prindere de reglare – comparator unic

SF-210340-C160: Nr. reper pt. comandă 02885391 – Stand orizontal – Prima alegere pentru alezoarele Xfix – 1 comparator – Ø maxim al sculei: 210 mm *(8,268")* – Lungime maximă a sculei: 340 mm *(13,386")* – Incluse în pachetul de livrare: adiţional plus Ø 57 mm *(2.244")* centrare cu arc pentru – HSK 63/80/100 și Capto C8 – nr. reper 02208620	
SF-210290V-C160: Nr. reper pt. comandă 02885392 – Stand vertical – Prima alegere pentru alezoarele Xfix – Ø maxim al sculei: 210 mm *(8,268")* – Lungime maximă a sculei: 290 mm *(11,417")* – Incluse în pachetul de livrare: adiţional Ø 57 mm *(2,244")* centrare cu arc pentru – HSK 63/80/100 și Capto C8 nr. reper 02208620	

Prindere de reglare – mai multe comparatoare

Posibilităţi de configurare cu mai multe comparatoare, consultaţi capitolul referitor la prinderea de reglare de la paginile 473-478 pentru mai multe detalii	

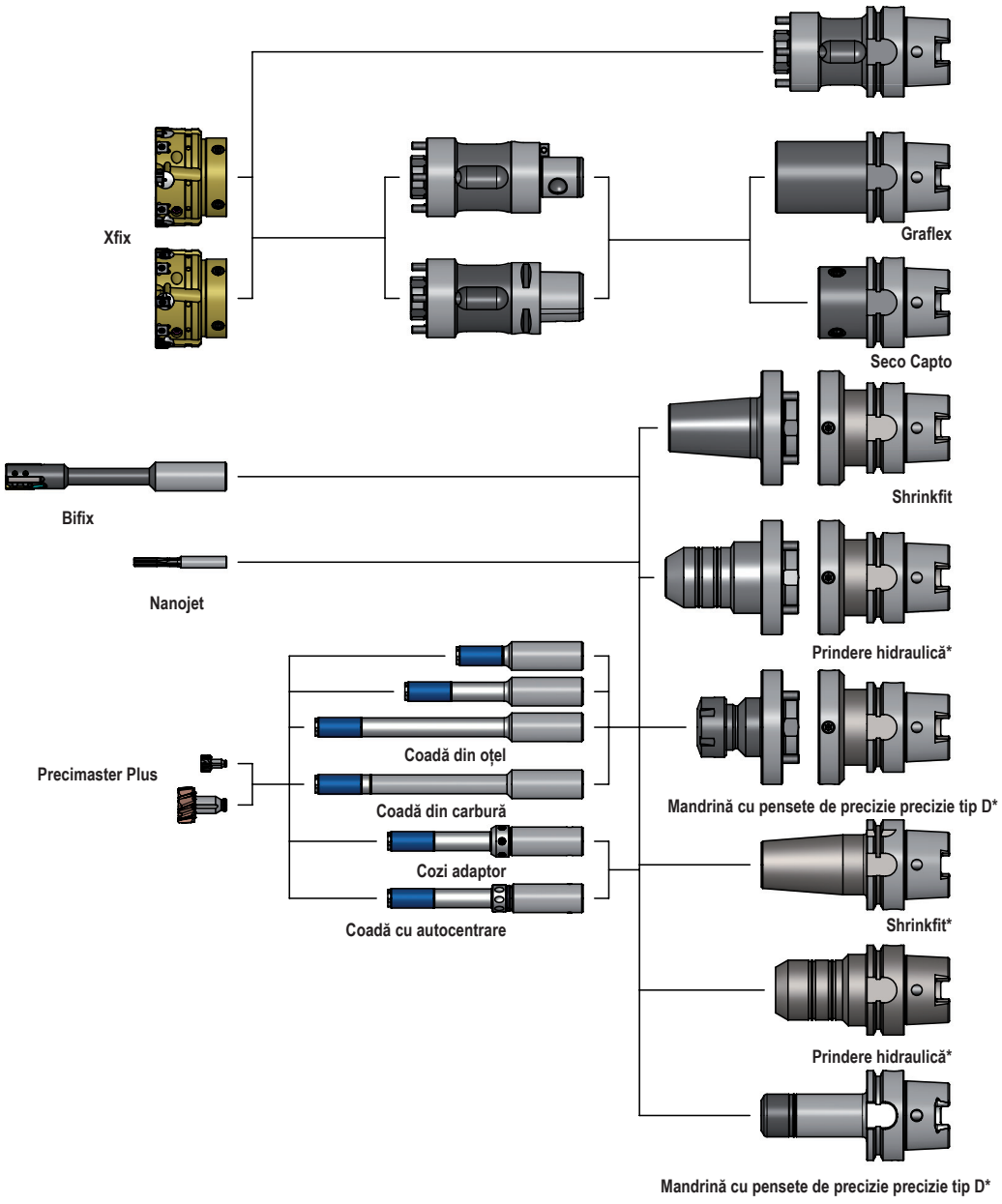
Vedere generală asupra sistemelor de scule



Diametru mm	*Diametru inci*	Raport diametru/ lungime maxim
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

Notă: Pentru diametre > 100 mm *(3,937")* sau L > 3 x D verificaţi greutatea maximă a sculei acceptată de utilaj.

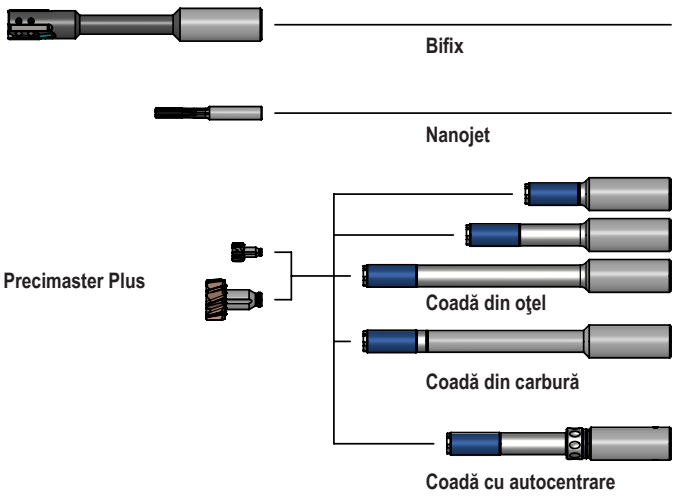
Aplicaţii dinamice



*Consultați catalogul PORT-SCULE

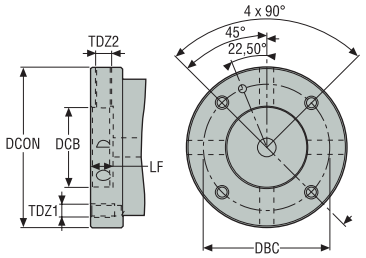
Cele mai bune performanțe se obțin cu prinderile rigide (prindere hidraulică, tip D sau Shrinkfit)

Aplicaţii statice



Dimensiune flanșă





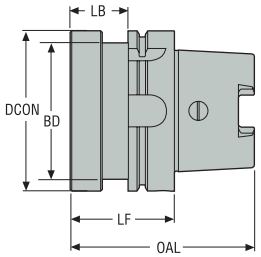
DCON	DBC +/- 0,1	DCB F8	LF	TDZ1	TDZ2
60	44	30	12	M5	M8x1
70	53	35	12	M6	M8x1
80	63	40	12	M6	M8x1
100	79	50	14	M8	M10x1
117	96	60	14	M8	M10x1
140	119	80	14	M10	M10x1

Piese de schimb, Piese incluse la livrare

Pentru	Șurub reglaj	Șurub clemă
		
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
70	HCM8X16X1/ISO4028	CHCM6X20/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Prindere HSK-A





—Notă: Tubul de lichid de răcire și șuruburile incluse în pachetul de livrare

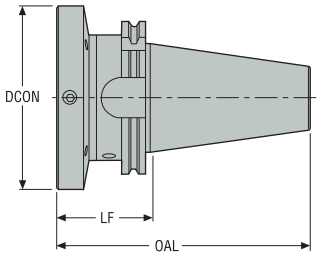
Reper Nr.	Număr reper	Con	DCON	BD	LB	LF	OAL	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SAH-23405100001	02836663	HSK-A 100	60,0 *2.362*	60,0 *2.362*	26,0 *1.024*	55,0 *2.165*	105,0 *4.134*	2,5 *5.510*
SAH-2340550001	02836566	HSK-A 50	60,0 *2.362*	42,0 *1.654*	34,0 *1.339*	60,0 *2.362*	85,0 *3.346*	0,95 *2.090*
SAH-2340580001	02836655	HSK-A 80	60,0 *2.362*	60,0 *2.362*	24,0 *0.945*	50,0 *1.969*	90,0 *3.543*	1,4 *3.090*
SAH-2340563001	02836574	HSK-A 63	60,0 *2.362*	53,0 *2.087*	34,0 *1.339*	60,0 *2.362*	92,0 *3.622*	1,2 *2.650*
SAH-23405100007	02836664	HSK-A 100	70,0 *2.756*	70,0 *2.756*	26,0 *1.024*	55,0 *2.165*	105,0 *4.134*	2,7 *5.950*
SAH-2340563003	02836575	HSK-A 63	70,0 *2.756*	53,0 *2.087*	34,0 *1.339*	60,0 *2.362*	92,0 *3.622*	1,3 *2.870*
SAH-2340580003	02836657	HSK-A 80	70,0 *2.756*	67,0 *2.638*	34,0 *1.339*	60,0 *2.362*	100,0 *3.937*	1,5 *3.310*
SAH-23405100002	02836665	HSK-A 100	80,0 *3.150*	80,0 *3.150*	26,0 *1.024*	55,0 *2.165*	105,0 *4.134*	2,9 *6.390*
SAH-2340563002	02836576	HSK-A 63	80,0 *3.150*	53,0 *2.087*	34,0 *1.339*	60,0 *2.362*	92,0 *3.622*	1,4 *3.090*
SAH-2340580002	02836658	HSK-A 80	80,0 *3.150*	67,0 *2.638*	34,0 *1.339*	60,0 *2.362*	100,0 *3.937*	1,6 *3.530*
SAH-2340563004	02836577	HSK-A 63	100,0 *3.937*	53,0 *2.087*	39,0 *1.535*	65,0 *2.559*	97,0 *3.819*	1,95 *4.300*
SAH-23405100003	02836666	HSK-A 100	100,0 *3.937*	85,0 *3.346*	36,0 *1.417*	65,0 *2.559*	115,0 *4.528*	3,5 *7.720*
SAH-2340580004	02836660	HSK-A 80	100,0 *3.937*	67,0 *2.638*	39,0 *1.535*	65,0 *2.559*	105,0 *4.134*	2,2 *4.850*

Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj	Șurub clemă
		
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
70	HCM8X16X1/ISO4028	CHCM6X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Prindere DIN 69871





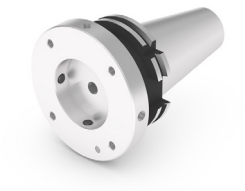
—Notă: Șuruburi incluse în pachetul de livrare

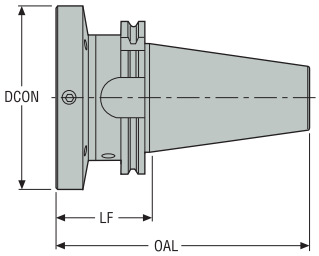
Reper Nr.	Număr reper	Con	DCON	LF	OAL	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SAH-2340640201	02836683	DIN40 ADB	60,0 *2.362*	50,0 *1.969*	118,4 *4.661*	1,3 *2.870*
SAH-2340650201	02836687	DIN50 ADB	60,0 *2.362*	50,0 *1.969*	151,8 *5.976*	3,1 *6.830*
SAH-2340650202	02836690	DIN50 ADB	80,0 *3.150*	50,0 *1.969*	151,8 *5.976*	3,5 *7.720*
SAH-2340640202	02836685	DIN40 ADB	80,0 *3.150*	55,0 *2.165*	123,4 *4.858*	1,7 *3.750*
SAH-2340640203	02836686	DIN40 ADB	100,0 *3.937*	60,0 *2.362*	128,4 *5.055*	2,3 *5.070*
SAH-2340650203	02836691	DIN50 ADB	100,0 *3.937*	60,0 *2.362*	161,8 *6.370*	4,3 *9.480*

Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj	Șurub clemă
		
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Prindere ANSI CAT





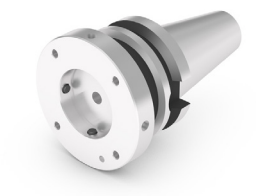
—Notă: Șuruburi incluse în pachetul de livrare
—Tiretă cu filet imperial

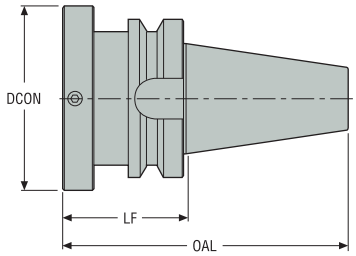
Reper Nr.	Număr reper	Con	DCON	LF	OAL	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SAH-2784940201	02836698	CAT 40	60,0 *2.362*	50,0 *1.969*	118,4 *4.661*	1,1 *2.430*
SAH-2784950201	02836707	CAT 50	60,0 *2.362*	50,0 *1.969*	151,8 *5.976*	3,1 *6.830*
SAH-2784940202	02836702	CAT 40	80,0 *3.150*	60,0 *2.362*	128,4 *5.055*	1,8 *3.970*
SAH-2784950202	02836709	CAT 50	80,0 *3.150*	60,0 *2.362*	161,8 *6.370*	3,4 *7.500*
SAH-2784940203	02836704	CAT 40	100,0 *3.937*	60,0 *2.362*	128,4 *5.055*	2,3 *5.070*
SAH-2784950203	02836710	CAT 50	100,0 *3.937*	80,0 *3.150*	181,8 *7.157*	5,5 *12.130*

Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj	Șurub clemă
		
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Prindere BT





—Notă: Șuruburi incluse în pachetul de livrare

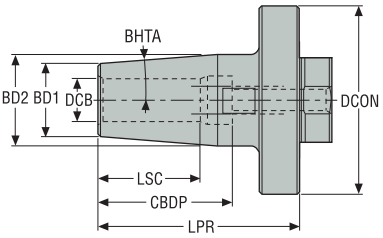
Reper Nr.	Număr reper	Con	DCON	LF	OAL	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SAH-2340740001	02836717	BT40 ADB	60,0 *2.362*	55,0 *2.165*	120,4 *4.740*	1,4 *3.090*
SAH-2340750001	02836724	BT50 ADB	60,0 *2.362*	70,0 *2.756*	171,8 *6.764*	4,2 *9.260*
SAH-2340740004	02836718	BT40 ADB	70,0 *2.756*	55,0 *2.165*	120,4 *4.740*	1,5 *3.310*
SAH-2340750002	02836725	BT50 ADB	70,0 *2.756*	70,0 *2.756*	171,8 *6.764*	4,4 *9.700*
SAH-2340740002	02836719	BT40 ADB	80,0 *3.150*	65,0 *2.559*	130,4 *5.134*	2,0 *4.410*
SAH-2340750003	02836726	BT50 ADB	80,0 *3.150*	70,0 *2.756*	171,8 *6.764*	4,6 *10.140*
SAH-2340740003	02836721	BT40 ADB	100,0 *3.937*	60,0 *2.362*	125,4 *4.937*	2,7 *5.950*
SAH-2340750004	02836727	BT50 ADB	100,0 *3.937*	70,0 *2.756*	171,8 *6.764*	5,1 *11.240*

Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj	Șurub clemă
		
60	HCM8X12X1/ISO4028	CHCM5X20/ISO4762
70	HCM8X16X1/ISO4028	CHCM6X20/ISO4762
80	HCM8X16X1/ISO4028	CHCM6X25/ISO4762
100	HCM10X20X1/ISO4028	CHCM8X25/ISO4762

Shrinkfit la capătul frontal





—Notă: Șuruburi de reglaj incluse în pachetul de livrare

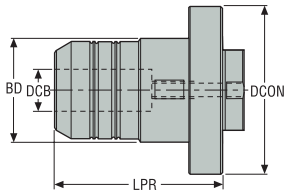
Reper Nr.	Număr reper	DCON	BD2	BD1	DCB	LSC	CBDP	LPR	Greutate	BHTA°
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
SAH-2341008236	10280202	60,0 *2.362*	27,0 *1.063*	21,0 *0.827*	8,0 *0.315*	26,0 *1.024*	36,0 *1.417*	70,0 *2.756*	0,5 *1.100*	4.5
SAH-2341012238	02836737	60,0 *2.362*	32,0 *1.260*	24,0 *0.945*	12,0 *0.472*	34,0 *1.339*	47,5 *1.870*	70,0 *2.756*	0,52 *1.150*	4.5
SAH-2341016241	02836741	70,0 *2.756*	34,0 *1.339*	27,0 *1.063*	16,0 *0.630*	39,0 *1.535*	50,5 *1.988*	75,0 *2.953*	0,7 *1.540*	4.5
SAH-2341020251	02836742	80,0 *3.150*	42,0 *1.654*	33,0 *1.299*	20,0 *0.787*	41,0 *1.614*	52,5 *2.067*	80,0 *3.150*	1,0 *2.200*	4.5
SAH-2341025260	02836743	100,0 *3.937*	53,0 *2.087*	44,0 *1.732*	25,0 *0.984*	47,0 *1.850*	58,5 *2.303*	80,0 *3.150*	2,2 *4.850*	4.5
SAH-2341032261	02836744	100,0 *3.937*	53,0 *2.087*	44,0 *1.732*	32,0 *1.260*	51,0 *2.008*	62,5 *2.461*	80,0 *3.150*	2,5 *5.510*	4.5

Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj
	
60	HCM6X12/ISO4028
70/80	HCM6X16/ISO4028
100	HCM8X12X1/ISO4028

Mandrină hidraulică la capătul frontal





—Notă: Șuruburi de reglaj incluse în pachetul de livrare

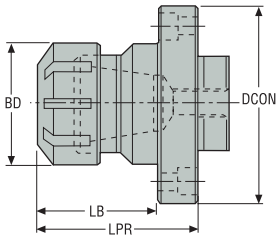
Reper Nr.	Număr reper	DCON	BD	DCB	LPR	Greutate
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SAH-2341106240	10280197	60,0 *2.362*	26,0 *1.024*	6,0 *0.236*	50,0 *1.969*	0,8 *1.760*
SAH-2341116253	02836749	70,0 *2.756*	38,0 *1.496*	16,0 *0.630*	50,0 *1.969*	0,75 *1.650*
SAH-2341104267	10280198	80,0 *3.150*	22,5 *0.886*	4,0 *0.157*	66,0 *2.598*	0,9 *1.980*
SAH-2341106268	10280199	80,0 *3.150*	26,5 *1.043*	6,0 *0.236*	64,5 *2.539*	0,9 *1.980*
SAH-2341108269	10280200	80,0 *3.150*	28,0 *1.102*	8,0 *0.315*	77,5 *3.051*	1,1 *2.430*
SAH-2341110242	10280201	80,0 *3.150*	30,0 *1.181*	10,0 *0.394*	77,5 *3.051*	1,1 *2.430*
SAH-2341112255	02836752	80,0 *3.150*	32,0 *1.260*	12,0 *0.472*	77,5 *3.051*	1,1 *2.430*
SAH-2341116256	02836754	80,0 *3.150*	38,0 *1.496*	16,0 *0.630*	82,5 *3.248*	1,2 *2.650*
SAH-2341120257	02836755	80,0 *3.150*	42,0 *1.654*	20,0 *0.787*	82,5 *3.248*	1,3 *2.870*
SAH-2341125258	02836756	80,0 *3.150*	50,0 *1.969*	25,0 *0.984*	90,0 *3.543*	1,7 *3.750*
SAH-2341112259	02836757	100,0 *3.937*	32,0 *1.260*	12,0 *0.472*	90,0 *3.543*	1,9 *4.190*
SAH-2341125260	02836758	100,0 *3.937*	50,0 *1.969*	25,0 *0.984*	100,0 *3.937*	2,8 *6.170*
SAH-2341132261	02836759	100,0 *3.937*	60,0 *2.362*	32,0 *1.260*	103,0 *4.055*	2,9 *6.390*

Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj
	
60	HCM6X12/ISO4028
70/80	HCM6X16/ISO4028
100	HCM8X12X1/ISO4028

Mandrină cu pensete ER la capătul frontal





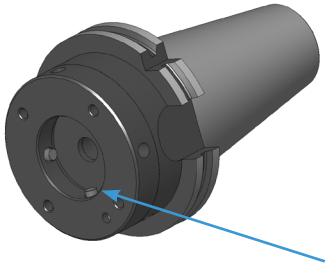
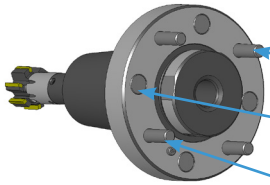
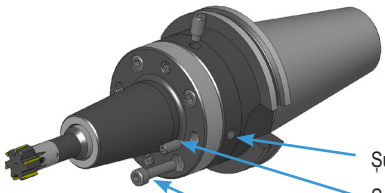
—Notă: Șuruburi de reglaj incluse în pachetul de livrare

Reper Nr.	Număr reper	Mărime	DCON	BD	LB	LPR	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SAH-23412ER25254	02836762	ER25	80,0 *3.150*	42,0 *1.654*	45,0 *1.772*	60,0 *2.362*	1,0 *2.200*
SAH-23412ER32255	02836763	ER32	80,0 *3.150*	50,0 *1.969*	45,0 *1.772*	60,0 *2.362*	1,2 *2.650*
SAH-23412ER40256	02836764	ER40	100,0 *3.937*	63,0 *2.480*	50,0 *1.969*	70,0 *2.756*	1,6 *3.530*

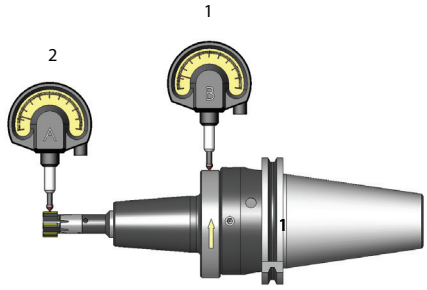
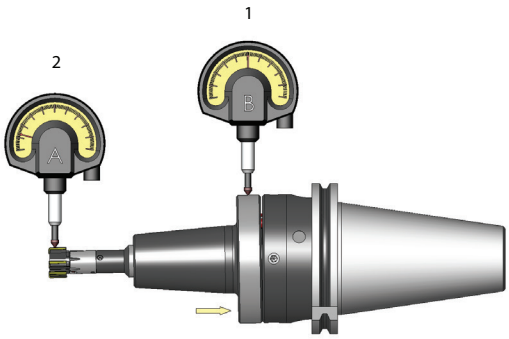
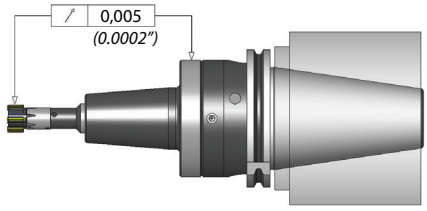
Piese de schimb, Piese incluse la livrare

Pentru DCON	Șurub reglaj
	
80	HCM6X16/ISO4028
100	HCM8X12X1/ISO4028

Instrucţiuni de asamblare

 Șuruburi de reglare radială	– Curăţaţi suprafaţa de contact – Asiguraţi-vă că șuruburile de reglare radială nu încurcă asamblarea
 Șurub de prindere Șuruburi de reglare unghiulară Știft de corectare (opţional)	– Asiguraţi-vă că șuruburile de reglare unghiulară nu încurcă asamblarea
 Șuruburi de reglare radială (4 buc.) Șuruburi de reglare unghiulară (4 buc.) Șuruburi de prindere (4 buc.)	– Treceţi la asamblare și strângeţi ușor șuruburile de prindere (x4)

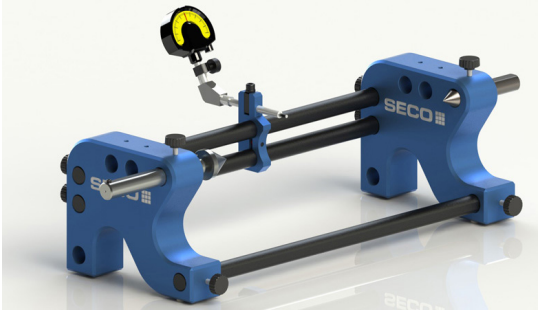
Instrucţiuni de reglare

– Montaţi scula în capul de alezare al utilajului – Reglaţi comparatorul 1 după cum este indicat (comparatorul 2 nu este necesar acum) – Rotiţi manual scula până se ajunge la punctul cel mai de jos – Treceţi la compensarea bătăii radiale, după cum indică săgeata – Verificaţi și repetaţi compensarea, dacă este nevoie	
– Reglaţi comparatorul 2 după cum este indicat – Rotiţi manual scula până se ajunge la punctul cel mai de jos – Treceţi la compensarea bătăii radiale, după cum indică săgeata – Verificaţi și repetaţi compensarea, dacă este nevoie	
– După ce aţi terminat reglarea, bătaia radială <5 µm *(197 µin)*, finalizaţi prinderea pentru a asigura asamblarea – Adaptorul reglabil poate fi presetat neatașat la utilaj, utilizând orice dispozitiv de presetare a sculelor disponibil în atelier – Reglarea finală trebuie efectuată întotdeauna pe capul de alezare al utilajului – Trebuie utilizat un comparator în microni. Se poate utiliza un singur comparator pentru ambele operaţii	

Prindere de reglare – comparator unic

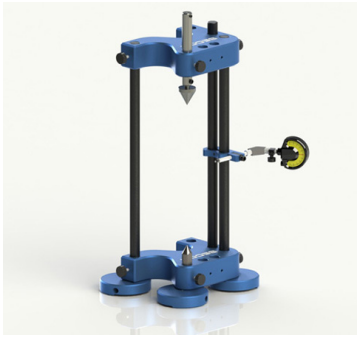
SF-210340-C160: Nr. reper pt. comandă 02885391

- Stand orizontal
- Prima alegere pentru alezoarele Xfix
- 1 comparator
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 340 mm *(13.386")*
- Încluse în pachetul de livrare: adiţional Ø 57 mmplus Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



SF-210290V-C160: Nr. reper pt. comandă 02885392

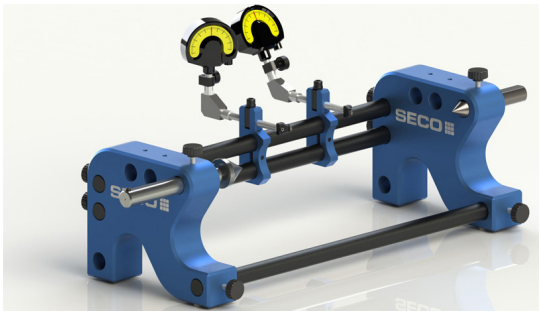
- Stand vertical
- Prima alegere pentru alezoarele Xfix
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 290 mm *(11.417")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



Prindere de reglare – comparator dublu

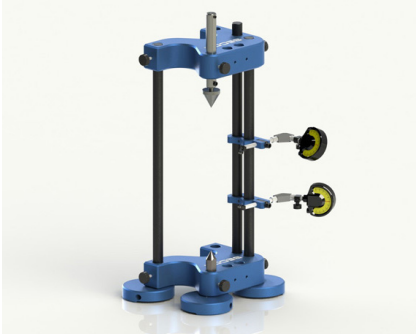
SF-210340-C160C190: Nr. reper pt. comandă 02885393

- Stand orizontal
- Prima alegere pentru alezoarele Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 340 mm *(13.386")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



SF-210290V-C160C190: Nr. reper pt. comandă 02885394

- Stand vertical
- Prima alegere pentru alezoarele Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 290 mm *(11.417")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620

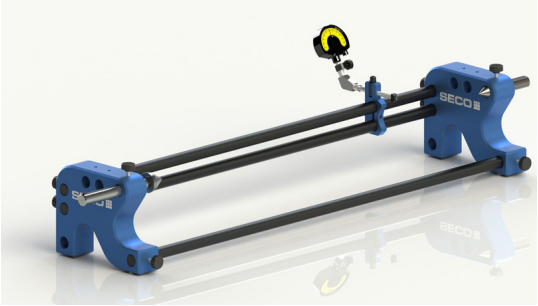


Pentru informaţii despre comandare, contactaţi reprezentantul local Seco Tools.

Prindere de reglare – comparator unic de mare capacitate

SF-210740-C160: Nr. reper pt. comandă 02885385

- Stand orizontal
- Prima alegere pentru alezoarele Xfix
- 1 comparator
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 740 mm *(29.134")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



SF-210690V-C160: Nr. reper pt. comandă 02885387

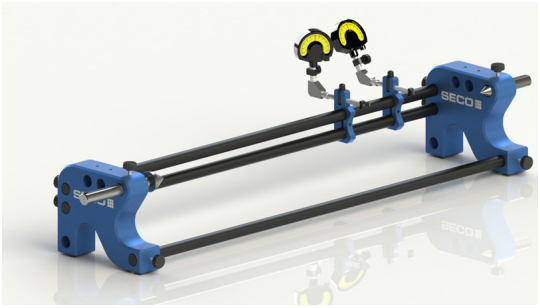
- Stand vertical
- Prima alegere pentru alezoarele Xfix
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 690 mm *(27.165")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



Prindere de reglare – comparator dublu de mare capacitate

SF-210740-C160C190: Nr. reper pt. comandă 02885388

- Stand orizontal
- Prima alegere pentru alezoarele Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 740 mm *(29.134")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



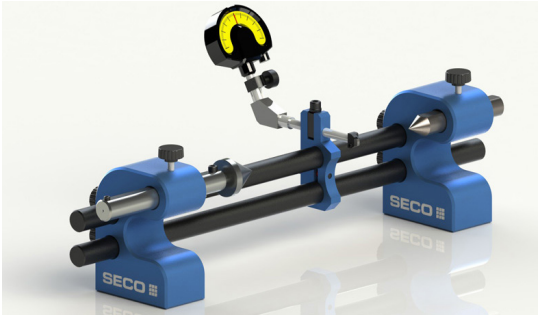
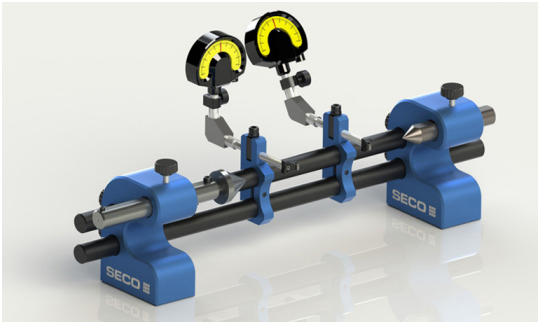
SF-210690V-C160C190: Nr. reper pt. comandă 02885390

- Stand vertical
- Prima alegere pentru alezoarele Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm *(8.268")*
- Lungime maximă a sculei: 690 mm *(27.165")*
- Incluse în pachetul de livrare: adiţional Ø 57 mm *(2.224")* centrare cu arc pentru
- HSK 63/80/100 și Capto C8 nr. reper 02208620



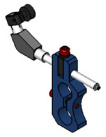
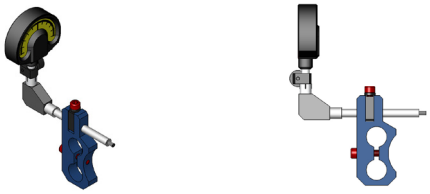
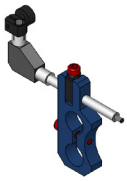
Pentru informaţii despre comandare, contactaţi reprezentantul local Seco Tools.

Prindere de reglare – compact

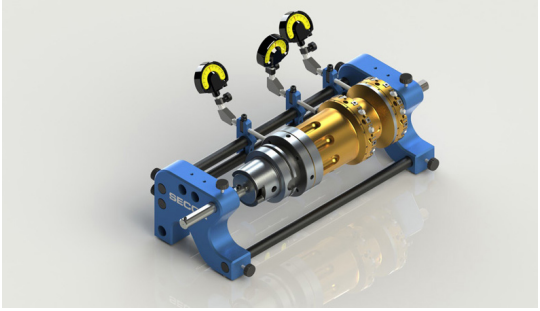
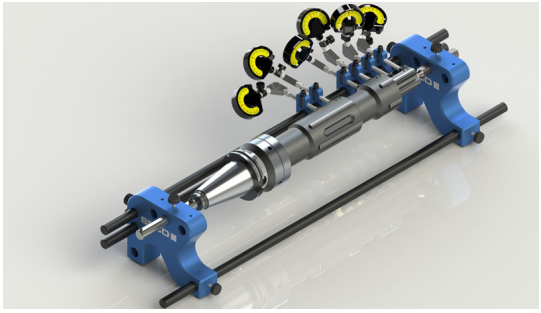
SF-60200-C160: Nr. reper pt. comandă 02885395 – Stand orizontal – Prima alegere pentru Ø mai mici de 60 mm *(2.362")* – 1 comparator – Ø maxim al sculei: 60,5 mm *(82.382")* – Lungime maximă a sculei: 200 mm *(7.874")*	
SF-60200-C160C190: Nr. reper pt. comandă 02885396 – Stand orizontal – Prima alegere pentru Ø mai mici de 60 mm *(2.362")* – 2 comparatoare – Ø maxim al sculei: 60,5 mm *(82.382")* – Lungime maximă a sculei: 200 mm *(7.874")*	

Pentru informaţii despre comandare, contactaţi reprezentantul local Seco Tools.

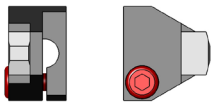
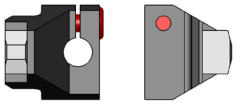
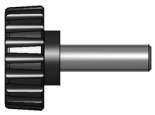
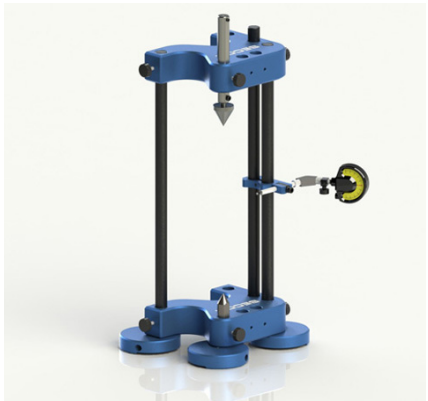
Braţe de măsurare suplimentare

	**SFB-60: Nr. reper pt. comandă 02208619** – Braţ de măsurare 60° – Ceas comparator inclus în livrare – Vârful de măsurare nu este inclus, consultaţi pagina 477
	**SFB-60 WC: Nr. reper pt. comandă 02885754** – Braţ pentru măsurare 60° – Comparatorul nu este inclus în pachet – Vârful de măsurare nu este inclus, vezi pag. 477
	**SFB-90: Nr. reper pt. comandă 02208622** – Braţ de măsurare 90° – Ceas comparator inclus în livrare – Vârful de măsurare nu este inclus, consultaţi pagina 477
	**SFB-90 WC: Nr. reper pt. comandă 02885755** – Braţ pentru măsurare 90° – Comparatorul nu este inclus în pachet – Vârful de măsurare nu este inclus, vezi pag. 477
	**DG-1: Nr. reper pt. comandă 75079579** – Cadran, 1 µm *(39 µin)*

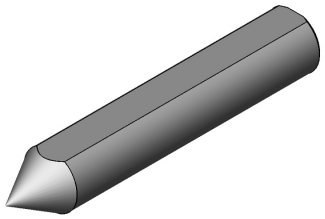
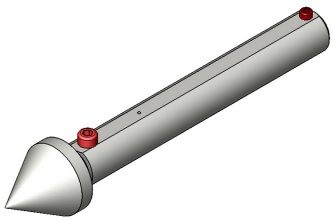
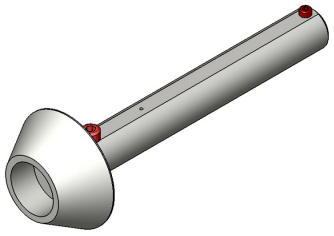
Exemplu de ansamblu de fixare cu mai multe comparatoare

Accesorii

	**SMES-406: Nr. reper pt. comandă 02819156** – Punct de măsurare pentru alezoare Xfix – Ø 4mm *(0,157")* – Cu vârf din carbură
	**SMES-900: Nr. reper pt. comandă 02208610** – Vârf de măsurare pentru alezoarele Bifix – Cu vârf din carbură
	**SMES-909: Nr. reper pt. comandă 02980090** – Punct de măsurare pentru alezoare Bifix – Cu vârf din carbură – 9 mm *(0,354")* decalat
	**SFHS-20: Nr. reper pt. comandă 2884025** – Șurub pentru fixare manuală – Adecvat pentru întreaga gamă de prindere de reglare
 	**SFVST- 100: Nr. reper pt. comandă 02884026** – Stand din oțel (set de 3) – Ø 100 mm *(3,937")* – Adecvat pentru a schimba prinderea de reglare orizontală la poziţie verticală

Vârfuri de centrare

SFC-2000HM: Nr. reper pt. comandă 02884023 – Punct central fix din carbură – Ø 20 mm *(0,787")* – Adecvat pentru gamele Xfix și Bifix standard și speciale – A se utiliza în partea frontală a sculei	
SSC-3400: Nr. reper pt. comandă 02208617 – Punct central cu arc – Ø 34 mm *(1,339")* – Adecvat pentru gamele Xfix și Bifix standard și speciale – A se utiliza în partea posterioară a sculei – Nu este adecvat pentru HSK63/80/100 și Capto C8	
SSC5700: Nr. reper pt. comandă 02208620 – Punct central cu arc – Trunchi de con Ø 57 mm *(2,244")* – Adecvat pentru gamele Xfix și Bifix standard și speciale – A se utiliza în partea posterioară a sculei – Adecvat pentru HSK63/80/100 și Capto C8	

Prezentare generală

Capete de alezare RB750, alezare de degroșare

Cap de alezare cu două port-plăcuţe cu mecanism de cuplare



Pag. 485-491

- Rată mare de îndepărtare a materialului, geometrie și poziţionare precise ale găurii
- Setare simetrică și alternantă
- Reglare simultană datorită mecanismului de cuplare a suporturilor de plăcuță
- Cu conexiuni Graflex® sau Seco Capto™

Interval de diametre între 18 mm și 205 mm
(0,709 și 8,071")

IT 9/10

Capete de alezare RB610, alezare de degroșare

Capete de așchiere duble, lungimi scurte



Pag. 497-500

- Rată mare de îndepărtare a materialului, geometrie și poziţionare precise ale găurii
- Setare simetrică și alternantă
- Cu conexiune Graflex® pentru sistem modular Graflex®
- Cu conexiune GL sau BA pentru bare antivibraţii Steadyline®

Interval de diametre între 28 mm și 116 mm
(1,102 și 4,567")

IT 9/10

Capete de alezare FB 760, tip Axiabore™, alezare de precizie

Capete de alezat de finisare, cu scule montate axial



Pag. 506-524

- Reglare micrometrică pentru o precizie a găurii de până la IT5
- Rigiditate mare a sculei pentru poziţionare și geometrie precise ale găurii
- Cap Nanobore™ pentru diametre mai mici
- Axialibrabore™ și - Axialibrabore™ Plus - pot fi echilibrate de precizie, adecvate HSM
- Adaptor multifuncţional (MPA) pentru diametre de alezare mai mari, teșire a muchiilor OD și canelare
- Cu conexiuni Graflex® sau Seco Capto™
- Este disponibilă și versiiunea digitală, pentru o reglare ușoară și rapidă a diametrului

Interval de diametre între 0,3 și 108 mm
(0,012 și 4,252")

+ teșire a muchiilor OD și prelucrare canale frontale

IT 5/6

Graflex® și Seco Capto ™

Graflex® și Seco Capto™ arbori, extensii și reductoare pentru a construi bare de alezare



Pag. 598-649

- Ansamblurile de bare de alezare pot fi construite rapid împreună la cele mai apropiate nevoi, fie prin utilizarea sistemelor modulare Graflex sau Seco Capto™, inclusiv o gamă largă de arbori și intermediari.
- Ambele sisteme oferă o conexiune rigidă și precisă pentru aplicaţiile de degroșare sau pentru finisare.
- Modulele pot primi, de asemenea, un număr mare de suporturi de scule, cum ar fi mandrine cu pensetă, mandrine hidraulice etc. (Consultaţi catalogul sistemelor de scule).

Prezentare generală

FB780, FB790, FB620 capete de alezare de finisare, tip radial

Capete de alezare fină, cu port-plăcuţe radiale





Pag. 543-551

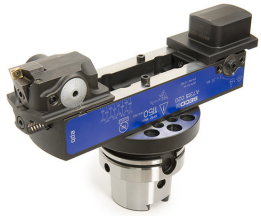
- Reglare micrometrică la 2,5 microni pentru o precizie a găurii de până la IT5
- Poziţionare şi geometrie precise ale găurii
- Capetele A790 Libraflex® pot fi echilibrate cu precizie, suport de plăcuţă adecvat HSM, pentru cea mai înaltă fiabilitate
- Se pot executa alezaje lungi, cu extensii din carbură (până la 7xD) sau cu bare Steadyline® (până la 10xD)
- Se pot utiliza la şanfrenare sau alezare inversă
- Cu conexiuni Graflex® sau Seco Capto™ pentru sisteme modulare
- Cu conexiune GL sau BA pentru barele antivibraţii Steadyline®

Interval de diametre între 15 mm și 205 mm
(0.591 și 8.071")

IT 5 și IT6

Traversele BB731S și traversele Jumbo JBB731S, traversele BB732 pentru Steadyline®

Pentru degroșarea și alezarea fină a diametrelor mari





Pag. 553-570

BB731S & JBB731S:

- Blocuri de alezare pentru alezare de degroșare și de precizie, alezare OD și alezare inversă
- Model robust pentru o rată mare de îndepărtare a materialului la alezarea de degroșare
- Reglare micrometrică pentru alezare de precizie
- Model optimizat de blocuri de alezat și bare de alezat mari realizate din aluminiu rezistent la efort pentru viteze mari
- Destinate instalării în suporturi de freză, tip de prindere cu flanșă

BB732:

- Conceput pentru a fi utilizat cu suporturile Steadyline pentru alezare adâncă, o calitate mai bună a suprafeţei, o productivitate mai mare și o durată de viaţă mai lungă a sculei
- Gama de diametre între 114-300 mm (4,488-11,811") pentru degroșare și 315 mm (12,402") pentru finisare

Interval Ø între 204 și 3205 mm
(8,031-126,181")

IT 5/6 (alezare de finisare) sau 9/10 (alezare de degroșare)
+ OD-alezare exterioară

IT6

Ø range 114 to 315 mm
(4.488-12.402")

Plăcuţe pentru alezare



Pag. 584-596

- Pentru operaţii de alezare în toate materialele
- Rezilienţă mare pentru degroșare
- Geometrii pozitive pentru finisare
- Calităţi pentru o durată mare de viaţă a sculei

Sistem modular port-sculă Graflex® sau Seco Capto™



Pag. 597-599

- Capetele de alezare dispun de coadă cu conexiune Graflex® sau Seco Capto™ pe partea utilajului, permiţând o gamă completă de lungimi și diametre de alezare
- Selectaţi arborii Graflex® sau Seco Capto™ necesari (HSK, DIN, BT, ANSI-CAT, Seco Capto™) și intermediarele și piesele de schimb pentru conexiunile Graflex® pentru capetele de alezare sunt prezentate în acel capitol

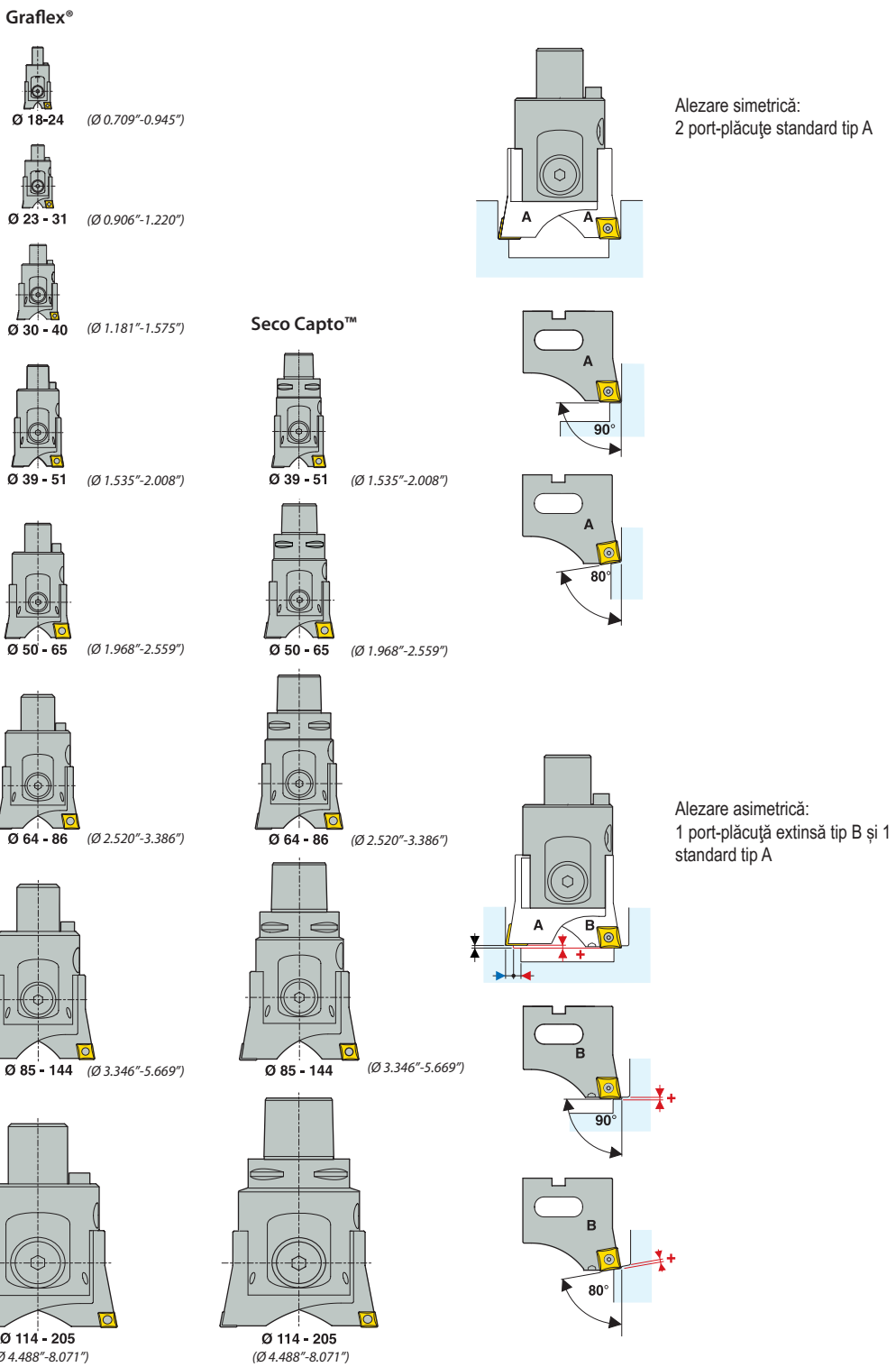


Alezare de degroșare

Gama de produse Seco pentru alezare de degroșare maximizează ratele de evacuare a materialului și precizia prin performanţe robuste și foarte rigide. Concepută pentru modele simetrice și alternante. Soluţiile de amortizare a vibraţiilor Steadyline™ completează gama, pentru a oferi niveluri și mai mari de stabilitate pentru prelucrarea cavităţilor adânci, în care sunt necesare console de scule lungi.

— Capetele de alezare de degroșare RB 750 oferă cele mai înalte performanţe de alezare de degroșare posibile
— Capetele de alezare de degroșare RB 610 sunt capete de alezare scurte, simple, pentru operaţii de degroșare

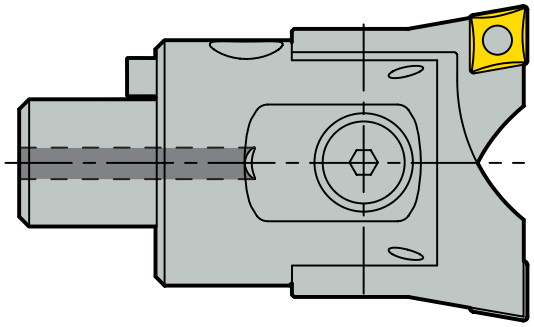
Vedere generală Capetele de alezat de degroșare



Caracteristici

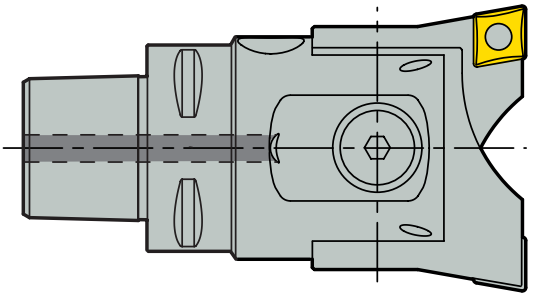
Capete de alezare de degroșare Graflex®

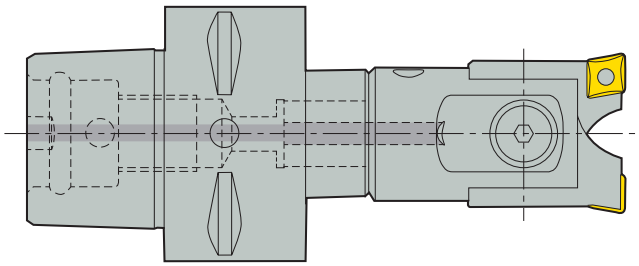
– Ø 18-205 mm *(0,709-8,071")*
– 8 capete de alezare de degroșare RB 750 cu conexiune Graflex® pentru alezaje cu diametrul între 18 și 205 mm *(0,709-8,071")*



Capete de alezare de degroșare Seco Capto™

– **Notă:** Alezajul minim al celui mai mic cap de alezare de degroșare Capto™ este Ø 39 mm *(1,535")* cu cea mai mică conexiune Capto™ C3 disponibilă.
– Pentru Ø 18-40 mm *(0,709-1,575")*, utilizați capete de alezare Graflex® cu mărimi de conexiune între G0 și G2 în combinație cu adaptorul Capto™/Graflex® adecvat.
– **Notă:** Caracteristici, instrucțiuni (procedura de instalare a suportului de plăcuță, setarea diametrului, instrucțiuni pentru alezarea inversă, depanare, condiție recomandate de prelucrare, viteze maxime), suporturile de plăcuțe și plăcuțele adecvate sunt similare pentru ambele tipuri de capete de alezare de degroșare RB 750 cu capacitate de alezare similară, indiferent de tipul de conexiune.
– Ansambluri modulare și condiții de prelucrare pentru adaptoare și extensii modulare Seco Capto™ și Graflex®: consultați catalogul de sisteme de scule.



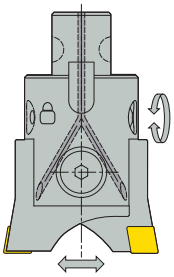


Caracteristici

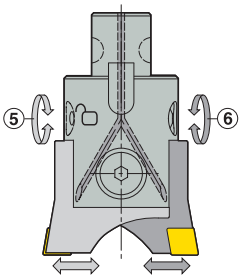
Un ansamblu/cap pentru alezare de degroșare este compus dintr-un corp (cap) 2 portplăcuțe

Este posibilă reglarea simultană sau independentă a port-plăcuţelor:

Reglare simultană cu ajutorul mecanismului de cuplare al suporturilor de plăcuță (capetele cele mai mici ∅ 18-24 mm *(0,709-0,9445")* nu au mecanism de cuplare). Fiecare șurub de cuplare deplasează ambele portplăcuţe simultan (sunt cuplate). Este posibilă reglarea diametrului fără preseter (1 treaptă = 0,1 mm *(0,004")* în diametru). Este posibilă și reglarea independentă: decuplaţi mecanismul de cuplare și fiecare șurub de reglare va acţiona doar asupra suportului său de plăcuță.



Reglare simultană



Reglare independentă

Alezare simetrică:

Alezare simetrică înseamnă că ambele muchii de tăiere au același diametru: Sunt necesare două port-plăcuţe standard tip A identice (cu același unghi de atac).

Alezare asimetrică:

Alezare alternantă înseamnă că o muchie aşchietoare este decalată ca muchie aşchietoare primară care funcţionează la un diametru mai mic decât a doua muchie reglată la diametrul de executat: Necesită un suport de plăcuță standard tip A și un suport de plăcuță extins tip B, pentru a obţine decalarea axială (+) dorită.

Suporturi de plăcuţe cu unghi de avans de 90° sau 80°

Suporturile de plăcuţe A75…CC… și A75…CP… au un unghi de avans de 90° pentru plăcuţe rombice: în principal adecvate pentru găuri înfundate și necesită un cuplu mai mic al capului de alezare.
Port-plăcuţele A75...SC... au unghiul de atac de 80° pentru plăcuţele pătrate: folosite în general la găuri străpunse și în condiţii grele. Orientarea unghiurilor de aşchiere conform ISO.

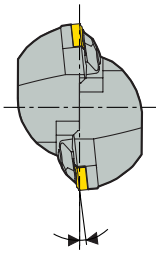
Suporturi de plăcuţă tip CC, CP, SC sau CN

Suporturile de plăcuţă A750...CC..., A750...CP... și A750...SC... au unghi de degajare de 0° (GAMO) și unghi de înclinaţie 0° (LAMS).

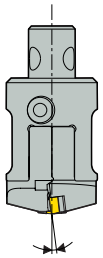
Suporturile de plăcuţă A750...CN... au unghi de degajare -6° (GAMO) și unghi de înclinare -6° (LAMS), permiţând utilizarea de plăcuţe CNMM negative și, în special, plăcuţe CNMG cu 4 muchii aşchietoare.

În acest caz, este important să se aleagă plăcuţele CN recomandate și să se respecte regimurile de aşchiere recomandate (vezi pag. 588).

Folosind alte plăcuţe, ex. cu unghiul de tăiere diferit, și/sau alte regimuri de aşchiere poate duce la deteriorarea utilajului și/sau a semifabricatului.



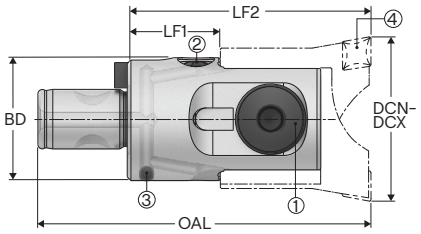
GAMO



LAMS

RB750
Graflex®



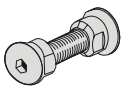


1. Șurub asamblare
2. Șurub reglaj
3. Șurub de blocare pentru mecanismul de cuplare
4. Șurub de blocare a plăcuţei

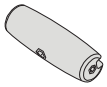
—Este posibilă o alezare simetrică și decalată
—Reglare simultană prin mecanismul de cuplare a suporturilor de plăcuţe

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	Modul de reglare simultană		Mod de reglare independent		RPM max.
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	Da	Nu	Da	Nu	
A75000	00026687	G0	18,0 *0.709*	24,0 *0.945*	38,0 *1.496*	12,5 *0.492*	35,0 *1.378*	16,5 *0.650*	0,1 *0.220*		■	■		15000
A75010	00026688	G1	23,0 *0.906*	31,0 *1.220*	42,5 *1.673*	13,5 *0.531*	40,0 *1.575*	21,5 *0.846*	0,1 *0.220*	■		■		12000
A75020	00026689	G2	30,0 *1.181*	40,0 *1.575*	51,0 *2.008*	16,0 *0.630*	46,0 *1.811*	27,0 *1.063*	0,2 *0.440*	■		■		9500
A75030	00026690	G3	39,0 *1.535*	51,0 *2.008*	69,0 *2.717*	24,0 *0.945*	65,0 *2.559*	35,0 *1.378*	0,3 *0.660*	■		■		7500
A75040	00026691	G4	50,0 *1.969*	65,0 *2.559*	78,0 *3.071*	27,0 *1.063*	72,0 *2.835*	43,0 *1.693*	0,5 *1.100*	■		■		5700
A75050	00026692	G5	64,0 *2.520*	86,0 *3.386*	92,0 *3.622*	30,0 *1.181*	82,0 *3.228*	54,0 *2.126*	0,9 *1.980*	■		■		4500
A75060	00026693	G6	85,0 *3.346*	144,0 *5.669*	119,0 *4.685*	37,0 *1.457*	105,0 *4.134*	70,0 *2.756*	1,8 *3.970*	■		■		3500
A75070	00026694	G7	114,0 *4.488*	205,0 *8.071*	143,0 *5.630*	39,0 *1.535*	120,0 *4.724*	95,0 *3.740*	3,7 *8.160*	■		■		2500

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cep
		
A75000	90A75000	90M0
A75010	90A75010	90M11
A75020	90A75020	90M21
A75030	90A75030	90M31
A75040	90A75040	90M41
A75050	90A75050	90M51
A75060	90A75060	90M61
A75070	90A75070	90M71

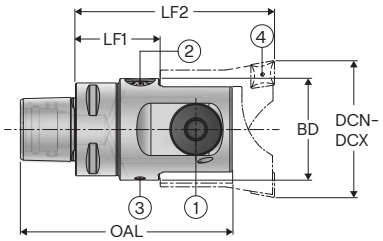
Accesorii

Pentru cap	Cheie clemă	Cheie de ghidare	Cheie plăcuţă	Cheie (tip T)	Cheie de reglare
					
A75000	03HL03	–	H4B-T07P	DOUBLE-T	H1.5-2D
A75010	03HL03	H4B-T06P	H4B-T07P	DOUBLE-T	H1.5-2D
A75020	03HL04	H4B-T07P	–	DOUBLE-T	H2.0-2D
A75030	03HL05	H4B-T08P	–	DOUBLE-T	H2.0-2D
A75040	03HL05	H4B-T09P	–	DOUBLE-T	H2.5-2D
A75050	03HL06	–	–	DOUBLE-T	03M03C
A75060	03HL08	–	–	DOUBLE-T	H04-4
A75070	03HL10	H4B-T15P	H4B-T15PL	DOUBLE-T	H04-4

RB750

Seco Capto™



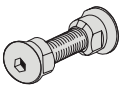


1. Șurub asamblare
2. Șurub reglaj
3. Șurub de blocare pentru mecanismul de cuplare
4. Șurub de blocare a plăcuței

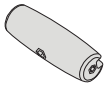
—Este posibilă o alezare simetrică și decalată
—Reglare simultană prin mecanismul de cuplare a suporturilor de plăcuțe

Reper Nr.	Număr reper	Spre mașină	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	Modul de reglare simultană		Mod de reglare independent		RPM max.
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	Da	Nu	Da	Nu	
C3-391.0750-30	02809726	C3	39,0 *1.535*	51,0 *2.008*	73,0 *2.874*	29,0 *1.142*	70,0 *2.756*	35,0 *1.378*	0,3 *0.660*	■		■		7500
C4-391.0750-40	02809728	C4	50,0 *1.969*	65,0 *2.559*	88,0 *3.465*	37,0 *1.457*	82,0 *3.228*	43,0 *1.693*	0,6 *1.320*	■		■		5700
C5-391.0750-50	02809733	C5	64,0 *2.520*	86,0 *3.386*	102,0 *4.016*	40,0 *1.575*	92,0 *3.622*	54,0 *2.126*	1,0 *2.200*	■		■		4500
C6-391.0750-60	02809735	C6	85,0 *3.346*	144,0 *5.669*	129,0 *5.079*	49,0 *1.929*	117,0 *4.606*	70,0 *2.756*	1,9 *4.190*	■		■		3500
C8-391.0750-70	02809736	C8	114,0 *4.488*	205,0 *8.071*	159,0 *6.260*	57,0 *2.244*	138,0 *5.433*	95,0 *3.740*	4,1 *9.040*	■		■		2500

Piese de schimb, Piese incluse la livrare

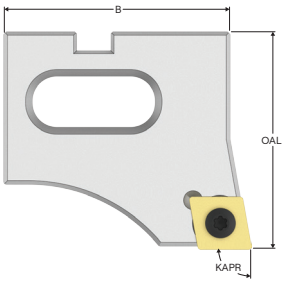
Pentru cap	Șurub ansamblu
	
C3-...-30	90A75030
C4-...-40	90A75040
C5-...-50	90A75050
C6-...-60	90A75060
C8-...-70	90A75070

Accesorii

Pentru cap	Cheie clemă	Cheie de ghidare	Cheie (tip T)	Cheie de reglare
				
C3-...-30	03HL05	H4B-T08P	DOUBLE-T	H2.0-2D
C4-...-40	03HL05	H4B-T09P	DOUBLE-T	H2.5-2D
C5-...-50	03HL06	–	DOUBLE-T	03M03C
C6-...-60	03HL08	–	DOUBLE-T	H04-4
C8-...-70	03HL10	–	DOUBLE-T	H04-4

Portplăcuță 90° pentru plăcuțe CC.. și CP..

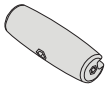




—Pentru montarea pe capete RB 750
—Alezarea simetrică necesită două suporturi standard pentru plăcuțe de tip A.
—Alezarea decalată necesită un suport standard de tip A și un suport extins de tip B.

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX ∅		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
A75000CP0590	00026695	Standard type A	RB 75000	18,0 *0.709*	24,0 *0.945*	22,5 *0.886*	16,5 *0.650*	0,1 *0.2*	90	CP...0502...
A75010CC0690	00026696	Standard type A	RB 75010	23,0 *0.906*	31,0 *1.220*	26,5 *1.043*	21,5 *0.846*	0,1 *0.2*	90	CC...0602...
A75020CC0690	00026697	Standard type A	RB 75020	30,0 *1.181*	40,0 *1.575*	30,0 *1.181*	27,0 *1.063*	0,1 *0.2*	90	CC...0602...
A75030CC0990	00026698	Standard type A	RB 75030	39,0 *1.535*	51,0 *2.008*	41,0 *1.614*	35,0 *1.378*	0,1 *0.2*	90	CC...09T3...
A75040CC1290	00026699	Standard type A	RB 75040	50,0 *1.969*	65,0 *2.559*	45,0 *1.772*	43,0 *1.693*	0,2 *0.4*	90	CC...1204...
A75050CC1290	00026700	Standard type A	RB 75050	64,0 *2.520*	86,0 *3.386*	52,0 *2.047*	54,0 *2.126*	0,3 *0.7*	90	CC...1204...
A75060CC1290	00026701	Standard type A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,6 *1.3*	90	CC...1204...
A75060CC1690	00030763	Standard type A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,6 *1.3*	90	CC...1605...
A75065CC1290	00026702	Standard type A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	0,9 *2.0*	90	CC...1204...
A75065CC1690	00030765	Standard type A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	0,9 *2.0*	90	CC...1605...
A75070CC1290	00026703	Standard type A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,0 *3.189*	95,0 *3.740*	1,2 *2.7*	90	CC...1204...
A75070CC1690	00030766	Standard type A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,0 *3.189*	95,0 *3.740*	1,2 *2.7*	90	CC...1605...
A75075CC1290	00026704	Standard type A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,0 *3.189*	141,0 *5.551*	2,0 *4.4*	90	CC...1204...
A75075CC1690	00030771	Standard type A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,0 *3.189*	141,0 *5.551*	2,0 *4.4*	90	CC...1605...

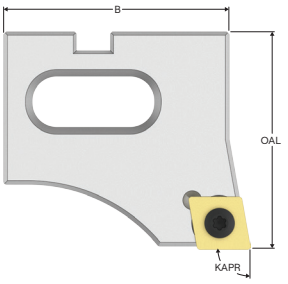
Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuței	Cheie plăcuță	Cheie (tip T)	Șurub
			
CC...0602...	H4B-T07P	DOUBLE-T	C02504-T07P
CC...09T3...	H4B-T15P	DOUBLE-T	C04008-T15P
CC...1204...	H4B-T15P	DOUBLE-T	C05012-T15P
CC...1605...	H4B-T15P	DOUBLE-T	C05012-T15P
CP...0502...	H4B-T07P	DOUBLE-T	C02245-T07P

Pentru plăcuțe recomandate pentru alezare de degroșare, consultați pagina (paginile) 588

Portplăcuţă 90° pentru plăcuţe CC.. și CP..

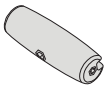




—Pentru montarea pe capete RB 750
—Alezarea simetrică necesită două suporturi standard pentru plăcuțe de tip A.
—Alezarea decalată necesită un suport standard de tip A și un suport extins de tip B.

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX ∅		OAL	B	Greutate	KRINS°	Mărimea plăcuţei potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
A75001CP0590	00026705	Extended type B	RB 75000	18,0 *0.709*	24,0 *0.945*	22,8 *0.898*	16,5 *0.650*	0,1 *0.2*	90	CP...0502...
A75011CC0690	00026706	Extended type B	RB 75010	23,0 *0.906*	31,0 *1.220*	26,85 *1.057*	21,5 *0.846*	0,1 *0.2*	90	CC...0602...
A75021CC0690	00026707	Extended type B	RB 75020	30,0 *1.181*	40,0 *1.575*	30,35 *1.195*	27,0 *1.063*	0,1 *0.2*	90	CC...0602...
A75031CC0990	00026708	Extended type B	RB 75030	39,0 *1.535*	51,0 *2.008*	41,4 *1.630*	35,0 *1.378*	0,1 *0.2*	90	CC...09T3...
A75041CC1290	00026709	Extended type B	RB 75040	50,0 *1.969*	65,0 *2.559*	46,5 *1.831*	43,0 *1.693*	0,2 *0.4*	90	CC...1204...
A75051CC1290	00026710	Extended type B	RB 75050	64,0 *2.520*	86,0 *3.386*	52,6 *2.071*	54,0 *2.126*	0,25 *0.6*	90	CC...1204...
A75061CC1290	00026711	Extended type B	RB 75060	85,0 *3.346*	115,0 *4.528*	68,6 *2.701*	70,0 *2.756*	0,6 *1.3*	90	CC...1204...
A75061CC1690	00030774	Extended type B	RB 75060	85,0 *3.346*	115,0 *4.528*	68,6 *2.701*	70,0 *2.756*	0,6 *1.3*	90	CC...1605...
A75066CC1290	00026712	Extended type B	RB 75060	114,0 *4.488*	144,0 *5.669*	68,6 *2.701*	100,0 *3.937*	1,0 *2.2*	90	CC...1204...
A75066CC1690	00030775	Extended type B	RB 75060	114,0 *4.488*	144,0 *5.669*	68,6 *2.701*	100,0 *3.937*	0,91 *2.0*	90	CC...1605...
A75071CC1290	00026713	Extended type B	RB 75070	114,0 *4.488*	160,0 *6.299*	81,6 *3.213*	95,0 *3.740*	1,2 *2.7*	90	CC...1204...
A75071CC1690	00030776	Extended type B	RB 75070	114,0 *4.488*	160,0 *6.299*	81,6 *3.213*	95,0 *3.740*	1,16 *2.6*	90	CC...1605...
A75076CC1290	00026714	Extended type B	RB 75070	159,0 *6.260*	205,0 *8.071*	81,6 *3.213*	141,0 *5.551*	2,0 *4.4*	90	CC...1204...
A75076CC1690	00030778	Extended type B	RB 75070	159,0 *6.260*	205,0 *8.071*	81,6 *3.213*	141,0 *5.551*	0,9 *2.0*	90	CC...1605...

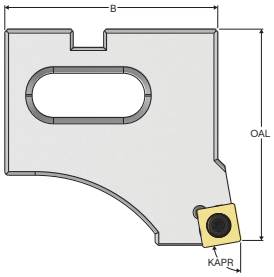
Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuţei	Cheie (tip T)	Cheie	Șurub
			
CC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
CC...09T3...	DOUBLE-T	H6B-T15P	C04008-T15P
CC...1204...	DOUBLE-T	H6B-T15P	C05012-T15P
CC...1605...	DOUBLE-T	H6B-T15P	C05012-T15P
CP...0502...	DOUBLE-T	H4B-T07P	C02245-T07P

Pentru plăcuțe recomandate pentru alezare de degroșare, consultaţi pagina (paginile) 588

Portplăcuță 80° pentru plăcuțe SC..



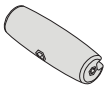


—Pentru montarea pe capete RB 750
—Alezarea simetrică necesită două suporturi standard pentru plăcuțe de tip A.
—Alezarea decalată necesită un suport standard de tip A și un suport extins de tip B.

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX ∅		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
A75000SC0580	00026715	Standard type A	RB 75000	18,0 *0.709*	24,0 *0.945*	22,5 *0.886*	16,5 *0.650*	0,1 *0.2*	80	SC...0502...
A75010SC0680	00026716	Standard type A	RB 75010	23,0 *0.906*	31,0 *1.220*	26,5 *1.043*	21,5 *0.846*	0,1 *0.2*	80	SC...0602...
A75020SC0680	00026717	Standard type A	RB 75020	30,0 *1.181*	40,0 *1.575*	30,0 *1.181*	27,0 *1.063*	0,1 *0.2*	80	SC...0602...
A75030SC0980	00026718	Standard type A	RB 75030	39,0 *1.535*	51,0 *2.008*	41,0 *1.614*	35,0 *1.378*	0,1 *0.2*	80	SC...09T3...
A75040SC1280	00026719	Standard type A	RB 75040	50,0 *1.969*	65,0 *2.559*	45,0 *1.772*	43,0 *1.693*	0,2 *0.4*	80	SC...1204...
A75050SC1280	00051986	Standard type A	RB 75050	64,0 *2.520*	86,0 *3.386*	52,0 *2.047*	54,0 *2.126*	0,3 *0.7*	80	SC...1204...
A75060SC1280	00052207	Standard type A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,56 *1.2*	80	SC...1204...
A75060SC1580	00039863	Standard type A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	70,0 *2.756*	0,56 *1.2*	80	SC...1505...
A75065SC1280	00051989	Standard type A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	1,0 *2.2*	80	SC...1204...
A75065SC1580	00039865	Standard type A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	100,0 *3.937*	1,0 *2.2*	80	SC...1505...
A75070SC1280	00026723	Standard type A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,4 *3.205*	95,0 *3.740*	1,2 *2.7*	80	SC...1204...
A75070SC1580	00039867	Standard type A	RB 75070	114,0 *4.488*	160,0 *6.299*	81,4 *3.205*	95,0 *3.740*	1,18 *2.6*	80	SC...1505...
A75075SC1280	00026724	Standard type A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,4 *3.205*	141,0 *5.551*	2,2 *4.9*	80	SC...1204...
A75075SC1580	00039869	Standard type A	RB 75070	159,0 *6.260*	205,0 *8.071*	81,4 *3.205*	141,0 *5.551*	2,1 *4.6*	80	SC...1505...
A75001SC0580	00092946	Extended type B	RB 75000	18,0 *0.709*	24,0 *0.945*	23,2 *0.913*	16,5 *0.650*	0,01 *0.0*	80	SC...0502...
A75011SC0680	00092947	Extended type B	RB 75010	23,0 *0.906*	31,0 *1.220*	27,3 *1.075*	21,5 *0.846*	0,02 *0.0*	80	SC...0602...
A75021SC0680	00092948	Extended type B	RB 75020	30,0 *1.181*	40,0 *1.575*	30,9 *1.217*	27,0 *1.063*	0,04 *0.1*	80	SC...0602...
A75031SC0980	00092949	Extended type B	RB 75030	39,0 *1.535*	51,0 *2.008*	42,2 *1.661*	35,0 *1.378*	0,08 *0.2*	80	SC...09T3...
A75041SC1280	00092961	Extended type B	RB 75040	50,0 *1.969*	65,0 *2.559*	46,4 *1.827*	43,0 *1.693*	0,2 *0.4*	80	SC...1204...
A75051SC1280	00092962	Extended type B	RB 75050	64,0 *2.520*	86,0 *3.386*	53,7 *2.114*	54,0 *2.126*	0,3 *0.7*	80	SC...1204...
A75061SC1580	00039864	Extended type B	RB 75060	85,0 *3.346*	115,0 *4.528*	70,3 *2.768*	70,0 *2.756*	0,57 *1.3*	80	SC...1505...
A75061SC1280	00092963	Extended type B	RB 75060	85,0 *3.346*	115,0 *4.528*	69,8 *2.748*	70,0 *2.756*	0,57 *1.3*	80	SC...1204...
A75066SC1280	00092964	Extended type B	RB 75060	114,0 *4.488*	144,0 *5.669*	69,8 *2.748*	100,0 *3.937*	0,96 *2.1*	80	SC...1204...
A75066SC1580	00039866	Extended type B	RB 75060	114,0 *4.488*	144,0 *5.669*	70,3 *2.768*	100,0 *3.937*	0,96 *2.1*	80	SC...1505...
A75071SC1280	00092965	Extended type B	RB 75070	114,0 *4.488*	160,0 *6.299*	82,8 *3.260*	95,0 *3.740*	1,2 *2.7*	80	SC...1204...
A75071SC1580	00039868	Extended type B	RB 75070	114,0 *4.488*	160,0 *6.299*	83,3 *3.280*	95,0 *3.740*	1,21 *2.7*	80	SC...1505...

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX ∅		OAL	B	Greutate	KRINS°	Mărimea plăcuţei potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
A75076SC1280	00092968	Extended type B	RB 75070	159,0 *6.260*	205,0 *8.071*	82,8 *3.260*	141,0 *5.551*	2,16 *4.8*	80	SC...1204...
A75076SC1580	00039870	Extended type B	RB 75070	159,0 *6.260*	205,0 *8.071*	83,3 *3.280*	141,0 *5.551*	2,14 *4.7*	80	SC...1505...

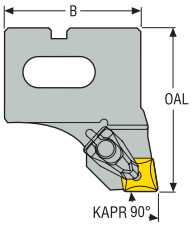
Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuţei	Cheie (tip T)	Cheie	Șurub
			
SC...0502...	DOUBLE-T	H4B-T07P	C02245-T07P
SC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
SC...09T3...	DOUBLE-T	–	C04008-T15P
SC...09T3...	DOUBLE-T	H6B-T15P	C04008-T15P
SC...1204...	DOUBLE-T	H6B-T15P	C05012-T15P
SC...1204...	DOUBLE-T	H6B-T15PL	C05012-T15P
SC...1505...	DOUBLE-T	H6B-T15P	C05012-T15P

Pentru plăcuţe recomandate pentru alezare de degroșare, consultaţi pagina (paginile) 588

Portplăcuță 90° pentru plăcuțe CN..





—Pentru montarea pe capete RB 750
—Alezarea simetrică necesită două suporturi standard pentru plăcuțe de tip A (suporturi extinse pentru plăcuțe de tip B pentru CN.. inserțiile nu sunt disponibile)
—GAMO = Unghi de degajare = - 6°
—LAMS = Unghiul de înclinare = - 6°

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX ∅		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
A75050CN1290	02786307	Standard type A	RB 75050	64,0 *2.520*	86,0 *3.386*	63,0 *2.480*	55,0 *2.165*	0,4 *0.9*	90	CN...1204...
A75060CN1290	02786308	Standard type A	RB 75060	85,0 *3.346*	115,0 *4.528*	68,0 *2.677*	69,5 *2.736*	0,6 *1.3*	90	CN...1204...
A75065CN1290	02786309	Standard type A	RB 75060	114,0 *4.488*	144,0 *5.669*	68,0 *2.677*	99,5 *3.917*	0,9 *2.0*	90	CN...1204...
A75070CN1290	02786310	Standard type A	RB 75070	114,0 *4.488*	160,0 *6.299*	85,0 *3.346*	95,0 *3.740*	1,2 *2.7*	90	CN...1204...
A75075CN1290	02786311	Standard type A	RB 75070	159,0 *6.260*	205,0 *8.071*	85,0 *3.346*	140,0 *5.512*	2,03 *4.5*	90	CN...1204...

Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuței	Șurub nicovală	Set clemă	Nicovală	Cheie
				
CN...1204...	CSC6312-T15P	CD12-S12	UCN120612	H6B-T15P

Pentru plăcuțe recomandate pentru alezare de degroșare, consultați pagina (paginile) 588

Instrucţiuni

Condiţii de prelucrare recomandate

Puterea mașinii:

Având in vedere că degroșarea necesită putere mare, vă recomandăm să verificaţi dacă mașina este potrivită. Alezarea asimetrică este o soluţie pentru reducerea necesarului de putere, avansul fiind divizat la 2 pentru aceeași adâncime de tăiere, comparativ cu cea simetrică.
Performanţe optime se obţin cu răcire internă (regimuri de așchiere mari, finisare superioară a suprafeţei, evacuare mai bună a așchiilor, viaţă mai lungă a plăcuţei).

Pentru instrucţiunile de utilizare detaliate, verifică instrucţiunile de utilizare livrate împreună cu pachetul capului de alezat sau cu barele Steadyline®.
Aceste instrucţiuni pot fi descărcate de pe www.secotools.com

Viteza maximă pentru capetele de degroșare

Cap	Capacitate ∅ mm	*Capacitate Ø inch*	RPM max.	Viteza maximă de așchiere implicită v_c la min Cap. m/min *(sf/min)*	Viteza maximă de așchiere implicită v_c la max Cap. m/min *(sf/min)*
Capete de alezare de degroșare (cu două suporturi de plăcuţe identice setate simetric), cu conexiune Graflex®					
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)*
Capete de alezare de degroșare (cu două suporturi de plăcuţe identice setate simetric), cu conexiune Seco Capto™					
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)*

Notă: Vitezele maxime sunt condiţionate de conceptul mecanic al capului și de calitatea echilibrării. Vitezele cuprinse în intervalul recomandat vor fi alese ţinând cont de toate condiţiile de prelucrare, ex.: materialul semifabricatului, muchia de așchiere, lungimea sculei, arborele mașinii. La viteze de la aproximativ 8000 RPM și mai mari, suporturile de bază și extensiile/reductoarele trebuie să fie bine echilibrate.

Instrucţiuni de depanare

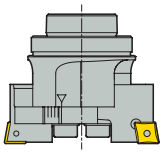
Problemă	Cauză posibilă	Soluţie
Control slab al aşchiei	Rata avansului prea mică	Măriţi avansul
	Adâncime de tăiere prea mare	Utilizaţi metoda asimetrică
Șocuri și vibraţii	Viteză prea mare	Reduceţi viteza, nu avansul
	Raport L/D extrem	Scurtează scula pentru a crește rigiditatea
		Mărește OD arborelui și prinderilor intermediare
		Utilizaţi o bară Steadyline
		Utilizează carbură sau metal greu pentru extensii
	Raza plăcuţei prea mare	Utilizaţi o plăcuţă cu rază mai mică.
	Piesă de lucru instabilă	Îmbunătăţește fixarea și suportul de prindere
	Unghiul de atac κ este 80°	Schimbă cu κ=90°, plăcuţe tip CC
Ciupirea sau spargerea plăcuţei	Plăcuţă aleasă greșit	Schimbă cu o calitate mai rezistentă a plăcuţei
		Utilizează o rază mai mare dacă este posibil
	Aşchiere cu întreruperi severe	Micșorează viteza, mărește avansul
	Aşchii sunt împachetate și re-tăiate	Verifică diferenţa între diametrul găurii și al barei de alezat
		Îmbunătăţește controlul aşchiilor, mărește avansul
Viaţă scurtă a sculei	Plăcuţă aleasă greșit	Schimbă cu o calitate mai rezistentă la uzură
	Viteza de aşchiere prea mare	Reduceţi viteza
	Ciupituri pe plăcuţă	Verifică adâncimea de aşchiere și avansul
	Presiune prea mică a lichidului de răcire	Creșteţi presiunea lichidului de răcire
Aşchiile nu sunt evacuate	Bara de alezare prea mare	Utilizaţi capete mai mici cu port-plăcuţe cu extensie dacă este posibil
	Adâncime de tăiere prea mare	Utilizaţi metoda asimetrică; de preferat plăcuţe CC.. în loc de CN.. (mai ales la utilizarea capetelor de alezat cu diametre mici).
	Spaţiu neadecvat sub alezaj	Reglaţi piesa mai sus pe masa de lucru
	Control slab al aşchiei	Vezi mai sus
Putere mică a mașinii	Rata avansului prea mare	Reduceţi rata avansului (nu mai puţin de 25% din raza plăcuţei)
	Adâncime de tăiere prea mare	Utilizaţi metoda asimetrică
	Putere mică a mașinii	RPM în zona de cuplu mic al arborelui: mărește viteza
		RPM în zona de schimbare a vitezelor: reglaţi RPM
		Utilizează plăcuţe cu unghi mai mare de degajare (HSS în cazuri extreme)
		Reduceţi adâncimea de tăiere
Bavuri excesive la ieșirea găurii	Rata avansului prea mare	Reduceţi avansul
	Port-plăcuţă tip CC 90°	Utilizează port-plăcuţă pătrată 80°
	Forţe de aşchiere prea mari	Reduceţi adâncimea de tăiere
		Reduceţi raza plăcuţei

RB 610 Capetele de alezat de degroșare – Prezentare generală

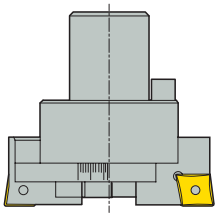
Conexiune Graflex®

Conexiune GL

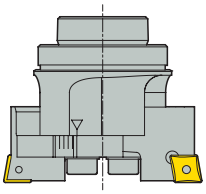
Conexiune BA



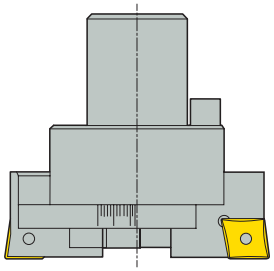
Ø 28–37 mm *(Ø 1.102–1.457")*



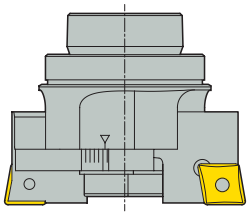
Ø 39–51 mm *(Ø 1.535–2.008")*



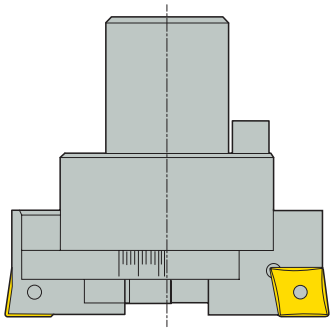
Ø 36–46 mm *(Ø 1.417–1.811")*



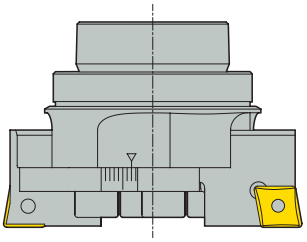
Ø 50–65 mm *(Ø 1.969–2.559")*



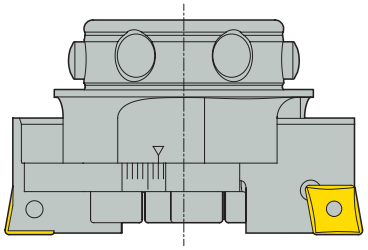
Ø 45–56 mm *(Ø 1.772–2.205")*



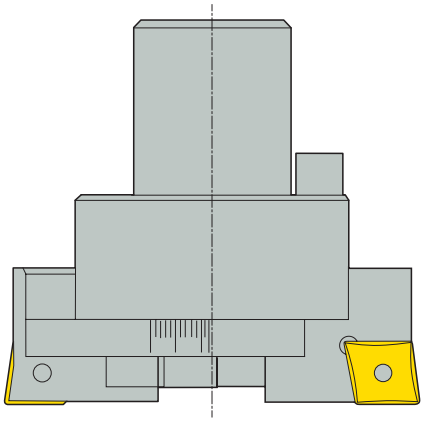
Ø 64–86 mm *(Ø 2.520–3.386")*



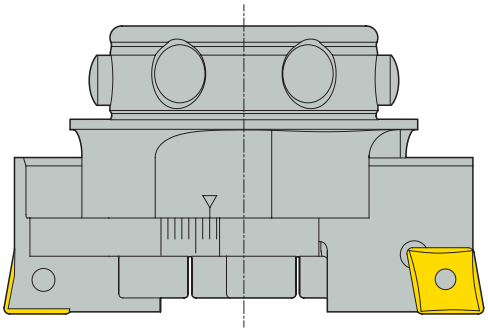
Ø 55–69 mm *(Ø 2.165–2.717")*



Ø 66–88 mm *(Ø 2.598–3.465")*



Ø 85–115 mm *(Ø 3.346–4.528")*



Ø 86–116 mm *(Ø 3.386–4.567")*

Capete de alezare de degroșare RB 610 – Ghid

Caracteristici

– Un ansamblu de cap de alezare de degroșare este o combinaţie de 1 corp (cap) și 2 suporturi de plăcuţă
– Atingerea preciziei geometrice a găurilor începând cu găuri turnate, tăiate cu flacără sau perorate
– Minimizarea dezechilibrului, graţie conceptului simetric

Compact

– Corp scurt pentru mărirea rigidităţii ansamblului de alezare și pentru a permite cel mai bun efect de amortizare atunci când se utilizează barele de strunjire și de alezare Steadyline®
– Greutate redusă pentru a permite o schimbare rapidă a sculei și o accelerare ușoară a arborelui

Reglare rapidă și intuitivă

– Fiecare portplăcuţă are un mecanism de reglare care permite setarea rapidă și ușoară a diametrului, atunci când se utilizează un preseter
– Scala gradată arată poziţia grosieră a portplăcuţelor

Port-plăcuţe

– Portplăcuţele A610…CC… au un unghi de atac de 90° pentru plăcuţele rombice, 0° unghiul de degajare și 0° unghiul de înclinare
– Portplăcuţele se potrivesc pe ambele tipuri de capete EPB 610 Graflex® și RB 610 GL

Productivitate

– Rigiditate mare datorită instalării strânse a suporturilor de plăcuţă în corpul capului, precum și datorită șuruburilor de prindere mari
– Posibilitate de a obţine o adâncime de așchiere ap de până la jumătate din lăţimea plăcuţei, maximizând rata de îndepărtare a materialului și permiţând o exploatare totală a plăcuţelor
– Alezare alternantă cu ajutorul unei garnituri de reglare (care face parte din pachetul de livrare al capului) pentru decalarea unui suport de plăcuţă pentru a mări adâncimea radială de așchiere sau pentru a o diviza
– Livrare a agentului de răcire complet direcţionată către muchiile așchietoare

Gama de produse

– Capetele de alezare de degroșare RB 610 sunt disponibile cu conexiune Graflex® pe partea utilajului, pentru operaţiuni de alezat convenţionale de console de până la 6xD,
– capetele de alezare de degroșare RB 610 cu conexiuni GL și BA pe partea utilajului sunt concepute pentru console mai lungi cu ansambluri de amortizare a vibraţiilor Steadyline®.

RB 610 Graflex®



– Graflex®: 4 capete de alezare de degroșare compacte pentru Ø 39-115 mm *(Ø 1,535-4,528")*
– Sistemul modular Graflex® permite alcătuirea de ansambluri de alezare optime din adaptoare Graflex®, module intermediare și capete de alezare

RB 610 GL și BA, pentru barele antivibraţii Steadyline®



GL



BA

– GL: 4 capete de alezare de degroșare scurte și compacte, pentru diametre 28-69 mm *(Ø 1,102-2,717 ")*
– BA: 2 capete de alezare de degroșare scurte și compacte, pentru diametru 66-116 mm *(Ø 2,598-4,567 ")*
– Adaptate în special barelor de strunjire și de alezare Steadyline®. Performanţele de alezare, atunci când se utilizează bare lungi Steadyline®, sunt similare cu ansamblurile mai scurte fără amortizare (<6xD).

Capete de alezare de degroșare RB 610 - Ghid

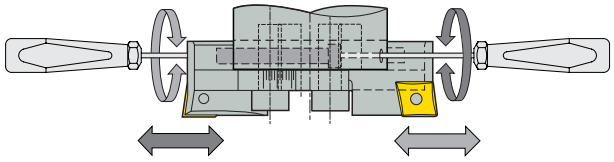
Setarea alezării simetrice:

Alezare simetrică înseamnă că ambele muchii de așchiere au același diametru și aceeași înălțime.

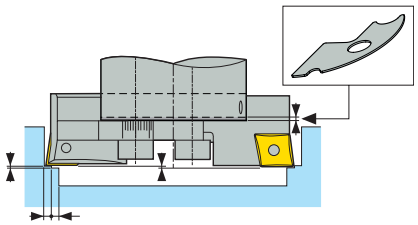
Setarea alezării alternante:

Alezare asimetrică înseamnă că o muchie de așchiere este decalată ca și operație de așchiere la un diametru mai mic decât a doua muchie reglată la diametrul de executat: Necesită un distanțier (inclus în pachet) montat între corpul capului de alezat și una dintre portplăcuțe pentru a obține o decalare axială (+), vezi tabelul de mai jos.

Shim Reper nr.	Grosime (mm)	*Grosimea (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*

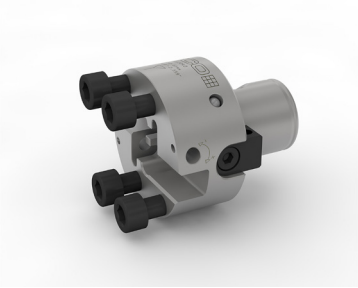


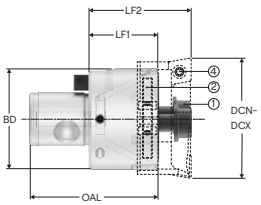
Setarea alezării simetrice:



Setarea alezării alternante:

RB610
Graflex®





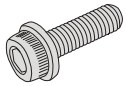
—Este posibilă o alezare simetrică și decalată
—Mecanism de reglare suport plăcuță individual
—Alimentare internă cu lichid de răcire către marginea de așchiere

1. Șurub de asamblare și cheie de prindere
2 & 4. Cheia pentru setarea diametrului și șurubul de fixare

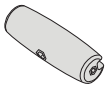
Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	RPM max.*
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A61030	02904453	G3	39,0 *1.535*	51,0 *2.008*	43,5 *1.713*	23,5 *0.925*	36,4 *1.433*	34,0 *1.339*	0,2 *0.4*	7500
A61040	02904454	G4	50,0 *1.969*	65,0 *2.559*	45,5 *1.791*	21,5 *0.846*	35,3 *1.390*	43,0 *1.693*	0,3 *0.7*	5700
A61050	02904455	G5	64,0 *2.520*	86,0 *3.386*	55,0 *2.165*	25,0 *0.984*	42,3 *1.665*	54,0 *2.126*	0,7 *1.5*	4500
A61060	02904457	G6	85,0 *3.346*	115,0 *4.528*	69,0 *2.717*	29,0 *1.142*	47,8 *1.882*	63,0 *2.480*	1,0 *2.2*	3500

Cartușele se comandă separat, consultați pagina (paginile) 500
* Informații suplimentare despre turația maximă, consultați paginile cu instrucțiuni. Notă: Greutatea este fără suport de plăcuțe

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Nicovală, alezare decalată	Cep
			
A61030	950DC0616	AU6103003	90M31
A61040	950D0616	AU6104003	90M41
A61050	950D0820	AU6105003	90M51
A61060	950D0822	AU6106003	90M61

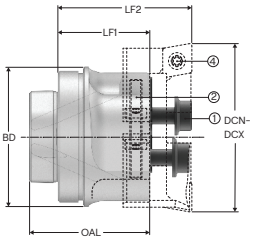
Accesorii

Pentru cap	Cheie clemă	Cheie (tip T)
		
A61030	03HL05	DOUBLE-T
A61040	03HL05	DOUBLE-T
A61050	03HL06	DOUBLE-T
A61060	03HL06	DOUBLE-T

RB610 Compact

GL





—Proiectat pentru bare de strunjire și alezare GL25, GL32, GL40 și GL50 Steadyline ®
—Este posibilă o alezare simetrică și decalată
—Mecanism de reglare suport plăcuță individual
—Alimentare internă cu lichid de răcire către marginea de așchiere

1. Șurub de asamblare și cheie de prindere
2 & 4. Cheia pentru setarea diametrului și șurubul de fixare

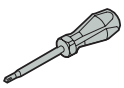
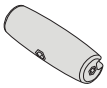
Reper Nr.	Număr reper	Od strony obrabiarki Mărime GL	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	RPM max.*
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
GL25-RB610-10	03307854	GL25	28,0 *1.102*	37,0 *1.457*	21,7 *0.854*	16,2 *0.638*	25,0 *0.984*	25,0 *0.984*	0,1 *0.2*	9500
GL32-0610-20	02904458	GL32	36,0 *1.417*	46,0 *1.811*	27,6 *1.087*	21,1 *0.831*	32,0 *1.260*	32,0 *1.260*	0,1 *0.2*	7500
GL40-0610-30	02904459	GL40	45,0 *1.772*	56,0 *2.205*	31,6 *1.244*	22,1 *0.870*	35,0 *1.378*	40,0 *1.575*	0,2 *0.4*	5700
GL50-0610-40	02904460	GL50	55,0 *2.165*	69,0 *2.717*	33,7 *1.327*	22,2 *0.874*	36,0 *1.417*	50,0 *1.969*	0,3 *0.7*	4500

Cartușele se comandă separat, consultați pagina (paginile) 500
* Informaţii suplimentare despre turaţia maximă, consultaţi paginile cu instrucţiuni. Notă: Greutatea este fără suport de plăcuţe

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Nicovală, alezare decalată
		
GL25-0610-10	950D0410	AU6101003
GL32-0610-20	950DC0412	AU6102003
GL40-0610-30	950DC0616	AU6103003
GL50-0610-40	950D0616	AU6104003

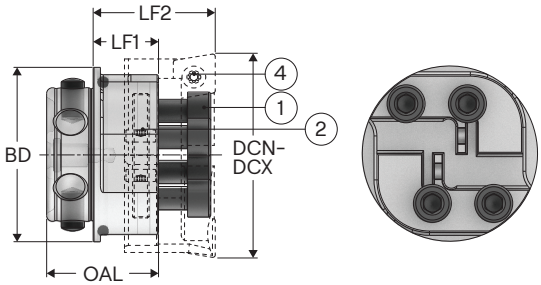
Accesorii

Pentru cap	Cheie clemă	Cheie plăcuţă	Cheie (tip T)
			
GL25-0610-10	03HL03	T07P-3	–
GL32-0610-20	03HL03	H4B-T07P	DOUBLE-T
GL40-0610-30	03HL05	–	DOUBLE-T
GL50-0610-40	03HL05	–	DOUBLE-T

RB610

BA





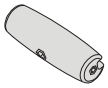
—Proiectat pentru bare de strunjire și alezare BA60 și BA80 Steadyline ®
—Este posibilă o alezare simetrică și decalată
—Mecanism de reglare suport plăcuță individual
—Alimentare internă cu lichid de răcire către marginea de așchiere

1. Șurub de asamblare și cheie de prindere
2 & 4. Cheia pentru setarea diametrului și șurubul de fixare

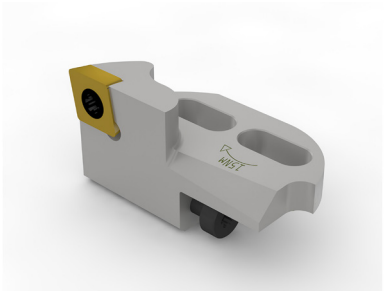
Reper Nr.	Număr reper	Od strony obrabiarki Mărime BA	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	RPM max.*
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
BA060-RB610-50	03204092	BA060	66,0 *2.598*	88,0 *3.465*	38,5 *1.516*	22,5 *0.886*	39,8 *1.567*	60,0 *2.362*	0,7 *1.5*	4000
BA080-RB610-60	03204093	BA080	86,0 *3.386*	116,0 *4.567*	44,5 *1.752*	22,5 *0.886*	41,3 *1.626*	80,0 *3.150*	1,2 *2.7*	3000

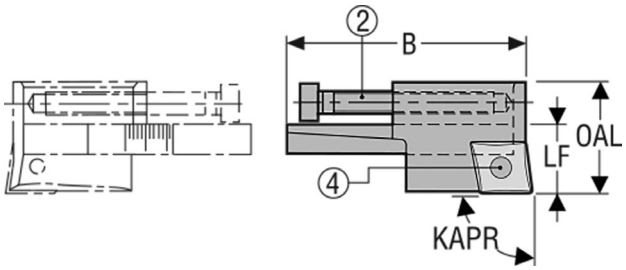
Cartușele se comandă separat, consultați pagina (paginile) 500
* Informații suplimentare despre turația maximă, consultați paginile cu instrucțiuni. Notă: Greutatea este fără suport de plăcuțe

Piese de schimb, Piese incluse la livrare

Pentru cap	Cheie clemă	Șurub clemă	Cheie (tip T)	Nicovală, alezare decalată
				
BA060-RB610-50	03HL06	950D0820	DOUBLE-T	AU6105003
BA080-RB610-60	03HL06	950D0822	DOUBLE-T	AU6106003

Insert holders



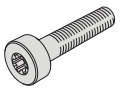


—Potrivit pentru capetele de alezare RB 610 cu conexiune Graflex®, GL sau BA

2. Șurub de reglare
4. Șurub de blocare a plăcuței

Reper Nr.	Număr reper	Pentru cap	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF	B	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
A61010CC0690	03307856	RB 61010	28,0 *1.102*	37,0 *1.457*	4,7 *0.185*	8,8 *0.346*	21,75 *0.856*	0,1 *0.2*
A61020CC0690	02971268	RB 61020	36,0 *1.417*	46,0 *1.811*	17,6 *0.693*	10,9 *0.429*	26,0 *1.024*	0,1 *0.2*
A61030CC0990	02904461	RB 61030	39,0 *1.535*	56,0 *2.205*	21,6 *0.850*	12,9 *0.508*	33,0 *1.299*	0,1 *0.2*
A61040CC0990	02904462	RB 61040	50,0 *1.969*	69,0 *2.717*	22,5 *0.886*	13,8 *0.543*	43,8 *1.724*	0,1 *0.2*
A61050CC1290	02904463	RB 61050	64,0 *2.520*	86,0 *3.386*	12,0 *0.472*	17,3 *0.681*	57,4 *2.260*	0,2 *0.4*
A61060CC1290	02904464	RB 61060	85,0 *3.346*	115,0 *4.528*	30,5 *1.201*	18,8 *0.740*	75,0 *2.953*	0,2 *0.4*

Piese de schimb, Piese incluse la livrare

Pentru portplăcuță	Șurub plăcuță	Șurub de reglare
		
A61010CC0690	C02504-T07P	–
A61020CC0690	C02504-T07P	19A61020
A61030CC0990	C04008-T15P	19A61030
A61040CC0990	C04008-T15P	19A61040
A61050CC1290	C05012-T15P	19A61050
A61060CC1290	C05012-T15P	19A61060

Pentru plăcuțe recomandate pentru alezare de degroșare, consultați pagina (paginile) 588
Notă: O cheie pentru prinderea șurubului de inserție face parte din conținutul de livrare a capetelor RB 610.

Capete de alezare de degroșare RB 610 – Instrucţiuni

Cuplu de strângere recomandat. Avansul maxim per rotaţie la alezare alternantă.

Capete de alezare de RB 610 - Dimensiuni	30	40	50	60
Cuplul de strângere a șuruburilor de blocare pentru prinderea suporturilor de plăcuţă (Nm)	2 x 25	4 x 25	4 x 40	4 x 40
Rata max. a avansului la alezare alternantă mm/rot *(in/rot)*	0,4 *(0.016 “)*	0,5 *(0.020 “)*	0,6 *(0.024 “)*	0,6 *(0.024 “)*

Condiţii de prelucrare recomandate
Puterea capului de alezare:

Având in vedere că degroșarea necesită putere mare, vă recomandăm să verificaţi dacă maşina este potrivită. Alezarea asimetrică este o soluţie pentru reducerea necesarului de putere, avansul fiind divizat la 2 pentru aceeași adâncime de tăiere, comparativ cu cea simetrică. Performanţe optime se obţin cu răcire internă (regimuri de aşchiere mari, finisare superioară a suprafeţei, evacuare mai bună a aşchiilor, viaţă mai lungă a plăcuţei).

Pentru instrucţiunile de utilizare detaliate, verifică instrucţiunile de utilizare livrate împreună cu pachetul capului de alezat sau cu barele Steadyline®. Aceste instrucţiuni pot fi descărcate de pe www.secotools.com

Viteza maximă pentru capetele de degroșare RB 610

NOTĂ! Vitezele maxime arătate în pagina de prezentare a capetelor de alezare sunt condiţionate de conceptul mecanic al capului și de calitatea echilibrării.

Vitezele cuprinse în intervalul recomandat vor fi alese ţinând cont de toate condiţiile de prelucrare, ex.: materialul semifabricatului, muchia de aşchiere, lungimea sculei, arborele maşinii.

În cazul operaţiilor de alezare cu barele Steadyline®, aveţi grijă să nu depăşiţi RPM maxim al barei: Vedeţi instrucţiunile de utilizare livrate împreună cu barele Steadyline® pentru strunjire și alezare.



Alezare de finisare

Acoperind o gamă largă de dimensiuni de găuri și materiale, familiile de produse Seco pentru alezare de precizie permit reglări de precizie până la microni, realizează finisări de suprafeţe de Ra <1 (RMS 44 micro/inci) și oferă alezaje în toleranţe IT5. Cu o axare constantă pe precizie și rigiditate, aceste produse facilitează respectarea chiar și a celor mai stricte specificaţii de piese. Soluţiile de amortizare a vibraţiilor Steadyline™ completează gama, pentru a oferi niveluri și mai mari de stabilitate pentru prelucrarea cavităţilor adânci, în care sunt necesare console de scule lungi.

- Capetele de alezare de precizie tip Axiabore FB 760 sunt concepute pentru precizie și finisare de suprafeţe pe diametre mici
- Gama noastră de capete fine de alezare Axiabore™ include acum și versiunea digitală, care face viaţa operatorului mai ușoară și reduce frecvenţa erorilor umane. Versiunea digitală ajută la configurarea mai ușoară și mai rapidă, cu o bună fiabilitate a procesului și eficienţă în alezarea fină a pieselor cu toleranţă ridicată
- Capetele de alezare de precizie radiale FB 620/780/790 sunt concepute pentru a oferi cele mai bune geometrii de alezaj pe diametre mai mari (până la 205 mm)

Prezentare generală



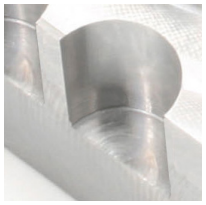




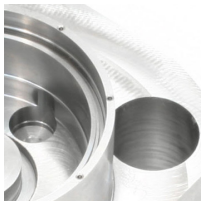
Alezare-OD



Canelare

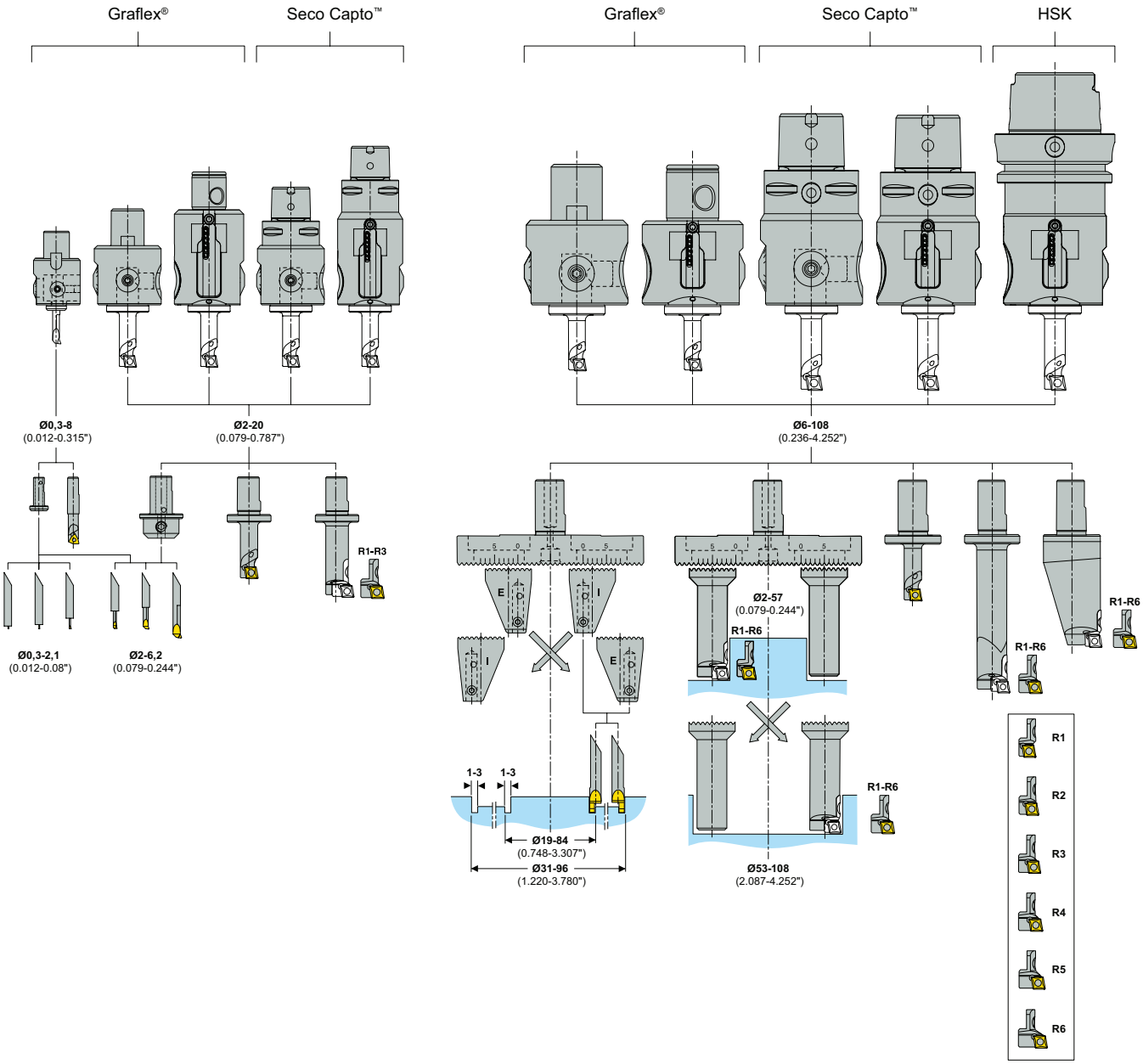


Alezare cu așchiere intermitentă



Alezare

Prezentare generală



Capete de alezare fine digitale Tip axial

Capetele de alezare fine Axial digitale oferă rezultate excelente pentru o funcţionare de alezare (IT5 realizabile). Acesta înlocuieşte utilizarea unui vernier analogic cu un afişaj digital detaşabil, universal: Atunci când vernierul unui cap de alezare convenţional, analogic nu este întotdeauna uşor de utilizat pentru reglarea diametrului pe maşină, ecranul mare al seriei FB 760 D permite reglarea confortabilă şi fiabilă a diametrului.

Seria FB 760 D revoluţionează filozofia de alezare, deoarece elimină necesitatea unui presetator: Toate operaţiile de presetare şi reglare se fac direct pe maşină, folosind controlerul universal de afişare digitală.

Scule de alezat
Scule de alezat, coadă din carbură solidă Ø 4 mm (Ø 0,1574") pentru cele mai mici diametre 2-108 mm (Ø 0,079--4,252"), unghi de avans 98°. Sculele au capătul din spate în unghi pentru orientarea muchiilor de aşchiere conform ISO.

Cutie de depozitare
Afişajul digital este dotat cu o cutie de ambalare unică şi durabilă, care va fi utilă pentru stocarea sau încărcarea dispozitivului de afişare digitală



Caracteristici

Afişaj digital universal, pentru capetele de alezare fine FB 760 D.
Controlerul universal cu afişare digitală poate fi utilizat pentru un număr nelimitat de capete de alezare Dispunând de un ecran mare, acesta permite citirea cu uşurinţă a setării diametrului capului de alezare, atât în modul absolut (diametrul real realizat cu setarea curentă), cât şi în modul relativ (reglarea eficientă a sistemului de setare micrometrică), fie în mm sau în inch.

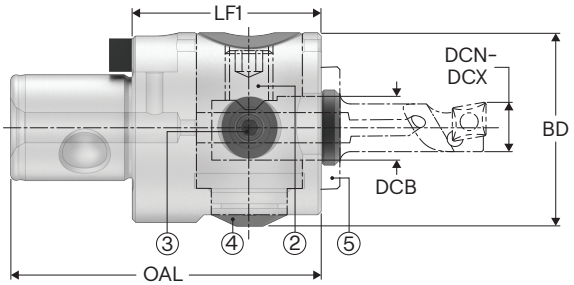
Afişajul digital universal a fost conceput pentru a vă uşura viaţa:
– Ecran luminos pentru a facilita citirea - rezoluţie de 1 µm
– Un sistem intuitiv şi uşor de utilizat, uşor de comutat între modul absolut / relativ, modul mm / inch
– Controler autonom: După ce a fost conectat la capul de alezare, controlerul rămâne în poziţie şi permite operatorului să utilizeze ambele mâini pentru a efectua setarea diametrului.
– Controlerul universal cu afişare digitală poate fi utilizat pentru un număr nelimitat de capete de alezare. Livrat cu un cablu USB, controlerul digital universal de afişare poate fi încărcat electric pe portul USB al utilajului sau computerului.



FB 760 – Capete de tip Axiabore™, neechilibrabile

Graflex®





—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)
—Axiabore™ plus – permite alezarea, precum și strunjire OD și canelare frontală

3. Șurub de blocare
4. Șurub de reglare micrometrică
2. Șurub asamblare
5. Sculă

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	BD	DCB	Greutate	*	Viteza de lucru max**	
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		RPM max.**	Max. m/min**
A76001	02462575	G2	0,3 *0.012*	8,0 *0.315*	41,0 *1.614*	25,0 *0.984*	25,0 *0.984*	6,0 *0.236*	0,2 *0.4*		30000	1500
A76002	02594930	G3	2,0 *0.079*	20,0 *0.787*	52,0 *2.047*	32,0 *1.260*	36,5 *1.437*	12,0 *0.472*	0,4 *0.9*		12000	1500
A76003	02594935	G5	6,0 *0.236*	108,0 *4.252*	75,0 *2.953*	45,0 *1.772*	54,0 *2.126*	16,0 *0.630*	0,9 *2.0*	*	8000	1000

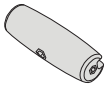
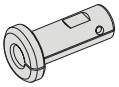
Notă: Greutatea este fără suport de plăcuțe

Pentru scule, vezi pag. 516-518

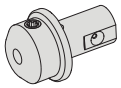
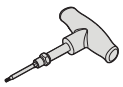
*Capacităţi - Axiabore™ plus - cap pentru alezare 6-108 mm (0.236-4.252") , alezare-OD 2-57 mm (0.079-2.244"), canelare frontală 19-96 mm (0.748-3.780").
*Max. 5000 RPM la utilizarea MPA.

**Viteza maximă, oricare dintre acestea este atinsă mai întâi fără a depăși niciuna dintre ele.

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare	Sealing Screws	Manșon	Cep
							
A76001	–	DOUBLE-T	H4B-H2.0	19M4001A	950A0406	05A7600604	90M21
A76002	AU7601212	–	03M03C	19A71030	–	–	90M3A
A76003	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	–	–	90M5A

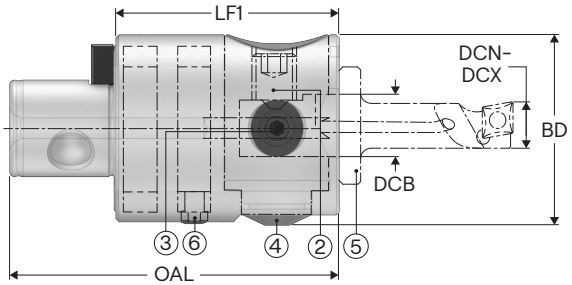
Accesorii

Pentru cap	Manșon	Cheia dinamometrică pentru șuruburile de blocare a inelului de echilibrare	Cheia dinamometrică pentru șuruburile de blocare și asamblare
			
A76001	–	–	H00-2009
A76002	05A7601204	–	H00-3030
A76003	–	H00T-4060	–

FB 760 – Capete de tip Axiabore™, echilibrabile

Graflex®





—Sistem integrat de echilibrare LibraOne bazat pe un singur inel de reglare a echilibrării
—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)

6. Șurub de blocare 2
3. Șurub de blocare 1
4. Șurub de reglare micrometrică
2. Șurub asamblare
5. Sculă

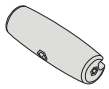
Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	BD	DCB	Greutate	*	Viteza de lucru max**	
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		RPM max.**	Max. m/min**
A76013	02594943	G5	6,0 *0.236*	33,0 *1.299*	95,0 *3.740*	65,0 *2.559*	54,0 *2.126*	16,0 *0.630*	1,2 *2.7*	*	20000	1500

Notă: Greutatea este fără suport de plăcuţe

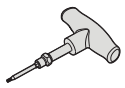
Pentru scule, vezi pag. 516-518

*Capacităţi – Axialibrabore™ Plus – cap, cu echilibrare.
**Viteza maximă, oricare dintre acestea este atinsă mai întâi fără a depăși niciuna dintre ele.

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare 1	Șurub de blocare 2	Cep
						
A76013	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	AU7601318	90M5A1

Accesorii

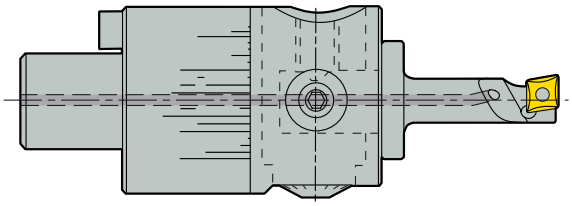
Pentru cap	Cheia dinamometrică pentru șuruburile de blocare a inelului de echilibrare	Cheia dinamometrică pentru șuruburile de blocare și asamblare
		
A76013	H00-4020-60	H00T-4060

Capete de alezare de precizie tip Axiabore™ pentru diametru de alezaj 0,3-108 mm (0,012-4,252")

Alegerea capetelor de tip Axiabore™	Capacitate ∅ mm	*Capacitate Ø inch*	HSM/ viteze maxime	Digital	Echilibrabile	Geometria găurii	Cost efectiv
Nanobore™ (dimensiune 1)	0,3-8	*0.012–0.315"*	30000 RPM			■■	■■
Axiabore™ (dimensiune 2)	2-20	*0.079–0.787"*	12000 RPM			■	■■
Digital Axiabore™ (dimensiune 2)	2-20	*0.079–0.787"*	12000 RPM	✓		■	■■
Axiabore™ Plus (dimensiune 3)	6-108	*0.236–4.252"*	8000* RPM sau 1000 m/min			■	■■■
Digital Axiabore™ Plus (dimensiune 3)	6-108	*0.236–4.252"*	8000* RPM sau 1000 m/min	✓		■	■■■
Axialibrabore™ Plus (dimensiune 3)	6-108	*0.236–4.252"*	20000* RPM sau 1500 m/min		✓	■■	■

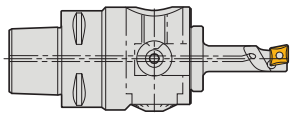
* Max. 5000 RPM la utilizarea MPA.

5 capetele tip Axiabore™ au conexiune Graflex®, Seco Capto™ sau HSK-A



Nanobore™ (dimensiune 1)
Axiabore™ (dimensiune 2)
Digital Axiabore™ (dimensiune 2)
Axiabore™ Plus (dimensiune 3)
Digital Axiabore™ Plus (dimensiune 3)
Axialibrabore™ Plus (dimensiune 3)

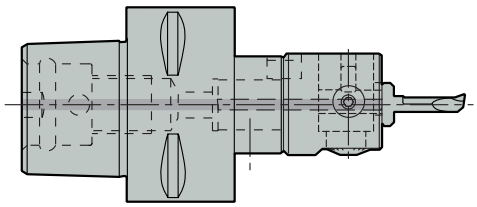
2 capete de alezare de precizie Axiabore™ FB 760 cu conexiune Seco Capto™ pentru alezaje: Ø 2-108 mm *(0,079-4,252")*



Axiabore™ – C3-391.0760-02
Axiabore™ Plus – C5-391.0760-03
Digital Axiabore™ – C3-391.FB760-02-D
Digital Axiabore™ Plus – C5-391.FB760-03-D

NOTĂ! Alezajul minim al celui mai mic cap de alezare de precizie Seco Capto™ este Ø 2 mm *(0,079")* cu cea mai mică conexiune Seco Capto™ C3 disponibilă. Pentru ∅ 0,3-8 mm *(0,012-0,315")* utilizaţi capetele de alezat Nanobore™ cu conexiunea G2 împreună cu adaptorul Seco Capto™/Graflex® corespunzător.

Adaptor Seco Capto™ și cap Graflex®: Ø 0,3-8 mm *(0,012-0,315")*



Adaptoare și extensii modulare Graflex® și Seco Capto™ : consultaţi catalogul de sisteme de scule.

NOTĂ! Caracteristici, instrucţiuni (procedura de instalare a sculei, setarea diametrului, procedura de asamblare MPA, viteze maxime, viteze de așchiere recomandate, depanare), sculele și suporturile de plăcuță adecvate sunt similare pentru ambele tipuri de capete de alezare de precizie 760 cu capacitate de alezare similară, indiferent de tipul de conexiune.

Afișaj digital pentru capetele de alezare fină digitale



Scule pentru alezare

Reţineţi! În pagina produsului, se precizează exact ce sculă se potrivește cu fiecare cap.

Scule de alezat, coadă din carbură solidă Ø 4 mm *(Ø 0,1574")* pentru cele mai mici diametre 0,3-6,2 mm *(Ø 0,012-0,244")*, unghi de avans 98°. Este necesară o bucșă de reducţie pentru a instala capete Nanobore™ și Axia(libra)bore™. Sculele au capătul din spate în unghi pentru orientarea muchiilor de așchiere conform ISO.

Bare de alezare, cozi tip plăcuţă Ø 6, 12 sau 16 mm *(Ø 0,236, 0,472, 0,630")* pentru Ø 6-13 mm *(Ø 0,236-0,512")*, tip „oţel" pentru scule scurte, tip „carbură" pentru scule lungi. Pentru plăcuţe WB..0301.. sau CC..0602.. și unghi de avans de 90°. Fixare directă în capul de alezat. Aplatizarea de blocare asigură o orientare a muchiei așchietoare conform ISO.

Bare de alezare, modulare, alcătuite dintr-o „coadă" și un „suport de plăcuţă" pentru diametre 13-63 mm *(Ø 0,512-2,480")*. Diametru coadă 12 sau 16 mm *(Ø 0,472, 0,630")*, „oţel" pentru scurte, „carbură" pentru lungi și „ușoare/aluminiu" pentru cele mai mari diametre. Fixare directă în capul de alezat.

Șase port-scule pentru plăcuţele CC..0602.. cu unghi de atac de 90°, compatibil cu toate cozile pentru a obţine o capacitate mare de alezare cu cozi normale.





Adaptoare cu utilizare multiplă (MPA)

MPA pentru alezare și alezare exterioară, precum și pentru canelare cu capetele Axiabore™ Plus. MPA și sculele au o interfaţă zimţată, care asigură trepte precise de orientare și poziţionare de 2,5 mm *(0,098")* pe diametru. Sunt incluse duzele pentru direcţionarea lichidului de răcire.

Alege componentele pentru a obţine o sculă tip MPA din tabelul de scule MPA. Vezi detaliile de asamblare în capitolul cu instrucţiuni.

Reglarea unui ansamblu pentru Alezare sau alezare exterioară.
Ambele ansambluri de alezare și de alezare exterioară utilizează aceeași coadă echipată cu o port-plăcuţă și o contragreutate. Ansamblul de alezare: Alege port-plăcuţa necesară pentru a fi asamblată în coada pentru alezare/alezare exterioară, utilizând tabelul de selecţie 'Alezare cu MPA' (vezi paginile următoare).

Ansamblul de alezare exterioară: Alege port-plăcuţa necesară pentru a fi asamblată în coada pentru alezare/alezare exterioară, utilizând tabelul de selecţie 'Alezarea exterioară cu MPA' (vezi paginile următoare). Vezi detaliile de asamblare în capitolul cu instrucţiuni.

Alcătuirea unui ansamblu de canelare

Un ansamblu de canelare necesită:

- O pereche de port-scule pentru scule de canelat (una E = „externă" și una I = „internă")
- O sculă de canelat „spre cep" sau „spre alezaj". Când canalul nu este spre un perete de cep sau spre un perete de alezaj, ambele tipuri de scule sunt adecvate. Consultaţi tabelele de selecţie „Sculă de canelat pentru canelare cu MPA"





Caracteristici

Cap Nanobore™, nr. de piesă A76001



Cap foarte mic pentru alezare de precizie Ø 0,3-8 mm *(Ø 0,012-0,315")*:
Diametru exterior 25 mm *(0,984")*, lungime 25 mm *(0,984")*, cu conexiune Graflex® mărime G2, instalare sculă Ø 6 mm *(Ø 0,236")*. Viteze de funcţionare de până la 30.000 rotaţii pe minut permit prelucrarea performantă a unor diametre foarte mici.

Bucșa de reducţie 6-4 mm *(0,236-0,157")* cu aplatizare de orientare și pin pentru instalarea de scule de alezat solide face parte din pachetul de livrare al capului.

Rezoluţia de setare a diametrului: 2,5 µm *(0,0001")*

Cap Axiabore™, nr. de piesă A76002



Capete mici pentru alezare de precizie Ø 2-20 mm *(Ø 0,079-0,787")*:
Diametru exterior 36,5 mm *(1,401")*, lungime 32 mm *(1,260")*, cu conexiune Graflex® mărimea G3 și conexiune Seco Capto™ mărimea C3, instalare sculă Ø 12 mm *(Ø 0,472")*. Aceste mărimi de capete sunt optimizate pentru alezaje greu accesibile.

Bucșa de reducţie 12-4 mm *(0,472-0,157")* cu aplatizare de orientare și pin pentru instalarea de scule de alezat solide face parte din pachetul de livrare al capului.

NOTĂ! Pot fi instalate și unelte mai mici de la Nanobore™ 0,3-2,1 mm *(0,012-0,083")*, dar viteza de prelucrare va fi limitată la 12000 de rotaţii pe minut: Sunt preferate capetele Nanobore®.

Rezoluţia de setare a diametrului: 2,5 µm *(0,0001")* pe diametru pentru capete analogice, 1 µm *(0,00004")* pe diametru pentru capete digitale

Axiabore™ Plus - cap, nr. de piesă A76003 și C5-391.0760-03







Capete multifuncţionale pentru alezare de precizie Ø 6-108 mm *(Ø 0,236-4,252")*, teșire a muchiilor OD Ø 2-57 mm *(Ø 0,079-2,244")* și canelare Ø 19-96 mm *(Ø 0,748-3,780")*:
Diametru exterior 54 mm *(Ø 2,126")*, lungime 45 mm *(Ø 1,772")*, cu conexiune Graflex® mărimea 5 și conexiune Seco Capto™ mărimea 5, instalare sculă Ø 16 mm *(Ø 0,630")*.
Scule adecvate: toate sculele cu diametru de coadă 16 mm *(Ø 0,630")*, pentru instalare directă în capete.

Acest cap a fost conceput și pentru echiparea cu MPA (adaptor cu utilizare multiplă), pentru alezarea fină a diametrelor mari, alezare exterioară și canelare.

Rezoluţia de setare a diametrului: 2,5 µm *(0,0001")* pe diametru pentru capete analogice, 1 µm *(0,00004")* pe diametru pentru capete digitale

Axialibrabore™ Plus - cap, nr. de piesă A76013



Cap echilibrabil pentru alezare de precizie Ø 6-33 mm *(Ø 0,236-1,299")*:
Aceleași caracteristici ca și capul - Axiabore™ Plus - dar cu echilibrare de precizie, lungime a corpului 65 mm *(2,559")*.
Cu conexiune Graflex® mărimea G5.
Capetele fin echilibrate permit viteze mari până la 20 000 RPM sau 1500 m/min (oricare criteriu este îndeplinit primul, fără a-l depăși pe al doilea), geometria găurii îmbunătăţită cu o reducere a încărcării arborelui maşinii.
Echilibrarea 'LibraOne' se execută prin reglarea inelului de echilibrare gradat în linie cu marcajul de pe capul de alezare (în conformitate cu codul de echilibrare al sculei folosite și a diametrului de alezat). Nu necesită tabel de valori.
Echilibrarea de precizie este posibilă doar pentru cele mai mici diametre de scule de alezat 6-33 mm *(0,236-1,299")*.

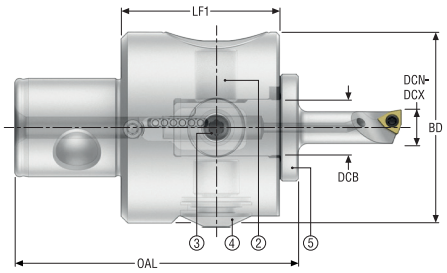
NOTĂ! La utilizarea unei scule „Alu" sau „MPA" mai mare de la - Axiabore™ Plus - în capetele - Axialibrabore™ Plus - reglarea de precizie nu este posibilă, iar inelul de echilibrare trebuie setat la poziţia de pre-echilibrare a capului (în funcţie de operaţia dorită, consultaţi capitolul Instrucţiuni).
Viteza maximă va fi cea de la - Axiabore™ Plus.

Rezoluţia de setare a diametrului: 2,5 µm *(0,0001")*

FB 760 D capete de tip Axiabore digitale, neechilibrabile

Graflex®





—Compatibil cu afișajul digital pentru a vedea incrementul scalei pe afișajul lat (afișajul digital va fi comandat separat)
—Axiabore™ plus – permite alezarea, precum și strunjire OD și canelare frontală

3. Bridă
4. Șurub de reglare micrometrică
2. Șurub asamblare
5. Sculă

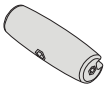
Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	BD	DCB	Greutate	Viteza de lucru max**	
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	RPM max.**	Max. m/min**
G3-FB760-02-D	10215570	G3	2,0 *0.079*	20,0 *0.787*	70,0 *2.756*	50,0 *1.969*	36,5 *1.437*	12,0 *0.472*	0,5 *1.1*	12000	1500
G5-FB760-03-D	10215571	G5	6,0 *0.236*	108,0 *4.252*	75,0 *2.953*	45,0 *1.772*	54,0 *2.126*	16,0 *0.630*	0,9 *2.0*	8000	1000

Notă: Greutatea este fără suport de plăcuţe

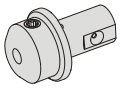
**Viteza maximă, oricare dintre acestea este atinsă mai întâi fără a depăși niciuna dintre ele.

Suporturile pentru plăcuțe și controlerul universal cu afișaj digital trebuie comandate separat, consultaţi paginile următoare.

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare
				
G3	AU7601212	–	03M03C	19A71030
G5	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

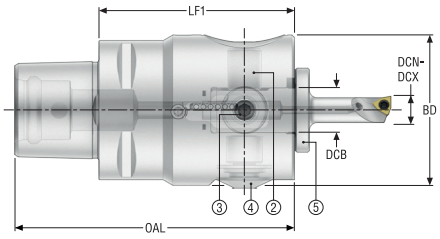
Accesorii

Pentru cap	Afișaj digital	Bucșă reducție	Cheie dinamometrică
			
G3	990FBDD01-Y	05A7601204	H00-3030
G5	990FBDD01-Y	–	H00-3030

FB 760 D capete de tip Axiabore digitale, neechilibrabile

Seco Capto™





—Compatibil cu afișajul digital pentru a vedea incrementul scalei pe afișajul lat (afișajul digital va fi comandat separat)
—Axiabore™ plus – permite alezarea, precum și strunjire OD și canelare frontală

3. Bridă
4. Șurub de reglare micrometrică
2. Șurub asamblare
5. Sculă

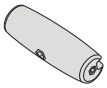
Reper Nr.	Număr reper	Od strony obrabiarki Mărime Capto	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	BD	DCB	Greutate	Viteza de lucru max**	
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	RPM max.**	Max. m/min**
C3-391.FB760-02-D	10215575	C3	2,0 *0.079*	20,0 *0.787*	89,0 *3.504*	70,0 *2.756*	36,5 *1.437*	12,0 *0.472*	0,5 *1.1*	12000	1500
C5-391.FB760-03-D	10215576	C5	6,0 *0.236*	108,0 *4.252*	100,0 *3.937*	70,0 *2.756*	54,0 *2.126*	16,0 *0.630*	1,3 *2.9*	8000	1000

Notă: Greutatea este fără suport de plăcuțe

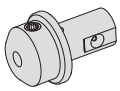
**Viteza maximă, oricare dintre acestea este atinsă mai întâi fără a depăși niciuna dintre ele.

Suporturile pentru plăcuțe și controlerul universal cu afișaj digital trebuie comandate separat, consultați paginile următoare.

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare
				
C3	AU7601212	–	03M03C	19A71030
C5	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

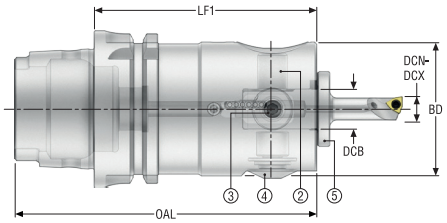
Accesorii

Pentru cap	Afișaj digital	Bucșă reducție	Cheie dinamometrică
			
C3	990FBDD01-Y	05A7601204	H00-3030
C5	990FBDD01-Y	–	H00-3030

FB 760 – Capete de tip Axiabore™

HSK-A





—Compatibil cu afișajul digital pentru a vedea incrementul scalei pe afișajul lat (afișajul digital va fi comandat separat)
—Axiabore™ plus – permite alezarea, precum și strunjire OD și canelare frontală

3. Bridă
4. Șurub de reglare micrometrică
2. Șurub asamblare
5. Sculă

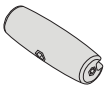
Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	BD	DCB	Greutate	Viteza de lucru max**	
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	RPM max.**	Max. m/min**
HSKA63-FB760-03-D	10215578	HSK-A63	6,0 *0.236*	108,0 *4.252*	122,0 *4.803*	90,0 *3.543*	54,0 *2.126*	16,0 *0.630*	1,8 *4.0*	8000	1000

Notă: Greutatea este fără suport de plăcuţe

**Viteza maximă, oricare dintre acestea este atinsă mai întâi fără a depăși niciuna dintre ele.

Suporturile pentru plăcuţe și controlerul universal cu afișaj digital trebuie comandate separat, consultaţi paginile următoare.

Piese de schimb, Piese incluse la livrare

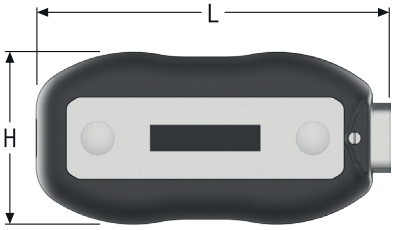
Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare
				
HSKA	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

Accesorii

Pentru cap	Afișaj digital	Cheie dinamometrică
		
HSKA	990FBDD01-Y	H00-3030

Afișaj digital pentru capetele de alezare digitale





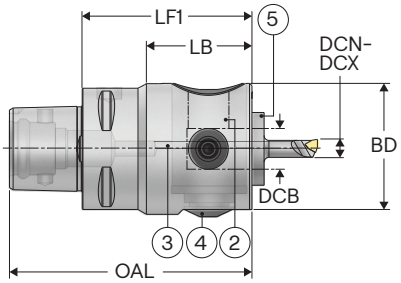
—Afișaj digital pentru capetele de alezare fină digitale
—Un afișaj digital poate fi utilizat pentru toate capetele de alezare digitale Seco
—Setarea diametrului în mm sau inch este posibilă
—Afișaj reversibil cu magnet pentru o prindere mai bună atunci când este montat pe capul de alezare digital în timpul configurării
—Baterie reîncărcabilă, de unică folosinţă în interior

Reper Nr.	Număr reper	L	H	Greutate
		mm *Inci*	mm *Inci*	kg *lbs*
990FBDD01	10215579	74,25 *2.92*	36 *1.42*	0,2 *0.008*

FB 760 – Capete de tip Axiabore™

Seco Capto™





—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)
—Axiabore™ plus – permite alezarea, precum și strunjire OD și canelare frontală

3. Bridă
4. Șurub de reglare micrometrică
2. Șurub asamblare
5. Sculă

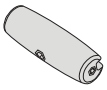
Reper Nr.	Număr reper	Spre mașină	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	BD	DCB	Greutate	*	Viteza de lucru max**	
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		RPM max.**	Max. m/min**
C5-391.0760-03	02822777	C5	6,0 *0.236*	108,0 *4.252*	95,0 *3.740*	65,0 *2.559*	54,0 *2.126*	16,0 *0.630*	1,2 *2.7*	*	8000	1500

Notă: Greutatea este fără suport de plăcuţe

Pentru scule, vezi pag. 516-518

*Max. 5000 RPM la utilizarea MPA.
**Capacităţi - Axiabore™ plus - cap pentru alezare 6-108 mm (0.236-4.252") , alezare-OD 2-57 mm (0.079-2.244"), canelare frontală 19-96 mm (0.748-3.780").

Piese de schimb, Piese incluse la livrare

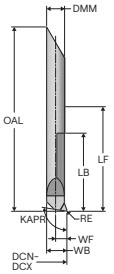
Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare
				
C5-...-03	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125

Accesorii

Pentru cap	Cheia dinamometrică pentru șuruburile de blocare și asamblare
	
C5-...-03	H00-3030

Unelte de alezat, carbură solidă
pentru capete FB 760





—Potrivit atât pentru capetele de alezare digitale, cât și analogice
—KAPR 98°
—Orientare muchie de așchiere ISO
—Lichid de răcire de-a lungul uneltei
—Materialul sculei: Carbură solidă*

Reper Nr.	Număr reper	Pentru cap	Capacitatea DCN-DCX ∅ mm***		OAL	LB	LF	DMM	WB	WF	RE	Regimuri de așchiere recomandate** a_p	Regimuri de așchiere recomandate** f	Greutate	Cod echilibrare
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A761402	02462579	FB 76001	0,3 *0.012*	0,6 *0.024*	30,7 *1.209*	1,2 *0.047*	15,5 *0.610*	4,0 *0.157*	0,25 *0.010*	0,1 *0.004*	0,0 *0.0*	0,02 *0.001*	0,01 *0*	0,01 *0.0*	–
A761412	02462581	FB 76001	0,5 *0.020*	1,1 *0.043*	30,7 *1.209*	2,0 *0.079*	15,5 *0.610*	4,0 *0.157*	0,45 *0.018*	0,2 *0.008*	0,0 *0.0*	0,02 *0.001*	0,01 *0*	0,1 *0.2*	–
A761422	02462583	FB 76001	1,0 *0.039*	2,1 *0.083*	30,7 *1.209*	5,0 *0.197*	15,5 *0.610*	4,0 *0.157*	0,95 *0.037*	0,45 *0.018*	0,1 *0.004*	0,03 *0.001*	0,02 *0.001*	0,1 *0.2*	–
A761432	02462584	FB 76001/02/12	2,0 *0.079*	3,2 *0.126*	30,7 *1.209*	8,0 *0.315*	15,5 *0.610*	4,0 *0.157*	1,8 *0.071*	0,88 *0.035*	0,1 *0.004*	0,05 *0.002*	0,02 *0.001*	0,1 *0.2*	E13
A761442	02462586	FB 76001/02/12	3,0 *0.118*	4,7 *0.185*	30,7 *1.209*	10,0 *0.394*	15,5 *0.610*	4,0 *0.157*	2,75 *0.108*	1,35 *0.053*	0,15 *0.006*	0,06 *0.002*	0,03 *0.001*	0,1 *0.2*	E14
A761452	02462587	FB 76001/02/12	4,5 *0.177*	6,2 *0.244*	35,7 *1.406*	15,0 *0.591*	20,5 *0.807*	4,0 *0.157*	3,95 *0.156*	1,95 *0.077*	0,15 *0.006*	0,08 *0.003*	0,03 *0.001*	0,1 *0.2*	E15

*Aceste unelte cu diam de coadă de 4 mm necesită utilizarea unei bucșe de reducţie, livrat cu capetele și kiturile potrivite.

** Pentru regimurile de așchiere recomandate, vezi pag. 592–595

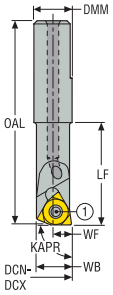
***+0,1 mm capacitate complementară realizabilă.

Bare de alezare, tip de plăcuţă

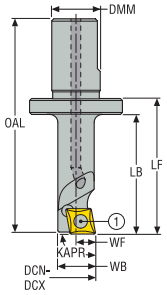
pentru capete FB 760



Design 1



Design 2



1 = Şurub de blocare a plăcuţei

—Potrivit atât pentru capetele de alezare digitale, cât şi analogice
—Orientare muchie de aşchiere ISO
—Agent de răcire complet
—Doar două dimensiuni de plăcuţe pentru toate sculele
—Materialul sculei * = Oţel, tip plăcuţe indexabile
—Materialul sculei ** = Carbură, tip plăcuţe
—KAPR 90°

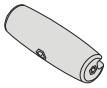
Reper Nr.	Număr reper	Pentru portsculă	Pentru cap	** Capacitatea DCN-DCX ∅		OAL	LB	LF	DMM	WB	WF	Greutate	Varianta	Mărimea plăcuţei potrivite	Cod echilibrare
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*			
A762001	02462590	*	FB 76001	6,0 *0.236*	8,0 *0.315*	31,7 *1.248*	0,0 –	16,0 *0.630*	6,0 *0.236*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	1	WB...0301..	–
A762002	02594947	*	FB 76002/12	6,0 *0.236*	8,0 *0.315*	39,7 *1.563*	16,0 *0.630*	20,0 *0.787*	12,0 *0.472*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	2	WB...0301..	S21
A762003	02594967	*	FB 76003/13	6,0 *0.236*	8,0 *0.315*	50,2 *1.976*	16,0 *0.630*	21,0 *0.827*	16,0 *0.630*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	2	WB...0301..	S31
A763002	02594948	*	FB 76002/12	8,0 *0.315*	10,0 *0.394*	45,7 *1.799*	22,0 *0.866*	26,0 *1.024*	12,0 *0.472*	7,4 *0.291*	3,9 *0.154*	0,1 *0.2*	2	WB...0301..	S22
A763003	02594968	*	FB 76003/13	8,0 *0.315*	10,0 *0.394*	56,2 *2.213*	22,0 *0.866*	27,0 *1.063*	16,0 *0.630*	7,4 *0.291*	3,9 *0.154*	0,1 *0.2*	2	WB...0301..	S32
A765002	02594957	*	FB 76002/12	10,0 *0.394*	13,0 *0.512*	53,5 *2.106*	30,0 *1.181*	34,0 *1.339*	12,0 *0.472*	9,35 *0.368*	4,8 *0.189*	0,1 *0.2*	2	CC...0602..	S23
A765003	02594969	*	FB 76003/13	10,0 *0.394*	13,0 *0.512*	64,0 *2.520*	30,0 *1.181*	35,0 *1.378*	16,0 *0.630*	9,35 *0.368*	4,8 *0.189*	0,1 *0.2*	2	CC...0602..	S33
A762201	02462591	**	FB 76001	6,0 *0.236*	8,0 *0.315*	41,7 *1.642*	0,0 –	26,0 *1.024*	6,0 *0.236*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	1	WB...0301..	–
A762202	02594958	**	FB 76002/12	6,0 *0.236*	8,0 *0.315*	50,7 *1.996*	27,0 *1.063*	31,0 *1.220*	12,0 *0.472*	5,5 *0.217*	2,9 *0.114*	0,1 *0.2*	2	WB...0301..	E21
A762203	02594970	**	FB 76003/13	6,0 *0.236*	8,0 *0.315*	61,2 *2.409*	27,0 *1.063*	32,0 *1.260*	16,0 *0.630*	5,5 *0.217*	2,9 *0.114*	0,2 *0.4*	2	WB...0301..	E31
A763202	02594961	**	FB 76002/12	8,0 *0.315*	10,0 *0.394*	60,7 *2.390*	37,0 *1.457*	41,0 *1.614*	12,0 *0.472*	7,4 *0.291*	3,9 *0.154*	0,1 *0.2*	2	WB...0301..	E22
A763203	02594971	**	FB 76003/13	8,0 *0.315*	10,0 *0.394*	71,2 *2.803*	37,0 *1.457*	42,0 *1.654*	16,0 *0.630*	7,4 *0.291*	3,9 *0.154*	0,2 *0.4*	2	WB...0301..	E32
A765202	02594962	**	FB 76002/12	10,0 *0.394*	13,0 *0.512*	78,5 *3.091*	55,0 *2.165*	59,0 *2.323*	12,0 *0.472*	9,35 *0.368*	4,8 *0.189*	0,1 *0.2*	2	CC...0602..	E23
A765203	02594972	**	FB 76003/13	10,0 *0.394*	13,0 *0.512*	89,0 *3.504*	55,0 *2.165*	60,0 *2.362*	16,0 *0.630*	9,35 *0.368*	4,8 *0.189*	0,2 *0.4*	2	CC...0602..	E33

**+0,2 mm capacitate complementară realizabilă.

Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuţei	Şurub plăcuţă
	
CC...0602..	C02504-T07P
WB...0301..	C02035-T06P

Accesorii

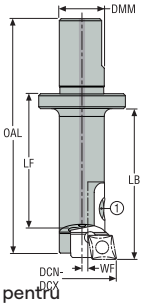
Cheie plăcuţă	Cheie (tip T)
	
H4B-T07P	DOUBLE-T
H4B-T06P	DOUBLE-T

Cozi de alezare, pentru bare modulare pentru alezare de finiţie

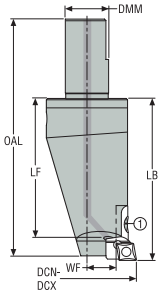
pentru capete FB 760



Design 1



Design 2



- Mai multe capacităţi care pot fi obţinute prin suporturi interschimbabile pentru plăcuţe
- Tipuri de cozi „oţel" pentru bare scurte, „carbură" pentru bare lungi, „aluminiu" pentru bare mari
- Agent de răcire complet

1 = Șurub de blocare

Reper Nr.	Număr reper	Coadă modulară de alezare tip	Pentru cap	** Capacitatea DCN-DCX ∅		***	OAL	LB	LF	DMM	WF	Greutate	Varianta
				mm *Inci*	mm *Inci*		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A760S20	02594963	Oţel	FB 76002/12	13,0 *0.512*	20,0 *0.787*		62,5 *2.461*	40,0 *1.575*	34,0 *1.339*	12,0 *0.472*	1,4 *0.055*	0,1 *0.2*	1
A760S30	02594973	Oţel	FB 76003/13	13,0 *0.512*	18,0 *0.709*		73,0 *2.874*	40,0 *1.575*	35,0 *1.378*	16,0 *0.630*	1,4 *0.055*	0,1 *0.2*	1
A760S31	02594974	Oţel	FB 76003/13	18,0 *0.709*	33,0 *1.299*		83,0 *3.268*	50,0 *1.969*	45,0 *1.772*	16,0 *0.630*	3,9 *0.154*	0,2 *0.4*	1
A760E20	02594964	Carbură	FB 76002/12	13,0 *0.512*	20,0 *0.787*		82,5 *3.248*	60,0 *2.362*	54,0 *2.126*	12,0 *0.472*	1,4 *0.055*	0,2 *0.4*	1
A760E30	02594965	Carbură	FB 76003/13	13,0 *0.512*	18,0 *0.709*		103,0 *4.055*	70,0 *2.756*	65,0 *2.559*	16,0 *0.630*	1,4 *0.055*	0,2 *0.4*	1
A760E31	02594966	Carbură	FB 76003/13	18,0 *0.709*	33,0 *1.299*		113,0 *4.449*	80,0 *3.150*	75,0 *2.953*	16,0 *0.630*	3,9 *0.154*	0,3 *0.7*	1
A760A32	02594977	Aluminium	FB 76003/13	33,0 *1.299*	48,0 *1.890*	***	88,0 *3.465*	60,0 *2.362*	50,0 *1.969*	16,0 *0.630*	11,5 *0.453*	0,2 *0.4*	2
A760A33	02594978	Aluminium	FB 76003/13	48,0 *1.890*	63,0 *2.480*	***	108,0 *4.252*	80,0 *3.150*	70,0 *2.756*	16,0 *0.630*	19,0 *0.748*	0,4 *0.9*	2

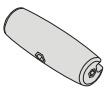
Notă: Greutatea este fără suport de plăcuţe.

**+0,2 mm capacitate complementară realizabilă.
*** Când este utilizat pe A760 13, nu este posibilă echilibrarea fină. Selectaţi combinaţia de cozi și de suporţi necesare utilizând diagrama de selectare de la pag. 520.

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub de blocare
	
A76002/12	C04008-T15P
A76003	C04008-T15P
A76003/13	C04008-T15P

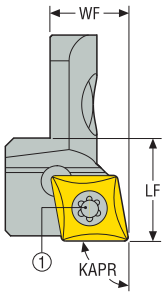
Accesorii

Cheie (tip T)	Cheie de blocare
	
DOUBLE-T	H6B-T15P
DOUBLE-T	H6B-T15P
DOUBLE-T	H6B-T15P

Portplăcuţe pentru capete de alezare de finisare

pentru capete FB 760





—Dimensiune de montare unică potrivită pentru toate cozile de alezare (şi de alezare OD)
—O dimensiune de plăcută pentru toate portplăcuţele.

1 = Şurub de blocare a plăcuţei

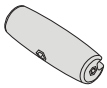
Reper Nr.	Număr reper	LF mm *Inci*	WF mm *Inci*	Greutate kg *lbs*	Mărimea plăcuţei potrivite	KRINS°
A765R1	02594979	10,0 *0.394*	4,95 *0.195*	0,1 *0.2*	CC...0602...	90
A765R2	02594983	10,0 *0.394*	6,2 *0.244*	0,1 *0.2*	CC...0602...	90
A765R3	02594984	10,0 *0.394*	7,45 *0.293*	0,1 *0.2*	CC...0602...	90
A765R4	02594987	10,0 *0.394*	8,7 *0.343*	0,1 *0.2*	CC...0602...	90
A765R5	02594989	10,0 *0.394*	9,97 *0.393*	0,1 *0.2*	CC...0602...	90
A765R6	02594990	10,0 *0.394*	11,2 *0.441*	0,1 *0.2*	CC...0602...	90

*WF atunci când este echipat cu plăcuţe tip CC..060204.
Selectaţi combinaţia de cozi şi de suporţi necesare utilizând diagrama de selectare de la pag. 520.

Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuţei	Şurub plăcuţă
	
CC...0602...	C02504-T07P

Accesorii

Cheie plăcuţă	Cheie (tip T)
	
H4B-T07P	DOUBLE-T

Diagramă de selecţie:
Scule de alezare și suporturi pentru plăcuţe potrivite pentru capete FB 760

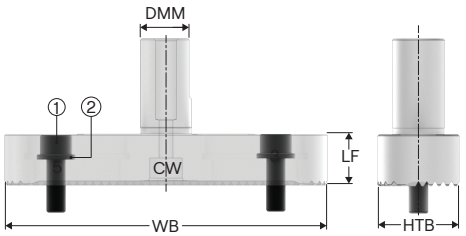
Pentru cap	Capacitate de alezare DCN-DCX ∅ mm	*inci*	Lungime de alezare LB mm	*inci*	Reper Nr. Scule pentru alezare	Port-plăcuţă	DMM mm	*inci*	Mărimea plăcuţei potrivite	Tip sculă
A760 01	0,3-0,6	*0.012-0.024*	1,2	*0.047*	A761402	–	4	*0.157*	–	Carbură solidă
	0,5-1,1	*0.020-0.043*	2	*0.078*	A761412	–	4	*0.157*	–	Carbură solidă
	1-2,1	*0.039-0.083*	-	-	A761422	–	4	*0.157*	–	Carbură solidă
	2-3,2	*0.079-0.126*	8	*0.315*	A761432	–	4	*0.157*	–	Carbură solidă
	3-4,7	*0.118-0.185*	10	*0.394*	A761442	–	4	*0.157*	–	Carbură solidă
	4,5-6,2	*0.177-0.244*	15	*0.591*	A761452	–	4	*0.157*	–	Carbură solidă
	6-8	*0.236-0.315*	16	*0.630*	A762001	–	6	*0.236*	WB..0301..	Oţel, tip de plăcuţe
	6-8	*0.236-0.315*	26	*1.024*	A762201	–	6	*0.236*	WB..0301..	Carbură, tip plăcuţe
A760 02/ A760 12	2-3,2	*0.079-0.126*	8	*0.315*	A761432	–	4	*0.157*	–	Carbură solidă
	3-4,7	*0.118-0.185*	10	*0.394*	A761442	–	4	*0.157*	–	Carbură solidă
	4,5-6,2	*0.177-0.244*	15	*0.591*	A761452	–	4	*0.157*	–	Carbură solidă
	6-8	*0.236-0.315*	16	*0.630*	A762002	–	12	*0.472*	WB..0301..	Oţel, tip de plăcuţe
	6-8	*0.236-0.315*	27	*1.063*	A762202	–	12	*0.472*	WB..0301..	Carbură, tip plăcuţe
	8-10	*0.315-0.394*	22	*0.866*	A763002	–	12	*0.472*	WB..0301..	Oţel, tip de plăcuţe
	8-10	*0.315-0.394*	37	*1.457*	A763202	–	12	*0.472*	WB..0301..	Carbură, tip plăcuţe
	10-13	*0.394-0.512*	30	*1.181*	A765002	–	12	*0.472*	CC..0602..	Oţel, tip de plăcuţe
	10-13	*0.394-0.512*	55	*2.165*	A765202	–	12	*0.472*	CC..0602..	Carbură, tip plăcuţe
	13-15,5	*0.512-0.610*	40	*1.575*	A760S20	A765R1	12	*0.472*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	13-15,5	*0.512-0.610*	60	*2.362*	A760E20	A765R1	12	*0.472*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	15,5-18	*0.610-0.709*	40	*1.575*	A760S20	A765R2	12	*0.472*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	15,5-18	*0.610-0.709*	60	*2.362*	A760E20	A765R2	12	*0.472*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	18-20	*0.709-0.787*	40	*1.575*	A760S20	A765R3	12	*0.472*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	18-20	*0.709-0.787*	60	*2.362*	A760E20	A765R3	12	*0.472*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
A760 03/ A760 13	6-8	*0.236-0.315*	16	*0.630*	A762003	–	16	*0.630*	WB..0301..	Oţel, tip de plăcuţe
	6-8	*0.236-0.315*	32	*1.260*	A762203	–	16	*0.630*	WB..0301..	Carbură, tip plăcuţe
	8-10	*0.315-0.394*	22	*0.866*	A763003	–	16	*0.630*	WB..0301..	Oţel, tip de plăcuţe
	8-10	*0.315-0.394*	37	*1.457*	A763203	–	16	*0.630*	WB..0301..	Carbură, tip plăcuţe
	10-13	*0.394-0.512*	30	*1.181*	A765003	–	16	*0.630*	CC..0602..	Oţel, tip de plăcuţe
	10-13	*0.394-0.512*	55	*2.165*	A765203	–	16	*0.630*	CC..0602..	Carbură, tip plăcuţe
	13-15,5	*0.512-0.610*	40	*1.575*	A760S30	A765R1	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	13-15,5	*0.512-0.610*	70	*2.756*	A760E30	A765R1	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	15,5-18	*0.610-0.709*	40	*1.575*	A760S30	A765R2	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	15,5-18	*0.610-0.709*	70	*2.756*	A760E30	A765R2	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	18-20,5	*0.709-0.807*	50	*1.969*	A760S31	A765R1	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	18-20,5	*0.709-0.807*	80	*3.150*	A760E31	A765R1	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	20,5-23	*0.807-0.906*	50	*1.969*	A760S31	A765R2	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	20,5-23	*0.807-0.906*	80	*3.150*	A760E31	A765R2	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	23-25,5	*0.906-1.00*	50	*1.969*	A760S31	A765R3	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	23-25,5	*0.906-1.00*	80	*3.150*	A760E31	A765R3	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	25,5-28	*1.004-1.102*	50	*1.969*	A760S31	A765R4	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	25,5-28	*1.004-1.102*	80	*3.150*	A760E31	A765R4	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	28-30,5	*1.102-1.201*	50	*1.969*	A760S31	A765R5	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	28-30,5	*1.102-1.201*	80	*3.150*	A760E31	A765R5	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	30,5-33	*1.201-1.299*	50	*1.969*	A760S31	A765R6	16	*0.630*	CC..0602..	Coadă din oţel cu suport pentru plăcuţă
	30,5-33	*1.201-1.299*	80	*3.150*	A760E31	A765R6	16	*0.630*	CC..0602..	Coadă din carbură cu suport pentru plăcuţă
	33-35,5*	*1.299-1.398**	60	*2.362*	A760A32	A765R1	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	35,5-38*	*1.299-1.496**	60	*2.362*	A760A32	A765R2	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	38-40,5*	*1.496-1.594**	60	*2.362*	A760A32	A765R3	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	40,5-43*	*1.594-1.693**	60	*2.362*	A760A32	A765R4	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	43-45,5*	*1.693-1.791**	60	*2.362*	A760A32	A765R5	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	45,5-48*	*1.791-1.890**	60	*2.362*	A760A32	A765R6	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	48-50,5*	*1.890-1.988**	80	*3.150*	A760A33	A765R1	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	50,5-53*	*1.988-2.087**	80	*3.150*	A760A33	A765R2	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	53-55,5*	*2.087-2.185**	80	*3.150*	A760A33	A765R3	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	55,5-58*	*2.185-2.283**	80	*3.150*	A760A33	A765R4	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	58-60,5*	*2.283-2.382**	80	*3.150*	A760A33	A765R5	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă
	60,5-63*	*2.382-2.480**	80	*3.150*	A760A33	A765R6	16	*0.630*	CC..0602..	Coadă din aluminiu cu suport pentru plăcuţă

Pentru diametre mai mari, consultaţi secţiunea Adaptor Multifuncţional (MPA).
* Când este utilizat pe A760 13, nu este posibilă echilibrarea fină.

Adaptoare cu utilizare multiplă (MPA)

pentru capete FB 760



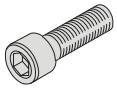


—Potrivit atât pentru Digital, cât și pentru Analog Axiabore™ Plus – numai pentru cap A760 03*
—Concepute pentru a susține o coadă și o contragreutate (pentru alezare sau alezare-OD) sau două suporturi pentru unelte de canelare (pentru canelare frontală)
—Lichidul de răcire interior cu o duză reglabilă (3)

1. Șurub asamblare
2. Șaibă
3. Duză reglabilă

		Capacitatea DCN-DCX ∅										
Reper Nr.	Număr reper	Pentru alezaj		Pentru strunjire exterioară		Pentru canelare		HTB	LF	DMM	WB	Greutate
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
BDA16BS25100	02595014	53,0 *2.087*	108,0 *4.252*	2,0 *0.079*	57,0 *2.244*	31,0 *1.220*	96,0 *3.780*	25,0 *0.984*	16,0 *0.630*	16,0 *0.630*	100,0 *3.937*	0,3 *0.660*

Piese de schimb, Piese incluse la livrare

Pentru	Șurub ansamblu	Șaibă
		
BDA16BS25100	950D0618	940ZC06

Accesorii

Pentru cap	Cheie clemă
	
BDA16BS25100	03HL05

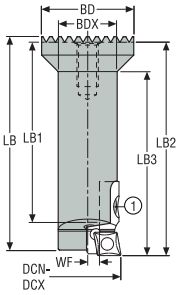
*Când este utilizat pe un cap - Axialibrabore™ Plus - A760 13, nu este posibilă echilibrarea fină, consultați pag. 510
Selectați componentele necesare pentru realizarea ansamblurilor de alezare, alezare-OD sau canelare, utilizând pag. următoare 525-536

Coadă și contragreutate, pentru alezare sau alezare-OD pe un MPA

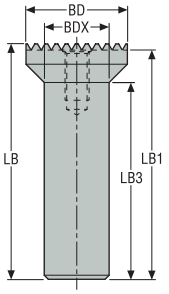
pentru capete FB 760



Design A



Design B



—Pentru a se potrivi la MPA
—Coada poate fi utilizată pentru alezare sau alezare-OD
—Are aceleași suporturi de plăcuțe ca și suporții modulari de alezare

1. Șurub asamblare

			** Capacitatea DCN-DCX ∅												
Reper Nr.	**Număr reper**	**Varianta**	**Pentru alezaj**		**Pentru strunjire exterioară**		**LB**	**LB1**	**LB2**	**LB3**	**WF**	**BDX**	**BD**	**Greutate**	**Varianta**
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
BAS25MH1660	02595019	Coada*	53,0 *2.087*	108,0 *4.252*	2,0 *0.079*	57,0 *2.244*	58,5 *2.303*	48,5 *1.909*	58,5 *2.303*	50,0 *1.969*	4,0 *0.157*	16,0 *0.630*	25,0 *0.984*	0,1 *0.2*	A
BAS25CW1660	02595016	Contragreu-tate	53,0 *2.087*	108,0 *4.252*	2,0 *0.079*	57,0 *2.244*	58,0 *2.283*	56,6 *2.228*	–	48,5 *1.909*	–	16,0 *0.630*	25,0 *0.984*	0,2 *0.4*	B

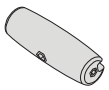
* Cartușele se comandă separat, consultați pagina (paginile) 519

**Capacitățile de alezare și de răsturnare OD sunt legate de suportul inserției selectate și de poziția de setare a brăzdarului utilizând „Insert Holders for alezing or OD-OversTurning Selection Chart“ de la pagina (paginile) 525-536

Piese de schimb, Piese incluse la livrare

Pentru	**Șurub ansamblu**
	
BAS25CW1660	–
BAS25MH1660	C04008-T15P

Accesorii

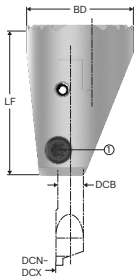
Pentru	**Cheie clemă**	**Cheie (tip T)**
		
BAS25CW1660	–	–
BAS25MH1660	H6B-T15P	DOUBLE-T

Suporturi pentru scule de canelare, pentru canelarea feţei pe un MPA

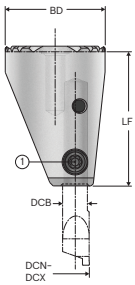
pentru capete FB 760



I



E



—Pentru a se potrivi la MPA
—Un suport pentru unelte de canelare este utilizat fie pentru a susţine o unealtă de canelare, fie pentru a acţiona ca o contragreutate

1. Șurub de blocare

Reper Nr.	Număr reper	Varianta	* Capacitatea DCN-DCX ∅ mm *Inci*	mm *Inci*	DCB mm *Inci*	LF mm *Inci*	BD mm *Inci*	Greutate kg *lbs*	Varianta
BAS25FGI35	02595021	Grooving tool holder I (internal)*	19,0 *0.748*	76,0 *2.992*	6,0 *0.236*	35,0 *1.378*	25,0 *0.984*	0,1 *0.2*	I (Intern)
BAS25FGE35	02595020	Grooving tool holder E (external)*	39,0 *1.535*	96,0 *3.780*	6,0 *0.236*	35,0 *1.378*	25,0 *0.984*	0,1 *0.2*	E (Exterior)

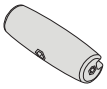
* Cartușe de comandat separat, consultaţi pagina (paginile) 524

* Capacitatea de canelare este legată de instrumentul de canelare selectat, de poziția de setare și de orientarea suportului pentru caneluri, utilizând „instrumentul de canelare împotriva canelării (sau împotriva alezajului)“, a se vedea pagina (paginile) 525-536

Piese de schimb, Piese incluse la livrare

Pentru	Șurub de blocare
	
BAS25FGE35	950L0607T15P
BAS25FGI35	950L0607T15P

Accesorii

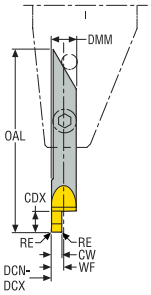
Pentru	Cheie (tip T)	Cheie de blocare
		
BAS25FGE35	DOUBLE-T	H6B-T15P
BAS25FGI35	DOUBLE-T	H6B-T15P

Unelte de canelare
pentru capete FB 760

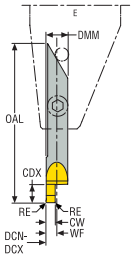


—Poate fi utilizat fie pentru suporturi de scule „externe", fie „interne", în funcţie de capacitate

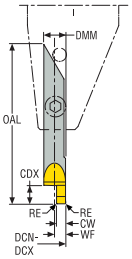
A



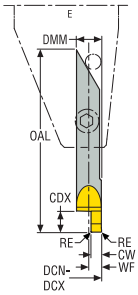
B



C



D



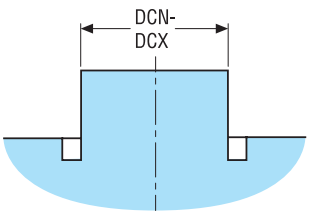
*** Capacitatea DCN-DCX ∅**

Reper Nr.	Număr reper	Varianta	Varianta A		Varianta B		Varianta C		Varianta D		OAL	CW	RE	DMM	WF	Adânci-mea maximă **	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
AFG0629101582	02595028	contra spigot	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	1,0 *0.039*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	2,0 *0.079*	0,07 *0.150*
AFG0629151582	02595029	contra spigot	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	1,5 *0.059*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	3,0 *0.118*	0,07 *0.150*
AFG0629201582	02595031	contra spigot	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	2,0 *0.079*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	4,0 *0.157*	0,1 *0.220*
AFG0629251582	02595032	contra spigot	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	2,5 *0.098*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	5,0 *0.197*	0,1 *0.220*
AFG0629301582	02595033	contra spigot	19,0 *0.748*	64,0 *2.520*	39,0 *1.535*	84,0 *3.307*	–	–	–	–	42,0 *1.654*	3,0 *0.118*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	6,0 *0.236*	0,1 *0.220*
AFG0629101581	02595022	Against bore	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	1,0 *0.039*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	2,0 *0.079*	0,1 *0.220*
AFG0629151581	02595023	Against bore	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	1,5 *0.059*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	3,0 *0.118*	0,07 *0.150*
AFG0629201581	02595024	Against bore	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	2,0 *0.079*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	4,0 *0.157*	0,1 *0.220*
AFG0629251581	02595026	Against bore	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	2,5 *0.098*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	5,0 *0.197*	0,1 *0.220*
AFG0629301581	02595027	Against bore	–	–	–	–	31,0 *1.220*	76,0 *2.992*	51,0 *2.008*	96,0 *3.780*	42,0 *1.654*	3,0 *0.118*	0,15 *0.006*	6,0 *0.236*	2,95 *0.116*	6,0 *0.236*	0,1 *0.220*

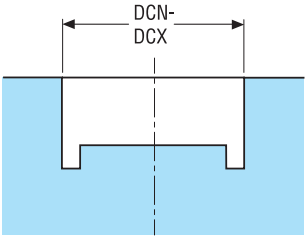
* Capacitatea de canelare este legată de instrumentul de canelare selectat, de poziţia de setare şi de orientarea suportului pentru caneluri, utilizând „instrumentul de canelare împotriva canelării (sau împotriva alezajului)", a se vedea pagina (paginile) 525-536

** Adâncime max. canal CDX

cule de canelat - contra spigot-

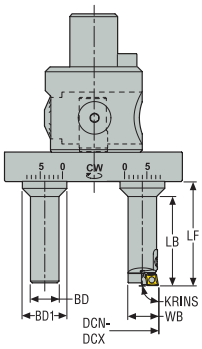


Scule de canelat - against bore-



Metric Diagramă de selecţie:
Scule de alezare și suporturi pentru plăcuţe potrivite pentru capete FB 760

Selectaţi suportul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a alezării.
Notă: Un ansamblu de alezare necesită:
- un - Axiabore™ plus - cap (A760 03)
- a MPA (BDA16BS25100)
- o coadă (BAS25MH1660)
- o contragreutate (BAS25CW1660).
- un suport pentru plăcuţe (A765R.) selectat din diagramă
- o plăcuţă

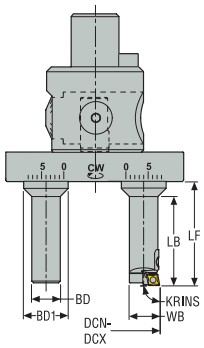


Capacitatea DCN-DCX ∅ mm*	Suportul plăcuţei Descriere	Poziţia cozii	Dimensiunea în mm					Unghi de atac KRINS°	Mărimea plăcuţei potrivite
			BD	BD1	LF	LB	WB		
53-55,5	A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
55,5-58	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
58-60,5	A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	0	16	25	58,5	50	19,5	90°	CC..0602..
60,5-63	A765 R2	1	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	0	16	25	58,5	50	20,7	90°	CC..0602..
63-65,5	A765 R1	2	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	1	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
65,5-68	A765 R2	2	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	1	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	0	16	25	58,5	50	23,3	90°	CC..0602..
68-70,5	A765 R1	3	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	2	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	1	16	25	58,5	50	22	90°	CC..0602..
70,5-73	A765 R2	3	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	2	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
73-75,5	A765 R1	4	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	3	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	2	16	25	58,5	50	22	90°	CC..0602..
75,5-78	A765 R2	4	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	3	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	2	16	25	58,5	50	23,2	90°	CC..0602..
78-80,5	A765 R1	5	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	4	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	3	16	25	58,5	50	22	90°	CC..0602..
80,5-83	A765 R2	5	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	4	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	3	16	25	58,5	50	23,2	90°	CC..0602..
83-85,5	A765 R1	6	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	5	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	4	16	25	58,5	50	22	90°	CC..0602..
85,5-88	A765 R2	6	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	5	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	4	16	25	58,5	50	23,2	90°	CC..0602..
88-90,5	A765 R1	7	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	6	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	5	16	25	58,5	50	22	90°	CC..0602..
90,5-93	A765 R2	7	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	6	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	5	16	25	58,5	50	23,2	90°	CC..0602..
93-95,5	A765 R1	8	16	25	58,5	50	17	90°	CC..0602..
	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
95,5-98	A765 R2	8	16	25	58,5	50	18,2	90°	CC..0602..
	A765 R4	7	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	6	16	25	58,5	50	23,2	90°	CC..0602..
98-100,5	A765 R3	8	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R5	7	16	25	58,5	50	22	90°	CC..0602..
100,5-103	A765 R4	8	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R6	7	16	25	58,5	50	23,2	90°	CC..0602..
103-105,5	A765 R5	8	16	25	58,5	50	22	90°	CC..0602..
105,5-108	A765 R6	8	16	25	58,5	50	23,2	90°	CC..0602..

* +0,2 mm (0,008") capacitate complementară realizabilă.
Descrierea detaliată a suporturilor de plăcuţe, consultaţi pagina (paginile) 519

Inci Diagramă de selecţie:
Scule de alezare și suporturi pentru plăcuţe potrivite pentru capete FB 760

Selectaţi suportul de canelare adecvat și notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a alezării.
Notă: Un ansamblu de alezare necesită:
- un - Axiabore™ plus - cap (A760 03)
- a MPA (BDA16BS25100)
- o coadă (BAS25MH1660)
- o contragreutate (BAS25CW1660).
- un suport pentru plăcuţe (A765R.) selectat din diagramă
- o plăcuţă

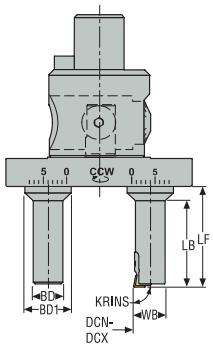


Capacitate DCN-DCX Ø inci*	Suportul plăcuţei Descriere	Poziţia cozii	Dimensiunea în inci					Unghi de atac KRINS°	Mărimea plăcuţei potrivite
			BD	BD1	LF	LB	WB		
2.087-2.185	A765 R1	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
2.185-2.283	A765 R2	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
2.283-2.382	A765 R1	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
2.382-2.480	A765 R2	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
2.480-2.579	A765 R1	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
2.579-2.677	A765 R2	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.917*	90°	CC..0602..
2.677-2.776	A765 R1	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
2.776-2.874	A765 R2	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
2.874-2.972	A765 R1	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
2.972-3.071	A765 R2	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.071-3.169	A765 R1	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.169-3.268	A765 R2	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.268-3.366	A765 R1	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.366-3.465	A765 R2	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.465-3.563	A765 R1	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.563-3.661	A765 R2	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.661-3.760	A765 R1	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
	A765 R3	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.760-3.858	A765 R2	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
	A765 R4	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
3.858-3.957	A765 R3	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R5	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
3.957-4.055	A765 R4	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R6	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
4.055-4.154	A765 R5	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
4.154-4.252	A765 R6	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..

* +0,2 mm (0,008") capacitate complementară realizabilă.
Descrierea detaliată a suporturilor de plăcuţe, consultaţi pagina (paginile) 519

Metric Diagramă de selecţie:
Suporturi de plăcuţe pentru alezare-OD cu MPA pentru capete FB 760

Selectaţi suportul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a alezării.
Notă: Un ansamblu de alezare-OD necesită:
- un - Axiabore™ plus - cap (A760 03)
- a MPA (BDA16BS25100)
- o coadă (BAS25MH1660)
- o contragreutate (BAS25CW1660).
- un suport pentru plăcuţe (A765R.) selectat din diagramă
- o plăcuţă

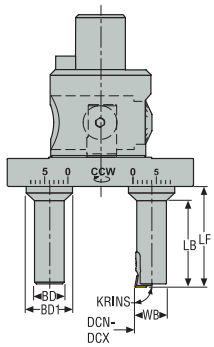


Capacitatea DCN-DCX ∅ mm*	Suportul plăcuţei Descriere	Poziţia cozii	Dimensiunea în mm					Unghi de atac KRINS°	Mărimea plăcuţei potrivite
			BD	BD1	LF	LB	WB		
2-4,5	A765 R6	0	16	25	58,5	50	23,2	90°	CC..0602..
4,5-7	A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
7-9,5	A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	0	16	25	58,5	50	20,7	90°	CC..0602..
9,5-12	A765 R5	1	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	0	16	25	58,5	50	19,5	90°	CC..0602..
12-14,5	A765 R6	2	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	1	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
14,5-17	A765 R5	2	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	1	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
17-19,5	A765 R6	3	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	2	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	1	16	25	58,5	50	18,2	90°	CC..0602..
19,5-22	A765 R5	3	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	2	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
22-24,5	A765 R6	4	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	3	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	2	16	25	58,5	50	18,2	90°	CC..0602..
24,5-27	A765 R5	4	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	3	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	2	16	25	58,5	50	17	90°	CC..0602..
27-29,5	A765 R6	5	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	4	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	3	16	25	58,5	50	18,2	90°	CC..0602..
29,5-32	A765 R5	5	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	4	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	3	16	25	58,5	50	17	90°	CC..0602..
32-34,5	A765 R6	6	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	5	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	4	16	25	58,5	50	18,2	90°	CC..0602..
34,5-37	A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	5	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	4	16	25	58,5	50	17	90°	CC..0602..
37-39,5	A765 R6	7	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	6	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	5	16	25	58,5	50	18,2	90°	CC..0602..
39,5-42	A765 R5	7	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	6	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	5	16	25	58,5	50	17	90°	CC..0602..
42-44,5	A765 R6	8	16	25	58,5	50	23,2	90°	CC..0602..
	A765 R4	7	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	6	16	25	58,5	50	18,2	90°	CC..0602..
44,5-47	A765 R5	8	16	25	58,5	50	22	90°	CC..0602..
	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	6	16	25	58,5	50	17	90°	CC..0602..
47-49,5	A765 R4	8	16	25	58,5	50	20,7	90°	CC..0602..
	A765 R2	7	16	25	58,5	50	18,2	90°	CC..0602..
49,5-52	A765 R3	8	16	25	58,5	50	19,5	90°	CC..0602..
	A765 R1	7	16	25	58,5	50	17	90°	CC..0602..
52-54,5	A765 R2	8	16	25	58,5	50	18,2	90°	CC..0602..
54,5-57	A765 R1	8	16	25	58,5	50	17	90°	CC..0602..

* +0,2 mm (0,008") capacitate complementară realizabilă.
Descrierea detaliată a suporturilor de plăcuţe, consultaţi pagina (paginile) 519

Inci Diagramă de selecţie:
Suporturi de plăcuţe pentru alezare-OD cu MPA pentru capete FB 760

Selectaţi suportul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a alezării.
Notă: Un ansamblu de alezare-OD necesită:
- un - Axiabore™ plus - cap (A760 03)
- a MPA (BDA16BS25100)
- o coadă (BAS25MH1660)
- o contragreutate (BAS25CW1660).
- un suport pentru plăcuţe (A765R.) selectat din diagramă
- o plăcuţă

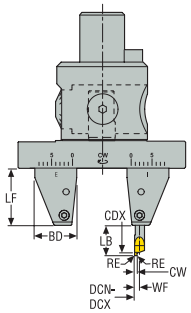


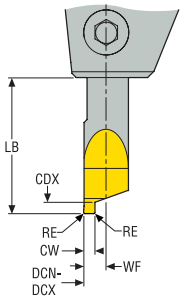
Capacitate DCN-DCX Ø inci*	Suportul plăcuţei Descriere	Poziţia cozii	Dimensiunea în inci					Unghi de atac KRINS°	Mărimea plăcuţei potrivite
			BD	BD1	LF	LB	WB		
0.079-0.177	A765 R6	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
0.177-0.276	A765 R5	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
0.276-0.374	A765 R6	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
0.374-0.472	A765 R5	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
0.472-0.571	A765 R6	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
0.571-0.669	A765 R5	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	0	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
0.669-0.768	A765 R6	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
0.768-0.866	A765 R5	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	1	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
0.866-0.965	A765 R6	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
0.965-1.063	A765 R5	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	2	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.063-1.161	A765 R6	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.161-1.260	A765 R5	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	3	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.260-1.358	A765 R6	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.358-1.457	A765 R5	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	4	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.457-1.555	A765 R6	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.555-1.654	A765 R5	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	5	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.654-1.654	A765 R6	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.913*	90°	CC..0602..
	A765 R4	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.654-1.850	A765 R5	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.866*	90°	CC..0602..
	A765 R3	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	6	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
1.850-1.949	A765 R4	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.815*	90°	CC..0602..
	A765 R2	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
1.949-2.047	A765 R3	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.768*	90°	CC..0602..
	A765 R1	7	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..
2.047-2.146	A765 R2	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.717*	90°	CC..0602..
2.146-2.244	A765 R1	8	*0.630*	*0.984*	*2.303*	*1.969*	*0.669*	90°	CC..0602..

* +0,2 mm (0,008") capacitate complementară realizabilă.
Descrierea detaliată a suporturilor de plăcuţe, consultaţi pagina (paginile) 519

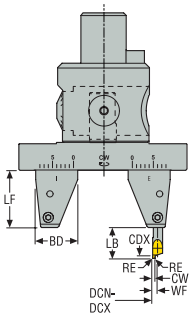
Metric Diagramă de selecţie:
Instrument de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 1

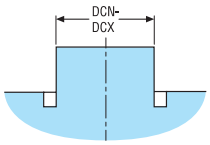




Cutie de asamblare 2



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

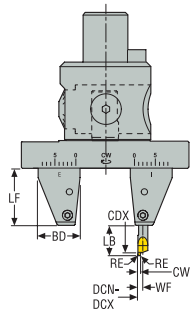
- un - Axiabore™ Plus - cap (A760 03)
- un MPA (BDA16BS25100)
- şi un suport I (poziţie internă) şi unul E (poziţie externă) pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
- o sculă de canelat spre ax (AFG...82) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

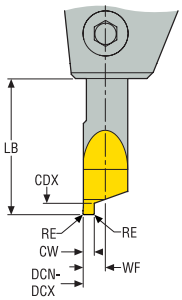
Capacitatea DCN-DCX ∅ mm*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în mm BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
19-24	AFG0629 10 1582	0-I	1	25	1	34	18	2,95	0,15	2,0
24-29		1-I	1	25	1	34	18	2,95	0,15	2,0
29-34		2-I	1	25	1	34	18	2,95	0,15	2,0
34-39		3-I	1	25	1	34	18	2,95	0,15	2,0
39-44		**0-E** / 4-I	1/2	25	1	34	18	2,95	0,15	2,0
44-49		**1-E** / 5-I	1/2	25	1	34	18	2,95	0,15	2,0
49-54		**2-E** / 6-I	1/2	25	1	34	18	2,95	0,15	2,0
54-59		**3-E** / 7-I	1/2	25	1	34	18	2,95	0,15	2,0
59-64		**4-E** / 8-I	1/2	25	1	34	18	2,95	0,15	2,0
64-69		5-E	2	25	1	34	18	2,95	0,15	2,0
69-74		6-E	2	25	1	34	18	2,95	0,15	2,0
74-79		7-E	2	25	1	34	18	2,95	0,15	2,0
79-84		8-E	2	25	1	34	18	2,95	0,15	2,0
19-24	AFG0629 15 1582	0-I	1	25	1,5	34	18	2,95	0,15	3,0
24-29		1-I	1	25	1,5	34	18	2,95	0,15	3,0
29-34		2-I	1	25	1,5	34	18	2,95	0,15	3,0
34-39		3-I	1	25	1,5	34	18	2,95	0,15	3,0
39-44		**0-E** / 4-I	1/2	25	1,5	34	18	2,95	0,15	3,0
44-49		**1-E** / 5-I	1/2	25	1,5	34	18	2,95	0,15	3,0
49-54		**2-E** / 6-I	1/2	25	1,5	34	18	2,95	0,15	3,0
54-59		**3-E** / 7-I	1/2	25	1,5	34	18	2,95	0,15	3,0
59-64		**4-E** / 8-I	1/2	25	1,5	34	18	2,95	0,15	3,0
64-69		5-E	2	25	1,5	34	18	2,95	0,15	3,0
69-74		6-E	2	25	1,5	34	18	2,95	0,15	3,0
74-79		7-E	2	25	1,5	34	18	2,95	0,15	3,0
79-84		8-E	2	25	1,5	34	18	2,95	0,15	3,0
19-24	AFG0629 20 1582	0-I	1	25	2	34	18	2,95	0,15	4,0
24-29		1-I	1	25	2	34	18	2,95	0,15	4,0
29-34		2-I	1	25	2	34	18	2,95	0,15	4,0
34-39		3-I	1	25	2	34	18	2,95	0,15	4,0
39-44		**0-E** / 4-I	1/2	25	2	34	18	2,95	0,15	4,0
44-49		**1-E** / 5-I	1/2	25	2	34	18	2,95	0,15	4,0
49-54		**2-E** / 6-I	1/2	25	2	34	18	2,95	0,15	4,0
54-59		**3-E** / 7-I	1/2	25	2	34	18	2,95	0,15	4,0
59-64		**4-E** / 8-I	1/2	25	2	34	18	2,95	0,15	4,0
64-69		5-E	2	25	2	34	18	2,95	0,15	4,0
69-74		6-E	2	25	2	34	18	2,95	0,15	4,0
74-79		7-E	2	25	2	34	18	2,95	0,15	4,0
79-84		8-E	2	25	2	34	18	2,95	0,15	4,0

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

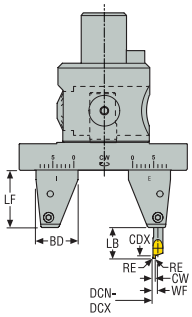
Metric Diagramă de selecţie:
Instrument de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

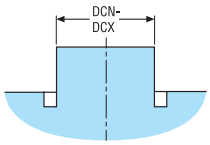
Cutie de asamblare 1





Cutie de asamblare 2

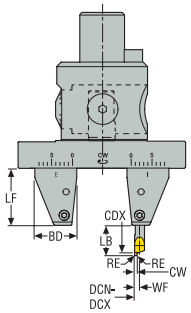


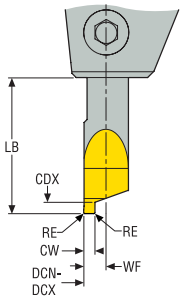
	Capacitatea DCN-DCX ∅ mm*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în mm BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.	19-24	AFG0629 25 1582	0-I	1	25	2,5	34	18	2,95	0,15	5,0
	24-29		1-I	1	25	2,5	34	18	2,95	0,15	5,0
	29-34		2-I	1	25	2,5	34	18	2,95	0,15	5,0
	34-39		3-I	1	25	2,5	34	18	2,95	0,15	5,0
	39-44		**0-E** / 4-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	44-49		**1-E** / 5-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	49-54		**2-E** / 6-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	54-59		**3-E** / 7-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	59-64		**4-E** / 8-I	1/2	25	2,5	34	18	2,95	0,15	5,0
	64-69		5-E	2	25	2,5	34	18	2,95	0,15	5,0
	69-74		6-E	2	25	2,5	34	18	2,95	0,15	5,0
	74-79		7-E	2	25	2,5	34	18	2,95	0,15	5,0
	79-84		8-E	2	25	2,5	34	18	2,95	0,15	5,0
Notă: Un ansamblu de canelat spre ax necesită:	19-24	AFG0629 30 1582	0-I	1	25	3	34	18	2,95	0,15	6,0
– un - Axiabore™ Plus - cap (A760 03)	24-29		1-I	1	25	3	34	18	2,95	0,15	6,0
– un MPA (BDA16BS25100)	29-34		2-I	1	25	3	34	18	2,95	0,15	6,0
– şi un suport I (poziţie internă) şi unul E (poziţie externă) pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)	34-39		3-I	1	25	3	34	18	2,95	0,15	6,0
	39-44		**0-E** / 4-I	1/2	25	3	34	18	2,95	0,15	6,0
	44-49		**1-E** / 5-I	1/2	25	3	34	18	2,95	0,15	6,0
– o sculă de canelat spre ax (AFG...82) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.	49-54		**2-E** / 6-I	1/2	25	3	34	18	2,95	0,15	6,0
	54-59		**3-E** / 7-I	1/2	25	3	34	18	2,95	0,15	6,0
	59-64		**4-E** / 8-I	1/2	25	3	34	18	2,95	0,15	6,0
	64-69		5-E	2	25	3	34	18	2,95	0,15	6,0
	69-74		6-E	2	25	3	34	18	2,95	0,15	6,0
	74-79		7-E	2	25	3	34	18	2,95	0,15	6,0
	79-84		8-E	2	25	3	34	18	2,95	0,15	6,0

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

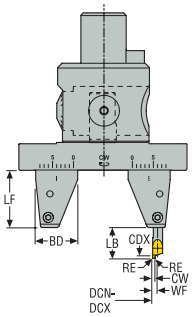
Inci Diagramă de selecţie:
Instrument de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 1

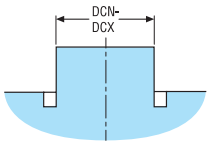




Cutie de asamblare 2



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

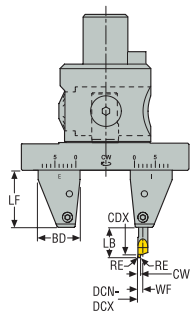
- un - Axiabore™ Plus - cap (A760 03)
- un MPA (BDA16BS25100)
- şi un suport I (poziţie internă) şi unul E (poziţie externă) pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
- o sculă de canelat spre ax (AFG...82) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

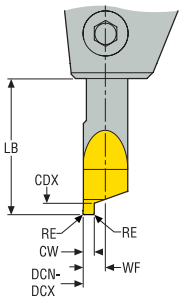
Capacitate DCN-DCX Ø inci*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în inci BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
0.748-0.945	AFG0629 10 1582	0-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
0.945-1.142		1-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.142-1.339		2-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.339-1.535		3-I	1	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.520-2.717		5-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.717-2.913		6-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.913-3.110		7-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.110-3.307		8-E	2	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
0.748-0.945	AFG0629 15 1582	0-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
0.945-1.142		1-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.142-1.339		2-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.339-1.535		3-I	1	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.520-2.717		5-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.717-2.913		6-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.913-3.110		7-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.110-3.307		8-E	2	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
0.748-0.945	AFG0629 20 1582	0-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
0.945-1.142		1-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.142-1.339		2-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.339-1.535		3-I	1	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.520-2.717		5-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.717-2.913		6-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.913-3.110		7-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.110-3.307		8-E	2	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

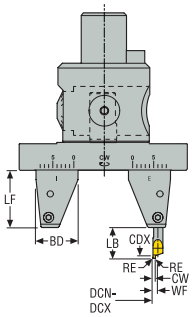
Inci Diagramă de selecţie:
Instrument de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 1

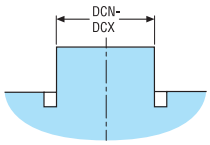




Cutie de asamblare 2



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

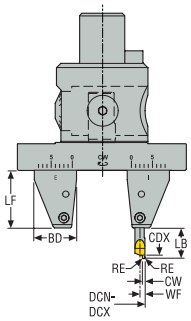
– un - Axiabore™ Plus - cap (A760 03)
– un MPA (BDA16BS25100)
– şi un suport I (poziţie internă) şi unul E (poziţie externă) pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
– o sculă de canelat spre ax (AFG...82) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

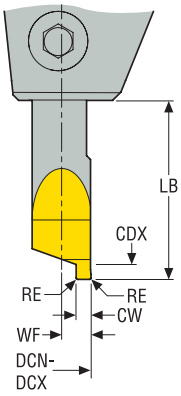
Capacitate DCN-DCX Ø inci*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în inci						Adâncimea maximă de canelare CDX
				BD	CW	LF	LB	WF	RE	
0.748-0.945	AFG0629 25 1582	0-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
0.945-1.142		1-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.142-1.339		2-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.339-1.535		3-I	1	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.520-2.717		5-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.717-2.913		6-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.913-3.110		7-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
3.110-3.307		8-E	2	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
0.748-0.945	AFG0629 30 1582	0-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
0.945-1.142		1-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.142-1.339		2-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.339-1.535		3-I	1	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.535-1.732		**0-E** / 4-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.732-1.929		**1-E** / 5-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.929-2.126		**2-E** / 6-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.126-2.323		**3-E** / 7-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.323-2.520		**4-E** / 8-I	1/2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.520-2.717		5-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.717-2.913		6-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.913-3.110		7-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
3.110-3.307		8-E	2	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

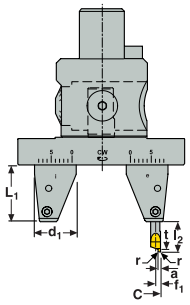
Metric Diagramă de selecţie:
Sculă de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 3

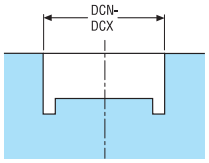




Cutie de asamblare 4



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

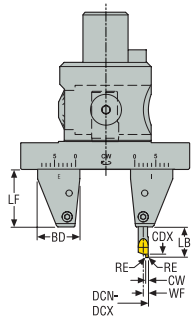
- un - Axiabore™ plus - cap (A760 03)
- un MPA (BDA16BS25100)
- şi un I (poziţie internă) şi un E (poziţie externă) suport pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
- o sculă de alezat (AFG...81) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

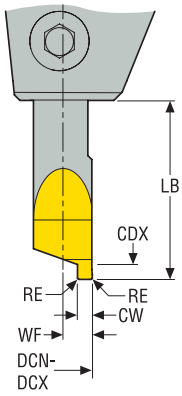
Capacitatea DCN-DCX ∅ mm*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în mm BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
31-36	AFG0629 10 1581	0-I	3	25	1	34	18	2,95	0,15	2,0
36-41		1-I	3	25	1	34	18	2,95	0,15	2,0
41-46		2-I	3	25	1	34	18	2,95	0,15	2,0
46-51		3-I	3	25	1	34	18	2,95	0,15	2,0
51-56		**0-E** / 4-I	3/4	25	1	34	18	2,95	0,15	2,0
56-61		**1-E** / 5-I	3/4	25	1	34	18	2,95	0,15	2,0
61-66		**2-E** / 6-I	3/4	25	1	34	18	2,95	0,15	2,0
66-71		**3-E** / 7-I	3/4	25	1	34	18	2,95	0,15	2,0
71-76		**4-E** / 8-I	3/4	25	1	34	18	2,95	0,15	2,0
76-81		5-E	4	25	1	34	18	2,95	0,15	2,0
81-86		6-E	4	25	1	34	18	2,95	0,15	2,0
86-91		7-E	4	25	1	34	18	2,95	0,15	2,0
91-96		8-E	4	25	1	34	18	2,95	0,15	2,0
31-36	AFG0629 15 1581	0-I	3	25	1,5	34	18	2,95	0,15	3,0
39-41		1-I	3	25	1,5	34	18	2,95	0,15	3,0
41-46		2-I	3	25	1,5	34	18	2,95	0,15	3,0
46-51		3-I	3	25	1,5	34	18	2,95	0,15	3,0
51-56		**0-E** / 4-I	3/4	25	1,5	34	18	2,95	0,15	3,0
56-61		**1-E** / 5-I	3/4	25	1,5	34	18	2,95	0,15	3,0
61-66		**2-E** / 6-I	3/4	25	1,5	34	18	2,95	0,15	3,0
66-71		**3-E** / 7-I	3/4	25	1,5	34	18	2,95	0,15	3,0
71-76		**4-E** / 8-I	3/4	25	1,5	34	18	2,95	0,15	3,0
76-81		5-E	4	25	1,5	34	18	2,95	0,15	3,0
81-86		6-E	4	25	1,5	34	18	2,95	0,15	3,0
86-91		7-E	4	25	1,5	34	18	2,95	0,15	3,0
91-96		8-E	4	25	1,5	34	18	2,95	0,15	3,0
31-36	AFG0629 20 1581	0-I	3	25	2	34	18	2,95	0,15	4,0
39-41		1-I	3	25	2	34	18	2,95	0,15	4,0
41-46		2-I	3	25	2	34	18	2,95	0,15	4,0
46-51		3-I	3	25	2	34	18	2,95	0,15	4,0
51-56		**0-E** / 4-I	3/4	25	2	34	18	2,95	0,15	4,0
56-61		**1-E** / 5-I	3/4	25	2	34	18	2,95	0,15	4,0
61-66		**2-E** / 6-I	3/4	25	2	34	18	2,95	0,15	4,0
66-71		**3-E** / 7-I	3/4	25	2	34	18	2,95	0,15	4,0
71-76		**4-E** / 8-I	3/4	25	2	34	18	2,95	0,15	4,0
76-81		5-E	4	25	2	34	18	2,95	0,15	4,0
81-86		6-E	4	25	2	34	18	2,95	0,15	4,0
86-91		7-E	4	25	2	34	18	2,95	0,15	4,0
91-96		8-E	4	25	2	34	18	2,95	0,15	4,0

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

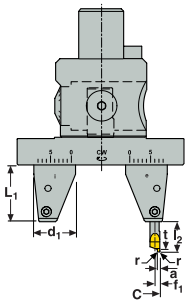
Metric Diagramă de selecţie:
Sculă de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 3

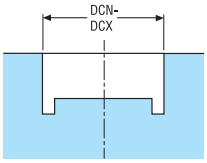




Cutie de asamblare 4



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

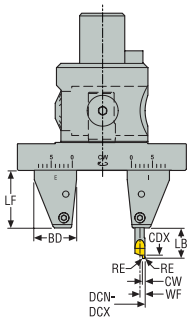
- un - Axiabore™ plus - cap (A760 03)
- un MPA (BDA16BS25100)
- şi un I (poziţie internă) şi un E (poziţie externă) suport pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
- o sculă de alezat (AFG...81) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

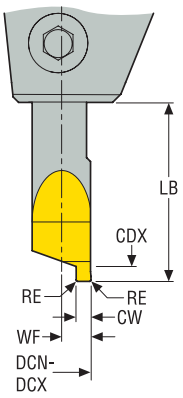
Capacitatea DCN-DCX ∅ mm*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în mm BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
31-36	AFG0629 25 1581	0-I	3	25	2,5	34	18	2,95	0,15	5,0
36-41		1-I	3	25	2,5	34	18	2,95	0,15	5,0
41-46		2-I	3	25	2,5	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")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

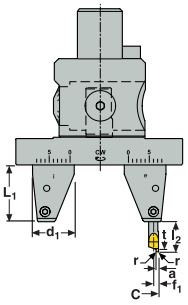
Inci Diagramă de selecţie:
Sculă de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 3

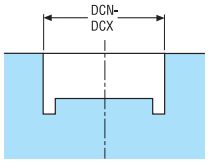




Cutie de asamblare 4



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

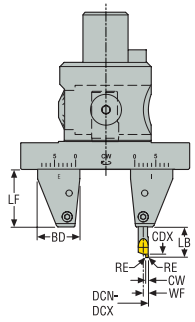
- un - Axiabore™ plus - cap (A760 03)
- un MPA (BDA16BS25100)
- şi un I (poziţie internă) şi un E (poziţie externă) suport pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
- o sculă de alezat (AFG...81) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

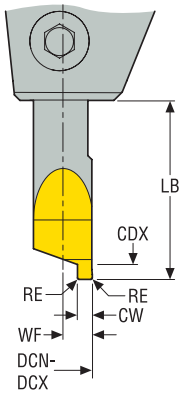
Capacitate DCN-DCX Ø inci*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în inci BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
1.220-1.417	AFG0629 10 1581	0-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.417-1.614		1-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.614-1.811		2-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.811-2.008		3-I	3	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
2.992-3.189		5-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.189-3.386		6-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.386-3.583		7-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
3.583-3.780		8-E	4	*0.984*	*0.0394*	*1.339*	*0.709*	*0.116*	*0.006*	0.079
1.220-1.417	AFG0629 15 1581	0-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.417-1.614		1-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.614-1.811		2-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.811-2.008		3-I	3	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
2.992-3.189		5-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.189-3.386		6-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.386-3.583		7-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
3.583-3.780		8-E	4	*0.984*	*0.0591*	*1.339*	*0.709*	*0.116*	*0.006*	0.118
1.220-1.417	AFG0629 20 1581	0-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.417-1.614		1-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.614-1.811		2-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
1.811-2.008		3-I	3	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
2.992-3.189		5-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.189-3.386		6-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.386-3.583		7-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157
3.583-3.780		8-E	4	*0.984*	*0.0787*	*1.339*	*0.709*	*0.116*	*0.006*	0.157

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

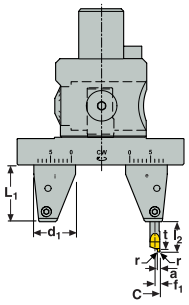
Inci Diagramă de selecţie:
Sculă de canelare -împotriva axului- pentru canelare cu MPA, pentru capete FB 760

Cutie de asamblare 3

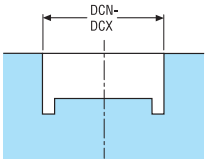




Cutie de asamblare 4



Selectaţi instrumentul de canelare adecvat şi notaţi poziţia suportului pentru caneluri de pe MPA pentru a obţine capacitatea necesară a canelurii.



Notă: Un ansamblu de canelat spre ax necesită:

- un - Axiabore™ plus - cap (A760 03)
- un MPA (BDA16BS25100)
- şi un I (poziţie internă) şi un E (poziţie externă) suport pentru scule de canelare (BAS25FGI35 şi BAS25FGE35) fie pentru a ţine o sculă de canelare, fie pentru a acţiona ca o contragreutate (consultaţi poziţia de setare din diagramă)
- o sculă de alezat (AFG...81) care trebuie selectat din diagramă, în funcţie de lăţimea şi diametrul canelurii.

Capacitate DCN-DCX Ø inci*	Sculă de canelare spre cep Descriere	Poziţia suportului pentru unelte de canelare**	Varianta	Dimensiunea în inci BD	CW	LF	LB	WF	RE	Adâncimea maximă de canelare CDX
1.220-1.417	AFG0629 25 1581	0-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.417-1.614		1-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.614-1.811		2-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.811-2.008		3-I	3	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
2.992-3.189		5-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
3.189-3.386		6-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
3.386-3.583		7-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
3.583-3.780		8-E	4	*0.984*	*0.0984*	*1.339*	*0.709*	*0.116*	*0.006*	0.197
1.220-1.417	AFG0629 30 1581	0-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.417-1.614		1-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.614-1.811		2-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
1.811-2.008		3-I	3	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.008-2.205		**0-E** / 4-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.205-2.402		**1-E** / 5-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.402-2.598		**2-E** / 6-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.598-2.795		**3-E** / 7-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.795-2.992		**4-E** / 8-I	3/4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
2.992-3.189		5-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
3.189-3.386		6-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
3.386-3.583		7-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236
3.583-3.780		8-E	4	*0.984*	*0.1181*	*1.339*	*0.709*	*0.116*	*0.006*	0.236

* +0,2 mm 0.008")capacitate complementară realizabilă. ** Valori recomandate **cu caractere aldine**.
Descrierea detaliată a sculelor de canelare, consultaţi pagina (paginile) 524

Instrucţiuni

Viteze maxime pentru capetele tip Axiabore™

Pentru mai multe detalii consultaţi instrucţiunile de utilizare livrate împreună cu capetele de alezare şi cu barele GL.

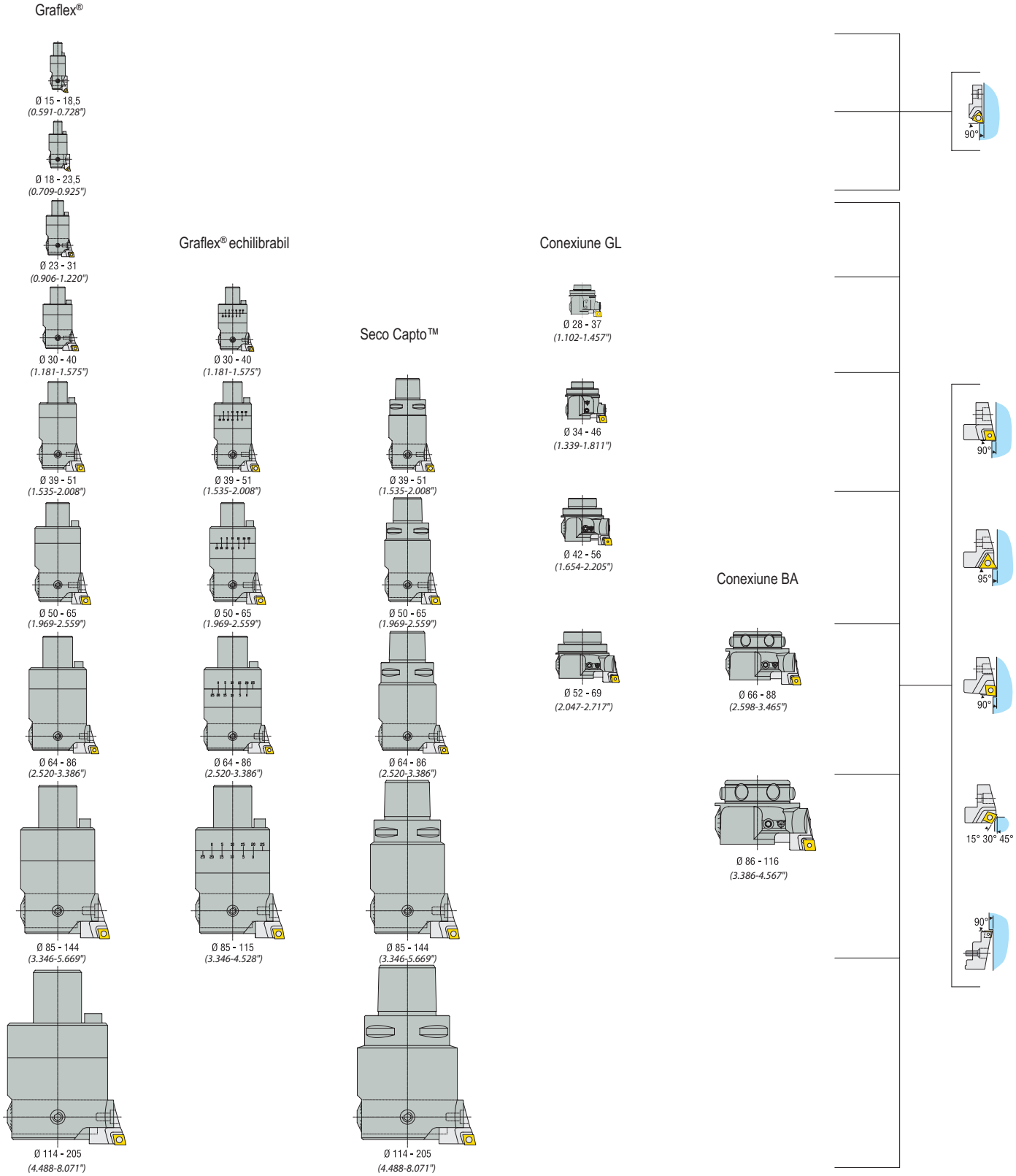
Cap	Capacitate Ø mm *(inci)*	Max. RPM cu sculă (RPM)	Max. RPM cu MPA (RPM)	Viteza max. de aşchiere v_c la min Cap. m/min *(sf/min)*	Viteza max. de aşchiere v_c la max Cap. m/min *(sf/min)*
Tip Axiabore™ cu conexiune Graflex®					
A76001	0,3-8 *(0.0118-0.315)*	30000	–	28* *(92*)*	754* *(2474*)*
A76002	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***)*
Tip Axiabore™ cu conexiune Seco Capto™					
C5-391.0760-03	6-108 *(0.236-4.25)*	8000*	5000	151* *(495*)*	1000** *(3281**)*

Notă: Vitezele maxime sunt condiţionate de conceptul mecanic al capului şi de calitatea echilibrării. Vitezele cuprinse în intervalul recomandat vor fi alese ţinând cont de toate condiţiile de prelucrare, ex.: materialul semifabricatului, muchia de aşchiere, lungimea sculei, arborele maşinii. La viteze de la aproximativ 8000 RPM şi mai mari, suporturile de bază şi intermediarii trebuie să fie bine echilibrate. Utilizarea capetelor echilibrabile şi a suporturilor echilibrate fin îmbunătăţeşte durata de viaţă a sculei şi performanţele de alezare chiar şi la viteze mai mici.
* Implică max viteza de aşchiere cu max RPM.
** Nu este accesibil cu toate sculele, consultaţi ***.
*** Max. viteza de aşchiere nu trebuie depăşită

Instrucţiuni de depanare (valabile și pentru capetele de alezare de precizie tip radial)

Problemă	Cauză posibilă	Soluţie
Viaţă scurtă a sculei	Calitate greșită a plăcuţei	Schimbă cu o calitate mai rezistentă la uzură
	Viteza de așchiere prea mare	Reduceţi viteza de așchiere.
	Adâncime de tăiere prea mare	Reduceţi adâncimea de tăiere
Șocuri și vibraţii	Viteza de așchiere prea mare	Reduceţi viteza de așchiere.
	Raport L/D extrem	Scurtează scula pentru a crește rigiditatea
		Utilizează scule de alezat mai puternice
		Utilizaţi o bară Steadyline
		Utilizează carbură sau metal greu pentru extensii
	Plăcuţă aleasă greșit	Micșorează raza vârfului plăcuţei
		Utilizează plăcuţe cu geometrie rotundă
	Adaos de prelucrare incorect	Modifică diametrul de pre-găurire
Toleranţă a diametrului găurii și repetabilitate slabe	Schimbare imprecisă a sculei	Coadă uzată sau defectă: de înlocuit
		Curăţă arborele și coada sculei
	Variaţia adaosului de prelucrare	Adaugă o etapă de semifinisare a alezajului
	Stabilitate redusă a arborelui	Utilizează plăcuţe cu geometrie mai ascuţită
Circularitate slabă	Dezechilibrare pronunţată a sculei de alezare	Verifică bătaia radială a arborelui
		Treceţi la capul de alezare LIBRAFLEX®
		Verifică reglarea inelului de echilibrare
		Reduceţi viteza
	Forţe de așchiere ridicate	Verifică adaosul de prelucrare și avansul
	Prindere slabă a semifabricatului	Verifică prinderea uniformă a semifabricatului
	Semifabricat asimetric	Reduceţi forţele de tăiere, treci la plăcuţe rotunde
		Măriţi viteza de tăiere, reduceţi avansul
Toleranţă slabă a poziţionării	Găurile originale nealiniate	Adaugă o etapă de semifinisare a alezajului
	Adâncime de tăiere prea mare	Micșorează adâncimea de tăiere, execută două treceri
Finisare slabă a suprafeţei	Raza plăcuţei greșită	Utilizează o raza a plăcuţei mai mare
	Rata avansului prea mare	Reduceţi avansul max. 30% din raza vârfului plăcuţei
	Control slab al așchiei	Utilizează răcirea prin interior
		Utilizează plăcuţe cu unghi mai mare de degajare (HSS în cazuri extreme)
		Verifică adâncimea de tăiere
Gaură conică	Uzura prematură a sculei	Schimbă cu o calitate mai rezistentă la uzură
		Modificaţi viteza de așchiere.
		Măriţi debitul agentului de răcire

Prezentare generală



Capete de alezare de precizie – ghid

Caracteristici

Un cap de alezare fină este un ansamblu compus dintr-un corp și o plăcuţă. Caracteristicile capetelor de finisare FB 620, FB 780 și FB 790 radiale:

Gama de produse

Seco oferă o gama variată de capete de alezat radiale pentru finiţie care se potrivesc nevoilor dumneavoastră:

Capete de alezare de precizie, radiale FB 620, FB 780 și FB 790



– Reglarea micrometrică: Mecanism de setare a suportului de plăcuţă cu șurub de reglare micrometric, 1 treaptă = 0,01 mm *(0,0004")* în diametru și un vernier, cu rezoluţia de 2,5 µm *(98,4 µin)* în diametru
– Precizia mecanismului garantează precizie repetabilă
– Orientarea unghiulară a muchiei aşchietoare conform DIN 69871/ISO 7388 pentru SA și ISO 12164 pentru HSK
– Lichid de răcire prin interior direcţionat către muchia aşchietoare
– Capetele de alezare FB 780 și FB 620 sunt pre-echilibrate pentru setarea mediană de diametru. FB 790 sunt echilibrate, pentru optimizarea performanţei

Notă: Caracteristici, Instrucţiuni (procedura de montare a sculei, reglarea diametrului, instrucţiuni pentru alezarea inversă, depanare condiţie recomandate, viteze maxime), port-plăcuţe și plăcuţele potrivite sunt similare pentru toate tipuri de capete de alezare FB 620, FB 780 și FB 790 la aceeași mărime, indiferent de tipul conexiunii.

Capete de finisare FB 620, tip radial, pentru barele antivibraţie Steadyline®



GL



BA

– 4 capete de alezare de precizie cu conexiune GL pe partea utilajului pentru alezare de precizie Ø 27-69 mm *(Ø 1,102-2,717")*
– 2 capete de alezare de precizie cu conexiune BA pe partea utilajului pentru alezare de precizie Ø 66-116 mm *(Ø 2,598-4,567")*

Designul lor compact permite atingerea performanţelor maxime atunci când se utilizează împreună cu barele de strunjire și alezare Steadyline® GL.

Capete de alezare de finisare FB 780, tip radial

9 capete de alezare de precizie cu conexiune Graflex® pe partea utilajului pentru alezare de precizie ∅ 15-205 mm *(Ø 0,591-8,071")* utilizând suporturi de plăcuţă instalate radial.

5 capete de alezare de precizie cu conexiune SecoCapto™ pe partea utilajului pentru alezare de precizie Ø 39-205 mm *(Ø 1,535-8,071")*.

Adaptor Seco Capto™ și cap Graflex®: ∅ 15-40 mm *(Ø 0,591-1,575")*.

Notă: Alezajul minim al celui mai mic cap de alezare de precizie Seco Capto™ este ∅ 39 mm *(Ø 1,535")* cu cea mai mică conexiune Seco Capto™ C3 disponibilă. Pentru ∅ 15-40 mm *(Ø 0,591-1,575")*, utilizaţi capete de alezare Graflex® cu mărimi de conexiune între G0 și G2 în combinaţie cu adaptorul Seco Capto™/Graflex® adecvat. Acest lucru oferă și modularitate atunci când se utilizează extensii Graflex® suplimentare.

Notă: Caracteristici, Instrucţiuni (procedura de montare a sculei, reglarea diametrului, instrucţiuni pentru alezarea inversă, depanare, condiţie recomandate, viteze maxime), port-plăcuţe și plăcuţele potrivite sunt similare pentru ambele tipuri de capete de alezare FB 780 la aceeași mărime, indiferent de tipul conexiunii.

Capetele de alezare echilibrabile pentru finiţie FB 790, tipul radial

5 capete de alezare „Libraflex®" echilibrabile cu conexiune Graflex® pe partea utilajului pentru alezare de precizie ∅ 30-115 mm *(Ø 1,181-4,528")*, la viteze ridicate, până la 1500 m/min *(4921 ft/min)*, utilizând suporturi de plăcuţă instalate radial.

Echilibrarea reduce solicitarea arborelui, permite optimizarea parametrilor de așchiere, și se obţine o calitate mai ridicată a prelucrării chiar și la viteze normale.

Echilibrare prin reglarea ambelor inele conform cu diametrul de alezat (nu necesită tabel de valori).



Caracteristici

Suporturi de plăcuţă

Un cap de alezare de precizie de tip radial este un ansamblu compus dintr-un corp (cap) și un suport de plăcuță.

Gama largă de port-plăcuţe pentru alezare fină, șanfrenare și alezare inversă este potrivită cu toate capetele de finisare FB 620, FB 780 și FB 790, tip radial.

Suporturi de plăcuţă pentru alezare de precizie

FBIH 782: unghi de avans 90° pentru plăcuţe WB
FBIH 724: unghi de avans 90° pentru plăcuţe TC
FBIH 725: unghi de avans 90° pentru plăcuţe CC
FBIH 726: unghi de avans 95° pentru plăcuţe CC

Notă: Unghiul de atac de 95° al port-plăcuţei se utilizează pentru a evita contactul feţei la alezarea peste un umăr.

Suporturi de plăcuţă de șanfrenare, ∅ 23 până la 160 mm *(Ø 0,906-6,299")*

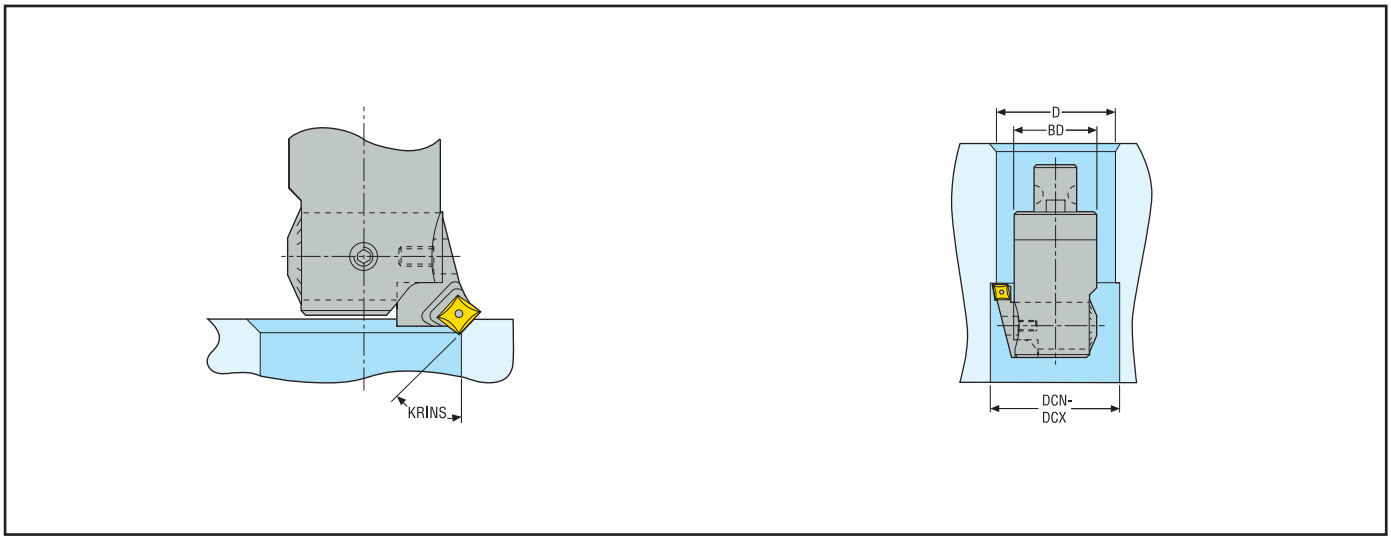
FBIH 729: disponibile cu un unghi de avans de 15°, 30° sau 45° pentru plăcuţe CC.

Libraflex® se poate echilibra și la echiparea cu port-plăcuţe de șanfrenare.

Suporturi de plăcuţă pentru alezare inversă, ∅ 26,5 până la 164 mm *(Ø 1,043-6,457")*

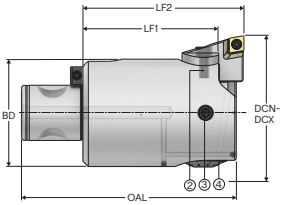
FBIH A789: unghi de avans 90° pentru plăcuţe WB și CC.

Echilibrarea de precizie a Libraflex® nu este posibilă cu port-plăcuţe de alezare inversă. În acest caz, cea mai mare echilibrare se obţine atunci când ambele inele de echilibrare sunt reglate la cea mai mare gradaţie.



FB780
Graflex®





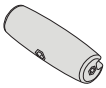
—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)

2. Șurub asamblare
3. Șurub de blocare
4. Șurub de reglare micrometrică

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	Mărimea port-plăcuței
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A78008	00056632	G0	15,0 *0.591*	18,5 *0.728*	44,0 *1.732*	27,5 *1.083*	35,0 *1.378*	14,0 *0.551*	0,1 *0.2*	09
A78009	00056633	G0	18,0 *0.709*	23,5 *0.925*	44,0 *1.732*	27,5 *1.083*	35,0 *1.378*	17,0 *0.669*	0,1 *0.2*	09
A78010	00072991	G1	23,0 *0.906*	31,0 *1.220*	51,5 *2.028*	32,5 *1.280*	40,0 *1.575*	21,5 *0.846*	0,2 *0.4*	10
A78020	00072992	G2	30,0 *1.181*	40,0 *1.575*	59,5 *2.343*	37,5 *1.476*	45,0 *1.772*	27,0 *1.063*	0,3 *0.7*	20
A78030	00072993	G3	39,0 *1.535*	51,0 *2.008*	82,0 *3.228*	54,5 *2.146*	65,0 *2.559*	35,0 *1.378*	0,6 *1.3*	30
A78040	00072995	G4	50,0 *1.969*	65,0 *2.559*	93,0 *3.661*	61,5 *2.421*	72,0 *2.835*	43,0 *1.693*	0,9 *2.0*	40
A78050	00072996	G5	64,0 *2.520*	86,0 *3.386*	109,0 *4.291*	71,5 *2.815*	82,0 *3.228*	54,0 *2.126*	1,6 *3.5*	50
A78060	00056551	G6	85,0 *3.346*	144,0 *5.669*	140,0 *5.512*	88,5 *3.484*	105,0 *4.134*	70,0 *2.756*	3,2 *7.1*	*60/65*
A78070	00056552	G7	114,0 *4.488*	205,0 *8.071*	160,0 *6.299*	98,5 *3.878*	115,0 *4.528*	95,0 *3.740*	6,4 *14.1*	*70/75*

Cartușele se comandă separat, consultați pagina (paginile) 548, 549-551
Notă: Greutatea este fără suport de plăcuțe

Piese de schimb, Piese incluse la livrare

Pentru	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare	Cep
					
A78008	960D30050S	DOUBLE-T	H4B-H2.0	19A7100403	–
A78009	LBHF0306R	DOUBLE-T	H4B-H2.0	19A71000	90M0
A78010	19TB0305	DOUBLE-T	H4B-H2.0	19A71000	90M1
A78020	19TB0305	H4B-H2.0	–	950L0406	90M2
A78030	19TB04075	–	03M03C	950L0608	90M3
A78040	19TB04075	–	03M03C	950L0612	90M4
A78050	950D0410	–	03M03C	950L0616	90M5
A78060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	90M6
A78070	950D0616	DOUBLE-T	H6B-H5.0L	950L1030	90M7

Accesorii

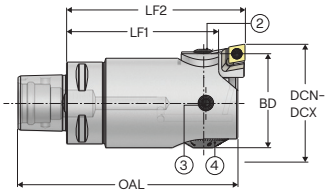
Cheia dinamometrică pentru șuruburile de blocare și asamblare

H00-2009
H00-2009
H00-2009
H00-2009
H00-3030
H00-3030
H00-3030
H00T-50100
H00T-50100

FB780

Seco Capto™





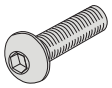
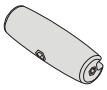
—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)

2. Șurub asamblare
3. Șurub de blocare
4. Șurub de reglare micrometrică

Reper Nr.	Număr reper	Spre mașină	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	Mărimea port-plăcuței
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
C3-391.0780-30	02809740	C3	39,0 *1.535*	51,0 *2.008*	86,0 *3.386*	59,5 *2.343*	70,0 *2.756*	35,0 *1.378*	0,6 *1.3*	30
C4-391.0780-40	02809742	C4	50,0 *1.969*	65,0 *2.559*	103,0 *4.055*	71,5 *2.815*	82,0 *3.228*	43,0 *1.693*	1,0 *2.2*	40
C5-391.0780-50	02809744	C5	64,0 *2.520*	86,0 *3.386*	119,0 *4.685*	81,5 *3.209*	92,0 *3.622*	54,0 *2.126*	1,7 *3.8*	50
C6-391.0780-60	02809745	C6	85,0 *3.346*	144,0 *5.669*	150,0 *5.906*	100,5 *3.957*	117,0 *4.606*	70,0 *2.756*	3,3 *7.3*	60
C8-391.0780-70	02809747	C8	114,0 *4.488*	205,0 *8.071*	181,0 *7.126*	121,5 *4.783*	138,0 *5.433*	95,0 *3.740*	7,1 *15.7*	70

Cartușele se comandă separat, consultați pagina (paginile) 548, 549-551
Notă: Greutatea este fără suport de plăcuțe

Piese de schimb, Piese incluse la livrare

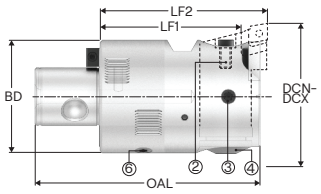
Pentru	Șurub ansamblu	Cheie (steag)	Cheie (tip T)	Cheie	Șurub de blocare
					
C3-391.0780-30	19TB04075	03M03C	–	–	950L0608
C4-391.0780-40	19TB04075	03M03C	–	–	950L0612
C5-391.0780-50	950D0410	03M03C	–	–	950L0616
C6-391.0780-60	950D0612	–	DOUBLE-T	H6B-H5.0L	950L0616
C8-391.0780-70	950D0616	–	DOUBLE-T	H6B-H5.0L	950L1030

Accesorii

Pentru	Cheia dinamometrică pentru șuruburile de blocare și asamblare
	
C3-391.0780-30	H00-3030
C4-391.0780-40	H00-3030
C5-391.0780-50	H00-3030
C6-391.0780-60	H00T-50100
C8-391.0780-70	H00T-50100

FB790 Libraflex® echilibrabil
Graflex®





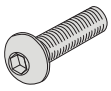
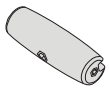
—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)
—Echilibrare prin reglarea ambelor inele conform cu diametrul de alezat
—Pentru viteze v_c de până la 1 495 m/min și mai mult, consultaţi pagina (paginile) 552

6. Șurub de blocare 2
2. Șurub asamblare
3. Șurub de blocare 1
4. Șurub de reglare micrometrică

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	Mărimea port-plăcuţei
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A79020	00055932	G2	30,0 *1.181*	40,0 *1.575*	59,5 *2.343*	37,5 *1.476*	45,0 *1.772*	27,0 *1.063*	0,3 *0.7*	20
A79030	00056005	G3	39,0 *1.535*	51,0 *2.008*	82,0 *3.228*	54,5 *2.146*	65,0 *2.559*	35,0 *1.378*	0,6 *1.3*	30
A79040	00056006	G4	50,0 *1.969*	65,0 *2.559*	93,0 *3.661*	61,5 *2.421*	72,0 *2.835*	43,0 *1.693*	0,9 *2.0*	40
A79050	00056007	G5	64,0 *2.520*	86,0 *3.386*	109,0 *4.291*	71,5 *2.815*	82,0 *3.228*	54,0 *2.126*	1,5 *3.3*	50
A79060	00001451	G6	85,0 *3.346*	115,0 *4.528*	140,0 *5.512*	88,5 *3.484*	105,0 *4.134*	70,0 *2.756*	3,0 *6.6*	60

Cartușele se comandă separat, consultaţi pagina (paginile) 548, 549-551
Notă: Greutatea este fără suport de plăcuţe

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare 1	Șurub de blocare 2	Cep
						
A79020	19TB0305	DOUBLE-T	H4B-H2.0	950L0406	960D30045S	90M2
A79030	19TB04075	–	03M03C	950L0608	AU7901030	90M3
A79040	19TB04075	–	03M03C	950L0612	AU7901040	90M4R
A79050	950D0410	–	03M03C	950L0616	AU7901050	90M51
A79060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	AU7901060	90M6

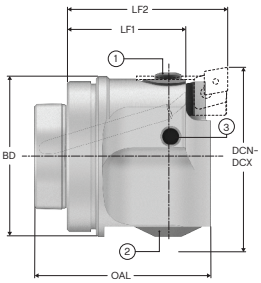
Accesorii

Pentru cap	Cheia dinamometrică pentru șuruburile de blocare a inelului de echilibrare	Cheia dinamometrică pentru șuruburile de blocare și asamblare
		
A79020	–	H00-2009
A79030	H00-3020	H00-3030
A79040	H00-3020	H00-3030
A79050	H00-3020	H00-3030
A79060	H00T-5050	H00T-50100

FB 620 - Capete de alezare de finiţie

compact, cu conexiune GL





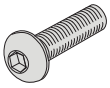
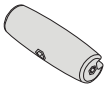
—Proiectat pentru bare de strunjire și alezare GL25, GL32, GL40 și GL50 Steadyline ®
—Alimentare internă cu lichid de răcire către marginea de așchiere
—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)

1. Șurub asamblare
2. Șurub de reglare micrometrică
3. Șurub de blocare

Reper Nr.	Număr reper	Od strony obrabiarki Mărime GL	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	RPM max.**
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
GL32-0620-20	02904469	GL32	34,0 *1.339*	46,0 *1.811*	35,2 *1.386*	23,7 *0.933*	32,0 *1.260*	32,0 *1.260*	0,2 *0.4*	7000
GL40-0620-30	02904470	GL40	42,0 *1.654*	56,0 *2.205*	40,7 *1.602*	24,7 *0.972*	35,0 *1.378*	40,0 *1.575*	0,3 *0.7*	5600
GL50-0620-40	02904471	GL50	52,0 *2.047*	69,0 *2.717*	43,7 *1.720*	25,7 *1.012*	36,0 *1.417*	50,0 *1.969*	0,4 *0.9*	4800

Cartușele se comandă separat, consultaţi pagina (paginile) 548, 549-551
** Informaţii suplimentare despre turaţia maximă, consultaţi paginile cu instrucţiuni.
Notă: Greutatea este fără suport de plăcuţe

Piese de schimb, Piese incluse la livrare

Pentru cap	Șurub ansamblu	Cheie clemă	Cheie (tip T)	Șurub de blocare
				
GL32-0620-20	19TB0305	H4B-H2.0	DOUBLE-T	950L0406
GL40-0620-30	19TB04075	03M03C	–	950L0608
GL50-0620-40	19TB04075	03M03C	–	950L0608

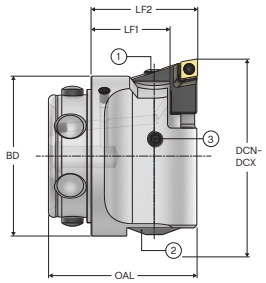
Accesorii

Pentru cap	Cheia dinamometrică pentru șuruburile de blocare și asamblare
	
GL32-0620-20	H00-2009
GL40-0620-30	H00-3030
GL50-0620-40	H00-3030

FB 620 BA - Capete de alezare de finiţie

Cu conexiune BA





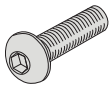
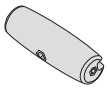
—Proiectat pentru bare de strunjire și alezare BA60 și BA80 Steadyline ®
—Alimentare internă cu lichid de răcire către marginea de așchiere
—Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 µm, pe diametru)

1. Șurub asamblare
2. Șurub de reglare micrometrică
3. Șurub de blocare

Reper Nr.	Număr reper	Od strony obrabiarki Mărime BA	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF1	LF2	BD	Greutate	RPM max.**
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
BA060-FB620-50	03204094	BA060	65,0 *2.559*	87,0 *3.425*	55,7 *2.193*	29,7 *1.169*	40,0 *1.575*	60,0 *2.362*	0,7 *1.5*	4000
BA080-FB620-60	03204095	BA080	85,0 *3.346*	115,0 *4.528*	58,2 *2.291*	26,7 *1.051*	41,2 *1.622*	80,0 *3.150*	1,2 *2.7*	3000

Cartușele se comandă separat, consultaţi pagina (paginile) 501
** Informaţii suplimentare despre turaţia maximă, consultaţi paginile cu instrucţiuni.
Notă: Greutatea este fără suport de plăcuţe

Piese de schimb, Piese incluse la livrare

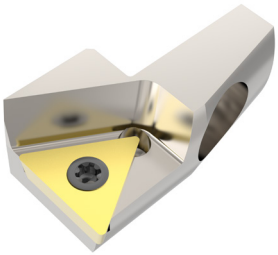
Pentru cap	Șurub ansamblu	Cheie (steag)	Cheie (tip T)	Cheie	Șurub de blocare
					
BA060-FB620-50	19TB04075	03M03C	–	–	950L0608
BA080-FB620-60	950D0514	–	DOUBLE-T	H6B-H5.0L	950L0608

Accesorii

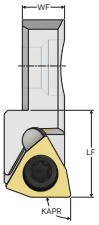
Pentru cap	Cheia dinamometrică pentru șuruburile de blocare și asamblare
	
BA060-FB620-50	H00-3030
BA080-FB620-60	H00T-50100

Port-plăcuţă

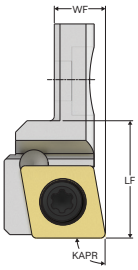
pentru capete de alezat de finisare FB 620 / 780 / 790



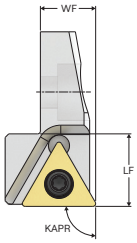
A



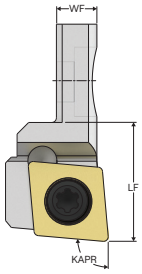
B



C



D

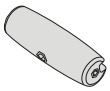


—Pentru capete de alezare raduale FB 620/ 780/ 790
—**Echilibrarea de precizie a capetelor FB A790 nu este posibilă atunci când se utilizează suporturi mari pentru plăcuţe.

Reper Nr.	Număr reper	Pas	Capacitatea DCN-DCX ∅		LF	WF	Greutate	Pentru cap	KRINS°	**	Mărimea port-plăcuţei	Mărimea plăcuţei potrivite	Varianta
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*						
A78209	00056634	90° pentru plăcuţe WB	15,0 *0.591*	23,5 *0.925*	7,2 *0.283*	4,0 *0.157*	0,1 *0.220*	FB 78008 / FB 78009	90		09	WB...0301...	A
A72510	00056580	90° pentru plăcuţe CC	23,0 *0.906*	31,0 *1.220*	10,3 *0.406*	4,5 *0.177*	0,1 *0.220*	FB 78010 / FB62010	90		10	CC...0602...	B
A72520	00056581	90° pentru plăcuţe CC	30,0 *1.181*	46,0 *1.811*	8,3 *0.327*	5,0 *0.197*	0,1 *0.220*	FB 78020 / FB 79020 / FB 62020	90		20	CC...0602...	B
A72530	00056582	90° pentru plăcuţe CC	39,0 *1.535*	56,0 *2.205*	10,3 *0.406*	8,0 *0.315*	0,1 *0.220*	FB 78030 / FB 79030 / FB 62030	90		30	CC...0602...	B
A72540	00056583	90° pentru plăcuţe CC	50,0 *1.969*	69,0 *2.717*	10,3 *0.406*	9,5 *0.374*	0,1 *0.220*	FB 78040 / FB 79040 / FB 62040	90		40	CC...0602...	B
A72550	00056584	90° pentru plăcuţe CC	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,5 *0.492*	0,1 *0.220*	FB 78050 / FB 79050 / FB 62050	90		50	CC...0602...	B
A7256A	02689978	90° pentru plăcuţe CC	85,0 *3.346*	115,0 *4.528*	14,5 *0.571*	18,5 *0.728*	0,1 *0.220*	BA080-FB620-60	90		6A	CC...09T3...	B
A72560	00056585	90° pentru plăcuţe CC	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	90		60	CC...09T3...	B
A72565	00056587	90° pentru plăcuţe CC	114,0 *4.488*	144,0 *5.669*	16,5 *0.650*	33,7 *1.327*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	90	**	65	CC...09T3...	B
A72570	00056588	90° pentru plăcuţe CC	114,0 *4.488*	160,0 *6.299*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78070	90		70	CC...09T3...	B
A72575	00056589	90° pentru plăcuţe CC	159,0 *6.260*	205,0 *8.071*	16,5 *0.650*	41,7 *1.642*	0,2 *0.440*	FB 78070	90		75	CC...09T3...	B
A72430	00056572	90° pentru plăcuţe TC	39,0 *1.535*	56,0 *2.205*	10,3 *0.406*	7,9 *0.311*	0,1 *0.220*	FB 78030 / FB 79030 / FB 62030	90		30	TC...1102...	C
A72440	00056573	90° pentru plăcuţe TC	50,0 *1.969*	69,0 *2.717*	10,3 *0.406*	9,4 *0.370*	0,1 *0.220*	FB 78040 / FB 79040 / FB 62040	90		40	TC...1102...	C
A72450	00056574	90° pentru plăcuţe TC	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,4 *0.488*	0,1 *0.220*	FB 78050 / FB 79050 / FB 62050	90		50	TC...1102...	C
A72460	00056575	90° pentru plăcuţe TC	85,0 *3.346*	115,0 *4.528*	16,3 *0.642*	18,9 *0.744*	0,1 *0.220*	FB 78060 / FB 79060 / FB 731S500	90		60	TC...1102...	C
A72465	00056577	90° pentru plăcuţe TC	114,0 *4.488*	144,0 *5.669*	16,5 *0.650*	33,7 *1.327*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	90	**	65	TC...1102...	C
A72470	00056578	90° pentru plăcuţe TC	114,0 *4.488*	160,0 *6.299*	16,3 *0.642*	18,9 *0.744*	0,2 *0.440*	FB 78070	90		70	TC...1102...	C
A72475	00056579	90° pentru plăcuţe TC	159,0 *6.260*	205,0 *8.071*	16,5 *0.650*	41,7 *1.642*	0,2 *0.440*	FB 78070	90		75	TC...1102...	C
A72610	00056590	95° pentru plăcuţe CC	23,0 *0.906*	31,0 *1.220*	10,3 *0.406*	4,5 *0.177*	0,1 *0.220*	FB 78010	95		10	CC...0602...	D
A72620	00056591	95° pentru plăcuţe CC	30,0 *1.181*	46,0 *1.811*	8,3 *0.327*	5,0 *0.197*	0,1 *0.220*	FB 78020 / FB 79020 / FB 62020	95		20	CC...0602...	D
A72630	00056592	95° pentru plăcuţe CC	39,0 *1.535*	56,0 *2.205*	10,3 *0.406*	8,0 *0.315*	0,1 *0.220*	FB 78030 / FB 79030 / FB 62030	95		30	CC...0602...	D
A72640	00056593	95° pentru plăcuţe CC	50,0 *1.969*	69,0 *2.717*	10,3 *0.406*	9,5 *0.374*	0,1 *0.220*	FB 78040 / FB 79040/ FB 62040	95		40	CC...0602...	D
A72650	00056594	95° pentru plăcuţe CC	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,5 *0.492*	0,1 *0.220*	FB 78050 / FB 79050 / FB 62050	95		50	CC...0602...	D
A72660	00056595	95° pentru plăcuţe CC	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	95		60	CC...09T3...	D
A72665	00056597	95° pentru plăcuţe CC	114,0 *4.488*	144,0 *5.669*	16,5 *0.650*	33,7 *1.327*	0,2 *0.440*	FB 78060 / FB 79060 / FB 731S500	95	**	65	CC...09T3...	D

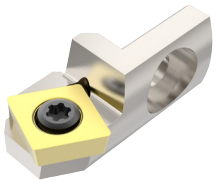
Reper Nr.	Număr reper	Pas	Capacitatea DCN-DCX ∅		LF	WF	Greutate	Pentru cap	KRINS°	**	Mărimea port-plăcuţei	Mărimea plăcuţei potrivite	Varianta
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*						
A72670	00056598	95° pentru plăcuţe CC	114,0 *4.488*	160,0 *6.299*	16,5 *0.650*	18,9 *0.744*	0,2 *0.440*	FB 78070	95		70	CC...09T3...	D
A72675	00056599	95° pentru plăcuţe CC	159,0 *6.260*	205,0 *8.071*	16,5 *0.650*	41,7 *1.642*	0,2 *0.440*	FB 78070	95		75	CC...09T3...	D

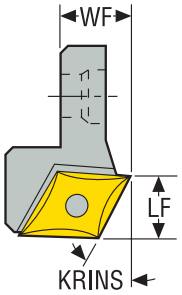
Piese de schimb, Piese incluse la livrare

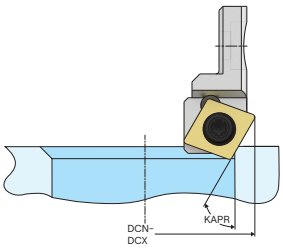
Pentru dimensiunea plăcuţei	Cheie plăcuţă	Şurub plăcuţă	Cheie (tip T)
			
WB...0301...	H4B-T06P	C02035-T06P	DOUBLE-T
CC...0602...	H4B-T07P	C02504-T07P	DOUBLE-T
CC...09T3...	H4B-T15P	C04008-T15P	DOUBLE-T
TC...1102...	H4B-T07P	C02504-T07P	DOUBLE-T

Suporturi pentru plăcuţe de şanfrenare

pentru capete de alezat de finisare FB 620 / 780 / 790





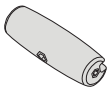


—Pentru capete de alezare raduale FB 620/ 780/ 790

Reper Nr.	Număr reper	Pentru cap	Mărimea port-plăcuţei	Capacitatea DCN-DCX ∅		LF	WF	Greutate	KRINS°	KAPR°	Mărimea plăcuţei potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*			
A72910CC0630	00086885	FB 78010	10	23,0 *0.906*	31,0 *1.220*	10,8 *0.425*	4,5 *0.177*	0,1 *0.220*	30	30	CC...0602...
A72920CC0630	00086888	FB 78020 / FB 79020/ GL32-0620-20	20	30,0 *1.181*	46,0 *1.811*	10,0 *0.394*	4,9 *0.193*	0,1 *0.220*	30	30	CC...0602...
A72930CC0630	00086891	FB 78030 / FB 79030 / FB 62030	30	39,0 *1.535*	56,0 *2.205*	10,5 *0.413*	8,1 *0.319*	0,1 *0.220*	30	30	CC...0602...
A72940CC0630	00086894	FB 78040 / FB 79040 / FB 62040	40	50,0 *1.969*	69,0 *2.717*	10,5 *0.413*	9,5 *0.374*	0,1 *0.220*	30	30	CC...0602...
A72950CC0630	00086897	FB 78050 / FB 79050	50	64,0 *2.520*	86,0 *3.386*	10,5 *0.413*	12,5 *0.492*	0,1 *0.220*	30	30	CC...0602...
A72960CC0930	00086900	FB 78060 / FB 79060 / A731S500	60	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	19,1 *0.752*	0,08 *0.180*	30	30	CC...09T3...
A72970CC0930	00086903	FB 78070	70	114,0 *4.488*	160,0 *6.299*	16,4 *0.646*	18,8 *0.740*	0,09 *0.200*	30	30	CC...09T3...
A72910CC0645	00086886	FB 78010	10	23,0 *0.906*	31,0 *1.220*	11,5 *0.453*	4,5 *0.177*	0,01 *0.020*	45	45	CC...0602...
A72920CC0645	00086889	FB 78020 / FB 79020 / FB 62020	20	30,0 *1.181*	46,0 *1.811*	10,0 *0.394*	5,0 *0.197*	0,1 *0.220*	45	45	CC...0602...
A72930CC0645	00086892	FB 78030 / FB 79030 / FB 62030	30	39,0 *1.535*	56,0 *2.205*	10,5 *0.413*	8,1 *0.319*	0,1 *0.220*	45	45	CC...0602...
A72940CC0645	00086895	FB 78040 / FB 79040 / FB 62040	40	50,0 *1.969*	69,0 *2.717*	10,5 *0.413*	9,5 *0.374*	0,1 *0.220*	45	45	CC...0602...
A72950CC0645	00086898	FB 78050 / FB 79050	50	64,0 *2.520*	86,0 *3.386*	10,3 *0.406*	12,4 *0.488*	0,02 *0.040*	45	45	CC...0602...
A72960CC0945	00086901	FB 78060 / FB 79060 / A731S500	60	85,0 *3.346*	115,0 *4.528*	16,5 *0.650*	19,1 *0.752*	0,2 *0.440*	45	45	CC...09T3...
A72970CC0945	00086904	FB 78070	70	114,0 *4.488*	160,0 *6.299*	16,4 *0.646*	18,8 *0.740*	0,09 *0.200*	45	45	CC...09T3...

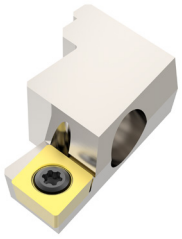
Pentru şuruburile de rezervă şi chei, consultaţi pagina (paginile) 596
**Pentru capacitatea DC cu Bridge bar şi Jumbo Bridge bar, consultaţi pagina 560

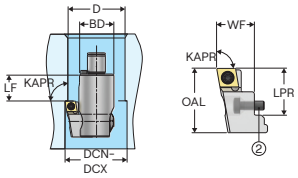
Piese de schimb, Piese incluse la livrare

Pentru dimensiunea plăcuţei	Cheie plăcuţă	Şurub plăcuţă	Cheie (tip T)
			
CC...0602...	H4B-T07P	C02504-T07P	DOUBLE-T
CC...09T3...	H4B-T15P	C04008-T15P	DOUBLE-T

Suport de plăcuţe pentru alezare inversă

pentru capete de alezat de finisare FB 620 / 780 / 790





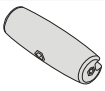
—Pentru capete de alezare raduale FB 620/ 780/ 790
—*Echilibrarea de precizie a capetelor FB A790 nu este posibilă atunci când se utilizează suporturi de plăcuţe pentru alezare inversă.
—KRINS 90°
—Dimensiunea adecvată a plăcuţei: CC...0602...

Reper Nr.	Număr reper	Pentru cap	Capacitate de alezare inversă DCN-DCX Ø		LF	BD	OAL	LPR	WF	Greutate
			mm	*(Inci)*	mm *(Inci)*	mm *(Inci)*	mm *(Inci)*	mm *(Inci)*	mm *(Inci)*	kg *(lbs)*
A789X10CC0690	00086907	A78010 A78020 & A79020 GL32-0620-20	39,5-47,5 46-56 49,7-61,7	*(1.555-1.870)* *(1.811-2.205)* *(1.957-2.429)*	16,5 *(0.650)* 21,5 *(0.846)* 7,75 *(0.305)*	21,5 *(0.846)* 27 *(1.063)* 32 *(1.260)*	30,5 *(1.201)*	16,0 *(0.630)*	12,8 *(0.504)*	0,01 *(0.020)*
A789X30CC0690	00086910	A78030 & A79030 A78040 & A79040 A78050 & A79050 GL40-0620-30 GL50-0620-40	53-65 61-76 69-91 57,6-70,2 67,6-80,2	*(2.087-2.559)* *(2.402-2.992)* *(2.717-3.583)* *(2.268-2.764)* *(2.661-3.157)*	32 *(1.260)* 39 *(1.535)* 49 *(1.929)* 1,75 *(0.069)* 2,75 *(0.108)*	35 *(1.378)* 43 *(1.693)* 54 *(2.126)* 40 *(1.575)* 50 *(1.969)*	30,0 *(1.181)*	23,0 *(0.906)*	15,0 *(0.591)*	0,03 *(0.070)*
A789X60CC0690	00086909	A78060 & A79060	89-119 *	*(3.504-4.685 *)*	50 *(1.969)*	70 *(1.969)*	50,0 *(1.969)*	38,5 *(1.516)*	21,0 *(0.827)*	0,09 *(0.200)*
A789X70CC0690	00086911	A78070	118-164	*(4.646-6.457)*	60 *(2.362)*	95 *(2.362)*	50,0 *(1.969)*	38,5 *(1.516)*	21,0 *(0.827)*	0,1 *(0.220)*

*Pentru capacitatea DC de alezare inversă cu Bridge bar și Jumbo Bridge bar, consultaţi pagina 564
Pentru șuruburile de rezervă și chei, consultaţi pagina (paginile) 596
Conţinutul de livrare al suporturilor de plăcuţe pentru alezare inversă include un șurub de prindere specific al suportului de plăcuţe, care trebuie utilizat în locul șurubului de prindere standard livrat împreună cu capetele de alezare.

DCN/DCX mini = D+BD/2 + 0,5 mm (0,02") de la diametrul de 39,5 la 47,5 (1,555" la 1,870")
DCB/DCX mini = D+BD/2 + 1 mm (0,039") de la diametrul de 46 la 64 (1,811" la 2,520")

Piese de schimb, Piese incluse la livrare

Pentru	Șurub ansamblu	Șurub plăcuţă	Cheie (tip T)	Cheie
				
A789X10CC0690	950F0308	C02504-T07P	DOUBLE-T	H4B-T07P
A789X30CC0690	950F0410	C02504-T07P	DOUBLE-T	H4B-T07P
A789X60CC0690	–	C02504-T07P	DOUBLE-T	H4B-T07P
A789X70CC0690	–	C02504-T07P	DOUBLE-T	H4B-T07P

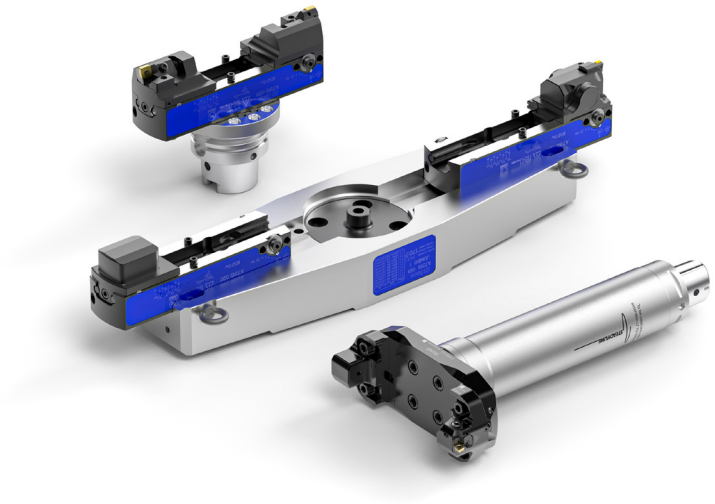
Capete de alezare de precizie FB 780/ 790 – instrucţiuni

Condiţii de prelucrare recomandate
Pentru mai multe detalii consultaţi instrucţiunile de utilizare livrate împreună cu capetele de alezare și cu barele GL.

Viteze maxime pentru capete de alezare de precizie, tip radial
Vitezele maxime indicate în paginile de produs ale capetelor de alezare depind de proiectarea mecanică și calitatea echilibrării capului de alezare. Vitezele cuprinse în intervalul recomandat vor fi alese ţinând cont de toate condiţiile de prelucrare, ex.: materialul semifabricatului, muchia de aşchiere, lungimea sculei, arborele maşinii.
În cazul operaţiilor de alezare cu barele Steadyline®, aveţi grijă să nu depăşiţi RPM maxim al barei: vedeţi instrucţiunile de utilizare livrate împreună barele Steadyline®.
Viteza inferioară max. RPM se foloseşte la capetele echipate cu port-scule de a alezare sau de şanfrenare. La utilizarea suporturilor de plăcuţă de alezare inversă în capete tip FB 620, FB 790 sau FB 780, utilizaţi valoarea max. de rotaţii pe minut pentru tipul A780 de mărime similară.

Cap	Capacitate Ø mm *(inci)*	RPM max.	Viteza maximă de aşchiere implicită v_c la min Cap. m/min *(sf/min)*	Viteza maximă de aşchiere implicită v_c la max Cap. m/min *(sf/min)*
FB 620 capete de alezare de finiţie, cu conexiune spre maşină GL și BA, pentru bare de alezare și strunjire cu amortizare a vibraţiilor Steadyline®				
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 Capete de alezare de finiţie, echilibrabile, cu conexiune Graflex®				
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 Capete de alezare de finiţie, cu conexiune Graflex®				
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 Capete de alezare de finiţie, cu conexiune Seco Capto™				
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)*

Notă: Vitezele maxime sunt condiţionate de conceptul mecanic al capului și de calitatea echilibrării. Vitezele cuprinse în intervalul recomandat vor fi alese ţinând cont de toate condiţiile de prelucrare, ex.: materialul semifabricatului, muchia de aşchiere, lungimea sculei, arborele maşinii. La viteze de la aproximativ 8000 RPM și mai mari, suporturile de bază și extensiile/reductoarele trebuie să fie bine echilibrate.



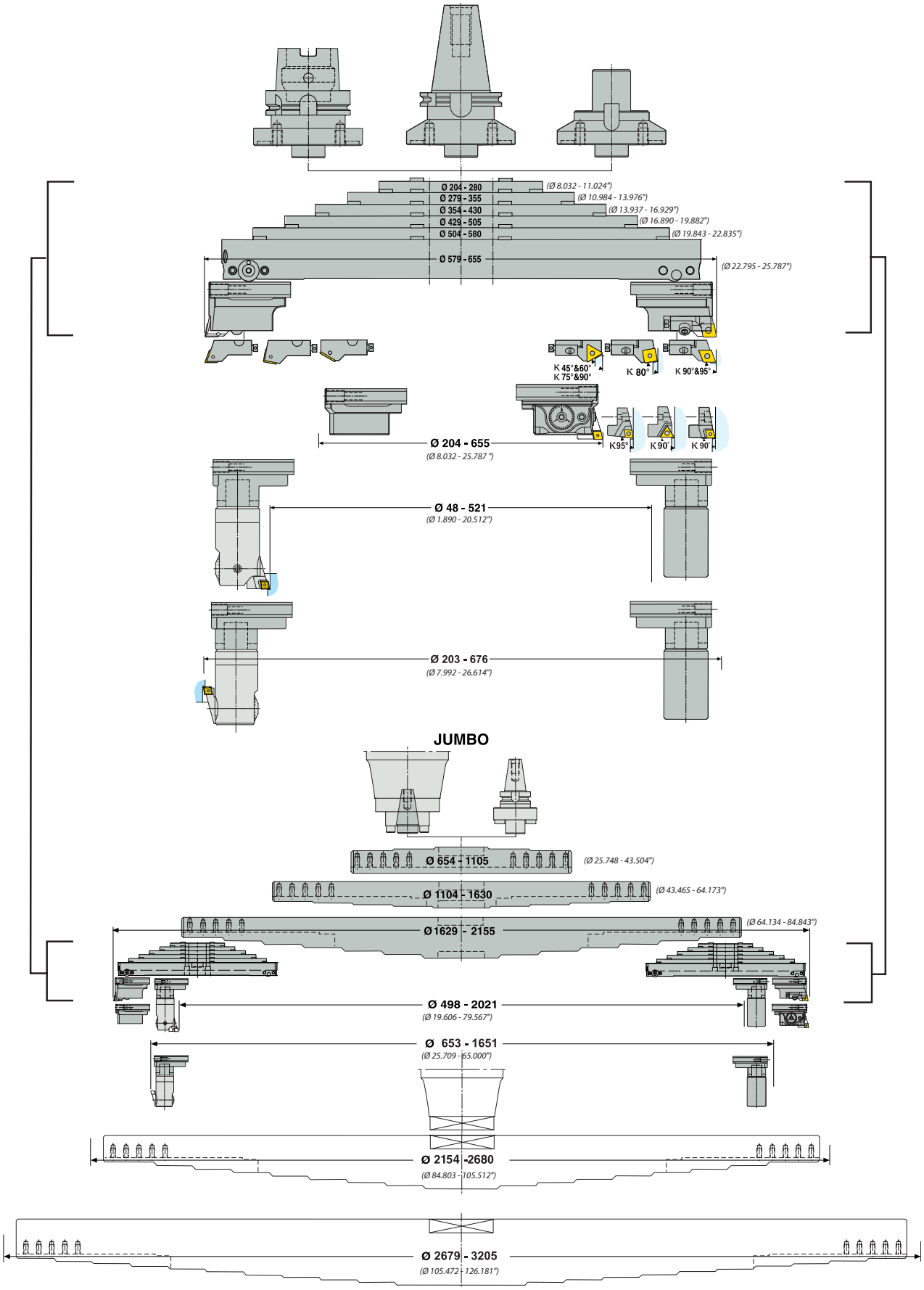
Soluţii de alezare cu diametru mare

Seco oferă o gamă completă de traverse de alezat și traverse de alezat mari pentru alezare de diametru mare, alezare exterioară și operaţii de alezare inversă.

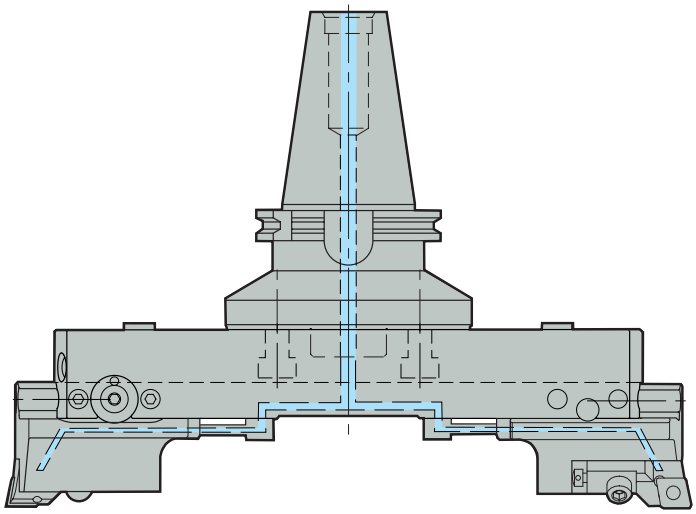
Combinaţie modulară – traverse și blocuri

Familie de produse		Gamă diametre	Operaţie	Capacităţi	Detalii
BB731 	Conceput pentru flexibilitate maximă. Traversele BB731 sunt disponibile într-o gamă largă de diametre ca produse standard.	204 -655 mm (8.03-25.78")	Alezare OD-alezare exterioară Alezare inversă	Vezi pag. ghid 559-564	A se vedea paginile 565
JBB731 	Barele Jumbo Bridge sunt fabricate din aluminiu de înaltă rezistenţă cu interfeţa ax din oţel.	654 -3,205 mm (25.75-126.18")	Alezare OD-alezare exterioară Alezare inversă	Vezi pag. ghid 559.564	Vezi pag. 566-568
BB732 	Barele BB732 sunt proiectate pentru a fi utilizate cu suporturile Steadyline® cu dorn, pentru a răspunde provocărilor în timpul aplicaţiilor de alezare cu diametru mare, cu finisaj bun al suprafeţei, productivitate ridicată și unelte mai lungi.	Alezare de degroșare 114 - 301 mm (4.488 - 11.850") Alezare de finisare 114 - 315 mm (4.488 - 12.402")	Alezare adâncă	Vezi pag. ghid 571.576	Vezi pag. 577-579

Prezentare generală



Caracteristici: Seria BB731



Aplicaţie

— Alezare (degroșare & finisare) Ø 204 – 655 mm (8.032" – 25.787").

— Alezare OD (degroșare & finisare) Ø 48 – 521 mm (1.890" – 20.512").

— Alezare inversă Ø 203 mm – 676 mm (7.992 – 26.614").

Beneficii și caracteristici

— Traversele de alezat au o conexiune pe partea utilajului Ø 130 mm (Ø 5,118") pentru instalare directă pe arbori pentru traverse de alezat (SA și HSK) sau pe adaptorul Graflex®.

— Bridge bar poate ţine capete de degroșare, finisare, contragreutate sau Graflex® .

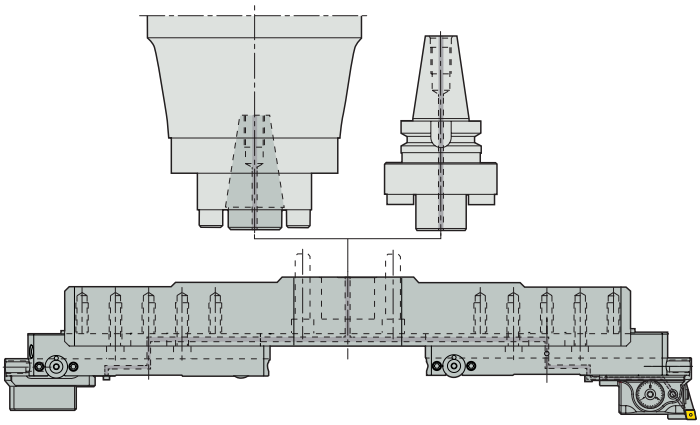
— Capetele de alezare sunt fixate în Bride bar cu ajutorul a doi cilindri acţionaţi de trei șuruburi de prindere: Un șurub de prindere are un disc opritor, care limitează culisarea capului în limitele de reglare și oprește capul să culiseze afară din Bridge bar. Glisare precisă și fără hopuri a blocului pentru reglare a diametrului 38 mm (Ø 1,496") cursă pe rază, utilizând șurubul de reglare al blocului, care este conectat la pinul de reţinere al traversei de alezat.

— La utilizarea adaptorului Graflex®, sunt posibile extensii, precum și prindere cu flanșă a capului de alezare, a se vedea sistemul modular Graflex®.

— Poziţie unghiulară a traversei de alezat la fiecare 30° pe arbori sau adaptorul Graflex®, pentru depozitare optimizată a magaziei.

— Răcire interioară, prin Bridge bar și prin cap direcţionată spre muchia de tăiere.

Caracteristici: Seria JBB731



Aplicaţie

— Alezare (degroșare & finisare) Ø 654 – 3078 mm (25.748" – 121.181").

— Alezare OD (degroșare & finisare) Ø 498 – 3071 mm (19.606" – 120.906").

— Alezare inversă (degroșare & finisare) Ø 653 – 3226 mm (25.709" – 127.008").

Beneficii și caracteristici

— Barele Jumbo Bridge sunt fabricate din aluminiu de înaltă rezistenţă cu interfeţa ax din oţel.

— Concepute pentru a susţine două bare clasice Bridge din seria BB731 în diferite poziţii.

— Barele Jumbo Bridge sunt livrate împreună cu două inele de ridicare.

— Dimensiunile A731S001, 002, 003 sunt livrate cu 4 șuruburi de blocare.

— Se poate monta pe un suport de frezare, suport cu flanșă tip 569, vârf Ø 60 mm (Ø 2,362") sau se poate monta direct pe axul mașinii (din 2079/50 partea piesei de prelucrat).

— Utilizând pivotul de centrare prezentat în accesorii.

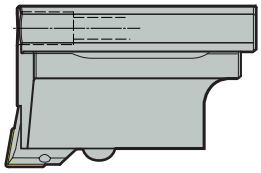
Dimensiunile A731S004-...* și A731S005-...* sunt disponibile la cerere, cu posibilităţi standard sau specifice de montare a axului, în funcţie de mașină:

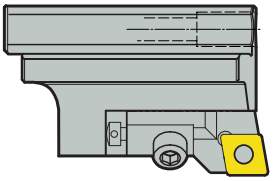
Capacitate Ø mm *(inch)*	Denumire	Dimensiuni în mm (*inci*), consultaţi desenul de la pagina produsului							
		DCB	LF	HTB	LB	CBDP	WB	DCON	Greutate
2154-2680 *(84.803-105.512")*	A731S004-...*	*	70 *(2.75591")*	300 *(11.811")*	160 *(6.29921")*	*	2140 *(84.25197")*	*	*
2679-3205 *(105.472-126.181")*	A731S005-...*	*	110 *(4.33071")*	400 *(15.748")*	200 *(7.87402")*	*	2665 *(104.9213")*	*	*

* Codul descrierii și dimensiunile vor fi completate ținând cont de tipul de montaj al axului.

Caracteristici: Blocuri de alezare pentru seriile BB731 și JBB731

Bloc de alezare de degroșare





Aplicaţie

— Cartușe disponibile cu unghi de atac de 90° și 80°.

— Alte cartușe cu interfaţă de instalare ISO5611/h1 = 16 mm (0,629”) sunt, de asemenea, adecvate.

Beneficii și caracteristici

— Un cap de alezare larg pereche necesită două blocuri de degroșare, fiecare echipat cu câte un cartuș.

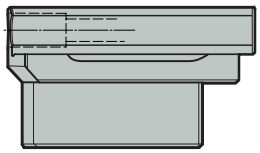
— O gamă extinsă de cartușe este disponibilă:

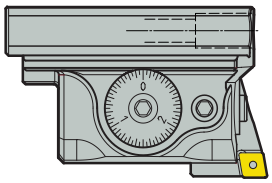
— Cartușe cu unghi de avans de 90°, recomandate în majoritatea aplicaţiilor de alezare, pentru un consum de putere mai mic.

— Cartușe cu unghi de avans de 80°, recomandate pentru alezare de găuri străpunse (și șanfrenare), în special în fontă, pentru a evita defectele la ieșire. Consumul de putere este mare.
— Cele două cartușe se pot regla la același diametru (alezare simetrică) sau se pot așeza decalat (alezare asimetrică).

— O pană pentru ridicarea cartușului este disponibilă ca accesoriu (Reper Nr. 18LS0316). Proceduri de asamblare și setare, consultaţi paginile 559-564.

Bloc de alezare de finisare





Aplicaţie

— Gamă largă de suporturi pentru plăcuţe disponibile la 90° și 95° KAPR.

— Adecvate pentru suporturile de plăcuţă pentru alezare de precizie A72460, A72560 sau A72660

Beneficii și caracteristici

— Un cap mare de alezare de finisare necesită un bloc de alezare de finisare echipat cu o portplăcuţă și o contragreutate.

— Blocurile de finisare au răcire interioară, direcţionată spre muchiile de așchiere.

— Introduceţi blocuri proiectate cu caracteristici de siguranţă care asigură faptul că blocurile nu vor avea un efect centrifugal la turaţii mai mari (blocurile nu vor ieși din bare)

Caracteristici: Blocuri de alezare Graflex®, pentru teșire a muchiilor OD sau alezare inversă

Subiectul 1

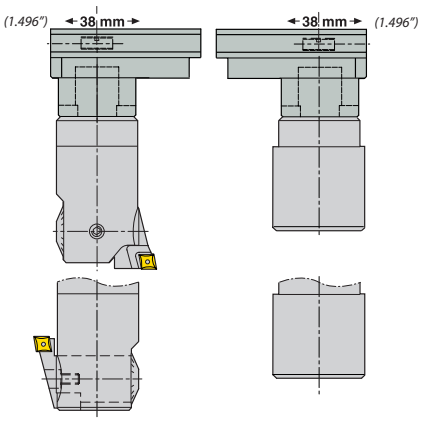
Aplicaţie

— Acest bloc are o conexiune frontală Graflex® mamă mărimea G5.

— posibil de utilizat la alezare OD și alezare inversă.

— Proceduri de asamblare și setare, consultaţi paginile 559-564.

— **NOTĂ!** Noile blocuri de alezare se potrivesc în vechile tipuri de Bridge bar.



Beneficii și caracteristici

— Orice cap de alezare Graflex®, unealtă specială sau unealtă standard sau modul Graflex® de dimensiune G5 pot fi montate pe bridge bar.

— Ex.: desenul care arată un ansamblu pentru alezare exterioară sau alezare inversă utilizând două blocuri de alezare Graflex® completate cu un cap de alezare de finisare Graflex® A78050 cu port-plăcuţă (ex. A72550 pentru alezare exterioară), o port-plăcuţă (ex. A789X30CC0690) și o contragreutate Graflex® (ex.: Part No. BM050W78050).

— Sunt posibile două poziţionări ale modulului Graflex®, deoarece are șuruburi cu vârf sferic poziţionate 2x2 și două știfturi plasate la 180°.

— Blocurile de degroșare au răcire interioară, direcţionată spre muchiile de așchiere.

— Aceste blocuri de alezare (nr. de piesă A731S 400, A731S 500, A731S 600, A731S 40128) se pot instala și în tipul anterior de traverse de alezat (nr. de piesă A731 0_0 -fără S-).

— Se vor utiliza instrucţiunile de montare și RPM max. de la tipul anterior de bare.

— Pentru a menţine echilibrarea, nu monta blocuri noi și vechi pe același Bridge bar.

Subiectul 2

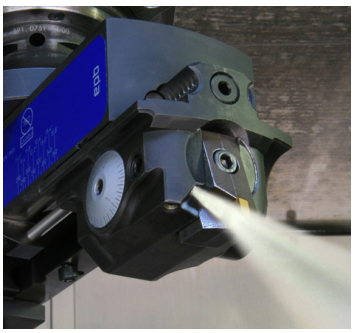
Sfaturi pentru alegerea accesoriilor pentru agent de răcire complet

Degroșare (bară Bridge cu 2 blocuri de alezare de degroșare):

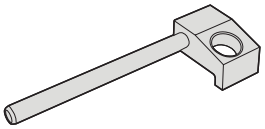
Pentru direcţionarea lichidului de răcire către ambele muchii de așchiere, folosiţi 2 conectoare (Reper Nr. AU731S00700), montate în Bridge Bar, și 2 seturi de duze de direcţionare (Reper Nr. AU731S40700), care se vor monta în fiecare bloc de degroșare. Pentru răcirea normală prin canalele blocului, folosiţi 2 conectoare (Reper Nr. AU731S00700), care se vor monta în Bridge bar.

Alezare de finisare (bară Bridge cu 1 bloc de alezare de finisare și 1 contragreutate):

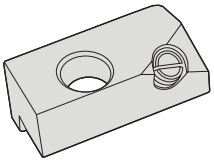
Folosiţi 1 conector (Reper Nr. AU731S00700), montat în Bridge Bar înainte de conectarea blocului de finisare. Deoarece blocurile de alezare au o duză pentru alimentarea cu lichid de răcire, direcţionarea lichidului este rezolvată.
Alezare exterioară (ex. bară Bridge cu 2 blocuri de alezare Graflex® echipate cu un cap de alezare de finisare și o contragreutate): Folosiţi 1 conector (Reper Nr. AU731S00700), montat în Bridge Bar înainte de conectarea blocului de Graflex® cu capul de alezare montat. Canalul central de lichid de răcire al blocului de alezare Graflex® va alimenta cu lichid de răcire capul de alezare instalat



Conectorul ţeavă răcire
(Reper Nr. AU731S00700)



Set duză pentru direcţionarea lichidului
(Part Nr. AU731S40700)



NOTĂ! Presiunea maximă admisă = 70 bari max.

Alcătuirea ansamblurilor de traversă de alezat

Un ansamblu pentru alezare de degroșare de până la Ø 655 mm *(Ø 25,787")* **necesită: 1 traversă de alezat (A731S 0_0) + 2 blocuri de alezare de degroșare (2x A731S 400) cu 2 cartușe*.**

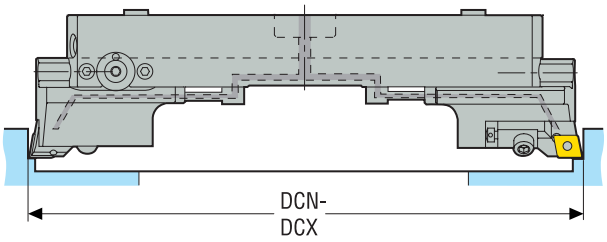


Fig. 1

Un ansamblu pentru alezare de precizie de până la Ø 655 mm *(Ø 25,787")* **necesită: 1 bară Bridge (A731S 0_0) + 1 bloc de alezare de finisare (A731S 500) cu 1 port-plăcuţă de finisare mărimea 60** + 1 bloc contragreutate (A731S 600).**

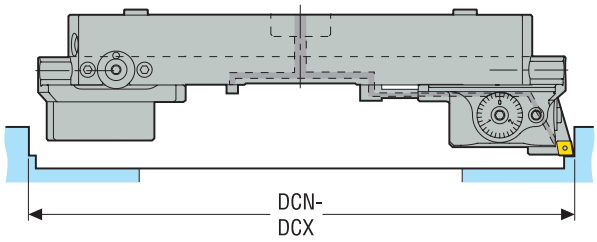


Fig. 2

Un ansamblu pentru alezare de degroșare de până la Ø 3205 mm *(Ø 126,181")* **necesită: 1 bară Jumbo Bridge (A731S 00_) + 2 bare Bridge (A731S 0_0) + 2 blocuri de alezare de degroșare (2x A731S 400) cu 2 cartușe*.**

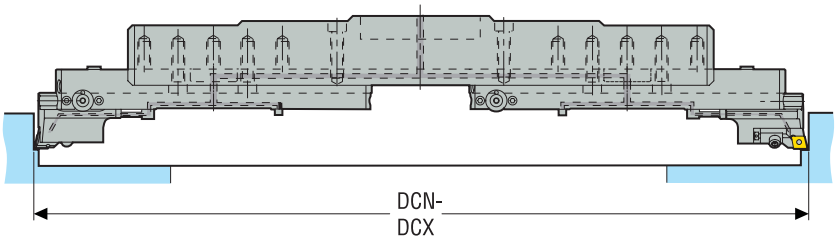


Fig. 3

Un ansamblu pentru alezare de precizie de până la Ø 3205 mm *(Ø 126,181")* **necesită: 1 bară Jumbo Bridge (A731S 00_) + 2 bare Bridge (A731S 0_0) + 1 bloc de alezare de finisare (A731S 500) cu 1 port-plăcuţă de finisare mărimea 60** + 1 bloc contragreutate (A731S 600).**

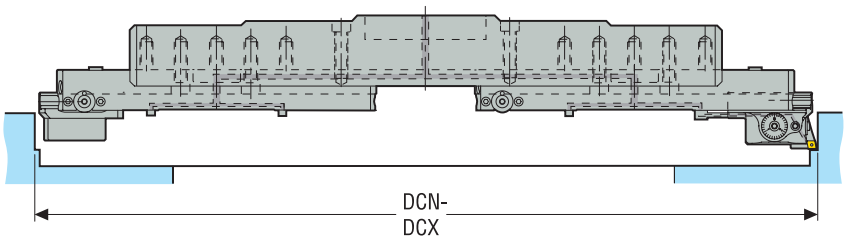


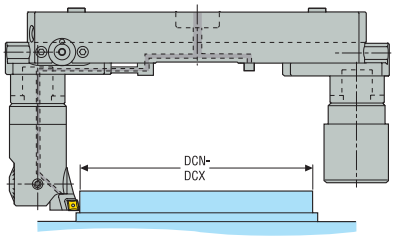
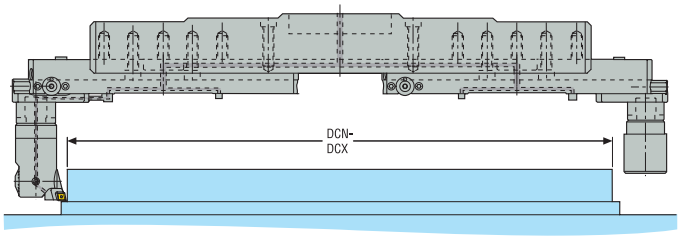
Fig. 4

* Cartușele trebuie comandate separat.
** Suporturile de plăcuţă trebuie comandate separat.

Construirea unui ansamblu Bridge bar:
Diagramă de selectare a Bridge bar pentru a construi un diametru de ALEZARE necesar

Pentru alezare DCN-DCX ∅ mm	*Pentru alezare DCN-DCX ∅ inci*	Traverse de alezat Jumbo	Bare de alezat clasice	Pentru alezare de degroșare		Pentru alezare de finisare	
					Fig.		Fig.
204-280	*8.031-11.024*	–	A731S 010	2x A731S 400 + 2 cartușe	1	A731S 500 + 1 Port-plăcuță + A731S 600	2
279-355	*10.984-13.976*	–	A731S 020				
354-430	*13.937-16.929*	–	A731S 030				
429-505	*16.890-19.882*	–	A731S 040				
504-580	*(19.843-22.835*	–	A731S 050				
579-655	*22.795-25.787*	–	A731S 060				
654-805	*25.748-31.693*	A731S 001	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Port-plăcuță + A731S 600	4
654-880	*25.748-34.646*		2x A731S 020				
804-955	*31.654-37.598*		2x A731S 030				
879-1030	*34.606-40.551*		2x A731S 040				
1029-1105	*40.512-43.504*		2x A731S 050				
1104-1255	*43.465-49.409*	A731S 002	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Port-plăcuță + A731S 600	4
1104-1330	*43.465-52.362*		2x A731S 020				
1179-1405	*46.417-55.315*		2x A731S 030				
1254-1480	*49.370-58.268*		2x A731S 040				
1329-1555	*52.323-61.220*		2x A731S 050				
1404-1630	*55.276-64.173*		2x A731S 060				
1629-1780	*64.134-70.079*	A731S 003	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Port-plăcuță + A731S 600	4
1629-1855	*64.134-73.031*		2x A731S 020				
1704-1930	*67.087-75.984*		2x A731S 030				
1779-2005	*70.039-78.937*		2x A731S 040				
1854-2080	*72.992-81.890*		2x A731S 050				
1929-2155	*75.945-84.843*		2x A731S 060				
2154-2305	*84.803-90.748*	A731S 004	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Port-plăcuță + A731S 600	4
2154-2380	*84.803-93.701*		2x A731S 020				
2229-2455	*87.756-96.654*		2x A731S 030				
2304-2530	*90.709-99.606*		2x A731S 040				
2379-2605	*93.661-105.512*		2x A731S 050				
2454-2680	*96.614-105.512*		2x A731S 060				
2679-2830	*105.472-111.417*	A731S 005	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Port-plăcuță + 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				

Construirea unui ansamblu de alezare exterioară Bridge bar:

Un ansamblu pentru teșire a muchiilor OD de precizie de până la Ø 521 mm *(Ø 20,512")* **necesită: 1 bară Bridge (A731S 0_0) + 2 blocuri Graflex® (2x A731S 40128) + ex. 1 cap de alezare de finisare (A780 50) cu 1 port-plăcuţă de finisare mărimea 60* + 1 contragreutate (BM050W78050).**
 Fig. 1
Un ansamblu pentru alezare de degroșare de până la Ø 3205 mm *(Ø 120,906")* **necesită: 1 bară Jumbo Bridge (A731S 00_) + 2 bare Bridge (A731S 0_0) + 2 blocuri de alezare de degroșare (2x A731S 400) cu 2 cartușe*.**
 Fig. 2
* Port-plăcuţele se comandă separat.

Construirea unui ansamblu de alezare exterioară Bridge bar: Diagramă de selectare a Bridge bar pentru a construi un diametru de alezare OD necesar

Pentru alezare-OD DCN-DCX ∅ mm	*Pentru alezare-OD* **DCN-DCX ∅** *inci*	**Traverse de alezat Jumbo**	**Bare de alezat clasice**	**Strunjire de finisare exterioară**	
					Fig.
48-146	*1.890-5.748*	–	A731S 010	2x A731S 40128 + 1x A780 50 + 1 Port-plăcuță + 1x BM050W78050	1
123-221	*4.843-8.701*	–	A731S 020		
198-296	*7.795-11.654*	–	A731S 030		
273-371	*10.748-14.606*	–	A731S 040		
348-446	*13.701-17.559*	–	A731S 050		
423-521	*16.654-20.512*	–	A731S 060		
498-671	*19.606-26.417*	A731S 001	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Port-plăcuță + 1x BM050W78050	2
498-746	*19.606-29.370*		2x A731S 020		
648-821	*25.512-32.323*		2x A731S 030		
723-896	*28.465-35.276*		2x A731S 040		
873-971	*34.370-38.228*		2x A731S 050		
948-1121	*37.323-44.134*	A731S 002	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Port-plăcuță + 1x BM050W78050	2
948-1196	*37.323-47.087*		2x A731S 020		
1098-1271	*43.228-50.039*		2x A731S 030		
1173-1346	*46.181-52.992*		2x A731S 040		
1323-1421	*52.087-55.945*		2x A731S 050		
1398-1496	*55.039-58.898*		2x A731S 060		
1473-1646	*57.992-64.803*	A731S 003	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Port-plăcuță + 1x BM050W78050	2
1473-1721	*57.992-67.756*		2x A731S 020		
1623-1796	*63.898-70.709*		2x A731S 030		
1698-1871	*66.850-73.661*		2x A731S 040		
1848-1946	*72.756-76.614*		2x A731S 050		
1923-2021	*75.709-79.567*		2x A731S 060		
1998-2171	*78.661-85.472*	A731S 004	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Port-plăcuță + 1x BM050W78050	2
1998-2246	*78.661-88.425*		2x A731S 020		
2148-2321	*84.567-91.378*		2x A731S 030		
2223-2396	*87.520-94.331*		2x A731S 040		
2373-2471	*93.425-97.283*		2x A731S 050		
2448-2546	*96.378-100.236*		2x A731S 060		
2523-2696	*99.331-106.142*	A731S 005	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Port-plăcuță + 1x BM050W78050	2
2523-2771	*99.331-109.094*		2x A731S 020		
2973-2846	*117.047-112.047*		2x A731S 030		
2748-2921	*108.189-115.000*		2x A731S 040		
2898-2996	*114.094-117.953*		2x A731S 050		
2973-3071	*117.047-120.906*		2x A731S 060		

Construirea unui ansamblu Bridge bar pentru alezare inversă:

Un ansamblu pentru alezare inversă de precizie de până la Ø 676 mm *(Ø 26.614")* **necesită: 1 bară Bridge (A731S 0_0) + 2 blocuri Graflex® (2x A731S 40128) + ex. 1 cap de alezare de finisare (A780 50) cu 1 port-plăcuţă de finisare mărimea 50* + 1 contragreutate (BM050W78050).**

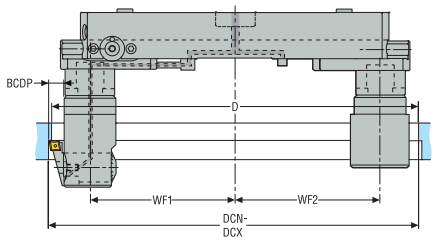


Fig. 1

Un ansamblu pentru alezare inversă de precizie de până la Ø 3226 mm (Ø 127,008") necesită: 1 bară Jumbo Bridge (A731S 00_) + 2 bare Bridge (A731S 0_0) + ex. 1 cap de alezare de finisare (A780 50) cu 1 port-plăcuţă de finisare inversă mărimea 50* + 1 contragreutate (BM050W78050).

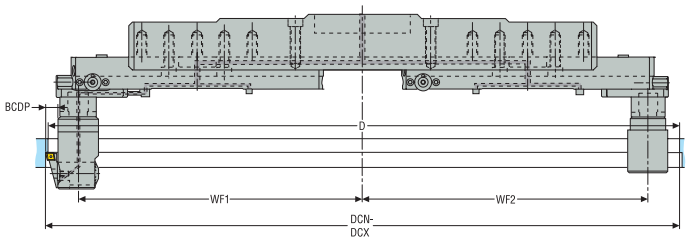


Fig. 2

* Port-plăcuţele se comandă separat.

Determinarea diametrului de acces minim (D min)

Condiţii de echilibrare: WF1 = WF2

D min = DC + 5- BCDP

BCDP = distanţa dintre muchia de aşchiere a plăcuţelor şi corpul capului de alezat A78050 montat (7,5 < BCDP < 18,5).

Două cazuri extreme:

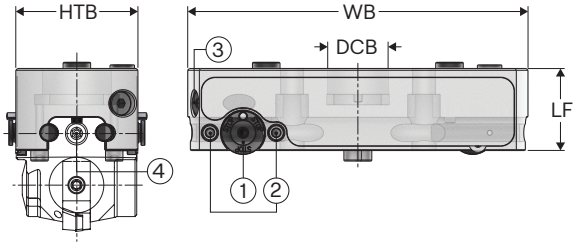
Capul de alezat A78050 reglat la capacitate minimă: D min = DCN - 2,5
Capul de alezat A78050 reglat la capacitate maximă: D min = DCX -13,5

Construirea unui ansamblu Bridge bar pentru alezare inversă: Diagramă de selectare a Bridge bar pentru a construi un diametru de alezare INVERSĂ necesar

Pentru alezare inversă DCN-DCX ∅ mm	*Pentru alezare inversă DCN-DCX ∅ inci*	Traverse de alezat Jumbo	Bare de alezat clasice	Pentru finisare alezare inversă	
					Fig.
203-301	*7.992-11.850*	–	A731S 010	2x A731S 40128 + 1x A780 50 + 1 suport de plăcuțe pentru alezare inversă + 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 suport de plăcuțe pentru alezare inversă + 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 suport de plăcuțe pentru alezare inversă + 1x BM050W78050	2
1103-1351	*43.425-53.189*		2x A731S 020		
1253-1426	*49.331-56.142*		2x A731S 030		
1328-1501	*52.283-59.094*		2x A731S 040		
1478-1576	*58.189-62.047*		2x A731S 050		
1553-1651	*61.142-65.000*		2x A731S 060		
1628-1801	*64.094-70.906*	A731S 003	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 suport de plăcuțe pentru alezare inversă + 1x BM050W78050	2
1628-1876	*64.094-73.858*		2x A731S 020		
1778-1951	*70.000-76.811*		2x A731S 030		
1853-2026	*72.953-79.764*		2x A731S 040		
2003-2101	*78.858-82.717*		2x A731S 050		
2078-2176	*81.811-85.669*		2x A731S 060		
2153-2326	*84.764-91.575*	A731S 004	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 suport de plăcuțe pentru alezare inversă + 1x BM050W78050	2
2153-2401	*84.764-94.528*		2x A731S 020		
2303-2476	*90.669-97.480*		2x A731S 030		
2378-2551	*93.622-100.433*		2x A731S 040		
2528-2626	*99.528-103.386*		2x A731S 050		
2603-2701	*102.480-106.339*		2x A731S 060		
2678-2851	*105.433-112.244*	A731S 005	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 suport de plăcuțe pentru alezare inversă + 1x BM050W78050	2
2678-2926	*105.433-115.197*		2x A731S 020		
2828-3001	*111.339-118.150*		2x A731S 030		
2903-3076	*114.291-121.102*		2x A731S 040		
3053-3151	*120.197-124.055*		2x A731S 050		
3128-3226	*123.150-127.008*		2x A731S 060		

BB 731S0x0 – Bridge bars





—Lichid de răcire prin Bridge bar

1. Șurub de blocare cu disc opritor
2. Șurub de blocare
3. Știft de fixare
4. Șurub de reglare a diametrului

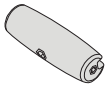
Reper Nr.	Număr reper	Spre semifabricat Capacitatea DCN-DCX Ø		HTB	WB	DCB	LF	Greutate
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
A731S010	02753664	204,0 *8.031*	280,0 *11.024*	70,0 *2.756*	195,0 *7.677*	40,0 *1.575*	47,0 *1.850*	3,6 *7.9*
A731S020	02753668	279,0 *10.984*	355,0 *13.976*	70,0 *2.756*	269,0 *10.591*	40,0 *1.575*	47,0 *1.850*	5,1 *11.2*
A731S030	02753670	354,0 *13.937*	430,0 *16.929*	70,0 *2.756*	344,0 *13.543*	40,0 *1.575*	47,0 *1.850*	6,5 *14.3*
A731S040	02753673	429,0 *16.890*	505,0 *19.882*	70,0 *2.756*	419,0 *16.496*	40,0 *1.575*	47,0 *1.850*	7,9 *17.4*
A731S050	02753675	504,0 *19.843*	580,0 *22.835*	70,0 *2.756*	494,0 *19.449*	40,0 *1.575*	47,0 *1.850*	10,5 *23.2*
A731S060	02753677	579,0 *22.795*	655,0 *25.787*	70,0 *2.756*	569,0 *22.402*	40,0 *1.575*	47,0 *1.850*	12,3 *27.1*

Cuplu de strângere de 20 Nm al şuruburilor de blocare (2) şi al şurubului de blocare cu disc opritor (1).
Înainte de setarea diametrului, asiguraţi-vă că ştiftul de fixare este cuplat. Pentru mai multe detalii consultaţi instrucţiunile de utilizare livrate împreună cu Bridge bar şi cu blocurile de alezare.
Max RPM, consultaţi pag. 570
Pentru capacităţile de alezare-OD, consultaţi pagina(paginile) 561-562
Pentru diametre mai mari, consultaţi barele Jumbo Bridge de la pagina (paginile) 566

Piese de schimb, Piese incluse la livrare

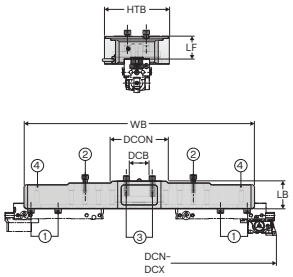
Pentru	Șurub de blocare
	
A731S010-60	19A71060

Accesorii

Pentru	Cheie (tip T)	Cheie	Cheie de blocare
			
A731S010-60	DOUBLE-T	H6B-H5.0L	03HL05

JBB 731S00 – Jumbo Bridge Bars





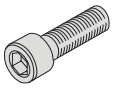
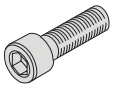
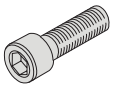
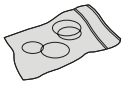
—Barele Jumbo Bridge sunt concepute pentru a susține două bare Bridge clasice în mai multe poziții
—Răcire prin barele Jumbo Bridge

1. Șurub asamblare
2. Șurub de blocare
3. Șurub de fixare
4. Dop de etanșare

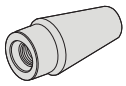
Reper Nr.	Număr reper	Spre semifabricat Capacitatea DCN-DCX Ø		HTB	LF	WB	DCON	DCB	CBDP	LB	Greutate	**
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A731S001	02828506	654,0 *25.748*	1105,0 *43.504*	180,0 *7.087*	63,0 *2.480*	640,0 *25.197*	135,0 *5.315*	60,0 *2.362*	24,0 *0.945*	77,0 *3.031*	20,25 *44.6*	
A731S002	02828516	1104,0 *43.465*	1630,0 *64.173*	200,0 *7.874*	50,0 *1.969*	1090,0 *42.913*	135,0 *5.315*	60,0 *2.362*	24,0 *0.945*	80,0 *3.150*	34,5 *76.1*	
A731S003	02904383	1629,0 *64.134*	2155,0 *84.843*	200,0 *7.874*	50,0 *1.969*	1615,0 *63.583*	135,0 *5.315*	60,0 *2.362*	24,0 *0.945*	80,0 *3.150*	67,0 *147.7*	**

Capacităţi de alezare, de strunjire OD și de alezare a spatelui pentru combinaţiile de bare Jumbo și Bridge, consultaţi pagina(paginile) de ghidare 559-564
**Dimensiuni mai mari A731S004-... (∅ 2154-2680 mm) și A731S005-... (∅ 2679-3205 mm) disponibil la cerere, consultaţi pagina(paginile) Ghidului 560

Piese de schimb, Piese incluse la livrare

Pentru DCN-DCX	Șurub ansamblu	Șurub de fixare	Șurub levier	Șurub de blocare	Inel O	Dop de etanșare
						
654-1105	950D1240	950D1670	90AS03	950D1250	90JT02	AU731S01100
1104-1630	950D1240	950D1680	90AS03	950D1250	90JT02	AU731S01100
1629-2155	950D1240	950D16120	90AS03	950D1250	90JT02	AU731S01100

Accesorii

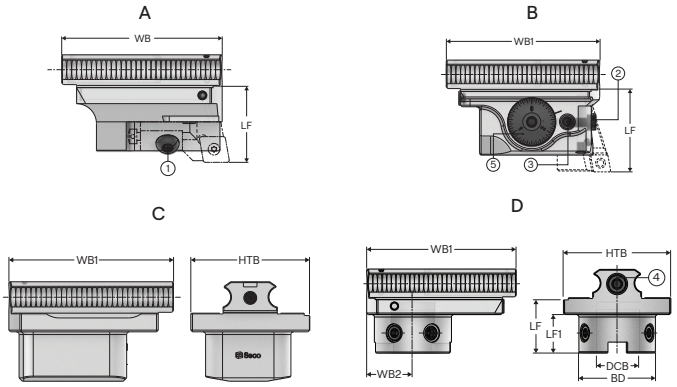
Pentru DCN-DCX	Pin de centrare
	
654-1105	E447153960
1104-1630	E447153960
1629-2155	E447153960

Setul de garnituri inelare conţine 6 garnituri inelare de ∅ 6 mm (0.236") pentru canalele de răcire și 1 garnitură inelară de ∅ 60 mm (2.362") pentru alezajul de susţinere al barelor Jumbo Bridge.

BBB 731S0xx – pentru blocuri de alezare și bare Jumbo



—Pentru montarea în Bridge bar
—Lichidului de răcire prin blocurile de alezare de degroșare, finiţie și Graflex



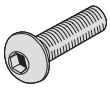
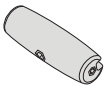
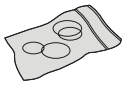
1. Șurub asamblare
5. Șurub de reglare micrometrică
3. Șurub de blocare

2. Șurub asamblare
4. Șurub de reglare a diametrului

Reper Nr.	Număr reper	Tiplul blocului de alezare	Spre semifabricat Capacitatea DCN-DCX Ø		HTB	LF	LF1	WB1	WB2	DCB	BD	Greutate	Varianta
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
A731S400	02753679	Bloc de alezare de degroșare*	204,0 *8.031*	2155,0 *84.843*	70,0 *2.756*	47,0 *1.850*	–	97,0 *3.819*	–	–	–	1,4 *3.1*	A
A731S500	02753680	Blocuri pentru alezare fină**	204,0 *8.031*	2155,0 *84.843*	70,0 *2.756*	47,0 *1.850*	–	97,0 *3.819*	–	–	–	1,5 *3.3*	B
A731S600	02753682	Contragreutate	204,0 *8.031*	2155,0 *84.843*	70,0 *2.756*	–	–	97,0 *3.819*	–	–	–	1,6 *3.5*	C
A731S40128	02753687	Graflex size G5***	48,0 *1.890*	2021,0 *79.567*	70,0 *2.756*	36,0 *1.417*	25,0 *0.984*	97,0 *3.819*	30,0 *1.181*	28,0 *1.102*	50,0 *1.969*	1,0 *2.2*	D

* Cartușe de comandat separat, consultaţi pagina (paginile) 569
** Suporturi pentru plăcuţe de alezare de finiţie, dimensiunea 60, se vor comanda separat, consultaţi pagina 548, 549
*** Când utilizaţi capul de alezare A78050, utilizaţi contragreutatea BM050W78050, consultaţi accesoriile de mai jos.

Piese de schimb, Piese incluse la livrare

Pentru	Șurub ansamblu	Șurub blocare cilindru	Cheie (tip T)	Cheie	Cheie de blocare	Inel O
						
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

Setul de garnituri inelare conţine 6 garnituri inelare de ∅ 6 mm (0.236“) pentru canalele de răcire și 1 garnitură inelară de ∅ 60 mm (2.362“) pentru alezajul de susţinere al barelor Jumbo Bridge.

Accesorii

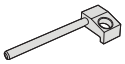
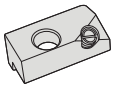
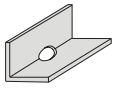
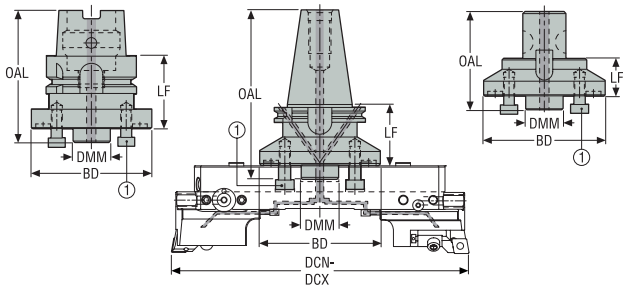
Pentru	Țeavă de conectare	Set răcire	Corner shim	Contragreutate
				
A731S400	AU731S00700	AU731S40700	18LS0316	–
A731S500	AU731S00700	–	–	–
A731S600	–	–	–	–
A731S40128	AU731S00700	–	–	BM050W78050

ABB 731 200 – Suporturi și adaptor pentru Bridge bars





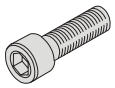
1. Șurub reglaj

– Suporturi HSK și SA pentru ansambluri scurte
– Adaptor Graflex® pentru ansambluri extinse
– Poziţia unghiulară a Bridge bar la fiecare 30°
– Livrată cu un inel de etanșare a cepului o'ring ∅ 58×3 mm

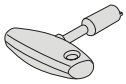
Reper Nr.	Număr reper	Machine side connection	Mărime	Spre semifabricat Capacitatea DCN-DCX Ø		OAL	LF	BD	DMM	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
E3471731200	02503392	DIN 69871-ADB	DIN50 ADB	204,0 *8.031*	655,0 *25.787*	166,75 *6.565*	65,0 *2.559*	130,0 *5.118*	40,0 *1.575*	5,9 *13.0*
E3416731200	02503393	BT JIS B 6339-ADB	BT50 ADB	204,0 *8.031*	655,0 *25.787*	166,75 *6.565*	65,0 *2.559*	130,0 *5.118*	40,0 *1.575*	5,64 *12.4*
E9306731200	02417268	ISO 12164-1/ DIN69893-A	HSK-A100	204,0 *8.031*	655,0 *25.787*	115,0 *4.528*	65,0 *2.559*	130,0 *5.118*	40,0 *1.575*	5,0 *11.0*
A731200	00056616	GRAFLEX	G7	204,0 *8.031*	655,0 *25.787*	90,0 *3.543*	40,0 *1.575*	130,0 *5.118*	40,0 *1.575*	4,0 *8.8*

Cuplu de strângere 80 Nm. Pentru mai multe detalii consultaţi instrucţiunile de utilizare livrate împreună cu Bridge bar și cu blocurile de alezare.

Piese de schimb, Piese incluse la livrare

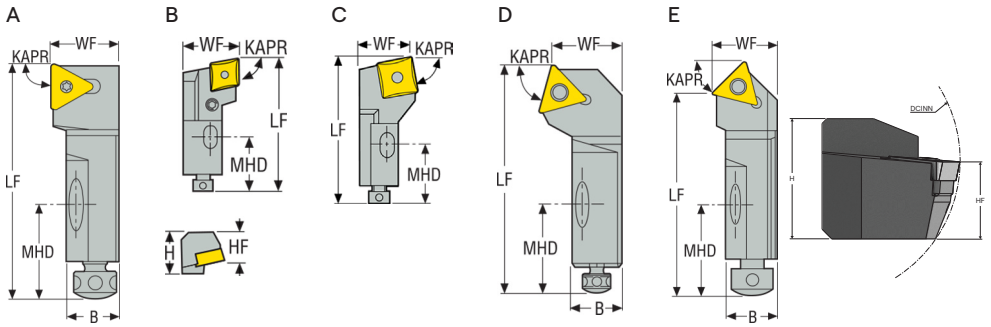
Pentru	Șurub ansamblu	Cheie	Sealing Screws	Cep
				
E3471731200	950D1230	10SMS795	950A0606	–
E3416731200	950D1230	10SMS795	950A0606	–
E9306731200	950D1230	10SMS795	–	–
A731200	950D1230	10SMS795	–	90M7

Accesorii

Pentru	Tub răcire	Dop de etanșare	Cheie fixă
			
E3471731200	–	–	–
E3416731200	–	–	–
E9306731200	20E9306	02E9306	03E9306
A731200	–	–	–

Cartuse, pentru Bridge bar, bloc de alezare de degroșare A731S400





—Pentru montarea pe blocul de alezare de degroșare

Reper Nr.	Număr reper	KAPR°	LF	MHD	WF	B	H	HF	DCINN	Greutate	Mărimea plăcuței potrivite	Varianta
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*		
SCGCL16CA-16	00039871	90,0 °	55,0 *2.165*	25,0 *0.984*	25,0 *0.984*	17,5 *0.689*	20,0 *0.787*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	CC..16..	A
STGCL16CA-16	00009197	90,0 °	63,0 *2.480*	25,0 *0.984*	24,96 *0.983*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	A
STGCL16CA-22	02600181	90,0 °	55,0 *2.165*	25,0 *0.984*	25,0 *0.984*	17,5 *0.689*	20,0 *0.787*	16,0 *0.630*	50,0 *1.969*	0,2 *0.4*	TC..2204..	A
PCGNL16CA-12	02484356	90,2 °	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	36,0 *1.417*	0,2 *0.4*	CN..12..	B
SSRCL16CA-15	00039872	75,0 °	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	20,0 *0.787*	20,0 *0.787*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	SC..15..	C
STRCL16CA-16	00008750	75,0 °	63,0 *2.480*	25,0 *0.984*	24,96 *0.983*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	D
STRCL16CA-22	02585320	75,0 °	63,0 *2.480*	25,0 *0.984*	25,0 *0.984*	17,5 *0.689*	20,0 *0.787*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..2204..	D
STTCL16CA-16	00009194	60,0 °	63,0 *2.480*	25,0 *0.984*	14,96 *0.589*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	D
STSCL16CA-16	00009193	45,0 °	53,0 *2.087*	25,0 *0.984*	24,96 *0.983*	20,0 *0.787*	25,0 *0.984*	16,0 *0.630*	60,0 *2.362*	0,2 *0.4*	TC..16T3..	E

Condiţii de prelucrare recomandate

Performanţe optime se obţin cu răcire internă (regimuri de aşchiere mari, finisare superioară a suprafeţei, evacuare mai bună a aşchiilor).

Alezarea de degroşare depinde de priorităţi: pentru avans mare sau rată mare de îndepărtare a materialului se vor regla casetele simetric (cea mai comună metodă, avans dublu faţă de reglarea asimetrică) sau se reglează asimetric (adâncime de aşchiere dublă).
La alezarea de finisare în oţel, în condiţii bune de stabilitate, se recomandă utilizarea plăcuţelor Cermet, pentru viteze mari și durată de viaţă mărită.

Pentru instrucţiunile de utilizare detaliate, verifică instrucţiunile de utilizare livrate împreună cu pachetul capului de alezat sau cu barele Steadyline®. Aceste instrucţiuni pot fi descărcate de pe www.secotools.com

Depanare

Vezi sfaturi de depanare, în capitolul capete de degroşare pag. 493, sau capitolul capete de finisare pag. 538.

Viteza maximă pentru Bridge bar

Datorită dimensiunilor foarte mari ale capetelor de alezare Bridge bar, o turaţie RPM necorespunzătoare poate duce la producerea unor accidente.
Mai jos sunt prezentate turaţiile maxime RPM pentru ansamblurile Bridge bar formate din bare Bridge (Reper Nr. A731S 0_0) pentru degroşare, pentru finisare şi blocuri contragreutate (Reper Nr. A731S _00) și bare Jumbo Bridge (Reper Nr. A731 00_).
Pentru alte asamblări vă rog să contactaţi reprezentantul Seco.

NOTĂ! La utilizarea blocurilor de alezare actuale (nr. de piesă A731S 400, A731S 500, A731S 600, A731S 40128) pe traversele de alezat de tip anterior (nr. de piesă A731 0_0 -fără S-), valoarea maximă de rotaţii pe minut care trebuie respectată este cea recomandată pentru traversele de alezat de tip anterior. Pentru a menţine echilibrul, nu combinaţi blocuri noi și anterioare pe aceeași traversă de alezat.

Cap bazat pe	Capacitate Ø mm *(inci)*	RPM max.	Viteza maximă de aşchiere implicită v_c la min Cap. m/min *(sf/min)*	Viteza maximă de aşchiere implicită v_c la max Cap. m/min *(sf/min)*
Toleranţa de fabricaţie a burghiului				
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)*
Traverse de alezat Jumbo (cu două bare de alezat identice şi capete de alezat reglate simetric)				
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)*

Notă: Vitezele maxime sunt condiţionate de conceptul mecanic al capului și de calitatea echilibrării. Vitezele cuprinse în intervalul recomandat vor fi alese ţinând cont de toate condiţiile de prelucrare, ex.: materialul semifabricatului, muchia de aşchiere, lungimea sculei, arborele maşinii.

Prezentare generală Traverse de alezare pentru bare Steadyline®



Adaptori Seco Capto™
LF 70-130 mm

Steadyline ® pentru freză cu dorn Ø 40
DIN / Seco Capto™ / HSK

Traversă SM40-BB732-011
Degroșare Ø 114-146 mm (4.488"-5.748")
Finisare Ø 114-160 mm (4.488"-6.299")

Traversă SM40-BB732-012
Degroșare Ø 145-177 mm (5.709"-6.969")
Finisare Ø 145-191 mm (5.709"-7.520")

Traversă SM40-BB732-013
Degroșare Ø 176-208 mm (6.930"-8.189")
Finisare Ø 176-222 mm (6.930"-8.740")

Traversă SM40-BB732-014
Degroșare Ø 207-239 mm (8.150"-9.410")
Finisare Ø 207-253 mm (8.150"-9.961")

Traversă SM40-BB732-015
Degroșare Ø 238-270 mm (9.370"-10.630")
Finisare Ø 238-284 mm (9.370"-11.181")

Traversă SM40-BB732-016
Degroșare Ø 176-301 mm (10.591"-11.850")
Finisare Ø 176-315 mm (10.591"-12.402")

Bloc de alezare de degroșare și cartușe
Casetă pentru plăcuța CC12 / CC16
KAPR 91,5°

Blocuri de alezare de finisare și cartușe
Casetă pentru plăcuța CC09
KAPR 95,5°

Caracteristici: Seria BB732 - Traverse de alezare pentru bare Steadyline®



Aplicaţie

— Conceput special pentru aplicaţii de alezare adâncă de până la 576 mm, acolo unde consola mare a sculei crește riscul de vibraţii.

— Alezare de degroșare 114 - 301 mm (4.488 - 11.850''). Alezare de finisare 114 - 315 mm (4.488 - 12.402'').

— Operaţie de alezare adâncă cu doar un vârf Ø 40 mm Steadyline® de la 437 la 576 mm în funcţie de combinaţie (trebuie luate în considerare condiţiile de așchiere max.) , performanţă ridicată în așchiere întreruptă (ex-corpuri de compresor, corpuri pompă).

— Este posibil să se atingă valoarea mai mare a rugozităţii în operaţiunile de alezare adâncă pe un diametru mai mare.

— Conceput pentru a fi montat pe suporturile de freză Steadyline® cu dorn de 40 mm, pentru o lungime funcţională totală de la 437 la 576 mm:
-HSK-A100
-DIN50 ADB
-BT50 TF ADB
-Seco Capto™ C8

Beneficii și caracteristici

— Aceeași traversă pentru lucrări de degroșare și finisare.

— Lichidul de răcire până la muchia de așchiere (sistemul central de răcire).

— Presiune maximă a lichidului de răcire cu Steadyline® 70 bari (1000 PSI).

— Până la IT6 (interval de toleranţă) – repetabilitate.

— Până la Ra 0,6 înalezarea de finisare.

— Pentru aplicaţii fine de alezare, precizia de setare a diametrului este de 2,5 µ pe diametru.

— Plăcuţe CC..09.. pentru alezare fină și CC..12... și CC..16.. disponibile pentru alezare de degroșare.

— În degroșare sunt posibile setări simetrice și eșalonate.

— Toate traversele sunt proiectate pentru a fi utilizate pe barele Steadyline ® cu dorn de 40 mm.
O bară specifică Steadyline® este proiectată pentru a fi montată pe suporturile de bază Seco Capto™ cu lungime funcţională de 70 până la 130 mm, pentru a ajunge la o adâncime mai mare de până la 576 mm (22,7'').

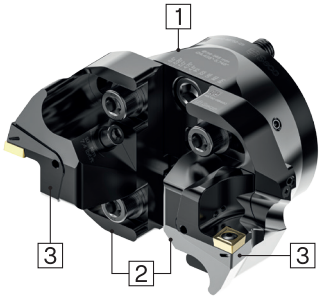
— Glisoare fixate cu șuruburi de fixare pentru a elimina riscul de ejectare centrifugală.

Construirea ansamblurilor de alezare pentru alezare de degroșare

Un sistem de traversă de alezare de degroșare necesită 1 traversă + 2 blocuri de degroșare + 2 casete identice CC12 sau CC16 pentru degroșare

Ansamblu de alezare de degroșare (fig. 5)

Asamblare		
Sr no	Produs	Cantitate
1	Traversă	1
2	Capete de alezat de degroșare	2
3	Port-plăcuță	2



Traversă

6 traverse proiectate pentru diferite diametre.
Toate traversele pot fi utilizate pentru degroșare și finisare.



Bloc de alezare de degroșare

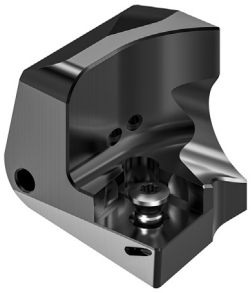
Capacitatea înspre piesă DCN Ø 114 la DCX Ø 301 mm.

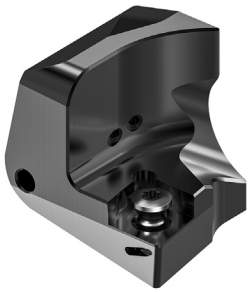
Un cap mare de alezare dublu necesită două glisoare de alezare de degroșare, fiecare echipat cu un cartuș.



Cartușe

Două dimensiuni ale casetei:
Cartușe cu CC12 și KAPR 91°
Cartușe cu CC16 și KAPR 91°



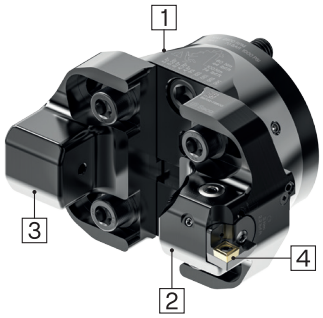


Construirea ansamblurilor de alezare pentru alezare fină

Un sistem de traversă de alezare fină necesită 1 traversă + 1 bloc de alezare fină + 1 suport de plăcuţă CC9 + 1 glisor contragreutate

Ansamblu de alezare fină (fig. 6)

Asamblare		
Sr no	Produs	Cantitate
1	Traversă	1
2	Capete pentru alezare de finisare	1
3	Contragreutate	1
4	Cartușe	1



Traversă

6 traverse proiectate pentru diferite diametre.
Toate traversele pot fi utilizate pentru degroșare și finisare.

Toate traversele pot fi utilizate numai pe suporturi SM40 (dorn de 40 mm) și un design adecvat cu SECO CAPTO.



Bloc de alezare de finisare

Capacitate înspre piesă DCN Ø 114 mm la DCX Ø 315 mm.



Contragreutate

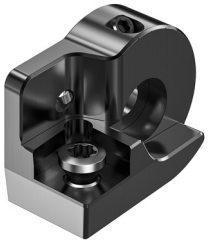
Reglaţi poziţia blocului de contragreutate pentru a fi simetric cu diametrul blocului de alezare fină, utilizând gradaţia traversei.



Cartușe

Cartușe cu plăcuţă CC09 și KAPR 95,5° proiectate pentru stabilitate.

Cartușe de prindere pe pistonul glisorului pentru fixare plăcuţei la 3 Nm sau 2,2 lbf.ft.



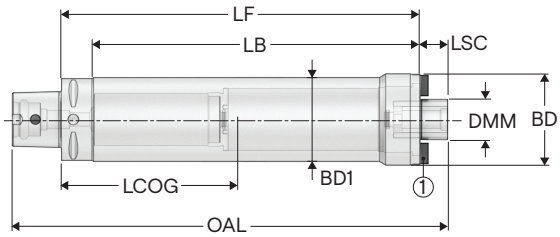
Construirea unui ansamblu Bridge bar:
Diagramă de selectare a Bridge bar pentru a construi un diametru de ALEZARE necesar

Pentru alezare DCN-DCX ∅ mm	*Pentru alezare DCN-DCX ∅ inci*	Bridge bar	Pentru alezare de degroșare		Pentru alezare de finisare	
				Fig.		Fig.
114-146	*4.488-5.748*	SM40-BB732-011	2x BB732-RB400 + 2 cartușe	5	BB732-FB500 + 1 cartușe +BB732-FB600	6
145-177	*5.709-6.969*	SM40-BB732-012				
176-208	*6.929-8.189*	SM40-BB732-013				
207-239	*8.150-9.410*	SM40-BB732-014				
238-270	*9.370-.10.630*	SM40-BB732-015				
269-301	*10.591-11.850*	SM40-BB732-016				

Bare Steadyline® adecvate pentru gama BB732

Bridge bar	Gamă diametre degroșare	Gamă diametre finisare	Lungimea funcțională secundară	Machine side connection	Suport Steadyline® spentru freză pe dorn	Greutatea totală a ansamblului KG (lbs)	Cuplu total oscilant Nm (ft lb)
SM40-BB732-011	114-146 mm (4.488- 5.748")	114-160 mm (4.488-6.300")	446,5 mm	HSK-A100	E9306555540350	23.1 (50.92)	48.7
			446,5 mm	DIN50 ADB	E3471555540350	24.2 (53.35)	49.1 (36.21)
			446,5 mm	BT50 TF ADB	E3216555540350	24.5 (54.01)	49.2 (36.22)
			446,5 mm	Seco Capto™ C8	C8-391.5555-40350	22.6 (49.82)	48.6 (35.84)
			516,5-576,5 mm	Seco Capto™ C8 + extensie suplimentară Seco Capto™	C8-SML40-350-KL1 + arborele de bază Seco Capto LF de 70 până la 130 mm	Depinde de arborele de bază Seco Capto selectat	
SM40-BB732-012	145-177 mm (5.709-6.969")	145-191 mm (5.709-7.520")	446,5 mm	HSK-A100	E9306555540350	23.9 (52.69)	51.8 (38.20)
			446,5 mm	DIN50 ADB	E3471555540350	25.0 (55.11)	52.2 (38.50)
			446,5 mm	BT50 TF ADB	E3216555540350	25.4 (55.99)	52.3 (38.57)
			446,5 mm	BT50 TF ADB	E3216555540350	25.4 (55.99)	52.3 (38.57)
			446,5 mm	Seco Capto™ C8	C8-391.5555-40350	23.4 (51.58)	51.7 (38.13)
			516,5-576,5 mm	Seco Capto™ C8 + extensie suplimentară Seco Capto™	C8-SML40-350-KL1 + arborele de bază Seco Capto LF de 70 până la 130 mm	Depinde de arborele de bază Seco Capto selectat	
SM40-BB732-013	176-208 mm (6.929-8.189")	176-222 mm (6.929-8.740")	437,5 mm	HSK-A100	E9306555540350	23.9 (52.69)	51.7 (38.13)
			437,5 mm	DIN50 ADB	E3471555540350	25.1 (55.33)	52.2 (38.50)
			437,5 mm	BT50 TF ADB	E3216555540350	25.4 (55.99)	52.2 (38.50)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	23.5 (51.80)	51.6 (38.05)
			507,5-567,5 mm	Seco Capto™ C8 + extensie suplimentară Seco Capto™	C8-SML40-350-KL1 + arborele de bază Seco Capto LF de 70 până la 130 mm	Depinde de arborele de bază Seco Capto selectat	
SM40-BB732-014	207-239 mm (8.150-9.410")	207-253 mm (8.150-9.961")	437,5 mm	HSK-A100	E9306555540350	24.6 (54.23)	54 (39.82)
			437,5 mm	DIN50 ADB	E3471555540350	25.7 (56.65)	54.5 (40.19)
			437,5 mm	BT50 TF ADB	E3216555540350	26.0 (57.32)	54.6 (40.27)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	24.1 (53.13)	53.9 (39.75)
			507,5-567,5 mm	Seco Capto™ C8 + extensie suplimentară Seco Capto™	C8-SML40-350-KL1 + arborele de bază Seco Capto LF de 70 până la 130 mm	Depinde de arborele de bază Seco Capto selectat	
SM40-BB732-015	238-270 mm (9.370-10.630")	238-284 mm (9.370-11.181")	437,5 mm	HSK-A100	E9306555540350	25.2 (55.55)	56.4 (41.59)
			437,5 mm	DIN50 ADB	E3471555540350	26.3 (57.98)	56.8 (41.89)
			437,5 mm	BT50 TF ADB	E3216555540350	26.7 (58.86)	56.9 (41.96)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	24.7 (54.45)	56.3 (41.52)
			507,5-567,5 mm	Seco Capto™ C8 + extensie suplimentară Seco Capto™	C8-SML40-350-KL1 + arborele de bază Seco Capto LF de 70 până la 130 mm	Depinde de arborele de bază Seco Capto selectat	
SM40-BB732-016	269-301 mm (10.591-11.850")	269-315 mm (10.591-12.402")	437,5 mm	HSK-A100	E9306555540350	25.8 (56.87)	58.2 (42.92)
			437,5 mm	DIN50 ADB	E3471555540350	26.9 (59.30)	58.7 (43.29)
			437,5 mm	BT50 TF ADB	E3216555540350	27.3 (60.18)	58.7 (43.29)
			437,5 mm	Seco Capto™ C8	C8-391.5555-40350	25.4 (55.99)	58.1 (42.85)
			507,5-567,5 mm	Seco Capto™ C8 + extensie suplimentară Seco Capto™	C8-SML40-350-KL1 + arborele de bază Seco Capto LF de 70 până la 130 mm	Depinde de arborele de bază Seco Capto selectat	





1. Știft

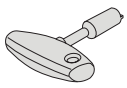
Reper Nr.	Număr reper	Mărime	DMM	LF	BD	BD1	LCOG	OAL	LB	LSC	RPM max.	RFID hole	Echilibrare	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
E9306555540350	02753468	HSK-A100	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	178,9 *7.043*	427,0 *16.811*	321,0 *12.638*	27,0 *1.063*	3000	1	PB	19,4 *42.8*
E3216555540350	02926043	BT50 TF ADB	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	169,0 *6.654*	478,8 *18.850*	312,0 *12.283*	27,0 *1.063*	3000	1	PB	20,7 *45.6*
E3471555540350	02753471	DIN50 ADB	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	171,4 *6.748*	478,75 *18.848*	330,9 *13.028*	27,0 *1.063*	3000	1	PB	20,4 *45.0*
C8-391.5555-40350	02753473	C8	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	89,0 *3.504*	182,6 *7.189*	425,0 *16.732*	317,0 *12.480*	27,0 *1.063*	3100	1	PB	19,0 *41.9*
C8-SML40-350-KL1	10249301	C8	40,0 *1.575*	350,0 *13.780*	89,0 *3.504*	82,0 *3.228*	189,5 *7.461*	425,0 *16.732*	320,0 *12.598*	27,0 *1.063*	2800	1	PB	15,5 *34.2*

Verificaţi greutatea ansamblului și cuplul oscilant

Piese de schimb, Piese incluse la livrare

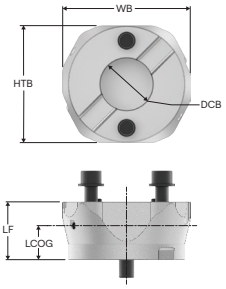
Pentru	Șurub	Sealing Screws	Cep
			
E930..	950D0616	–	16C2161621A
E321..	950D0616	950A0606	16C2161621A
E347..	950D0616	950A0606	16C2161621A
C8-391..	950D0616	–	16C2161621A
C8-SML..	950D0616	–	16C2161621A

Accesorii

Pentru	Tub răcire	Dop de etanșare	Cheie fixă 3
			
E930..	20E9306	02E9306	03E9306
E321..	–	–	–
E347..	–	–	–
C8-391..	–	–	–
C8-SML..	–	–	–

BB73201x – Bridge bar pentru alezare adâncă





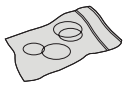
—A se monta pe un suport Steadyline® pentru freză cu dorn de 40 mm, vezi pag. 577
—Lichid de răcire prin Bridge bar

Reper Nr.	Număr reper	DCN	DCX	HTB	WB	DCB	LF	LCOG	Greutate
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
SM40-BB732-011	10270854	114,0 *4.488*	146,0 *5.748*	90,0 *3.543*	98,0 *3.858*	40,0 *1.575*	44,0 *1.732*	25,39 *1.000*	2,0 *4.4*
SM40-BB732-012	10270855	145,0 *5.709*	177,0 *6.969*	90,0 *3.543*	129,0 *5.079*	40,0 *1.575*	44,0 *1.732*	25,46 *1.002*	2,9 *6.4*
SM40-BB732-013	10270856	176,0 *6.929*	208,0 *8.189*	104,0 *4.094*	160,0 *6.299*	40,0 *1.575*	35,0 *1.378*	20,95 *0.825*	2,9 *6.4*
SM40-BB732-014	10270857	207,0 *8.150*	239,0 *9.409*	104,0 *4.094*	191,0 *7.520*	40,0 *1.575*	35,0 *1.378*	21,22 *0.835*	3,6 *7.9*
SM40-BB732-015	10270858	238,0 *9.370*	270,0 *10.630*	104,0 *4.094*	222,0 *8.740*	40,0 *1.575*	35,0 *1.378*	21,38 *0.842*	4,2 *9.3*
SM40-BB732-016	10270859	269,0 *10.591*	301,0 *11.850*	104,0 *4.094*	253,0 *9.961*	40,0 *1.575*	35,0 *1.378*	21,5 *0.846*	4,8 *10.6*

Cuplu de strângere 100 Nm (74 lbf. Ft)
Pentru mai multe detalii consultaţi instrucţiunile de utilizare livrate împreună cu Bridge bar şi cu blocurile de alezare.

Max RPM, consultaţi pag. 570

Piese de schimb, Piese incluse la livrare

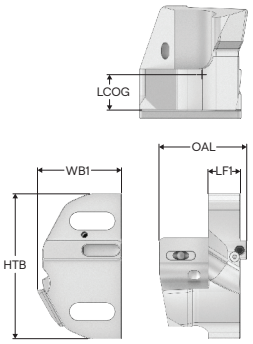
Pentru	Set
	
SM40..011	90BB01
SM40..012	90BB01
SM40..013	90BB02
SM40..014	90BB02
SM40..015	90BB02
SM40..016	90BB02

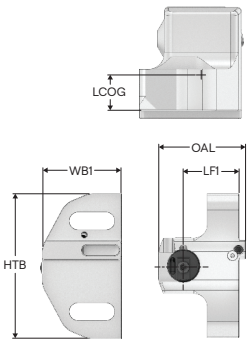
Accesorii

Pentru	Cheie clemă	Cheie de blocare
		
SM40..011	03HL10	03HL08
SM40..012	03HL10	03HL08
SM40..013	03HL10	03HL08
SM40..014	03HL10	03HL08
SM40..015	03HL10	03HL08
SM40..016	03HL10	03HL08

BB732 - Blocuri de alezare de degroșare și finisare pentru Bridge bar BB732





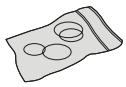


—A se asambla pe traversa BB732
—Lichid de răcire prin blocuri de alezare de degroșare și finisare
—Un ansamblu de alezare de degroșare necesită două blocuri de alezare de degroșare
—Un ansamblu de alezare de finisare necesită un bloc de alezare de finisare și o contragreutate

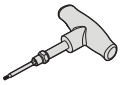
Reper Nr.	Număr reper	Tiplul blocului de alezare	Spre semifabricat Capacitatea DCN-DCX Ø		LCOG	HTB	OAL	LF1	WB1	Greutate
			mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*
BB732-RB400	10270863	Bloc de alezare de degroșare	114,0 *4.488*	301,0 *11.850*	16,04 *0.631*	90,0 *3.543*	54,5 *2.146*	20,0 *0.787*	52,0 *2.047*	0,7 *1.5*
BB732-FB500	10270864	Blocuri pentru alezare fină	114,0 *4.488*	315,0 *12.402*	17,97 *0.707*	90,0 *3.543*	54,0 *2.126*	34,5 *1.358*	48,95 *1.927*	0,8 *1.8*
BB732-FB600	10270865	Contragreutate	114,0 *4.488*	315,0 *12.402*	18,36 *0.723*	90,0 *3.543*	54,0 *2.126*	–	48,95 *1.927*	0,8 *1.8*

Cartușe de comandat separat, consultaţi pagina (paginile) 569

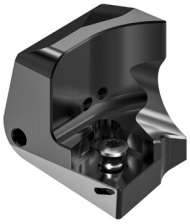
Piese de schimb, Piese incluse la livrare

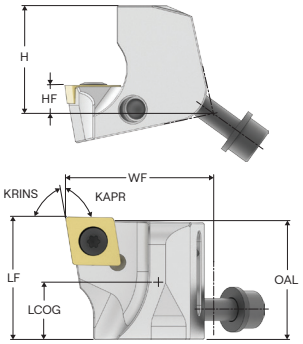
Pentru	Set
	
BB732-RB400	–
BB732-FB500	90FB00
BB732-FB600	–

Accesorii

Pentru	Klucz	Cheie de blocare	Cheie dinamometrică
			
BB732-RB400	03H03	03HL08	H00T-50100
BB732-FB500	–	03HL08	H00-3030
BB732-FB600	03H03	03HL08	–

Cartuse pentru degroșare, pentru blocurile de degroșare Bridge bar BB732-RB400

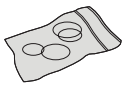




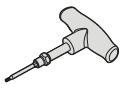
—A se asambla pe un bloc de alezare de degroșare pentru BB732

Reper Nr.	Număr reper	KAPR°	KRINS°	Spre semifabricat Capacitatea DCN-DCX Ø		H	HF	WF	LF	LCOG	OAL	Greutate	Mărimea plăcuței potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
BB732-RB400-CC1291	10270860	91.0 °	80.0	114,0 *4.488*	301,0 *11.850*	28,0 *1.102*	7,53 *0.296*	38,445 *1.514*	32,5 *1.280*	14,82 *0.583*	31,56 *1.243*	0,2 *0.4*	CC..12..
BB732-RB400-CC1691	10270862	91.0 °	80.0	114,0 *4.488*	301,0 *11.850*	28,0 *1.102*	7,52 *0.296*	38,445 *1.514*	32,5 *1.280*	14,54 *0.572*	31,42 *1.237*	0,2 *0.4*	CC..16..

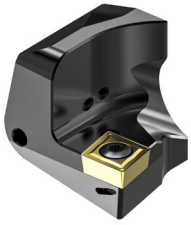
Piese de schimb, Piese incluse la livrare

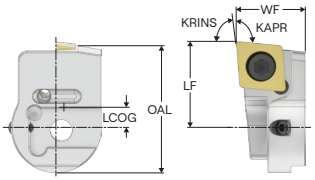
Pentru	Set
	
BB732-RB400-CC1291	90RB01
BB732-RB400-CC1691	90RB01

Accesorii

Pentru	Klucz	Cheie clemă	Cheie (șurubelniță)	Cheie dinamometrică
				
BB732-RB400-CC1291	03H03	H00T-50100	T15P-2D	T00-15P50
BB732-RB400-CC1691	03H03	–	T15P-2D	H00T-50100

Cartuse pentru finisare, pentru blocurile de finisare Bridge bar BB732-FB500

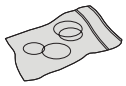




—A se asambla pe un bloc de alezare de finisare pentru BB732

Reper Nr.	Număr reper	KAPR°	KRINS°	Spre semifabricat Capacitatea DCN-DCX Ø		WF	LF	LCOG	OAL	Greutate	Mărimea plăcuței potrivite
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	kg *lbs*	
BB732-FB500-CC0995	10270861	95.5 °	80.0	114,0 *4.488*	315,0 *12.402*	14,5 *0.571*	18,0 *0.709*	4,18 *0.165*	26,44 *1.041*	0,1 *0.2*	CC..09..

Piese de schimb, Piese incluse la livrare

Pentru	Set
	
BB732-FB500-CC0995	90FB01

Accesorii

Pentru	Klucz	Cheie (șurubelniță)	Cheie dinamometrică
			
BB732-FB500-CC0995	03H03	T15P-2	H00-3030

Date de așchiere și linii directoare

Trebuie respectate valorile de pornire recomandate pentru inserţiile și gradele enumerate pe cutia de inserţii, dar trebuie luaţi în considerare mulţi parametri, cum ar fi consola lungă a sculei, utilizarea tehnologiei Steadyline®, materialul piesei de prelucrat, forţa de prindere a interfeţei fusului mașinii, capacitatea cuplului la turaţia dată, puterea netă (...).

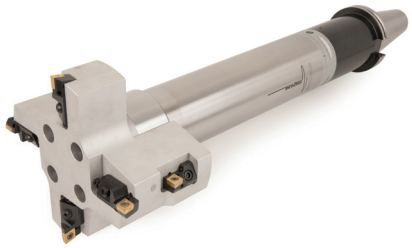
Combinaţia acestor parametri poate necesita modificări ale condiţiilor obișnuite de așchiere în comparaţie cu aplicaţiile mai convenţionale. Contactaţi reprezentantul Seco local pentru asistenţă în optimizarea parametrilor de așchiere pentru aceste operaţii sensibile.

Toate traversele pot fi utilizate numai pe suporturi SM40 (dorn de 40 mm) și un design adecvat cu SECO CAPTO.

Nu utilizaţi turaţia maximă la cuplul maxim de așchiere.

Soluţii personalizate pentru alezare

Seco Tools are o experienţă solidă în execuţia de soluţii de alezare personalizate:



— Soluţii antivibraţii Steadyline® pentru alezare de degroșare și de precizie,
— Bare de alezat cu mai multe muchii,
— Extensii speciale cu manșoane de ghidare, pentru operaţiuni cu consolă lungă,
— Bare combinate pentru operaţii de găurire, alezare adâncă, șanfrenare, alezare, filetare...

Pentru mai multe informaţii contactaţi agentul Seco de pe zona dvs.

Selectarea unei plăcuţe pentru alezare

Aceasta este o selecţie a plăcuţelor din gama Seco, care sunt potrivite pentru alezare. Mărimea selectată a plăcuţei este cea potrivită pentru gama de capete de alezare.
Plăcuţele pentru degroșare au o mare rezilienţă pentru a îndepărta mult material și au geometrie pozitivă pentru reducerea cuplului necesar la arbore.

Plăcuţele pentru finisare au geometri pozitive, muchii ascuţite și rezistente la uzură pentru controlul exact al toleranţei, geometriei și finisării suprafeţei găurii.

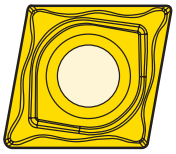
Codificare, exemple

CCMT120408	–	M3	–	TP3501
1		2		3

1.
Mărime (ISO designation)

2.
Geometria

3.
Calitate Seco



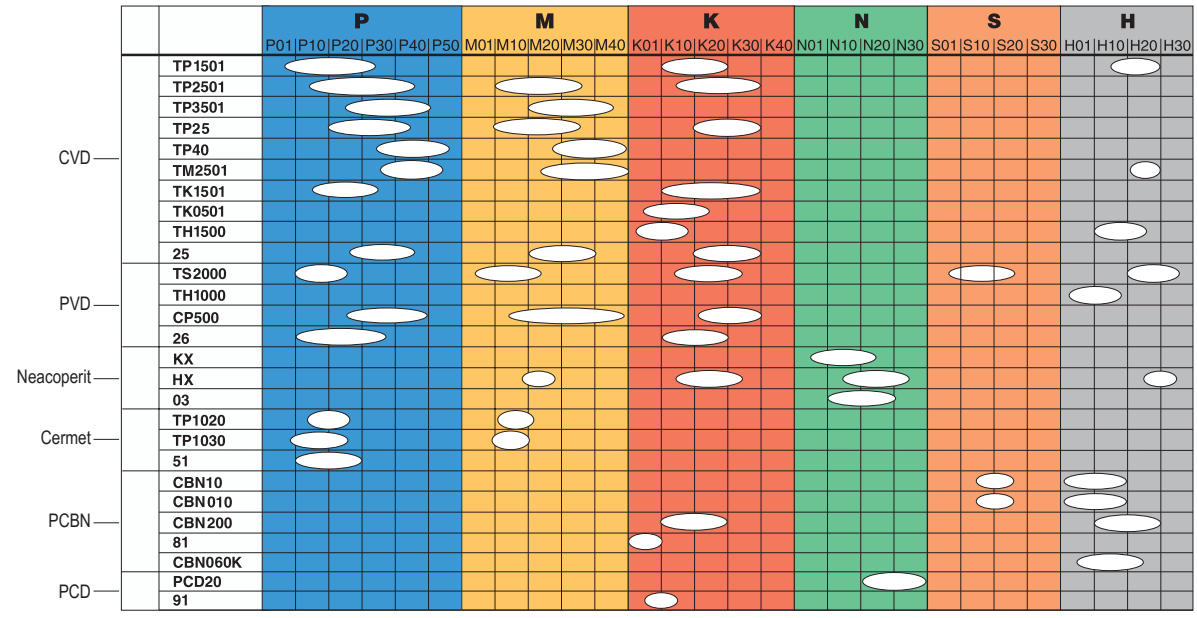
CCGT09T304	–	03	–	G3
1		2		3

1.
Mărime (ISO designation)

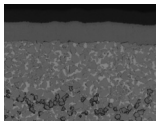
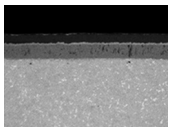
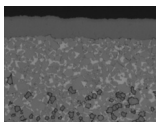
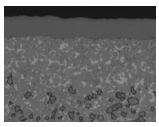
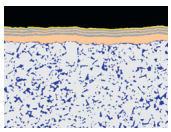
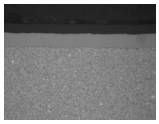
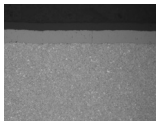
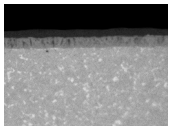
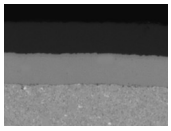
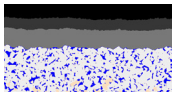
2.
Calitate

3.
Geometria port-sculelor

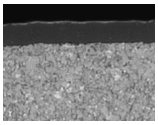
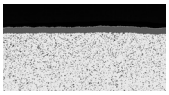
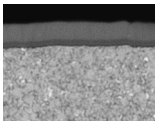
Calităţi de plăcuţe pentru alezare - clasificarea ISO a materialului semifabricatului



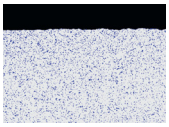
Clasele acoperite CVD recomandate pentru alezare

TP1501		Tehnologie **Duratomic®** de calitate acoperită. Calitate cu rezistenţă foarte mare la căldură și uzură pentru prelucrări generale de strunjire în oţeluri și o soluţie de rezervă pentru alte grupe de material. Ti(C,N) + Al_2O_3 + ...
TP25		Calitate universală cu performanţe mari într-o gamă largă de aplicaţii în oţel, oţel inoxidabil și fomtă. O alternativă de încredere atunci când vitezele de așchiere sunt limitate sau când se cere o finisare superioară a suprafeţei. Ti(C,N) + Al_2O_3 + Detectarea muchiilor utilizate (Chrome)
TP2501		Tehnologie **Duratomic®** de calitate acoperită. Calitate cu rezistenţă mare la uzură cu muchie puternică pentru o gmă largă de aplicaţii de strunjire în oţel, oţel inoxidabil și fontă. Ti(C,N) + Al_2O_3 + ...
TP3501		TP3501 este destinată aplicaţiilor de strunjire în cazul în care cererea principală este pentru rezilienţă și fiabilitate în oţel și oţel inoxidabil. Ti(C,N) + Al_2O_3 DURATOMIC®
TP40		TP40 este calitatea de bază pentru strunjire în intervalul P40. Calitate foarte tenace pentru operaţiuni solicitante în piese turnate și forjare din oţel, precum și în toate tipurile de oţel inoxidabil. TiC/Ti(C,N) + TiN
TK0501		Tehnologie **Duratomic®** de calitate acoperită. Calitate extrem de rezistentă la uzură optimizată pentru prelucrarea fontei cenușii și a fontei nodulare. Ti(C,N) + Al_2O_3 + Detectarea muchiilor utilizate (Chrome)
TK1501		Tehnologie **Duratomic®** de calitate acoperită. Calitate foarte rezistentă la uzură pentru prelucrarea fontei și a oţelurilor. Calitate pentru prelucrarea fontei nodulare în aplicaţii solicitante și cu așchiere intermitentă. Ti(C,N) + Al_2O_3 + Detectarea muchiilor utilizate (Chrome)
TM2501		Calitate Duratomic®. Foarte capabilă pentru strunjirea oţelului inoxidabil cu o combinaţie de rezistenţă mare la uzură și o tenacitate mare a muchiei. Prima alegere pentru strunjirea oţelului inoxidabil austenitic. Complementară pentru strunjirea oţelului cu intermitenţe mari. Ti(C,N) + Al_2O_3 + Detectarea muchiilor utilizate (Chrome)
TH1500		Tehnologie DURATOMIC® de calitate acoperită. Calitate foarte dură cu granulaţie superfină pentru debitarea oţelului călit și o alternativă pentru finisarea fontei. Ti(C,N) + Al_2O_3
25		Calitate universală. Calitate proiectată pentru o gamă largă de aplicaţii de alezare în oţel, oţel inoxidabil și fontă. O combinaţie bună de rezistenţă la uzură și tenacitate. Ti (C, N) + Al2O3.

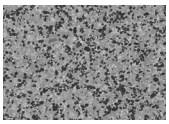
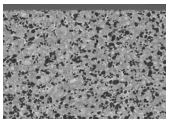
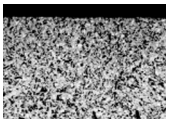
Clasele acoperite PVD recomandate pentru alezare

TS2000		Microstructură dură destinată în principal operaţiunilor de finisare a superaliajelor și aliajelor de titan. De asemenea, se descurcă bine în operaţiunile de finisare în oţel inoxidabil. (Ti,al)N + TiN
CP500 & 26G6		Un calitare foarte tenace destinată finisării și degroșării medii a oţelului inoxidabil. Poate gestiona foarte bine operaţiile de aşchiere intermitentă. CP500 este, de asemenea, o alternativă pentru aliajele de aluminiu. (Ti,al)N + TiN
TH1000		Calitate foarte dură cu granulaţie superfină pentru debitarea componentelor din oţel călit sau superaliaje, iar datorită tenacităţii muchiei de aşchiere se pretează la aşchiere intermitentă sau la aşchierea matrialelor cu crustă.

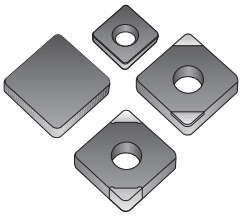
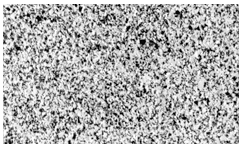
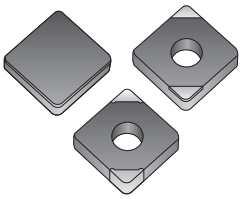
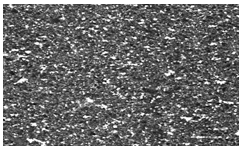
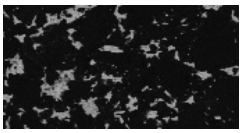
Clasele neacoperite recomandate pentru alezare

KX & 03G3		Microstructură destinată prelucrării aluminiului și altor materiale neferoase.
HX		Calitate universală neacoperită pentru prelucrarea fontei și oţelului călit, cu rezultate bune și în materiale neferoase.

Cermet recomandat pentru alezare

TP1020		Cermet cu rezistenţă la uzură foarte ridicată, destinat celor mai înalte cerinţe de finisare a suprafeţei, cu predictibilitate și control în oţel și oţel inoxidabil.
TP1030		Cermet cu acoperire PVD cu rezistenţă la uzură foarte ridicată, destinat celor mai înalte cerinţe de finisare a suprafeţei, cu predictibilitate și control în oţel și oţel inoxidabil. Acoperire nanolaminată Ti-Al-Si-N
51G1		Cermet cu acoperire PVD cu o rezistenţă la uzură foarte mare. Destinat pentru operaţii de finisare în oţeluri, acolo unde apar cerinţe stricte la finisarea suprafeţei.

Clasele CBN și PCD recomandate pentru alezare

CBN010		Format: Solid, faţă completă sau vârfuri brazate (o singură faţă sau două feţe). Compoziţie: 50% cBN cu mărimea medie a grăunţilor de 2 µm într-un liant ceramic TiC. Acoperirea: Fără acoperire.
CBN10 & 81B1		Calitate CBN, nitrură cubică de bor, pentru prelucrări ușoare continue sau cu întreruperi moderate. Destinat pentru alezarea fină în oţel călit și în superaliaje.
CBN060K		Solid, vârfuri brazate (faţă simplă și faţă dublă) sau strat sinterizat. Prima opţiune pentru aşchierile continue până la moderat întrerupte în oţel călit (a_p < 0,5 mm). Noua acoperire PVD (Ti,Si)N dezvoltată pentru prelucrare de mare viteză. Un nou liant unic de superaliaj.
CBN200		Format: Faţă completă sau vârfuri brazate (o singură parte). Compoziţie: 85% CBN cu mărimea medie a grăunţilor de 2 µm într-un liant ceramic Co-W-Al. Acoperirea: Fără acoperire.
PCD20 & 91J3		PCD, diamant policristalin, pentru alezarea aluminiului și aliaje de aluminiu, alamă, bronz și materiale sintetice.

Plăcuţe, recomandate pentru finisare, cu parametri de aşchierere

Reper Nr.	Neacoperite, flanc rectificat şi fragmentator de aşchii presat			Acoperită Fragmentator presat					Acoperită Flanc rectificat cu fragmentator Aşchiere pe stânga	Adâncimea de aşchiere a_p mm *(inci)*	Picioare pe dinte f mm *(inci)*
	KX	HX	03D3	TP2501	TP3501	TP40	25C4	TK1501	CP500		
CPGT050204			02434654							2 *(0.079)*	0,08-0,2 *(0.0031-0.0079)*
CCMT060204-F1				02960857	03095430	00008505		03062942	00096854	2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060204-F2		74011732				74018652				2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCGT060204L-UX									02497631	2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCGT060204F-AL	00015710									2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060204-M3				02960858	03095431			03062944		2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT09T308-F1				02960861	03095443	00008518		03063857	00096858	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT09T308-MF2				02956309	03095446				02754822	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCGT09T304L-UX									02497640	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCGT09T308F-AL	00015754									2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT120408-F1				02960854	03095449			03062626		4 *(0.157)*	0,15-0,4 *(0.0059-0.0157)*
CCMT120408-MF2				02956311	03095452					4 *(0.157)*	0,15-0,4 *(0.0059-0.0157)*
CCGT120408L-UX									02610062	4 *(0.157)*	0,15-0,4 *(0.0059-0.0157)*
CCGT120408F-AL	00015790									5 *(0.197)*	0,15-0,4 *(0.0059-0.0157)*
SCMT060204-M3				02960423	03096621					2,5 *(0.098)*	0,1-0,22 *(0.0039-0.0087)*
SCMT09T308-F1				02960396	03096625			03062629	00099708	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
SCMT09T308-MF2				02956318	03096627				02755042	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
SCMT120408-F1				02960397	03096630				00099804	4 *(0.157)*	0,15-0,4 *(0.0059-0.0055)*
SCMT120408-M3				02960429	03096631			03063990		4 *(0.157)*	0,15-0,4 *(0.0059-0.0055)*
TCMT16T308-F1				02960408	03096643				00091357	5 *(0.197)*	0,15-0,4 *(0.0059-0.0055)*
TCMT16T308-MF2				02956323	03096645				02755046	5 *(0.197)*	0,15-0,4 *(0.0059-0.0055)*
TCGT16T308F-AL	00015875									4 *(0.157)*	0,15-0,4 *(0.0059-0.0055)*
SCMT150512-F2						74007348				7 *(0.276)*	0,2-0,5 *(0.0079-0.0197)*

Pentru regimurile de aşchiere, vezi pag. -. 592-595

Plăcuţe CN.., recomandate pentru degroșare (două feţe)

Reper Nr.	Acoperită Fragmentator presat				Adâncimea de așchiere a_p mm *(inci)*	Picioare pe dinte f mm *(inci)*
	TP3500	TP40	TM2501	TP25		
CNMG120408-M3			03275990	03275989	4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF3		74030598	03275999	03275998	4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF4			03273904		4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MF1			03275995		4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*
CNMG120408-MR7		74017309	03276001		4,5 *(0.177)*	0,25-0,35 *(0.00984-0.01378)*

Pentru regimurile de așchiere, vezi pag. -. 592-595

Plăcuţe, recomandate pentru finisare, cu parametri de aşchierere

Reper Nr.	Acoperită							Cermet			Adâncimea de aşchiere a_p mm *(inci)*	Picioare pe dinte f mm *(inci)*
	TP1501	TS2000	TK1501	CP500	26G6	TH1000	TH1500	51G1	TP1020	TP1030		
CCGT060200								00083915			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT0602005-F1				02430287							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060201-F1				02430307							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060202					00039546			00096634			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204					00081826			00048334			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204L-UX				02497631							2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060202-F1	02960383	02614299		00096853					02754786	02754435	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT060204-F1	02960856	02615873	03062942	00096854		02825858			02754791	02754792	2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMW060202F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW060204F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060202S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204E-L1-B											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T301-F1				02430311							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T302					00048337			00048339			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304					00077338			00048344			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304L-UX				02497640							2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT09T302-F1	02960837			00096856					02754805	02754806	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T304-F1	02960844	02615874	03063856	00096857		02731806			02754811	02754812	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T308-F1	02960853	02615876	03063857	00096858		02731807				02754821	2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMW09T304F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW09T308F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304E-L1-B											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308E-L1-B											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110204								00000721			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110201-F1				02430376							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110202-F1				02430419							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110204-F1	02960401			02430421							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110208-F1	02960403			00098986							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204E-L1-C											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208E-L1-C											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208S-01020-LF											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMW110204F-L1											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030100								00083089			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102								00091845			0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102L				02416632							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGW030102											0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*

Tabelul continuă pe pagina următoare.

Pentru regimurile de aşchiere, vezi pag. -. 592-595

Plăcuţe, recomandate pentru finisare, cu parametri de aşchierere

Reper Nr.	CBN				PCD		Adâncimea de aşchiere a_p mm *(inci)*	Picioare pe dinte f mm *(inci)*
	CBN010	CBN060K	CBN200	81B1	PCD20	91J3		
CCGT060200							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT0602005-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060201-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060202							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT060204L-UX							2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMT060202-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT060204-F1							2 *(0.079)*	0,1-0,22 *(0.0039-0.0087)*
CCMW060202F-L1					00089760		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW060204F-L1					00005684		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060202S-01020-LF			02464698				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204S-01020-LF	02916281		02464699				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW060204E-L1-B	02843086	02776337	02649599				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T301-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T302							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGT09T304L-UX							2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMT09T302-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T304-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMT09T308-F1							2,5 *(0.098)*	0,1-0,3 *(0.0039-0.0118)*
CCMW09T304F-L1					00005686		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCMW09T308F-L1					00095357		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304E-L1-B	02843126	02776338	02649607				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308E-L1-B	02937148		02649608				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T304S-01020-LF	02916282		02464702				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
CCGW09T308S-01020-LF			02464703				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110204							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGT110201-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110202-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110204-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMT110208-F1							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204E-L1-C	02848657	02776346					0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208E-L1-C	02848792						0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110204S-01020-LF			02464742				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCGW110208S-01020-LF			02464744				0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
TCMW110204F-L1					00005689		0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030100							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGT030102L							0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*
WBGW030102				00096761		00096763	0,01-0,3 *(0.000394-0.01181)*	0,03-0,15 *(0.0011811-0.0059055)*

Pentru regimurile de aşchiere, vezi pag. -. 592-595

Viteze de tăiere recomandate pentru alezare (legate de materialul piesei de prelucrat și calitatea plăcuței) – metric

SMG	v_c (m/min)										
	KX & HX	03	TP40	TP1501	TP2501	TP3501	TK0501	TK1501	TH1000	TH1500	CP500
P1			60-180	60-350	60-250	60-230					80-200
P2			60-180	60-350	60-250	60-230					80-200
P3			60-180	60-350	60-250	60-230					80-200
P4			60-180	60-350	60-250	60-230					80-200
P5			60-150	60-300	60-250	60-230					80-200
P6			60-140	60-300	60-230	60-200					80-180
P7			60-140	60-300	60-230	60-200					80-160
P8			60-120	60-250	60-230	60-200					80-130
P11			60-120	60-300	60-250	60-200					80-180
M1			60-130	100-200	60-200	60-200					60-160
M2			60-130	100-200	60-200	60-200					60-160
M3			60-120	100-180	60-200	60-200					60-150
M4			60-110	100-180	60-190	60-190					60-150
M5			60-110	100-180	60-180	60-180					60-150
K1			60-140	100-250		60-180	60-230	60-230			60-160
K2			60-140	100-250		60-180	60-230	60-230			60-160
K3			60-140	100-250		60-180	60-230	60-230			60-160
K4			60-140	100-250		60-180	60-200	60-200			60-160
K5			60-140	100-250		60-180	60-200	60-200			60-160
K6			60-130	100-250		60-180	60-200	60-200			60-160
K7			60-130	100-250		60-180	60-200	60-200			60-160
N1	150-800	150-800									150-800
N2	150-800	150-800									150-800
N3	150-500	150-500									150-500
N11	150-400	150-400									150-400
S1	20-50	20-50									20-50
S2	20-50	20-50									20-50
S3	20-50	20-50									20-50
S11	20-50	20-50									20-50
S12	20-50	20-50									20-50
S13	20-50	20-50									20-50
H3									50-150	50-150	
H5									50-140	50-140	
H7									50-150	50-150	
H8									30-130	30-130	
H11									30-120	30-120	
H12									30-120	30-120	
H21											
H31											

SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

Viteze de tăiere recomandate pentru alezare (legate de materialul piesei de prelucrat și calitatea plăcuţei) – *Inci*

SMG	v_c *(sf/min)*										
	KX & HX	03	TP40	TP1501	TP2501	TP3501	TK0501	TK1501	TH1000	TH1500	CP500
P1			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P2			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P3			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P4			*197-591*	*197-1148*	*197-820*	*197-755*					*262-656*
P5			*197-492*	*197-984*	*197-820*	*197-755*					*262-656*
P6			*197-459*	*197-984*	*197-755*	*197-656*					*262-591*
P7			*197-459*	*197-984*	*197-755*	*197-656*					*262-525*
P8			*197-394*	*197-820*	*197-755*	*197-656*					*262-427*
P11			*197-394*	*197-984*	*197-820*	*197-656*					*262-591*
M1			*197-427*	*328-656*	*197-656*	*197-656*					*197-525*
M2			*197-427*	*328-656*	*197-656*	*197-656*					*197-525*
M3			*197-394*	*328-591*	*197-656*	*197-656*					*197-492*
M4			*197-361*	*328-591*	*197-623*	*197-623*					*197-492*
M5			*197-361*	*328-591*	*197-591*	*197-591*					*197-492*
K1			*197-459*	*328-820*		*197-591*	*197-755*	*197-755*			*197-525*
K2			*197-459*	*328-820*		*197-591*	*197-755*	*197-755*			*197-525*
K3			*197-459*	*328-820*		*197-591*	*197-755*	*197-755*			*197-525*
K4			*197-459*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
K5			*197-459*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
K6			*197-427*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
K7			*197-427*	*328-820*		*197-591*	*197-656*	*197-656*			*197-525*
N1	*492-2625*	*492-2625*									*492-2625*
N2	*492-2625*	*492-2625*									*492-2625*
N3	*492-1640*	*492-1640*									*492-1640*
N11	*492-1312*	*492-1312*									*492-1312*
S1	*66-164*	*66-164*									*66-164*
S2	*66-164*	*66-164*									*66-164*
S3	*66-164*	*66-164*									*66-164*
S11	*66-164*	*66-164*									*66-164*
S12	*66-164*	*66-164*									*66-164*
S13	*66-164*	*66-164*									*66-164*
H3									*164-492*	*164-492*	
H5									*164-459*	*164-459*	
H7									*164-492*	*164-492*	
H8									*98-427*	*98-427*	
H11									*98-394*	*98-394*	
H12									*98-394*	*98-394*	
H21											
H31											

SMG = Grupa de material Seco v_c= m/min Toţi parametri de așchiere sunt valori de start.

Viteze de tăiere recomandate pentru alezare (legate de materialul piesei de prelucrat și calitatea plăcuței) – metric

SMG	v_c (m/min)												
	26	25	TS2000	TP1020	TP1030	51	CBN10/ CBN010	81	CBN200	82	PCD20	91	Axiabore
P1	80-200	60-180		100-350	100-350	100-350							80-250
P2	80-200	60-180		100-350	100-350	100-350							80-250
P3	80-200	60-180		100-350	100-350	100-350							80-250
P4	80-200	60-180		100-350	100-350	100-350							80-250
P5	80-200	60-180		100-350	100-350	100-350							70-230
P6	80-180	60-160		100-300	100-300	100-300							70-230
P7	80-160	60-160		100-250	100-250	100-250							70-230
P8	80-130	60-130		100-250	100-250	100-250							70-200
P11	80-180	60-150		100-300	100-300	100-300							70-200
M1	60-160	60-140	60-200	80-200	80-200	80-200							60-200
M2	60-160	60-140	60-200	80-200	80-200	80-200							60-200
M3	60-150	60-130	60-200	80-200	80-200	80-200							60-180
M4	60-150	60-120	60-180	80-180	80-180	80-180							60-170
M5	60-150	60-120	60-180	80-180	80-180	80-180							60-170
K1	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K2	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K3	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K4	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-130
K5	60-160	60-160		100-250	100-250	100-250							50-100
K6	60-160	60-160		100-180	100-180	100-180							50-100
K7	60-160	60-160		100-180	100-180	100-180							50-100
N1	150-800										300-1500	300-1500	200-800
N2	150-800										300-1500	300-1500	200-800
N3	150-500										200-800	200-800	200-800
N11	150-400										180-800	180-800	200-800
S1	20-50		20-80										20-60
S2	20-50		20-80										20-60
S3	20-50		20-80										60-50
S11	20-50		20-80										20-50
S12	20-50		20-80										20-50
S13	20-50		20-80										20-50
H3							80-180	80-180					
H5							80-200	80-200					
H7							80-150	80-150					
H8							80-150	80-150					
H11													
H12													
H21													
H31													

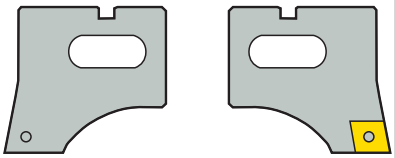
SMG = Grupa de material Seco v_c= m/min Toți parametri de așchiere sunt valori de start.

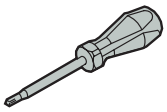
Viteze de tăiere recomandate pentru alezare (legate de materialul piesei de prelucrat şi calitatea plăcuţei) – *Inci*

SMG	v_c *(sf/min)*												
	26	25	TS2000	TP1020	TP1030	51	CBN10/ CBN010	81	CBN200	82	PCD20	91	Axiabore
P1	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P2	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P3	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P4	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*262-820*
P5	*262-656*	*197-591*		*328-1148*	*328-1148*	*328-1148*							*230-755*
P6	*262-591*	*197-525*		*328-984*	*328-984*	*328-984*							*230-755*
P7	*262-525*	*197-525*		*328-820*	*328-820*	*328-820*							*230-755*
P8	*262-427*	*197-427*		*328-820*	*328-820*	*328-820*							*230-656*
P11	*262-591*	*197-492*		*328-984*	*328-984*	*328-984*							*230-656*
M1	*197-525*	*197-459*	*197-656*	*262-656*	*262-656*	*262-656*							*197-656*
M2	*197-525*	*197-459*	*197-656*	*262-656*	*262-656*	*262-656*							*197-656*
M3	*197-492*	*197-427*	*197-656*	*262-656*	*262-656*	*262-656*							*197-591*
M4	*197-492*	*197-394*	*197-591*	*262-591*	*262-591*	*262-591*							*197-558*
M5	*197-492*	*197-394*	*197-591*	*262-591*	*262-591*	*262-591*							*197-558*
K1	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-492*
K2	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-492*
K3	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-492*
K4	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*			*984-3281*	*984-3281*			*197-427*
K5	*197-525*	*197-525*		*328-820*	*328-820*	*328-820*							*164-328*
K6	*197-525*	*197-525*		*328-591*	*328-591*	*328-591*							*164-328*
K7	*197-525*	*197-525*		*328-591*	*328-591*	*328-591*							*164-328*
N1	*492-2625*										*984-4921*	*984-4921*	*656-2625*
N2	*492-2625*										*984-4921*	*984-4921*	*656-2625*
N3	*492-1640*										*656-2625*	*656-2625*	*656-2625*
N11	*492-1312*										*591-2625*	*591-2625*	*656-2625*
S1	*66-164*		*66-262*										*66-197*
S2	*66-164*		*66-262*										*66-197*
S3	*66-164*		*66-262*										*197-164*
S11	*66-164*		*66-262*										*66-164*
S12	*66-164*		*66-262*										*66-164*
S13	*66-164*		*66-262*										*66-164*
H3							*262-591*	*262-591*					
H5							*262-656*	*262-656*					
H7							*262-492*	*262-492*					
H8							*262-492*	*262-492*					
H11													
H12													
H21													
H31													

SMG = Grupa de material Seco v_c= m/min Toţi parametri de aşchiere sunt valori de start.

Cheile de blocare și șuruburile plăcuțelor pentru toate suporturile de plăcuțe pentru alezare, sculele și cartușele

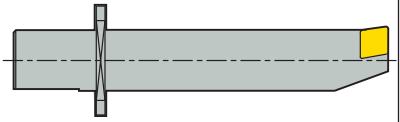


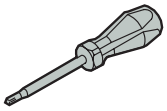




		Accesorii		Piese de schimb	
		Șurubelniță Torx pentru șurubul de blocare a plăcuței*		Șurub de blocare a plăcuței	
	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
Pentru suport de plăcuțe pentru alezare de degroșare	CP...0502	T07P-3	07	C02245-T07P	07
	CC...0602	T07P-3	07	C02504-T07P	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

* O cheie Torx este livrată cu fiecare cap de alezare de degroșare.

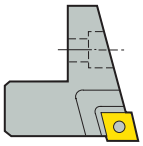


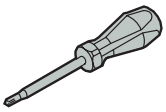




		Accesorii		Piese de schimb	
		Șurubelniță Torx pentru șurubul de blocare a plăcuței*		Șurub de blocare a plăcuței	
	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
Pentru scule de tip Axiabore™	WB...0301...	T06P-3	06	C02035-T06P	06
	CC...0602...	T07P-3	07	C02504-T07P	07
	–	T15P-3	15	C04008-T15P	15

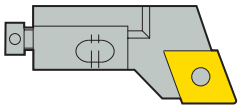
Piese de schimb pentru suporturi pentru plăcuțe

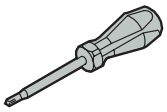






		Piese de schimb			
		Cheie plăcuță		Șurub de blocare a plăcuței	
	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
Pentru suporturile de plăcuțe pentru finiție, suporturile de plăcuțe pentru șanfrenare și suporturile de plăcuțe pentru alezare inversă	WB...0301...	T06P-2	06	C02035-T06P	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

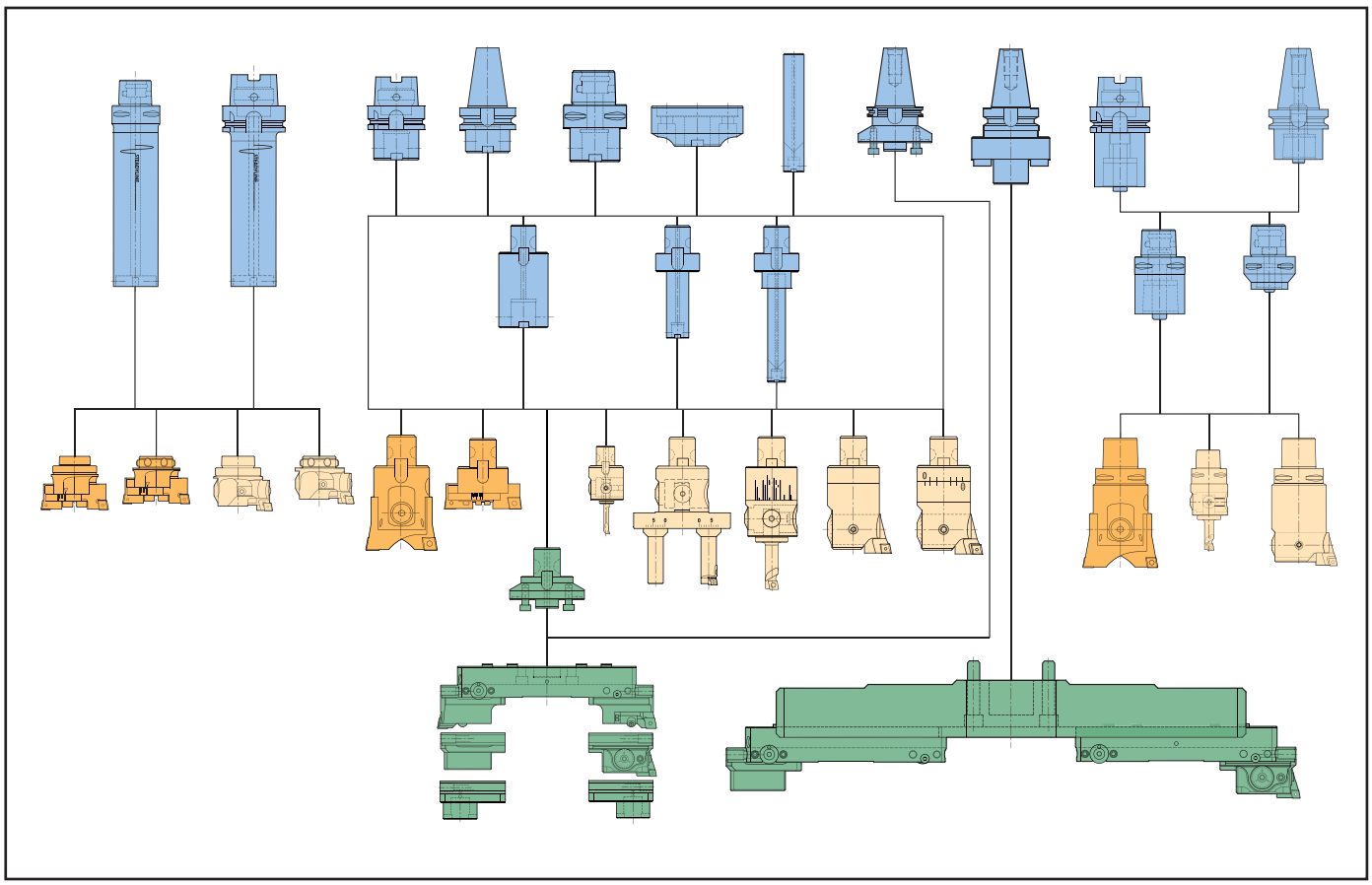






		Accesorii		Piese de schimb	
		Șurubelniță Torx pentru șurubul de blocare a plăcuței*		Șurub de blocare a plăcuței	
	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
Pentru cartușe	CC...16...	T15P-2	15	C05012-T15P	15
	SC...15...	T15P-2	15	C05012-T15P	15
	TC...16...	T15P-2	15	C03509-T15P	15
	TC...22...	T15P-2	15	C05012-T15P	15

Suporţi potriviţi pentru capetele de alezare



Capetele de alezare dispun de conexiune Graflex®, Seco Capto™, GL sau BA pe partea utilajului

Capetele de alezare pot fi folosite în orice tip de maşină, împreună cu adaptoare potrivite Graflex® sau Seco Capto™ sau bare antivibraţie Steadyline® pentru alezare/strunjire.

Amortizare a vibraţiilor Steadyline® **pentru operaţii de alezare**
Capetele de alezare cu conexiune GL sau BA pe partea utilajului sunt concepute pentru a fi montate pe barele de alezare/strunjire Steadyline® cu conexiune HSK-T/A și Seco Capto™ pe partea utilajului. Se pot executa astfel operaţii de alezare de degroșare sau finisare cu console de 6xD, 8xD și 10xD în condiţii foarte stabile.

Bare de alezare modulare Graflex® și Seco Capto™
Toate alezajele cu lungimea de 6xD pot fi executate cu intermediari Graflex®, ex. variantele extralungi din carbură. Cea mai bună stabilitate se obţine alegând intermediarul cel mai lung și mai solid posibil, completând cu intermediare mai mici.

Conexiunile Graflex® și Seco Capto™ garantează o orientare unică a capului de alezat, orientarea muchiei fiind in concordanţă cu ISO. Modulele Graflex® sunt concepute să poate fi conectate împreună din lateral.

Pentru capete de alezare cu conexiune GL pe partea utilajului pentru Steadyline®, selectaţi cea mai scurtă bară Steadyline® din catalogul de port-scule. Aceste bare au spre maşină conexiune HSK-T/A și Seco Capto™. Se pot echipa și alte tipuri de arbori utilizând cele mai scurte adaptoare Seco Capto™.
Pentru capete de alezare clasice (oţel), selectaţi arborii și intermediarele Graflex® și Seco Capto™ clasice din catalogul de port-scule.
Pentru Bridge bars, vezi adaptori și prinderi directe Graflex® la pag. 568.

Notă! Jumbo Bridge bar sunt concepute pentru prinderea într-o port-sculă de alezare sau direct în arborele maşinii.



Graflex®

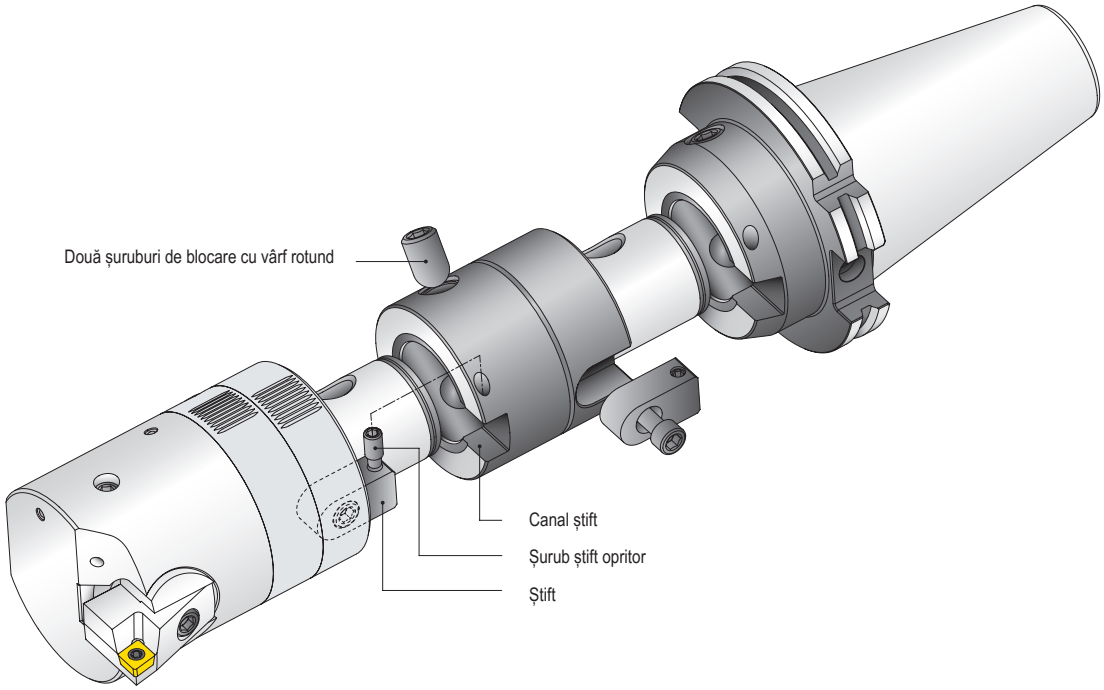
Ansamblurile Graflex® includ arbori, intermediare, port-scule și capete de alezare care pot fi asamblate rapid atunci când sunt necesare. Adecvate pentru frezare, găurire, filetare, alezare și alezare adâncă, modulele Graflex® oferă scule de lungimi și diametre variate și pot fi instalate pe toate tipurile de utilaje prin simpla înlocuire a arborelui de bază Graflex®.

- Rigiditate excelentă a conexiunii
- Gamă largă de module care oferă flexibilitate ridicată
- Posibilităţi de agent de răcire prin interior
- Repetabilitate bună

Instrucţiuni pentru blocarea cozilor G cu conexiune clasică Graflex® în capetele de alezare (utilizând un cep cu șurub opritor).

La alezare, nu este necesară strângerea șurubului opritor, deoarece conexiune este autoblocabilă.
La degroșarea în condiții grele, se recomandă aplicarea unui cuplu de strângere mai mare pentru șuruburile cu vârf sferic din conexiunea Graflex®.

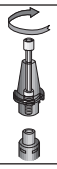
Consultaţi, de asemenea, „Procedura de asamblare cu conexiune Graflex®" din catalogul de port-scule.



Instrucţiuni de blocare a conexiunii Seco Capto™ cozi C. în capetele de alezat: Nu sunt necesare instrucţiuni specifice. Pentru capetele de alezat, se aplică instrucţiunile generale, vezi mai jos.

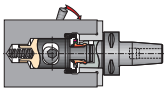
Cuplurile de strângere pentru conexiunile receptoarelor Seco Capto™ cu prindere cu bolţ central (port-scule de bază, intermediare).

Mărimi Seco Capto™	Cuplul de strângere al bolţului central (Nm)	Cuplul de strângere al bolţului central (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



Cuplurile de strângere pentru conexiunile receptoarelor Seco Capto™ cu prindere pe segment, acţionate de blocare laterală a arborelui cu came (montare pe flanșă).

Mărimi Seco Capto™	Cuplul de strângere a camei (Nm)	Cuplul de strângere a camei (ft/lbs)
C3	35	26
C4	50	37
C5	70	52
C6	90	66
C8	130	96

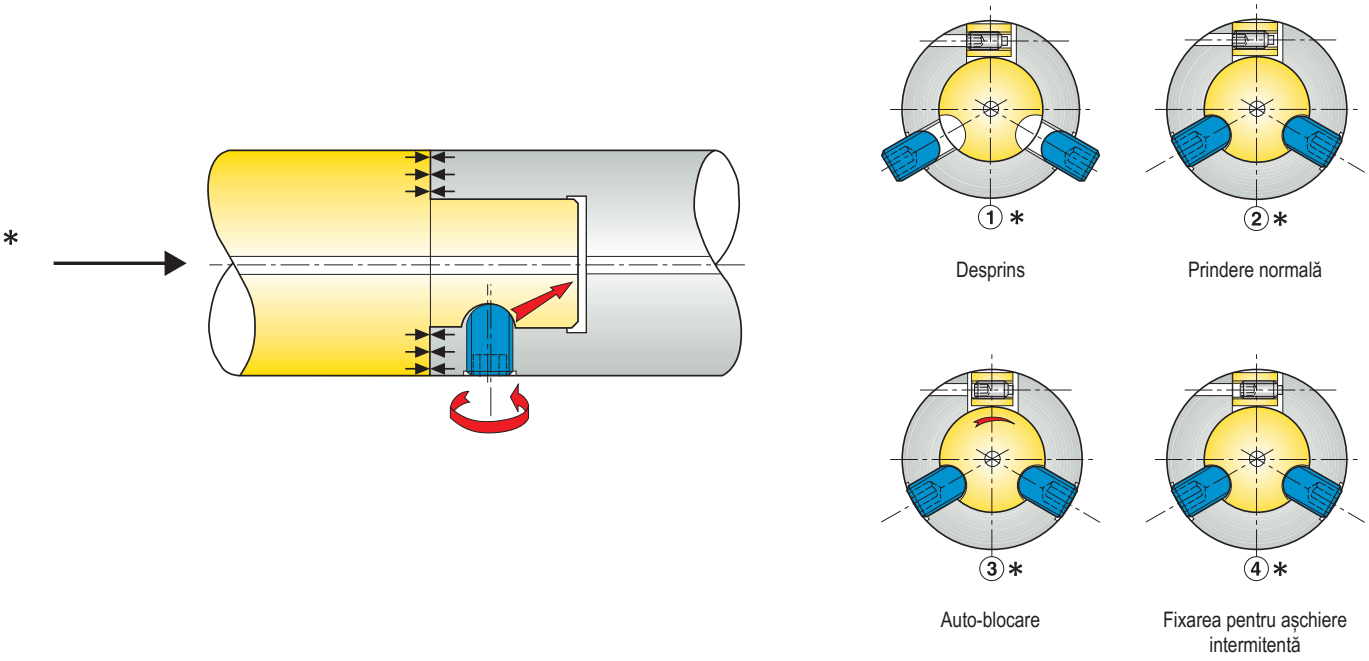


Conexiunea Seco Capto™ prezintă un con cu autoblocare. Atunci când se utilizează sistemul cu bolţ central, deșurubaţi bolţul central până când capul bolţului intră în contact cu port-scula, făcând ca bolţul să forţeze decuplarea conului. Atunci când se utilizează sistemul de cuplare lateral cu camă, decuplarea camei va forţa decuplarea conului.

Sistem modular Graflex® – Ghid

1. Asamblează arborele Graflex® și modulele utilizând cepul pentru orientarea ușoară. Strânge șuruburile cu vârf rotund și asigură-te că latura stângă a știftului este în contact cu latura stângă a canalului pentru știft.
2. Cuplul puternic din timpul prelucrării ex. alezare poate conduce la rotirea microscopică a lagărului în raport cu alezajul, duce la deplasări microscopice ale suprafeţei de contact a șuruburilor cu vârf rotund. Acest lucru duce la o auto-blocare suplimentară, mărind rigiditatea sistemului (Desen 3).
3. Pentru operaţiuni cu aşchieri intermitente ex. frezare grea, șurubul de blocare din cep trebuie strâns pentru a evita mișcarea de micro rotaţie și pentr ua preveni auto-blocarea (Desen 4).

Procedura de asamblare 'Optimizată' Graflex®

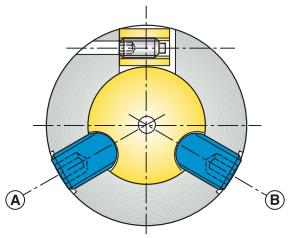


Desprins | Prindere normală | Auto-blocare | Fixarea pentru aşchiere intermitentă

*Desenele 1, 2, 3 și 4 sunt văzute din faţă la o asamblare normală, ex. la utilizarea unui suport de asamblare Tool Boy.

Procedura de asamblare 'Optimizată' Graflex®

Faţa stângă

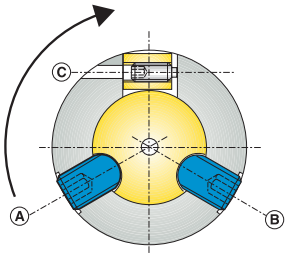


Prindere normală pentru aşchiere continuă, ex. alezare, frezare ușoară

1. Curăţaţi piesele care urmează să fie asamblate și aplicaţi o peliculă subţire de protecţie la oxidare
2. Asamblaţi piesele asigurându-vă că faţa stângă a cepului intră în contact cu faţa stângă a slotului de cep
3. Strângeţi ușor șurubul A
4. Strângeţi ușor șurubul B

5. 'Strânge' șurubul A (ușor).
6. 'Strânge' șurubul B (ușor).

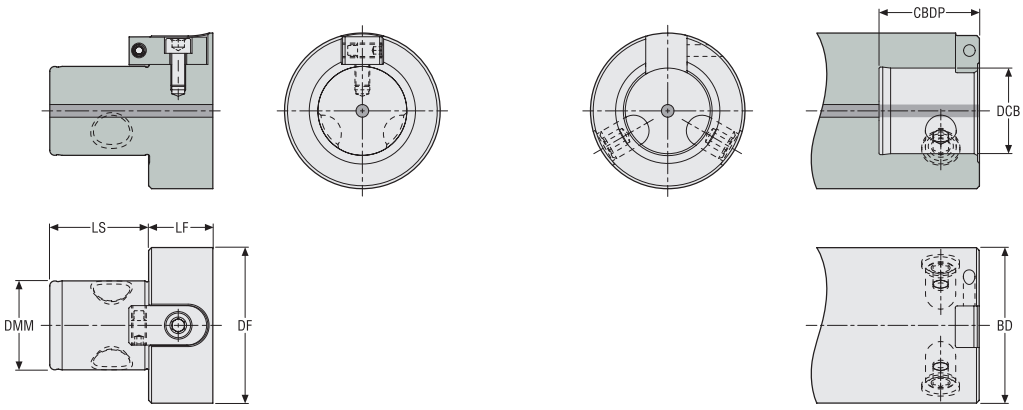
Faţa stângă



Prindere pentru aşchiere intermitentă ex. alezare cu întreruperi, frezare grea

5. Strânge șurubul de blocare C.
6. Strânge șurubul A (puternic).
7. Strânge șurubul B (puternic).
8. Verifică strângerea șurubului de blocare

Graflex®, norme dimensionale



Descriere catalog partea dinspre mașină	Gaură pentru cip RFID*	DF	DMM	LS	LF
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*
G0	Nu	16 *0.630*	8 *0.315*	12 *0.472*	8 *0.315*
G1	Nu	20 *0.787*	11 *0.433*	13 *0.512*	9,5 *0.374*
G2	Nu	25 *0.984*	14 *0.551*	16 *0.630*	11 *0.433*
G3	Nu	32 *1.260*	18 *0.709*	20 *0.787*	14 *0.551*
G4	Nu	40 *1.575*	22 *0.866*	24 *0.945*	17 *0.669*
G5	Nu	50 *1.969*	28 *1.102*	30 *1.181*	20 *0.787*
G6	Nu	63 *2.480*	36 *1.417*	40 *1.575*	26 *1.024*
G7	Nu	90 *3.543*	46 *1.811*	50 *1.969*	26 *1.024*

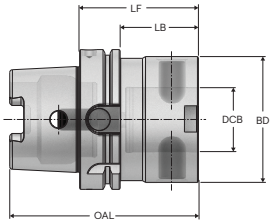
Spre catalog partea dinspre mașină	Gaură pentru cip RFID*	CBDP	DCB	BD
		mm *Inci*	mm *Inci*	mm *Inci*
G0	Nu	16 *0.630*	8 *0.315*	12 *0.472*
G1	Nu	20 *0.787*	11 *0.433*	13 *0.512*
G2	Nu	25 *0.984*	14 *0.551*	16 *0.630*
G3	Nu	32 *1.260*	18 *0.709*	20 *0.787*
G4	Nu	40 *1.575*	22 *0.866*	24 *0.945*
G5	Nu	50 *1.969*	28 *1.102*	30 *1.181*
G6	Nu	63 *2.480*	36 *1.417*	40 *1.575*
G7	Nu	90 *3.543*	46 *1.811*	50 *1.969*

Notă: Dimensiunile spre mașină și spre semifabricat se aplică la toate portsculele arătate în pagina de produs.
* Nu există găuri pentru cip RFID

G 401 – Arbori Graflex®

HSK-A/ ISO12164-1-HSK-A

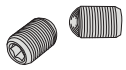




—Pentru dopurile HSK, tuburi pentru lichid de răcire, și chei, vezi pag. Accesorii pentru operare și reglare pag. 625

Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
EM93034012870	00086917	HSK-A50	G5	28,0 *1.102*	70,0 *2.756*	44,0 *1.732*	50,0 *1.969*	95,0 *3.740*	1	PB	0,9 *1.980*
EM93044011445	02469722	HSK-A63	G2	14,0 *0.551*	45,0 *1.772*	19,0 *0.748*	25,0 *0.984*	77,0 *3.031*	1	G6.3	0,7 *1.540*
EM93044011850	00086918	HSK-A63	G3	18,0 *0.709*	50,0 *1.969*	24,0 *0.945*	32,0 *1.260*	82,0 *3.228*	1	G6.3	0,8 *1.760*
EM93044012255	00088217	HSK-A63	G4	22,0 *0.866*	55,0 *2.165*	29,0 *1.142*	40,0 *1.575*	87,0 *3.425*	1	G6.3	0,9 *1.980*
EM93044012860	00086920	HSK-A63	G5	28,0 *1.102*	60,0 *2.362*	34,0 *1.339*	50,0 *1.969*	92,0 *3.622*	1	PB	1,0 *2.200*
EM930440128100	00086921	HSK-A63	G5	28,0 *1.102*	100,0 *3.937*	74,0 *2.913*	50,0 *1.969*	132,0 *5.197*	1	PB	1,6 *3.530*
EM930440128140	00086922	HSK-A63	G5	28,0 *1.102*	140,0 *5.512*	114,0 *4.488*	50,0 *1.969*	172,0 *6.772*	1	PB	2,18 *4.810*
EM93044013670	00086923	HSK-A63	G6	36,0 *1.417*	70,0 *2.756*	44,0 *1.732*	63,0 *2.480*	102,0 *4.016*	1	PB	1,3 *2.870*
EM930440136120	00086924	HSK-A63	G6	36,0 *1.417*	120,0 *4.724*	94,0 *3.701*	63,0 *2.480*	152,0 *5.984*	1	PB	2,38 *5.250*
EM93064011855	00086925	HSK-A100	G3	18,0 *0.709*	55,0 *2.165*	26,0 *1.024*	32,0 *1.260*	105,0 *4.134*	1	G6.3	2,2 *4.850*
EM93064012260	00086926	HSK-A100	G4	22,0 *0.866*	60,0 *2.362*	31,0 *1.220*	40,0 *1.575*	110,0 *4.331*	1	G6.3	2,3 *5.070*
EM93064012865	00086927	HSK-A100	G5	28,0 *1.102*	65,0 *2.559*	36,0 *1.417*	50,0 *1.969*	115,0 *4.528*	1	PB	2,4 *5.290*
EM930640128110	00086928	HSK-A100	G5	28,0 *1.102*	110,0 *4.331*	81,0 *3.189*	50,0 *1.969*	160,0 *6.299*	1	PB	3,1 *6.830*
EM930640128150	00086929	HSK-A100	G5	28,0 *1.102*	150,0 *5.906*	121,0 *4.764*	50,0 *1.969*	200,0 *7.874*	1	PB	3,7 *8.160*
EM93064013675	00083432	HSK-A100	G6	36,0 *1.417*	75,0 *2.953*	46,0 *1.811*	63,0 *2.480*	125,0 *4.921*	1	PB	2,8 *6.170*
EM930640136120	00086931	HSK-A100	G6	36,0 *1.417*	120,0 *4.724*	91,0 *3.583*	63,0 *2.480*	170,0 *6.693*	1	PB	3,9 *8.600*
EM930640136160	00086932	HSK-A100	G6	36,0 *1.417*	160,0 *6.299*	131,0 *5.157*	63,0 *2.480*	210,0 *8.268*	1	PB	4,8 *10.580*
EM93064014685	00074385	HSK-A100	G7	46,0 *1.811*	85,0 *3.346*	56,0 *2.205*	90,0 *3.543*	135,0 *5.315*	1	PB	4,0 *8.820*
EM930640146160	00086933	HSK-A100	G7	46,0 *1.811*	160,0 *6.299*	131,0 *5.157*	90,0 *3.543*	210,0 *8.268*	1	PB	7,67 *16.910*
HSKA125-G6-120	03229653	HSK-A125	G6	36,0 *1.417*	120,0 *4.724*	91,0 *3.583*	63,0 *2.480*	183,0 *7.205*	1	PB	5,1 *11.240*
HSKA125-G7-120	03229654	HSK-A125	G7	46,0 *1.811*	120,0 *4.724*	91,0 *3.583*	90,0 *3.543*	183,0 *7.205*	1	PB	7,1 *15.650*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub ansamblu
	
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

Accesorii

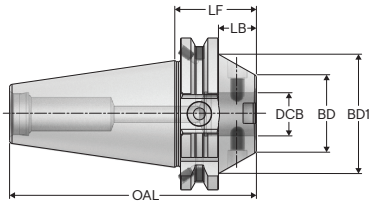
Pentru mărimea	Cheie de blocare
	
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

G 401 – Arbori Graflex®

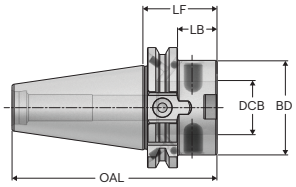
SA/SK/DIN 69871-ADB



Design 1

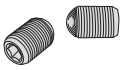


Design 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
EM34694011190	02503292	DIN40 ADB	G1	11,0 *0.433*	90,0 *3.543*	70,9 *2.791*	20,0 *0.787*	–	158,4 *6.236*	2	1	G6.3	1,0 *2.200*
EM34694011435	02469729	DIN40 ADB	G2	14,0 *0.551*	35,0 *1.378*	15,9 *0.626*	25,0 *0.984*	–	103,4 *4.071*	2	1	G6.3	0,83 *1.830*
EM34694011490	02503293	DIN40 ADB	G2	14,0 *0.551*	90,0 *3.543*	70,9 *2.791*	25,0 *0.984*	–	158,4 *6.236*	2	1	G6.3	1,1 *2.430*
EM34694011835	02420097	DIN40 ADB	G3	18,0 *0.709*	35,0 *1.378*	15,9 *0.626*	32,0 *1.260*	50,0 *1.969*	103,4 *4.071*	1	1	G6.3	1,0 *2.200*
EM346940118100	02503298	DIN40 ADB	G3	18,0 *0.709*	100,0 *3.937*	80,9 *3.185*	32,0 *1.260*	–	168,4 *6.630*	2	1	G6.3	1,3 *2.870*
EM34694012235	02503299	DIN40 ADB	G4	22,0 *0.866*	35,0 *1.378*	15,9 *0.626*	40,0 *1.575*	50,0 *1.969*	103,4 *4.071*	1	1	G6.3	0,92 *2.030*
EM346940122100	02503300	DIN40 ADB	G4	22,0 *0.866*	100,0 *3.937*	80,9 *3.185*	40,0 *1.575*	–	168,4 *6.630*	2	1	G6.3	1,5 *3.310*
EM34694012840	02458421	DIN40 ADB	G5	28,0 *1.102*	40,0 *1.575*	20,9 *0.823*	50,0 *1.969*	–	108,4 *4.268*	2	1	PB	1,0 *2.200*
EM34694012880	02503301	DIN40 ADB	G5	28,0 *1.102*	80,0 *3.150*	60,9 *2.398*	50,0 *1.969*	–	148,4 *5.843*	2	1	PB	1,5 *3.310*
EM346940128120	02503302	DIN40 ADB	G5	28,0 *1.102*	120,0 *4.724*	100,9 *3.972*	50,0 *1.969*	–	188,4 *7.417*	2	1	PB	2,1 *4.630*
EM34694013660	02503303	DIN40 ADB	G6	36,0 *1.417*	60,0 *2.362*	40,9 *1.610*	63,0 *2.480*	–	128,4 *5.055*	2	1	PB	1,3 *2.870*
EM346940136120	02503304	DIN40 ADB	G6	36,0 *1.417*	120,0 *4.724*	100,9 *3.972*	63,0 *2.480*	–	188,4 *7.417*	2	1	PB	2,7 *5.950*
EM347140114100	02503306	DIN50 ADB	G2	14,0 *0.551*	100,0 *3.937*	80,9 *3.185*	25,0 *0.984*	–	201,7 *7.941*	2	1	G6.3	2,9 *6.390*
EM34714011835	02503307	DIN50 ADB	G3	18,0 *0.709*	35,0 *1.378*	15,9 *0.626*	32,0 *1.260*	–	136,7 *5.382*	2	1	G6.3	2,67 *5.890*
EM347140118110	02503308	DIN50 ADB	G3	18,0 *0.709*	110,0 *4.331*	90,9 *3.579*	32,0 *1.260*	–	211,7 *8.335*	2	1	G6.3	3,1 *6.830*
EM34714012235	02503309	DIN50 ADB	G4	22,0 *0.866*	35,0 *1.378*	15,9 *0.626*	40,0 *1.575*	80,0 *3.150*	136,7 *5.382*	1	1	G6.3	2,88 *6.350*
EM347140122120	02503311	DIN50 ADB	G4	22,0 *0.866*	120,0 *4.724*	100,9 *3.972*	40,0 *1.575*	–	221,7 *8.728*	2	1	G6.3	3,4 *7.500*
EM34714012840	02503312	DIN50 ADB	G5	28,0 *1.102*	40,0 *1.575*	20,9 *0.823*	50,0 *1.969*	–	141,7 *5.579*	2	1	PB	2,75 *6.060*
EM347140128100	02503315	DIN50 ADB	G5	28,0 *1.102*	100,0 *3.937*	80,9 *3.185*	50,0 *1.969*	–	201,7 *7.941*	2	1	PB	3,56 *7.850*
EM347140128140	02503316	DIN50 ADB	G5	28,0 *1.102*	140,0 *5.512*	120,9 *4.760*	50,0 *1.969*	–	241,7 *9.516*	2	1	PB	4,08 *8.990*
EM34714013645	02503317	DIN50 ADB	G6	36,0 *1.417*	45,0 *1.772*	25,9 *1.020*	63,0 *2.480*	–	146,7 *5.776*	2	1	PB	2,9 *6.390*
EM347140136100	02503318	DIN50 ADB	G6	36,0 *1.417*	100,0 *3.937*	80,9 *3.185*	63,0 *2.480*	–	201,7 *7.941*	2	1	PB	4,1 *9.040*
EM347140136140	02503319	DIN50 ADB	G6	36,0 *1.417*	140,0 *5.512*	120,9 *4.760*	63,0 *2.480*	–	241,7 *9.516*	2	1	PB	5,1 *11.240*
EM34714014650	02503320	DIN50 ADB	G7	46,0 *1.811*	50,0 *1.969*	30,9 *1.217*	90,0 *3.543*	–	151,7 *5.972*	2	1	PB	3,3 *7.280*
EM347140146120	02503321	DIN50 ADB	G7	46,0 *1.811*	120,0 *4.724*	100,9 *3.972*	90,0 *3.543*	–	221,7 *8.728*	2	1	PB	6,5 *14.330*
EM347140146200	02503324	DIN50 ADB	G7	46,0 *1.811*	200,0 *7.874*	180,9 *7.122*	90,0 *3.543*	–	301,7 *11.878*	2	1	PB	10,4 *22.930*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub ansamblu	Sealing Screws
		
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

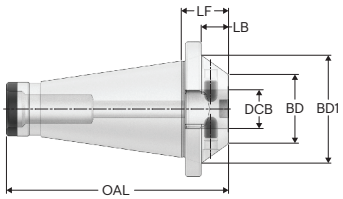
Accesorii

Pentru mărimea	Cheie de blocare
	
DIN40/ G1	03H02
DIN40/ G2	03H025
DIN40/ G3	03H03
DIN40/ G4	03H04
DIN40/ G5	03H05
DIN40/ G6	03H06
DIN50/ G2	03H025
DIN50/ G3	03H03
DIN50/ G4	03H04
DIN50/ G5	03H05
DIN50/ G6	03H06
DIN50/ G7	03H10
EM34714014650	03H10

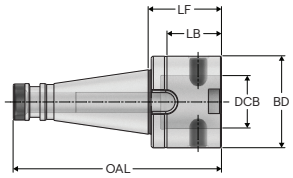
G 401 – Arbori Graflex®
DIN 2080



Design 1

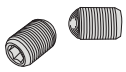


Design 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
EM00404013650	00076707	DIN(2080)40	G6	36,0 *1.417*	50,0 *1.969*	0,0 –	63,0 *2.480*	–	143,4 *5.646*	2	0	PB	1,3 *2.870*
EM00504012835	00076710	DIN(2080)50	G5	28,0 *1.102*	35,0 *1.378*	19,8 *0.780*	50,0 *1.969*	78,0 *3.071*	161,8 *6.370*	1	0	PB	2,94 *6.480*
EM00504013640	00076714	DIN(2080)50	G6	36,0 *1.417*	40,0 *1.575*	24,8 *0.976*	63,0 *2.480*	–	166,8 *6.567*	2	0	PB	2,9 *6.390*
EM00504014645	00076718	DIN(2080)50	G7	46,0 *1.811*	45,0 *1.772*	29,8 *1.173*	90,0 *3.543*	–	171,8 *6.764*	2	0	PB	3,34 *7.360*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub ansamblu
	
G5	90F5
G6	90F6
G7	90F7

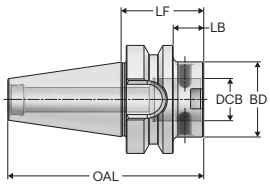
Accesorii

Pentru mărimea	Cheie de blocare
	
G5	03H05
G6	03H06
G7	03H10

G 401 – Arbori Graflex®

BT JIS B 6339-AD





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
EM40404011835	00056699	BT30 AD	G3	18,0 *0.709*	35,0 *1.378*	13,0 *0.512*	32,0 *1.260*	83,4 *3.283*	0	G6.3	0,5 *1.100*
EM40404012850	00056705	BT30 AD	G5	28,0 *1.102*	50,0 *1.969*	25,0 *0.984*	50,0 *1.969*	98,4 *3.874*	0	PB	0,7 *1.540*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub ansamblu
	
EM40404011835	90F3
EM40404012850	90F5

Accesorii

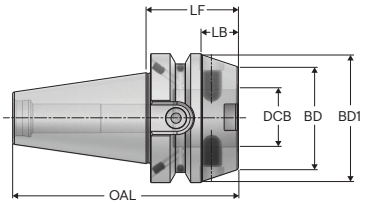
Pentru mărimea	Cheie de blocare
	
EM40404011835	03H03
EM40404012850	03H05

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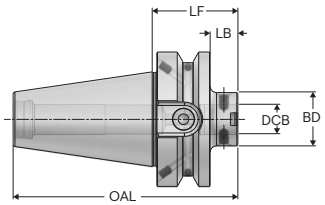
BT JIS B 6339-ADB



Design 1

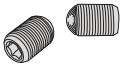


Design 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
EM34144011190	02503364	BT40 ADB	G1	11,0 *0.433*	90,0 *3.543*	63,0 *2.480*	20,0 *0.787*	–	155,4 *6.118*	2	1	G6.3	1,1 *2.430*
EM34144011440	02469725	BT40 ADB	G2	14,0 *0.551*	40,0 *1.575*	13,0 *0.512*	25,0 *0.984*	–	105,4 *4.150*	2	1	G6.3	0,98 *2.160*
EM34144011490	02503365	BT40 ADB	G2	14,0 *0.551*	90,0 *3.543*	63,0 *2.480*	25,0 *0.984*	–	155,4 *6.118*	2	1	G6.3	1,2 *2.650*
EM34144011840	02503366	BT40 ADB	G3	18,0 *0.709*	40,0 *1.575*	13,0 *0.512*	32,0 *1.260*	62,0 *2.441*	105,4 *4.150*	1	1	G6.3	1,07 *2.360*
EM341440118100	02503367	BT40 ADB	G3	18,0 *0.709*	100,0 *3.937*	73,0 *2.874*	32,0 *1.260*	–	165,4 *6.512*	2	1	G6.3	1,31 *2.890*
EM34144012245	02503368	BT40 ADB	G4	22,0 *0.866*	45,0 *1.772*	18,0 *0.709*	40,0 *1.575*	62,0 *2.441*	110,4 *4.346*	1	1	G6.3	1,2 *2.650*
EM341440122100	02503370	BT40 ADB	G4	22,0 *0.866*	100,0 *3.937*	73,0 *2.874*	40,0 *1.575*	–	165,4 *6.512*	2	1	G6.3	1,6 *3.530*
EM34144012845	02457989	BT40 ADB	G5	28,0 *1.102*	45,0 *1.772*	18,0 *0.709*	50,0 *1.969*	62,0 *2.441*	110,4 *4.346*	1	1	PB	1,2 *2.650*
EM34144012880	02503371	BT40 ADB	G5	28,0 *1.102*	80,0 *3.150*	53,0 *2.087*	50,0 *1.969*	–	145,4 *5.724*	2	1	PB	1,6 *3.530*
EM341440128120	02503372	BT40 ADB	G5	28,0 *1.102*	120,0 *4.724*	93,0 *3.661*	50,0 *1.969*	–	185,4 *7.299*	2	1	PB	2,2 *4.850*
EM34144013650	02503373	BT40 ADB	G6	36,0 *1.417*	50,0 *1.969*	0,0 –	63,0 *2.480*	–	115,4 *4.543*	2	0	PB	1,2 *2.650*
EM341440136120	02503374	BT40 ADB	G6	36,0 *1.417*	120,0 *4.724*	0,0 –	63,0 *2.480*	–	185,4 *7.299*	2	1	PB	2,8 *6.170*
EM341640114110	02503375	BT50 ADB	G2	14,0 *0.551*	110,0 *4.331*	72,0 *2.835*	25,0 *0.984*	–	211,8 *8.339*	2	1	G6.3	3,8 *8.380*
EM34164011845	02503376	BT50 ADB	G3	18,0 *0.709*	45,0 *1.772*	7,0 *0.276*	32,0 *1.260*	70,0 *2.756*	146,8 *5.780*	1	1	G6.3	3,6 *7.940*
EM341640118120	02503377	BT50 ADB	G3	18,0 *0.709*	120,0 *4.724*	82,0 *3.228*	32,0 *1.260*	–	221,8 *8.732*	2	1	G6.3	4,0 *8.820*
EM34164012250	02503378	BT50 ADB	G4	22,0 *0.866*	50,0 *1.969*	12,0 *0.472*	40,0 *1.575*	70,0 *2.756*	151,8 *5.976*	1	1	G6.3	3,7 *8.160*
EM341640122140	02503379	BT50 ADB	G4	22,0 *0.866*	140,0 *5.512*	102,0 *4.016*	40,0 *1.575*	–	241,8 *9.520*	2	1	G6.3	4,4 *9.700*
EM34164012855	02503380	BT50 ADB	G5	28,0 *1.102*	55,0 *2.165*	17,0 *0.669*	50,0 *1.969*	98,0 *3.858*	156,8 *6.173*	1	1	PB	4,0 *8.820*
EM341640128100	02503381	BT50 ADB	G5	28,0 *1.102*	100,0 *3.937*	62,0 *2.441*	50,0 *1.969*	–	201,8 *7.945*	2	1	PB	4,3 *9.480*
EM341640128140	02503382	BT50 ADB	G5	28,0 *1.102*	140,0 *5.512*	102,0 *4.016*	50,0 *1.969*	–	241,8 *9.520*	2	1	PB	4,9 *10.800*
EM34164013663	02503383	BT50 ADB	G6	36,0 *1.417*	63,0 *2.480*	25,0 *0.984*	63,0 *2.480*	98,0 *3.858*	164,8 *6.488*	1	1	PB	4,3 *9.480*
EM341640136100	02503384	BT50 ADB	G6	36,0 *1.417*	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	–	201,8 *7.945*	2	1	PB	4,7 *10.360*
EM341640136140	02503385	BT50 ADB	G6	36,0 *1.417*	140,0 *5.512*	102,0 *4.016*	63,0 *2.480*	–	241,8 *9.520*	2	1	PB	5,6 *12.350*
EM34164014665	02503386	BT50 ADB	G7	46,0 *1.811*	65,0 *2.559*	27,0 *1.063*	90,0 *3.543*	98,0 *3.858*	166,8 *6.567*	1	1	PB	4,4 *9.700*
EM341640146120	02503387	BT50 ADB	G7	46,0 *1.811*	120,0 *4.724*	82,0 *3.228*	90,0 *3.543*	–	221,8 *8.732*	2	1	PB	6,9 *15.210*
EM341640146200	02503388	BT50 ADB	G7	46,0 *1.811*	200,0 *7.874*	162,0 *6.378*	90,0 *3.543*	–	301,8 *11.882*	2	1	PB	10,7 *23.590*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub ansamblu	Sealing Screws
		
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

Accesorii

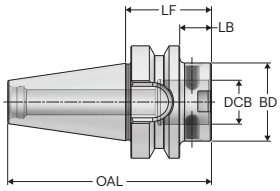
Pentru mărimea	Cheie de blocare
	
BT40/ G1	03H02
BT40/ G2	03H025
BT40/ G3	03H03
BT40/ G4	03H04
BT40/ G5	03H05
BT40/ G6	03H06
BT50/ G2	03H025
BT50/ G3	03H03
BT50/ G4	03H04
BT50/ G5	03H05
BT50/ G6	03H06
BT50/ G7	03H10

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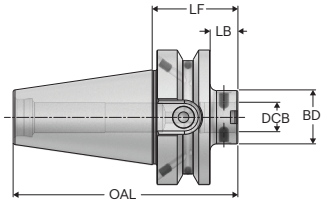
BT Taper-face-AD/ADB



Design 1

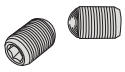


Design 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
EM40024011850	02998757	BT30 TF AD	G3	18,0 *0.709*	50,0 *1.969*	28,0 *1.102*	32,0 *1.260*	98,4 *3.874*	1	0	G6.3	0,6 *1.320*
EM40024012250	02998758	BT30 TF AD	G4	22,0 *0.866*	50,0 *1.969*	28,0 *1.102*	40,0 *1.575*	98,4 *3.874*	1	0	G6.3	0,6 *1.320*
EM321440122100	02998754	BT40 TF ADB	G4	22,0 *0.866*	100,0 *3.937*	73,0 *2.874*	40,0 *1.575*	165,4 *6.512*	2	1	G6.3	1,6 *3.530*
EM321440128120	02926006	BT40 TF ADB	G5	28,0 *1.102*	120,0 *4.724*	93,0 *3.661*	50,0 *1.969*	185,4 *7.299*	2	1	PB	2,2 *4.850*
EM321440136120	02998755	BT40 TF ADB	G6	36,0 *1.417*	120,0 *4.724*	93,0 *3.661*	63,0 *2.480*	185,4 *7.299*	2	1	PB	2,8 *6.170*
EM321640128140	02998756	BT50 TF ADB	G5	28,0 *1.102*	140,0 *5.512*	102,0 *4.016*	50,0 *1.969*	241,8 *9.520*	2	1	PB	4,9 *10.800*
EM321640136140	02926009	BT50 TF ADB	G6	36,0 *1.417*	140,0 *5.512*	102,0 *4.016*	63,0 *2.480*	241,8 *9.520*	2	1	PB	5,6 *12.350*
EM321640146200	02926010	BT50 TF ADB	G7	46,0 *1.811*	200,0 *7.874*	162,0 *6.378*	90,0 *3.543*	301,8 *11.882*	2	1	PB	10,8 *23.810*

Piese de schimb, Piese incluse la livrare

Pentru	Sealing Screws	Șurub ansamblu
		
EM321440122100	950A0406	90F4
EM321440128120	950A0406	90F5
EM321440136120	950A0406	90F6
EM321640128140	950A0606	90F5
EM321640136140	950A0606	90F6
EM321640146200	950A0606	90F7
EM40024011850	–	90F3
EM40024012250	–	90F4

Accesorii

Cheie de blocare

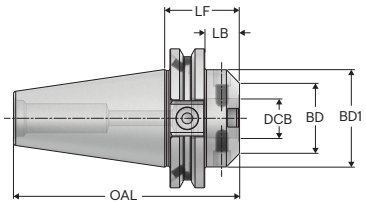
03H03
03H04
03H04
03H05
03H06
03H05
03H06
03H10

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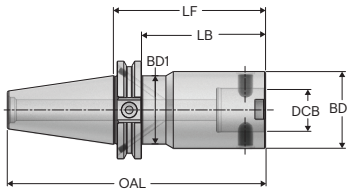
CAT / ASME B5.50-1994-ADB



Design 1



Design 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	BD1	OAL	Varianta	RFID hole	Echili-brare	Greutate
				Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*				lbs
EM25024011435	02469734	CAT40 ADB	G2	0.551	1.380	0.630	0.984	1.750	4.070	1	1	G6.3	2.120
EM25024011835	00056660	CAT40 ADB	G3	0.709	1.380	0.630	1.260	1.750	4.070	1	1	G6.3	2.200
EM25024012235	00056661	CAT40 ADB	G4	0.866	1.380	0.630	1.575	1.750	4.070	1	1	G6.3	1.980
EM25024012840	00056663	CAT40 ADB	G5	1.102	1.570	0.820	1.969	1.750	4.270	2	1	PB	1.980
EM250240128100	00056662	CAT40 ADB	G5	1.102	3.940	3.190	1.969	1.750	7.420	2	1	PB	3.970
EM25024013660	00056665	CAT40 ADB	G6	1.417	2.360	1.610	2.480	1.750	5.060	2	1	PB	2.870
EM25044011835	00056666	CAT50 ADB	G3	0.709	1.380	0.630	1.260	2.750	5.380	1	1	G6.3	6.830
EM25044012235	00056667	CAT50 ADB	G4	0.866	1.380	0.630	1.575	2.750	5.380	1	1	G6.3	6.610
EM25044012840	00056669	CAT50 ADB	G5	1.102	1.570	0.820	1.969	2.750	5.580	2	1	PB	6.610
EM250440128100	00056668	CAT50 ADB	G5	1.102	3.940	3.190	1.969	2.750	7.940	2	1	PB	8.380
EM25044013645	00056671	CAT50 ADB	G6	1.417	1.770	1.020	2.480	2.750	5.780	1	1	PB	6.610
EM250440136120	00056670	CAT50 ADB	G6	1.417	4.720	3.970	2.480	2.750	9.520	1	1	PB	10.360
EM25044014665	00056675	CAT50 ADB	G7	1.811	2.560	1.810	3.543	2.750	5.970	2	1	PB	8.380
EM250440146120	00056673	CAT50 ADB	G7	1.811	4.720	3.970	3.543	2.750	8.730	2	1	PB	13.890
EM250440146200	00056674	CAT50 ADB	G7	1.811	7.870	7.120	3.543	2.750	11.880	2	1	PB	22.270

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Sealing Screws	Șurub ansamblu
		
CAT40/ G2	950A0406	90F2
CAT40/ G3	950A0406	90F3
CAT40/ G4	950A0406	90F4
CAT40/ G5	950A0406	90F5
CAT40/ G6	950A0406	90F6
CAT50/ G3	950A0606	90F3
CAT50/ G4	950A0606	90F4
CAT50/ G5	950A0606	90F5
CAT50/ G6	950A0606	90F6
CAT50/ G7	950A0606	90F7

Accesorii

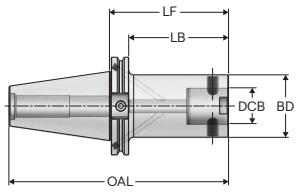
Cheie de blocare

03H025
03H03
03H04
03H05
03H06
03H03
03H04
03H05
03H06
03H10

G 401 – Arbori Graflex®

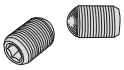
CAT TF / ASME B5.50-2009-ADB





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				Inci	*Inci*	*Inci*	*Inci*	*Inci*				lbs
EM26424011880	02998750	CAT40 TF ADB	G3	0.709	3.150	2.398	1.260	5.843	2	1	G6.3	2.650
EM26424012280	02998751	CAT40 TF ADB	G4	0.866	3.150	2.398	1.575	5.843	2	1	G6.3	3.090
EM264240128100	02998752	CAT40 TF ADB	G5	1.102	3.937	3.185	1.969	6.630	2	1	PB	4.190
EM264240136100	02998753	CAT40 TF ADB	G6	1.417	3.937	3.185	2.480	6.630	2	1	PB	5.290
EM264440122100	02964322	CAT50 TF ADB	G4	0.866	3.937	3.185	1.575	7.943	2	1	G6.3	7.280
EM264440128100	02964323	CAT50 TF ADB	G5	1.102	3.937	3.185	1.969	7.943	2	1	PB	7.940
EM264440136120	02926850	CAT50 TF ADB	G6	1.417	4.724	3.972	2.480	8.732	1	1	PB	10.140
EM264440146200	02926851	CAT50 TF ADB	G7	1.811	7.874	7.122	3.543	11.880	2	1	PB	22.710

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Sealing Screws	Șurub ansamblu
		
EM26424011880	950A0406	90F3
EM26424012280	950A0406	90F4
EM264240128100	950A0406	90F5
EM264240136100	950A0406	90F6
EM264440122100	950A0606	90F4
EM264440128100	950A0606	90F5
EM264440136120	950A0606	90F6
EM264440146200	950A0606	90F7

Accesorii

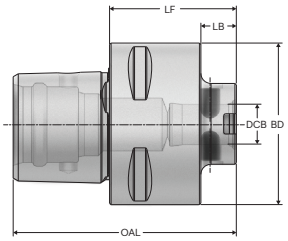
Cheie de blocare

03H03
03H04
03H05
03H06
03H04
03H05
03H06
03H10

G 401 – Adaptoare Graflex®

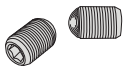
Seco Capto™





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C3-391.0401-08025	02532939	C3	G0	8,0 *0.315*	25,0 *0.984*	7,0 *0.276*	16,0 *0.630*	44,0 *1.732*	0	G6.3	0,2 *0.440*
C3-391.0401-11025	02532940	C3	G1	11,0 *0.433*	25,0 *0.984*	7,0 *0.276*	20,0 *0.787*	44,0 *1.732*	0	G6.3	0,14 *0.310*
C3-391.0401-14025	02532941	C3	G2	14,0 *0.551*	25,0 *0.984*	7,0 *0.276*	25,0 *0.984*	44,0 *1.732*	0	G6.3	0,2 *0.440*
C3-391.0401-18030	02532942	C3	G3	18,0 *0.709*	30,0 *1.181*	0,0 –	32,0 *1.260*	49,0 *1.929*	0	G6.3	0,16 *0.350*
C4-391.0401-18035	02532943	C4	G3	18,0 *0.709*	35,0 *1.378*	12,0 *0.472*	32,0 *1.260*	59,0 *2.323*	0	G6.3	0,4 *0.880*
C4-391.0401-22035	02532944	C4	G4	22,0 *0.866*	35,0 *1.378*	0,0 –	40,0 *1.575*	59,0 *2.323*	0	G6.3	0,31 *0.680*
C5-391.0401-14030	02532945	C5	G2	14,0 *0.551*	30,0 *1.181*	7,0 *0.276*	25,0 *0.984*	60,0 *2.362*	1	G6.3	0,47 *1.040*
C5-391.0401-18035	02532947	C5	G3	18,0 *0.709*	35,0 *1.378*	12,0 *0.472*	32,0 *1.260*	65,0 *2.559*	1	G6.3	0,5 *1.100*
C5-391.0401-22035	02532948	C5	G4	22,0 *0.866*	35,0 *1.378*	12,0 *0.472*	40,0 *1.575*	65,0 *2.559*	1	G6.3	0,5 *1.100*
C5-391.0401-28045	02532949	C5	G5	28,0 *1.102*	45,0 *1.772*	22,0 *0.866*	50,0 *1.969*	75,0 *2.953*	1	PB	0,7 *1.540*
C6-391.0401-18035	02532950	C6	G3	18,0 *0.709*	35,0 *1.378*	10,0 *0.394*	32,0 *1.260*	73,0 *2.874*	1	G6.3	0,9 *1.980*
C6-391.0401-22040	02532951	C6	G4	22,0 *0.866*	40,0 *1.575*	15,0 *0.591*	40,0 *1.575*	78,0 *3.071*	1	G6.3	0,9 *1.980*
C6-391.0401-28050	02532952	C6	G5	28,0 *1.102*	50,0 *1.969*	25,0 *0.984*	50,0 *1.969*	88,0 *3.465*	1	PB	1,1 *2.430*
C6-391.0401-36055	02532953	C6	G6	36,0 *1.417*	55,0 *2.165*	0,0 –	63,0 *2.480*	93,0 *3.661*	1	PB	1,2 *2.650*
C8-391.0401-28050	02532954	C8	G5	28,0 *1.102*	50,0 *1.969*	17,0 *0.669*	50,0 *1.969*	98,0 *3.858*	1	PB	2,0 *4.410*
C8-391.0401-36055	02532955	C8	G6	36,0 *1.417*	55,0 *2.165*	22,0 *0.866*	63,0 *2.480*	103,0 *4.055*	1	PB	2,1 *4.630*
C8-391.0401-46065	02532956	C8	G7	46,0 *1.811*	65,0 *2.559*	35,0 *1.378*	90,0 *3.543*	113,0 *4.449*	1	PB	2,8 *6.170*

Piese de schimb, Piese incluse la livrare

Pentru	Șurub ansamblu
	
G0	90F0
G1	90F1
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

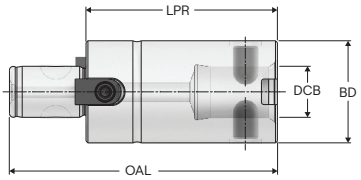
Accesorii

Pentru mărimea	Cheie de blocare
	
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

G 402 – Extensii Graflex®

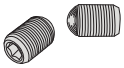
Graflex®





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LPR	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M402000	00056752	G0	G0	8,0 *0.315*	30,0 *1.181*	16,0 *0.630*	42,0 *1.654*	0	PB	0,1 *0.220*
M402001	00056753	G0	G0	8,0 *0.315*	50,0 *1.969*	16,0 *0.630*	62,0 *2.441*	0	PB	0,1 *0.220*
M402110	00056754	G1	G1	11,0 *0.433*	30,0 *1.181*	20,0 *0.787*	43,0 *1.693*	0	PB	0,1 *0.220*
M402111	00056755	G1	G1	11,0 *0.433*	50,0 *1.969*	20,0 *0.787*	63,0 *2.480*	0	PB	0,2 *0.440*
M402220	00056756	G2	G2	14,0 *0.551*	30,0 *1.181*	25,0 *0.984*	46,0 *1.811*	0	PB	0,2 *0.440*
M402221	00056757	G2	G2	14,0 *0.551*	50,0 *1.969*	25,0 *0.984*	66,0 *2.598*	0	PB	0,2 *0.440*
M402330	00056758	G3	G3	18,0 *0.709*	40,0 *1.575*	32,0 *1.260*	60,0 *2.362*	0	PB	0,3 *0.660*
M402331	75056759	G3	G3	18,0 *0.709*	60,0 *2.362*	32,0 *1.260*	80,0 *3.150*	0	PB	0,4 *0.880*
M402440	00056760	G4	G4	22,0 *0.866*	40,0 *1.575*	40,0 *1.575*	64,0 *2.520*	0	PB	0,4 *0.880*
M402441	00056761	G4	G4	22,0 *0.866*	60,0 *2.362*	40,0 *1.575*	84,0 *3.307*	0	PB	0,6 *1.320*
M402444	02786252	G4	G4	22,0 *0.866*	200,0 *7.874*	40,0 *1.575*	224,0 *8.819*	0	PB	1,95 *4.300*
M402550	00056762	G5	G5	28,0 *1.102*	50,0 *1.969*	50,0 *1.969*	80,0 *3.150*	0	PB	0,8 *1.760*
M402551	00056763	G5	G5	28,0 *1.102*	75,0 *2.953*	50,0 *1.969*	105,0 *4.134*	0	PB	1,2 *2.650*
M402552	00056764	G5	G5	28,0 *1.102*	100,0 *3.937*	50,0 *1.969*	130,0 *5.118*	0	PB	1,5 *3.310*
M402554	02786254	G5	G5	28,0 *1.102*	250,0 *9.843*	50,0 *1.969*	280,0 *11.024*	0	PB	3,8 *8.380*
M402660	00056765	G6	G6	36,0 *1.417*	60,0 *2.362*	63,0 *2.480*	100,0 *3.937*	0	PB	1,4 *3.090*
M402661	00056766	G6	G6	36,0 *1.417*	90,0 *3.543*	63,0 *2.480*	130,0 *5.118*	0	PB	2,2 *4.850*
M402662	00056767	G6	G6	36,0 *1.417*	120,0 *4.724*	63,0 *2.480*	160,0 *6.299*	0	PB	2,9 *6.390*
M402664	02786255	G6	G6	36,0 *1.417*	300,0 *11.811*	63,0 *2.480*	340,0 *13.386*	0	PB	7,2 *15.870*
M402770	00056768	G7	G7	46,0 *1.811*	60,0 *2.362*	90,0 *3.543*	110,0 *4.331*	0	-	2,9 *6.390*
M402771	00056769	G7	G7	46,0 *1.811*	90,0 *3.543*	90,0 *3.543*	140,0 *5.512*	0	-	4,4 *9.700*
M402772	00056770	G7	G7	46,0 *1.811*	120,0 *4.724*	90,0 *3.543*	170,0 *6.693*	0	-	5,8 *12.790*
M402774	02786257	G7	G7	46,0 *1.811*	300,0 *11.811*	90,0 *3.543*	350,0 *13.780*	0	-	14,6 *32.190*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Cep	Șurub ansamblu
		
G0	90M0	90F0
G1	90M1	90F1
G2	90M2	90F2
G3	90M3	90F3
G4	90M4	90F4
G5	90M5	90F5
G6	90M6	90F6
G7	90M7	90F7

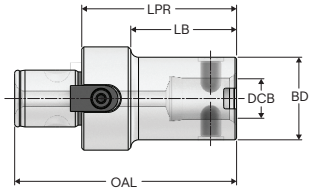
Accesorii

Pentru mărimea	Cheie de blocare
	
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

G 403 – Reducţii Graflex®

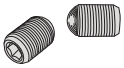
Graflex®





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LPR	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M40310	00056771	G1	G0	8,0 *0.315*	30,0 *1.181*	22,0 *0.866*	16,0 *0.630*	43,0 *1.693*	0	PB	0,1 *0.220*
M40320	00056772	G2	G0	8,0 *0.315*	30,0 *1.181*	19,0 *0.748*	16,0 *0.630*	46,0 *1.811*	0	PB	0,1 *0.220*
M40321	00056773	G2	G1	11,0 *0.433*	30,0 *1.181*	19,0 *0.748*	20,0 *0.787*	46,0 *1.811*	0	PB	0,1 *0.220*
M40330	00056774	G3	G0	8,0 *0.315*	30,0 *1.181*	16,0 *0.630*	16,0 *0.630*	50,0 *1.969*	0	PB	0,2 *0.440*
M40331	00056775	G3	G1	11,0 *0.433*	30,0 *1.181*	16,0 *0.630*	20,0 *0.787*	50,0 *1.969*	0	PB	0,15 *0.330*
M40332	00056776	G3	G2	14,0 *0.551*	30,0 *1.181*	16,0 *0.630*	25,0 *0.984*	50,0 *1.969*	0	PB	0,2 *0.440*
M40341	00056778	G4	G1	11,0 *0.433*	30,0 *1.181*	13,0 *0.512*	20,0 *0.787*	54,0 *2.126*	0	PB	0,25 *0.550*
M40342	00056779	G4	G2	14,0 *0.551*	30,0 *1.181*	13,0 *0.512*	25,0 *0.984*	54,0 *2.126*	0	PB	0,3 *0.660*
M40343	00056780	G4	G3	18,0 *0.709*	30,0 *1.181*	13,0 *0.512*	32,0 *1.260*	54,0 *2.126*	0	PB	0,3 *0.660*
M40350	00056781	G5	G0	8,0 *0.315*	40,0 *1.575*	20,0 *0.787*	16,0 *0.630*	70,0 *2.756*	0	PB	0,47 *1.040*
M40351	00056783	G5	G1	11,0 *0.433*	40,0 *1.575*	20,0 *0.787*	20,0 *0.787*	70,0 *2.756*	0	PB	0,5 *1.100*
M40352	00056785	G5	G2	14,0 *0.551*	40,0 *1.575*	20,0 *0.787*	25,0 *0.984*	70,0 *2.756*	0	PB	0,5 *1.100*
M40353	00056787	G5	G3	18,0 *0.709*	40,0 *1.575*	20,0 *0.787*	32,0 *1.260*	70,0 *2.756*	0	PB	0,6 *1.320*
M40354	00056789	G5	G4	22,0 *0.866*	40,0 *1.575*	20,0 *0.787*	40,0 *1.575*	70,0 *2.756*	0	PB	0,6 *1.320*
M40363	00056797	G6	G3	18,0 *0.709*	40,0 *1.575*	14,0 *0.551*	32,0 *1.260*	80,0 *3.150*	0	PB	1,0 *2.200*
M40364	00056799	G6	G4	22,0 *0.866*	40,0 *1.575*	14,0 *0.551*	40,0 *1.575*	80,0 *3.150*	0	PB	1,0 *2.200*
M40365	00056807	G6	G5	28,0 *1.102*	45,0 *1.772*	19,0 *0.748*	50,0 *1.969*	85,0 *3.346*	0	PB	1,1 *2.430*
M40375	00056811	G7	G5	28,0 *1.102*	50,0 *1.969*	24,0 *0.945*	50,0 *1.969*	100,0 *3.937*	0	-	2,1 *4.630*
M40376	00056812	G7	G6	36,0 *1.417*	55,0 *2.165*	29,0 *1.142*	63,0 *2.480*	105,0 *4.134*	0	-	2,3 *5.070*

Piese de schimb, Piese incluse la livrare

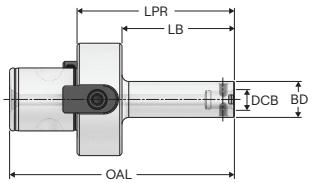
Pentru mărimea	Cep	Șurub ansamblu
		
M40310	90M1	90F0
M40320	90M2	90F0
M40321	90M2	90F1
M40330	90M3	90F0
M40331	90M3	90F1
M40332	90M3	90F2
M40341	90M4	90F1
M40342	90M4	90F2
M40343	90M4	90F3
M40350	90M5	90F0
M40351	90M5	90F1
M40352	90M5	90F2
M40353	90M5	90F3
M40354	90M5	90F4
M40363	90M6	90F3
M40364	90M6	90F4
M40365	90M6	90F5
M40375	90M7	90F5
M40376	90M7	90F6

Accesorii

Pentru mărimea	Cheie de blocare
	
M40310	03H02
M40320	03H02
M40321	03H02
M40330	03H02
M40331	03H02
M40332	03H025
M40341	03H02
M40342	03H025
M40343	03H03
M40350	03H02
M40351	03H02
M40352	03H025
M40353	03H03
M40354	03H04
M40363	03H03
M40364	03H04
M40365	03H05
M40375	03H05
M40376	03H06

G 403 – Reducţii Graflex® lungi
Graflex®





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LPR	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M40350070	00056782	G5	G0	8,0 *0.315*	70,0 *2.756*	50,0 *1.969*	16,0 *0.630*	100,0 *3.937*	0	PB	0,6 *1.320*
M40351080	00056784	G5	G1	11,0 *0.433*	80,0 *3.150*	60,0 *2.362*	20,0 *0.787*	110,0 *4.331*	0	PB	0,6 *1.320*
M40352100	00056786	G5	G2	14,0 *0.551*	100,0 *3.937*	80,0 *3.150*	25,0 *0.984*	130,0 *5.118*	0	PB	0,8 *1.760*
M40353120	00056788	G5	G3	18,0 *0.709*	120,0 *4.724*	100,0 *3.937*	32,0 *1.260*	150,0 *5.906*	0	PB	1,1 *2.430*
M40354150	00056790	G5	G4	22,0 *0.866*	150,0 *5.906*	130,0 *5.118*	40,0 *1.575*	180,0 *7.087*	0	PB	1,7 *3.750*
M40361090	00056794	G6	G1	11,0 *0.433*	90,0 *3.543*	64,0 *2.520*	20,0 *0.787*	130,0 *5.118*	0	PB	1,08 *2.380*
M40362110	00056796	G6	G2	14,0 *0.551*	110,0 *4.331*	84,0 *3.307*	25,0 *0.984*	150,0 *5.906*	0	PB	1,3 *2.870*
M40363120	00056798	G6	G3	18,0 *0.709*	120,0 *4.724*	94,0 *3.701*	32,0 *1.260*	160,0 *6.299*	0	PB	1,5 *3.310*
M40364150	00056800	G6	G4	22,0 *0.866*	150,0 *5.906*	124,0 *4.882*	40,0 *1.575*	190,0 *7.480*	0	PB	2,1 *4.630*
M40365190	00056808	G6	G5	28,0 *1.102*	190,0 *7.480*	164,0 *6.457*	50,0 *1.969*	230,0 *9.055*	0	PB	3,3 *7.280*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Cep	Şurub ansamblu
		
M40350070	90M5	90F0
M40351080	90M5	90F1
M40352100	90M5	90F2
M40353120	90M5	90F3
M40354150	90M5	90F4
M40361090	90M6	90F1
M40362110	90M6	90F2
M40363120	90M6	90F3
M40364150	90M6	90F4
M40365190	90M6	90F5

Accesorii

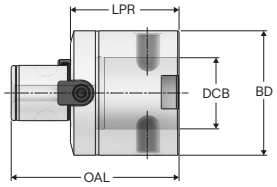
Cheie de blocare

03H02
03H02
03H025
03H03
03H04
03H02
03H025
03H03
03H04
03H05

G 403 – Amplificatoare Graflex®

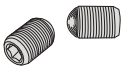
Graflex®





Reper Nr.	Număr reper	CTMS	CTWS	DCB	LPR	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M40356	00056791	G5	G6	36,0 *1.417*	55,0 *2.165*	63,0 *2.480*	85,0 *3.346*	0	PB	1,1 *2.430*
M40367	00056810	G6	G7	46,0 *1.811*	80,0 *3.150*	90,0 *3.543*	120,0 *4.724*	0	PB	3,5 *7.720*

Piese de schimb, Piese incluse la livrare

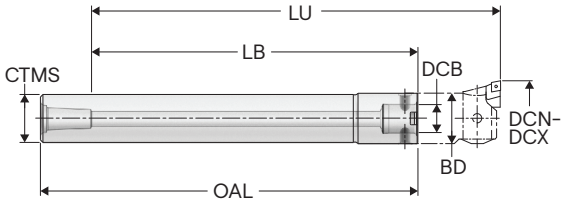
Pentru	Cep	Șurub ansamblu
		
M40356	90M5	90F6
M40367	90M6	90F7

Accesorii

Pentru	Cheie de blocare
	
M40356	03H06
M40367	03H10

G 401 – Arbori Graflex® , oţel
Cilindrică





—Potrivit pentru lungime alezare de precizie până la LU cu cap de alezare de precizie tip A780 sau A790
—Coada cilindrică CTMS dinspre maşină cu toleranţa h5 este compatibilă cu portsculele Shrinkfit

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M4011408	00086938	14	G0	8,0 *0.315*	15,0 *0.591*	18,5 *0.728*	120,0 *4.724*	14,0 *0.551*	110,0 *4.331*	75,0 *2.953*	0	G6.3	0,2 *0.440*
M4011608	00086935	16	G0	8,0 *0.315*	18,0 *0.709*	23,5 *0.925*	150,0 *5.906*	16,0 *0.630*	137,0 *5.394*	102,0 *4.016*	0	G6.3	0,3 *0.660*
M4012011	00086936	20	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	150,0 *5.906*	20,0 *0.787*	140,0 *5.512*	100,0 *3.937*	0	G6.3	0,33 *0.730*
M4012514	00086937	25	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	150,0 *5.906*	25,0 *0.984*	139,0 *5.472*	93,0 *3.661*	0	G6.3	0,6 *1.320*
M4013218	00086939	32	G3	18,0 *0.709*	39,0 *1.535*	51,0 *2.008*	150,0 *5.906*	32,0 *1.260*	155,0 *6.102*	90,0 *3.543*	0	G6.3	0,9 *1.980*

Piese de schimb, Piese incluse la livrare

Pentru	Şurub ansamblu
	
M4011408	90F01
M4011608	90F0
M4012011	90F1
M4012514	90F2
M4013218	90F3

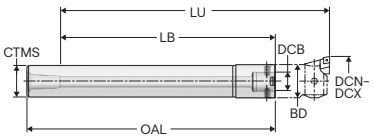
Accesorii

Pentru	Cheie de blocare
	
M4011408	03H025
M4011608	03H02
M4012011	03H02
M4012514	03H025
M4013218	03H03

G 401 – Arbori Graflex®, oţel

Cilindrică

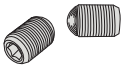




—Potrivit pentru lungime alezare de precizie până la LU cu cap de alezare de precizie tip A780 sau A790
—Coada cilindrică CTMS dinspre maşină cu toleranţa h5 este compatibilă cu portsculele Shrinkfit

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID hole	Echili-brare	Greutate
				Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*			lbs
M40107511	00056741	0,750 in	G1	0.433	0.906	1.220	5.906	0.827	5.510	3.906	0	G6.3	0.660

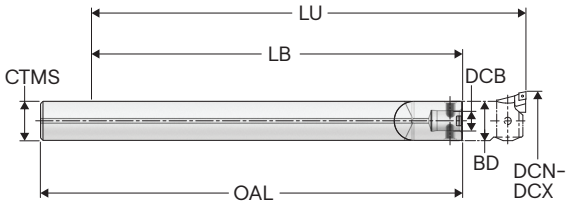
Piese de schimb, Piese incluse la livrare

Pentru mărimea	Cheie de blocare	Şurub ansamblu
		
M40107511	03H02	90F1

G 401 – Arbori Graflex®, carbură

Cilindrică





—Potrivit pentru lungime alezare de precizie până la LU cu cap de alezare de precizie tip A780 sau A790
—CTMS toleranţă h5

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID hole	Echilibrare	Greutate *Greutate*
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M4011408C	00073004	14	G0	8,0 *0.315*	15,0 *0.591*	18,5 *0.728*	152,0 *5.984*	14,0 *0.551*	140,0 *5.512*	105,0 *4.134*	0	G6.3	0,3 *0.660*
M4011608C	00056747	16	G0	8,0 *0.315*	18,0 *0.709*	23,5 *0.925*	175,0 *6.890*	16,0 *0.630*	160,0 *6.299*	125,0 *4.921*	0	G6.3	0,5 *1.100*
M4012011C	00056749	20	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	212,0 *8.346*	20,0 *0.787*	200,0 *7.874*	160,0 *6.299*	0	G6.3	0,9 *1.980*
M4012514C	00056750	25	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	262,0 *10.315*	25,0 *0.984*	250,0 *9.843*	204,0 *8.031*	0	G6.3	1,71 *3.770*
M4013218C	00056751	32	G3	18,0 *0.709*	39,0 *1.535*	51,0 *2.008*	317,0 *12.480*	32,0 *1.260*	320,0 *12.598*	255,0 *10.039*	0	G6.3	3,44 *7.580*

Piese de schimb, Piese incluse la livrare

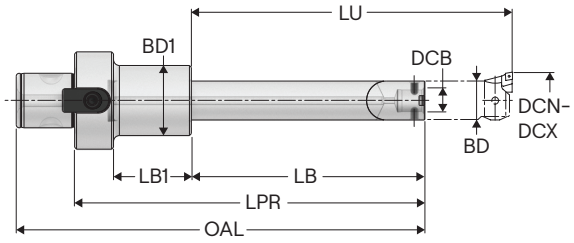
Pentru	Şurub ansamblu
	
M4011408C	90F01
M4011608C	90F0
M4012011C	90F1
M4012514C	90F2
M4013218C	90F3

Accesorii

Pentru	Cheie de blocare
	
M4011408C	03H025
M4011608C	03H02
M4012011C	03H02
M4012514C	03H025
M4013218C	03H03

G 403 – Reducţii Graflex® extra lungi, carbură

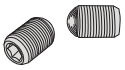




—Extensiile foarte lungi sunt fabricate din carbură.
—Potrivit pentru lungime alezare de precizie până la LU cu cap de alezare de precizie tip A780 sau A790

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	LPR	BD	BD1	LU	LB	LB1	RFID hole	Echili-brare	Greutate *Greutate*
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
M40350C150	00057604	G5	G0	8,0 *0.315*	18,0 *0.709*	23,5 *0.925*	180,0 *7.087*	150,0 *5.906*	16,0 *0.630*	32,0 *1.260*	130,0 *5.118*	95,0 *3.740*	35,0 *1.378*	0	PB	1,0 *2.200*
M40351C180	00056943	G5	G1	11,0 *0.433*	23,0 *0.906*	31,0 *1.220*	210,0 *8.268*	180,0 *7.087*	20,0 *0.787*	36,0 *1.417*	160,0 *6.299*	120,0 *4.724*	40,0 *1.575*	0	PB	1,3 *2.870*
M40352C220	00057605	G5	G2	14,0 *0.551*	30,0 *1.181*	40,0 *1.575*	250,0 *9.843*	220,0 *8.661*	25,0 *0.984*	41,0 *1.614*	200,0 *7.874*	155,0 *6.102*	45,0 *1.772*	0	PB	2,01 *4.430*

Piese de schimb, Piese incluse la livrare

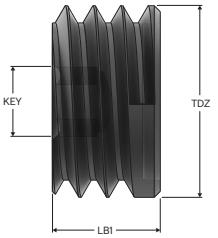
Pentru	Cep	Șurub ansamblu
		
M40350C150	90M5	90F0
M40351C180	90M5	90F1
M40352C220	90M5	90F2

Accesorii

Pentru	Cheie de blocare
	
M40350C150	03H02
M40351C180	03H02
M40352C220	03H025

HSK tuburi de răcire, chei și dopuri de etanșare





—Port-sculele HSK-A la Seco Capto sunt livrate cu un furtun specific pentru lichidul de răcire, disponibil ca piesă de schimb, și necesită o cheie cu tub de răcire specifică; consultaţi paginile de produs pag. 632, 633-634

Descriere	Reper Nr.	Număr reper	Pentru portscule HSK Tip A și E	LB1	LB2	KEY	CNT	TDZ	BHTA°
				mm *Inci*	mm *Inci*	mm *Inci*	mm		
Tuburi pentru lichid de răcire (1)	20E9301	00088814	HSK-A32 & HSK-E32	5,5 *0.217*	20,5 *0.807*	–	6	M10x1	1,0
	20E9302	00088815	HSK-A40 & HSK-E40	7,5 *0.295*	22,0 *0.866*	–	8	M12x1	1,0
	20E9303	00086740	HSK-A50 & HSK-E50	9,5 *0.374*	23,5 *0.925*	–	6	M16x1	1,0
	20E9304	00086741	HSK-A63 & HSK-E63	11,5 *0.453*	25,0 *0.984*	–	8	M18x1	1,0
	20E9306	00086742	HSK-A100 & HSK-E100	15,5 *0.610*	28,5 *1.122*	–	6	M24x1,5	1,0
	20E9307	00088816	HSK-A125	17,5 *0.689*	30,5 *1.201*	–	18	M30x1.5	1,0
Chei pentru tuburi de răcire (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	–	–	–	–	–	–
Bușoane de etanșare (3)	02E9301	00031588	HSK-A32 & HSK-E32	5,0 *0.197*	–	3,0 *0.118*	–	M10x1	–
	02E9302	00031593	HSK-A40 & HSK-E40	7,0 *0.276*	–	4,0 *0.157*	–	M12x1	–
	02E9303	00001002	HSK-A50 & HSK-E50	9,0 *0.354*	–	5,0 *0.197*	–	M16x1	–
	02E9304	00010101	HSK-A63 & HSK-E63	11,0 *0.433*	–	6,0 *0.236*	–	M18x1	–
	02E9306	00014002	HSK-A100 & HSK-E100	15,0 *0.591*	–	10,0 *0.394*	–	M24x1,5	–
	02E9307	00033649	HSK-A125	17,0 *0.669*	–	12,0 *0.472*	–	M30x1.5	–

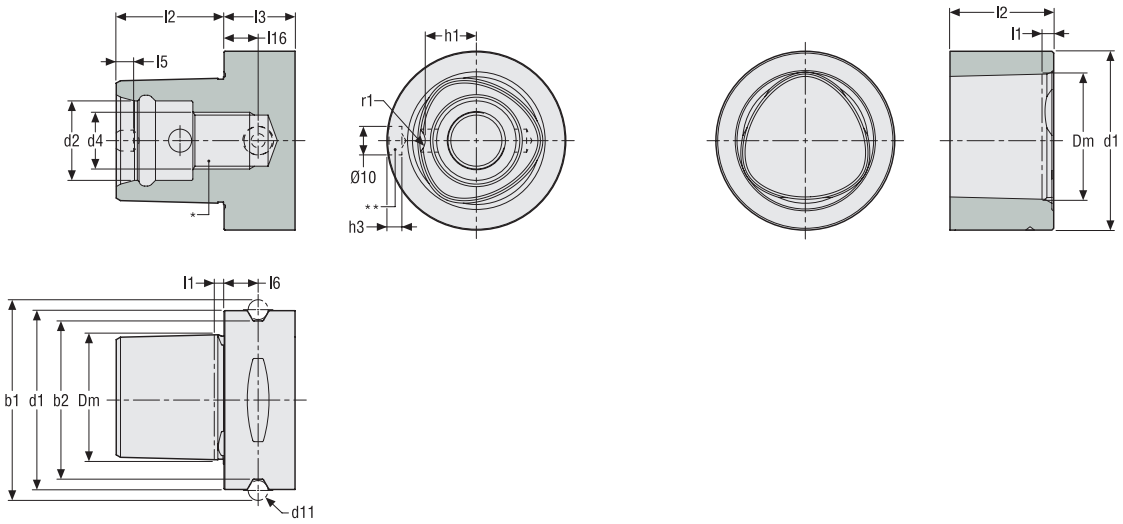


Seco Capto™

Seco Capto™ este un sistem port-sculă modular de top, cu schimbare rapidă, pentru montarea și înlocuirea rapidă a port-sculelor de muchie așchietoare. Gama de scule modulare Seco Capto™ utilizează cuplarea cu coadă poligonală (PSC), în conformitate cu ISO 26623, și dispune de o conexiune conică autoblocantă.

— Gamă de port-scule, cum ar fi Shrinkfit, cu pensete și freză pe dorn
— Arbori de bază Seco Capto™ cu conexiuni HSK, DIN, BT
— Casetă Seco Capto™ pentru mai multă fiabilitate și șurub de blocare

Seco Capto™ , norme dimensionale
ISO 26623-1-PSC/ ISO 26623-2-PSC



Descriere catalog partea dinspre mașină	Gaură pentru cip RFID**	d_1	d_2	d_4	d_{11}	Dm	b_1	b_2	l_1	l_2	$l_{3\ min}$	l_5	l_6	l_{16}	h_1	h_3	r_1
		mm *Inci*	mm *Inci*		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*
C3	Nu**	32 *1.260*	15 *0.591*	M12	5 *0.197*	22 *0.866*	39 *1.535*	28,3 *1.114*	2,5 *0.098*	19 *0.748*	15 *0.591*	3,2 *0.126*	6 *0.236*	9 *0.354*	9 *0.354*	5,4 *0.213*	3 *0.118*
C4	Nu**	40 *1.575*	18 *0.709*	M14	5 *0.197*	28 *1.102*	46 *1.811*	35,3 *1.390*	2,5 *0.098*	24 *0.945*	20 *0.787*	4 *0.157*	8 *0.315*	12 *0.472*	11 *0.433*	5,2 *0.205*	3 *0.118*
C5	**	50 *1.969*	21 *0.827*	M16	7 *0.276*	35 *1.378*	59,3 *2.335*	44,4 *1.748*	3 *0.118*	30 *1.181*	20 *0.787*	5,3 *0.209*	10 *0.394*	12 *0.472*	14 *0.551*	5,1 *0.201*	4 *0.157*
C6	**	63 *2.480*	28 *1.102*	M20	7 *0.276*	44 *1.732*	70,7 *2.783*	55,8 *2.197*	3 *0.118*	38 *1.496*	22 *0.866*	6,2 *0.244*	12 *0.472*	12 *0.472*	18 *0.709*	5 *0.197*	5 *0.197*
C8	**	80 *3.150*	32 *1.260*	M20	7 *0.276*	55 *2.165*	86 *3.386*	71,1 *2.799*	3 *0.118*	48 *1.890*	30 *1.181*	8 *0.315*	12 *0.472*	12 *0.472*	22,2 *0.874*	4,9 *0.193*	6 *0.236*

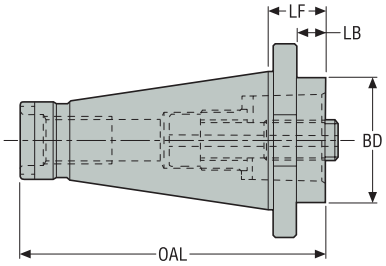
Spre catalog partea dinspre mașină	Gaură pentru cip RFID**	$d_{1\ min}$	d_3	Dm	l_1	l_2	l_3	l_4
		mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*
C3	Nu	32 *1.260*	2 *0.079*	22 *0.866*	2,3 *0.091*	18,4 *0.724*	16,5 *0.650*	9,4 *0.370*
C4	Nu	40 *1.575*	2,5 *0.098*	28 *1.102*	2,3 *0.091*	23,4 *0.921*	21 *0.827*	11,5 *0.453*
C5	Nu	50 *1.969*	3 *0.118*	35 *1.378*	2,8 *0.110*	29,4 *1.157*	26 *1.024*	14,5 *0.571*
C6	**	63 *2.480*	4 *0.157*	44 *1.732*	2,8 *0.110*	37,4 *1.472*	33,5 *1.319*	18,5 *0.728*
C8	**	80 *3.150*	5 *0.197*	55 *2.165*	2,8 *0.110*	47,4 *1.866*	43 *1.693*	22,8 *0.898*

Notă: Dimensiunile spre mașină și spre semifabricat se aplică la toate portsculele arătate în pagina de produs.
* Partea dinspre mașină Seco Capto™ a extensiilor scurte poate fi montată doar în arbori cu prindere pe segment (nu cu bolț central de prindere). Partea dinspre mașină Seco Capto™ a reducțiilor scurte
poate fi montată doar în arbori cu prindere pe segment (nu cu bolț central de prindere).
** Pentru a vedea dacă există gaură pentru cip RFID, vezi coloana „Gaură RFID" din pagina de produs: 1 = există gaură pentru cip RFID, la cerere se poate monta un cip RFID.
0 = nu există gaură pentru cip RFID, la cerere, se poate executa o gaură pentru Cip RFID și se poate monta un cip RFID.

C 00 – Suporturi DIN 2080 la Seco Capto™ – ISO 26623-2

DIN 2080

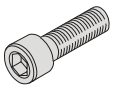




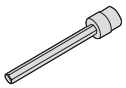
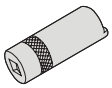
Accesorii:
3 = Cheie de extensie
4 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C3-390.00-40030	75039844	DIN(2080)40	C3	30,0 *1.181*	18,4 *0.724*	32,0 *1.260*	123,4 *4.858*	0	–	0,9 *1.980*
C4-390.00-40030	75039848	DIN(2080)40	C4	30,0 *1.181*	18,4 *0.724*	40,0 *1.575*	123,4 *4.858*	0	–	1,0 *2.200*
C4-390.00-40060	75039849	DIN(2080)40	C4	60,0 *2.362*	48,4 *1.906*	40,0 *1.575*	153,4 *6.039*	0	–	1,08 *2.380*
C5-390.00-40030	75039852	DIN(2080)40	C5	30,0 *1.181*	18,4 *0.724*	50,0 *1.969*	123,4 *4.858*	0	–	0,81 *1.790*
C6-390.00-40075	00048158	DIN(2080)40	C6	75,0 *2.953*	0,0 –	63,0 *2.480*	168,4 *6.630*	0	–	1,82 *4.010*
C3-390.00-50030	75039846	DIN(2080)50	C3	30,0 *1.181*	14,8 *0.583*	32,0 *1.260*	156,8 *6.173*	0	–	2,5 *5.510*
C3-390.00-50060	75039847	DIN(2080)50	C3	60,0 *2.362*	44,8 *1.764*	32,0 *1.260*	186,8 *7.354*	0	–	2,5 *5.510*
C4-390.00-50030	75039850	DIN(2080)50	C4	30,0 *1.181*	14,8 *0.583*	40,0 *1.575*	156,8 *6.173*	0	–	2,5 *5.510*
C4-390.00-50060	75039851	DIN(2080)50	C4	60,0 *2.362*	44,8 *1.764*	40,0 *1.575*	186,8 *7.354*	0	–	2,5 *5.510*
C5-390.00-50030	75039854	DIN(2080)50	C5	30,0 *1.181*	14,8 *0.583*	50,0 *1.969*	156,8 *6.173*	0	–	2,62 *5.780*
C5-390.00-50070	75039855	DIN(2080)50	C5	70,0 *2.756*	54,8 *2.157*	50,0 *1.969*	196,8 *7.748*	0	–	3,29 *7.250*
C6-390.00-50030	75039856	DIN(2080)50	C6	30,0 *1.181*	14,8 *0.583*	63,0 *2.480*	156,8 *6.173*	0	–	2,56 *5.640*
C6-390.00-50080	75039857	DIN(2080)50	C6	80,0 *3.150*	64,8 *2.551*	63,0 *2.480*	206,8 *8.142*	0	–	3,27 *7.210*
C8-390.00-50070	75039858	DIN(2080)50	C8	70,0 *2.756*	54,8 *2.157*	80,0 *3.150*	196,8 *7.748*	0	–	3,8 *8.380*
C8-390.00-50120	75039859	DIN(2080)50	C8	120,0 *4.724*	104,8 *4.126*	80,0 *3.150*	246,8 *9.717*	0	–	5,6 *12.350*

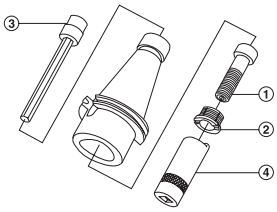
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Piuliță de fixare
		
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

Accesorii

Pentru	Prelungitor	Cheie fixă
		
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

Accesorii / Piese de schimb



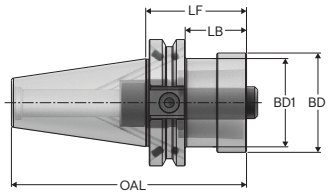
Accesorii:
3 = Cheie de extensie
4 = Cheie

Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare

C 55/58 – Suporturi CAT la Seco Capto™

CAT / ASME B5.50-2009-ADB

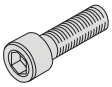




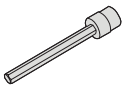
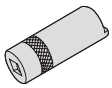
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				Inci	*Inci*	*Inci*	*Inci*				lbs
C3-A390B.45-40060	02925929	CAT40 ADB	C3	2.362	1.610	1.260	5.055	2	0	PB	2.200
C4-A390B.45-40030	02925932	CAT40 ADB	C4	1.181	0.429	1.575	3.874	2	0	PB	1.980
C4-A390B.45-40060	02925933	CAT40 ADB	C4	2.362	1.610	1.575	5.055	2	0	PB	2.430
C5-A390B.45-40040	02925935	CAT40 ADB	C5	1.575	0.823	1.969	4.268	2	0	PB	2.200
C5-A390B.45-40080	02925936	CAT40 ADB	C5	3.150	2.398	1.969	5.843	2	0	PB	3.310
C6-A390B.45-40085	02925939	CAT40 ADB	C6	3.346	1.378	2.480	6.039	2	0	PB	4.190
C3-A390B.45-50030	02925930	CAT50 ADB	C3	1.181	0.429	1.260	5.185	2	0	PB	6.390
C3-A390B.45-50060	02925931	CAT50 ADB	C3	2.362	1.610	1.260	6.366	2	0	PB	5.970
C4-A390B.45-50030	02925948	CAT50 ADB	C4	1.181	0.429	1.575	5.185	2	0	PB	5.780
C4-A390B.45-50060	02925934	CAT50 ADB	C4	2.362	1.610	1.969	6.366	2	0	PB	6.610
C5-A390B.45-50030	02925937	CAT50 ADB	C5	1.181	0.429	1.969	5.185	2	0	PB	5.510
C5-A390B.45-50070	02925938	CAT50 ADB	C5	2.756	2.004	1.969	6.760	2	0	PB	6.610
C6-A390B.45-50030	02925940	CAT50 ADB	C6	1.181	0.429	2.480	5.185	2	0	PB	5.510
C6-A390B.45-50080	02925941	CAT50 ADB	C6	3.150	2.398	2.480	7.154	2	0	PB	7.940
C8-A390B.45-50070	02925942	CAT50 ADB	C8	2.756	2.004	3.150	6.760	2	0	PB	7.940
C8-A390B.45-50120	02925943	CAT50 ADB	C8	4.724	3.972	3.150	8.728	2	0	PB	12.350

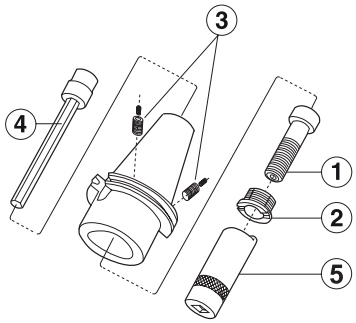
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Dop	Piuliță de fixare	Dop de etanșare
				
CAT40/ C3	5512063-10	564301701	5512091-04	–
CAT40/ C4	5512063-07	564301701	5512091-03	–
CAT40/ C5	5512063-08	564301701	5512091-01	–
CAT40/ C6	5512063-13	564301701	5512091-02	–
CAT50/ C3	5512063-10	564301702	5512091-04	–
CAT50/ C4-50030	5512063-07	564301701	5512091-03	564301702
CAT50/ C4-50060	5512063-07	564301702	5512091-03	–
CAT50/ C5	5512063-08	564301702	5512091-01	–
CAT50/ C6	5512063-09	564301702	5512091-02	–
CAT50/ C8	5512063-09	564301702	5512091-02	–

Accesorii

Pentru	Prelungitor	Cheie fixă
		
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

Accesorii / Piese de schimb



Accesorii:
4 = Cheie de extensie
5 = Cheie

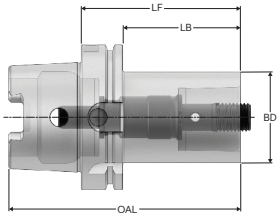
Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare
3 = Dopuri (dibluri)

C 410 – Suporturi HSK-A la Seco Capto™ – ISO 26623-2

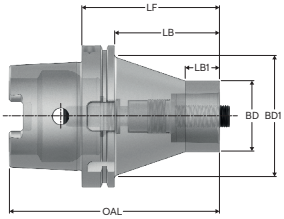
HSK-A/ ISO12164-1-HSK-A



Design 1



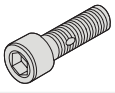
Design 2



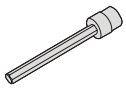
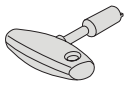
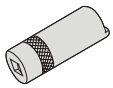
Accesorii:
2 = Cheie de extensie
4 = Cheie
6 = Cheie pentru tubul de lichid de răcire

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
HA10-C3-032-080	10197961	HSK-A100	C3	80,0 *3.150*	51,0 *2.008*	–	32,0 *1.260*	–	130,0 *5.118*	1	1	PB	2,5 *5.510*
HA06-C3-032-075	10197962	HSK-A63	C3	75,0 *2.953*	49,0 *1.929*	–	32,0 *1.260*	–	107,0 *4.213*	1	1	PB	0,9 *1.980*
HA10-C4-040-090	10197963	HSK-A100	C4	90,0 *3.543*	61,0 *2.402*	–	40,0 *1.575*	–	140,0 *5.512*	1	1	PB	2,5 *5.510*
HA06-C4-040-080	10197964	HSK-A63	C4	80,0 *3.150*	54,0 *2.126*	–	40,0 *1.575*	–	112,0 *4.409*	1	1	PB	1,1 *2.430*
HA10-C5-050-100	10197965	HSK-A100	C5	100,0 *3.937*	71,0 *2.795*	–	50,0 *1.969*	–	150,0 *5.906*	1	1	PB	2,9 *6.390*
HA06-C5-050-090	10197966	HSK-A63	C5	90,0 *3.543*	64,0 *2.520*	–	50,0 *1.969*	–	122,0 *4.803*	1	1	PB	1,3 *2.870*
HA10-C6-063-110	10197967	HSK-A100	C6	110,0 *4.331*	81,0 *3.189*	–	63,0 *2.480*	–	160,0 *6.299*	1	1	PB	3,6 *7.940*
HA10-C8-080-120	10197968	HSK-A100	C8	120,0 *4.724*	91,0 *3.583*	–	80,0 *3.150*	–	170,0 *6.693*	1	1	PB	4,8 *10.580*
HSKA125-C6-120	03229625	HSK-A125	C6	120,0 *4.724*	91,0 *3.583*	–	63,0 *2.480*	–	183,0 *7.205*	1	1	PB	5,2 *11.460*
HSKA125-C6-120-V	03229626	HSK-A125	C6	120,0 *4.724*	91,0 *3.583*	30,0 *1.181*	63,0 *2.480*	108,0 *4.252*	183,0 *7.205*	2	1	PB	6,4 *14.110*
HSKA125-C8-130	03229627	HSK-A125	C8	130,0 *5.118*	101,0 *3.976*	–	80,0 *3.150*	–	193,0 *7.598*	1	1	PB	6,5 *14.330*
HSKA125-C8-130-V	03229628	HSK-A125	C8	130,0 *5.118*	101,0 *3.976*	30,0 *1.181*	80,0 *3.150*	105,0 *4.134*	193,0 *7.598*	2	1	PB	7,8 *17.200*

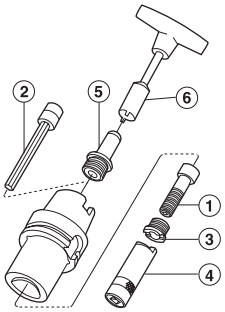
Piese de schimb, Piese incluse la livrare

Pentru	Şurub central	Tub răcire	Piuliţă de fixare
			
HA06-C3-032-075	5512067-01	5692020-04	5512091-04
HA06-C4-040-080	5512067-02	5692020-04	5512091-03
HA06-C5-050-090	5512067-03	5692020-04	5512091-01
HA10-C3-032-080	5512067-01	5692020-06	5512091-04
HA10-C4-040-090	5512067-02	5692020-06	5512091-03
HA10-C5-050-100	5512067-03	5692020-06	5512091-01
HA10-C6-063-110	5512067-04	5692020-06	5512091-02
HA10-C8-080-120	5512067-04	5692020-06	5512091-02
HSKA125-C6-120	5512063-09	5692020-07	5512091-02
HSKA125-C6-120-V	5512063-09	5692020-07	5512091-02
HSKA125-C8-130	5512063-09	5692020-07	5512091-02
HSKA125-C8-130-V	5512063-09	5692020-07	5512091-02

Accesorii

Pentru	Prelungitor	Cheie	Cheie fixă
			
HA06-C3-032-075	5680015-05	5680094-04	5680065-13
HA06-C4-040-080	5680015-05	5680094-04	5680065-10
HA06-C5-050-090	5680015-01	5680094-04	5680065-11
HA10-C3-032-080	5680015-05	5680094-06	5680065-13
HA10-C4-040-090	5680015-05	5680094-06	5680065-10
HA10-C5-050-100	5680015-01	5680094-06	5680065-11
HA10-C6-063-110	5680015-02	5680094-06	5680065-12
HA10-C8-080-120	5680015-02	5680094-06	5680065-12
HSKA125-C6-120	5680015-02	5680094-07	5680065-12
HSKA125-C6-120-V	5680015-02	5680094-07	5680065-12
HSKA125-C8-130	5680015-02	5680094-07	5680065-12
HSKA125-C8-130-V	5680015-02	5680094-07	5680065-12

Accesorii / Piese de schimb



Accesorii:
2 = Cheie de extensie
4 = Cheie
6 = Cheie pentru tubul de lichid de răcire

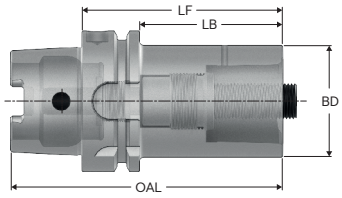
Piese de schimb:
1 = Șurub central
3 = Piuliță de fixare
5 = Tuburi de agent de răcire*

*Fiecare portsculă HSK-A la Seco Capto™ se livrează cu o conductă specifică pentru lichidul de răcire

C 411 – Suporturi HSK-T la Seco Capto™ – ISO 26623-2

HSK-T/ ISO12164-3-HSK-T

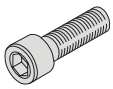




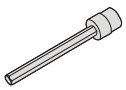
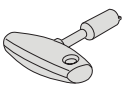
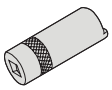
Accesorii:
2 = Cheie de extensie
4 = Cheie
6 = Cheie pentru tubul de lichid de răcire

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C4-390.411-63080	02786511	HSK-T63	C4	80,0 *3.150*	54,0 *2.126*	40,0 *1.575*	112,0 *4.409*	1	–	1,1 *2.430*
C5-390.411-63090	02786520	HSK-T63	C5	90,0 *3.543*	64,0 *2.520*	50,0 *1.969*	122,0 *4.803*	1	–	1,5 *3.310*
C4-390.411-100090	02786519	HSK-T100	C4	90,0 *3.543*	61,0 *2.402*	40,0 *1.575*	140,0 *5.512*	1	–	2,6 *5.730*
C5-390.411-100100	02786521	HSK-T100	C5	100,0 *3.937*	71,0 *2.795*	50,0 *1.969*	150,0 *5.906*	1	–	3,0 *6.610*
C6-390.411-100110	02786522	HSK-T100	C6	110,0 *4.331*	81,0 *3.189*	63,0 *2.480*	160,0 *6.299*	1	–	3,6 *7.940*
C8-390.411-100120	02786523	HSK-T100	C8	120,0 *4.724*	91,0 *3.583*	80,0 *3.150*	170,0 *6.693*	1	–	4,8 *10.580*

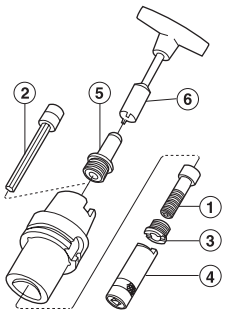
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Tub răcire	Piuliță de fixare
			
C4-390.411-100090	5512063-07	20E9306	5512091-03
C4-390.411-63080	5512063-07	5692020-04	5512091-03
C5-390.411-100100	5512063-08	20E9306	5512091-01
C5-390.411-63090	5512063-08	5692020-04	5512091-01
C6-390.411-100110	5512063-09	5692020-06	5512091-02
C8-390.411-100120	5512063-09	5692020-06	5512091-02

Accesorii

Pentru	Prelungitor	Cheie	Cheie fixă
			
C4-390.411-100090	5680015-05	5680094-06	5680065-10
C4-390.411-63080	5680015-05	5680094-04	5680065-10
C5-390.411-100100	5680015-01	5680094-06	5680065-11
C5-390.411-63090	5680015-01	5680094-04	5680065-11
C6-390.411-100110	5680015-02	5680094-06	5680065-12
C8-390.411-100120	5680015-02	5680094-06	5680065-12

Accesorii / Piese de schimb



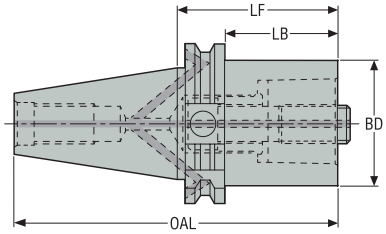
Accesorii:
2 = Cheie de extensie
4 = Cheie
6 = Cheie pentru tubul de lichid de răcire

Piese de schimb:
1 = Șurub central
3 = Piuliță de fixare
5 = Tuburi de agent de răcire*

*Fiecare portsculă HSK-A la Seco Capto™ se livrează cu o conductă specifică pentru lichidul de răcire

C 140 – Suporturi DIN la Seco Capto™ – ISO 26623-2
DIN 69871-ADB

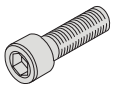




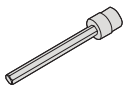
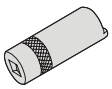
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C3-390B.140-40030	02924104	DIN40 ADB	C3	30,0 *1.181*	10,9 *0.429*	32,0 *1.260*	98,4 *3.874*	0	PB	0,8 *1.760*
C3-390B.140-40060	02924105	DIN40 ADB	C3	60,0 *2.362*	40,9 *1.610*	32,0 *1.260*	128,4 *5.055*	0	PB	0,9 *1.980*
C4-390B.140-40030	02924108	DIN40 ADB	C4	30,0 *1.181*	10,9 *0.429*	40,0 *1.575*	98,4 *3.874*	0	PB	0,8 *1.760*
C4-390B.140-40060	02924109	DIN40 ADB	C4	60,0 *2.362*	40,9 *1.610*	40,0 *1.575*	128,4 *5.055*	0	PB	1,1 *2.430*
C5-390B.140-40040	02924112	DIN40 ADB	C5	40,0 *1.575*	20,9 *0.823*	50,0 *1.969*	108,4 *4.268*	0	PB	0,9 *1.980*
C5-390B.140-40080	02924113	DIN40 ADB	C5	80,0 *3.150*	60,9 *2.398*	50,0 *1.969*	148,4 *5.843*	0	PB	1,5 *3.310*
C6-390B.140-40085	02924116	DIN40 ADB	C6	85,0 *3.346*	65,9 *2.594*	63,0 *2.480*	153,4 *6.039*	0	PB	1,8 *3.970*
C3-390B.140-50030	02924106	DIN50 ADB	C3	30,0 *1.181*	10,9 *0.429*	32,0 *1.260*	131,7 *5.185*	0	PB	2,6 *5.730*
C3-390B.140-50060	02924107	DIN50 ADB	C3	60,0 *2.362*	40,9 *1.610*	32,0 *1.260*	161,7 *6.366*	0	PB	2,7 *5.950*
C4-390B.140-50030	02924110	DIN50 ADB	C4	30,0 *1.181*	10,9 *0.429*	40,0 *1.575*	131,7 *5.185*	0	PB	2,6 *5.730*
C4-390B.140-50060	02924111	DIN50 ADB	C4	60,0 *2.362*	40,9 *1.610*	40,0 *1.575*	161,7 *6.366*	0	PB	2,8 *6.170*
C5-390B.140-50030	02924114	DIN50 ADB	C5	30,0 *1.181*	10,9 *0.429*	50,0 *1.969*	131,7 *5.185*	0	PB	2,6 *5.730*
C5-390B.140-50070	02924115	DIN50 ADB	C5	70,0 *2.756*	50,9 *2.004*	50,0 *1.969*	171,7 *6.760*	0	PB	3,1 *6.830*
C6-390B.140-50030	02924117	DIN50 ADB	C6	30,0 *1.181*	10,9 *0.429*	63,0 *2.480*	131,7 *5.185*	0	PB	2,4 *5.290*
C6-390B.140-50080	02924118	DIN50 ADB	C6	80,0 *3.150*	60,9 *2.398*	63,0 *2.480*	181,7 *7.154*	0	PB	3,6 *7.940*
C8-390B.140-50070	02924119	DIN50 ADB	C8	70,0 *2.756*	50,9 *2.004*	80,0 *3.150*	171,7 *6.760*	0	PB	3,7 *8.160*
C8-390B.140-50120	02924120	DIN50 ADB	C8	120,0 *4.724*	100,9 *3.972*	80,0 *3.150*	221,7 *8.728*	0	PB	5,5 *12.130*

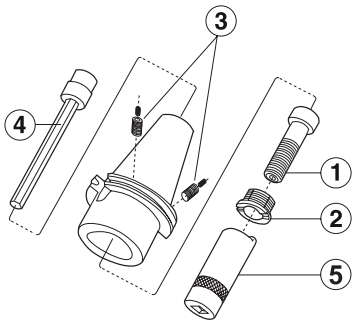
Piese de schimb, Piese incluse la livrare

Pentru	Şurub central	Dop	Piuliţă de fixare
			
C3-400	5512063-10	564301701	5512091-04
C3-500	5512063-10	564301702	5512091-04
C4-400	5512063-07	564301701	5512091-03
C4-500	5512063-07	564301702	5512091-03
C5-400	5512063-08	564301701	5512091-01
C5-500	5512063-08	564301702	5512091-01
C6-400	5512063-13	564301701	5512091-02
C6-500	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Accesorii

Pentru	Prelungitor	Cheie fixă
		
C3-400	5680015-05	5680065-13
C3-500	5680015-05	5680065-13
C4-400	5680015-05	5680065-10
C4-500	5680015-05	5680065-10
C5-400	5680015-01	5680065-11
C5-500	5680015-01	5680065-11
C6-400	5680015-01	5680065-12
C6-500	5680015-02	5680065-12
C8	5680015-02	5680065-12

Accesorii / Piese de schimb



Accesorii:
4 = Cheie de extensie
5 = Cheie

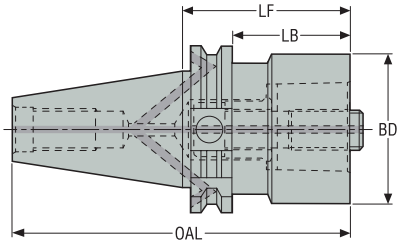
Piese de schimb:
1 = Şurub central
2 = Piuliţă de fixare
3 = Dopuri (dibluri)

C 5191 – Seco Capto™, suporturi de bază – ISO 26623-2

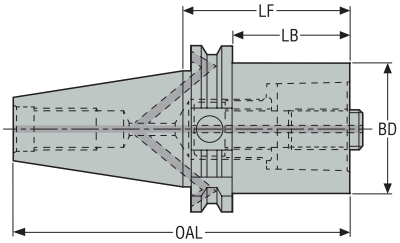
DIN Taper-face-ADB



Design 1



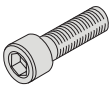
Design 2



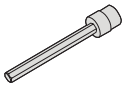
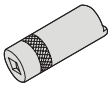
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF mm *Inci*	LB mm *Inci*	BD mm *Inci*	OAL mm *Inci*	RFID hole	Echili-brare	Greutate kg *lbs*
E316951915050	03030258	DIN40 TF ADB	C5	50,0 *1.969*	30,9 *1.217*	50,0 *1.969*	118,4 *4.661*	1	PB	1,1 *2.430*
E317151915070	03030264	DIN50 TF ADB	C5	70,0 *2.756*	50,9 *2.004*	50,0 *1.969*	171,7 *6.760*	1	PB	3,1 *6.830*
E317151916350	03030262	DIN50 TF ADB	C6	50,0 *1.969*	30,9 *1.217*	63,0 *2.480*	151,7 *5.972*	0	–	2,9 *6.390*
E3171519163100	03030265	DIN50 TF ADB	C6	100,0 *3.937*	80,9 *3.185*	63,0 *2.480*	201,7 *7.941*	1	PB	4,1 *9.040*
E317151918070	03030263	DIN50 TF ADB	C8	70,0 *2.756*	50,9 *2.004*	80,0 *3.150*	171,7 *6.760*	0	–	3,9 *8.600*
E3171519180120	03030266	DIN50 TF ADB	C8	120,0 *4.724*	100,9 *3.972*	80,0 *3.150*	221,7 *8.728*	0	–	5,6 *12.350*

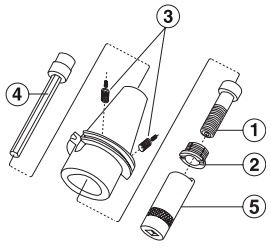
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Dop	Piuliță de fixare
			
DIN40 TF/ C5	5512063-08	564301701	5512091-01
DIN50 TF/ C5	5512063-08	564301702	5512091-01
DIN50 TF/ C6-C8	5512063-09	564301702	5512091-02

Accesorii

Pentru	Prelungitor	Cheie fixă
		
DIN40 TF/ C5	5680015-01	5680065-11
DIN50 TF/ C5	5680015-01	5680065-11
DIN50 TF/ C6-C8	5680015-02	5680065-12

Accesorii / Piese de schimb



Accesorii:
4 = Cheie de extensie
5 = Cheie

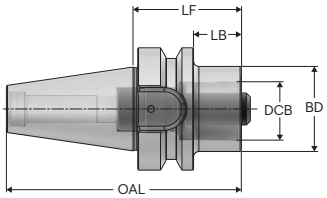
Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare
3 = Dopuri (dibluri)

C 55/58 – Suporturi BT la Seco Capto™ – ISO 26623-2

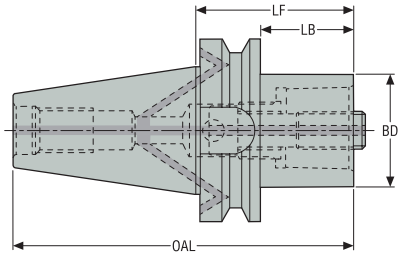
BT



Design 1



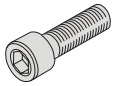
Design 2



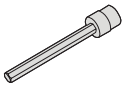
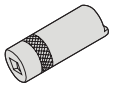
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C3-390.55-30030	75039807	BT30 AD	C3	30,0 *1.181*	8,0 *0.315*	32,0 *1.260*	78,4 *3.087*	0	PB	0,53 *1.170*
C3-390.55-30060	75039808	BT30 AD	C3	60,0 *2.362*	38,0 *1.496*	32,0 *1.260*	108,4 *4.268*	0	PB	0,73 *1.610*
C3-390B.55-40030	02925959	BT40 ADB	C3	30,0 *1.181*	3,0 *0.118*	32,0 *1.260*	95,4 *3.756*	0	PB	1,0 *2.200*
C3-390B.55-40060	02925960	BT40 ADB	C3	60,0 *2.362*	33,0 *1.299*	32,0 *1.260*	125,4 *4.937*	0	PB	1,1 *2.430*
C4-390B.55-40030	02925963	BT40 ADB	C4	30,0 *1.181*	3,0 *0.118*	40,0 *1.575*	95,4 *3.756*	0	PB	0,9 *1.980*
C4-390B.55-40060	02925964	BT40 ADB	C4	60,0 *2.362*	33,0 *1.299*	40,0 *1.575*	125,4 *4.937*	0	PB	1,2 *2.650*
C5-390B.55-40050	02925967	BT40 ADB	C5	50,0 *1.969*	23,0 *0.906*	50,0 *1.969*	115,4 *4.543*	0	PB	1,1 *2.430*
C5-390B.55-40090	02925968	BT40 ADB	C5	90,0 *3.543*	63,0 *2.480*	50,0 *1.969*	155,4 *6.118*	0	PB	1,7 *3.750*
C6-390B.55-40075	02925971	BT40 ADB	C6	75,0 *2.953*	54,6 *2.150*	63,0 *2.480*	140,4 *5.528*	0	PB	1,7 *3.750*
C3-390B.58-50040	02925961	BT50 ADB	C3	40,0 *1.575*	2,0 *0.079*	32,0 *1.260*	141,8 *5.583*	0	PB	3,5 *7.720*
C3-390B.58-50070	02925962	BT50 ADB	C3	70,0 *2.756*	32,0 *1.260*	32,0 *1.260*	171,8 *6.764*	0	PB	3,7 *8.160*
C4-390B.58-50040	02925965	BT50 ADB	C4	40,0 *1.575*	2,0 *0.079*	40,0 *1.575*	141,8 *5.583*	0	PB	3,5 *7.720*
C4-390B.58-50070	02925966	BT50 ADB	C4	70,0 *2.756*	32,0 *1.260*	40,0 *1.575*	171,8 *6.764*	0	PB	3,8 *8.380*
C5-390B.58-50040	02925969	BT50 ADB	C5	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	0	PB	3,4 *7.500*
C5-390B.58-50080	02925970	BT50 ADB	C5	80,0 *3.150*	42,0 *1.654*	50,0 *1.969*	181,8 *7.157*	0	PB	3,9 *8.600*
C6-390B.58-50050	02925972	BT50 ADB	C6	50,0 *1.969*	12,0 *0.472*	63,0 *2.480*	151,8 *5.976*	0	PB	3,5 *7.720*
C6-390B.58-50100	02925973	BT50 ADB	C6	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	201,8 *7.945*	0	PB	4,6 *10.140*
C8-390B.58-50070	02925974	BT50 ADB	C8	70,0 *2.756*	32,0 *1.260*	80,0 *3.150*	171,8 *6.764*	0	PB	4,0 *8.820*
C8-390B.58-50120	02925975	BT50 ADB	C8	120,0 *4.724*	82,0 *3.228*	80,0 *3.150*	221,8 *8.732*	0	PB	5,9 *13.010*

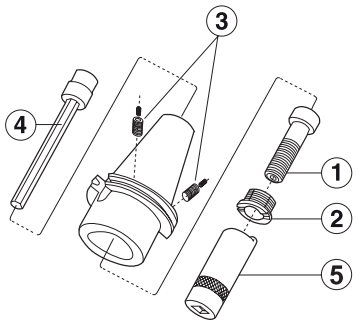
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Dop	Piuliță de fixare
			
C3-390.55	5512063-10	–	5512091-04
C3-390B.55	5512063-10	564301701	5512091-04
C3-390B.58	5512063-10	564301702	5512091-04
C4-390B.55	5512063-07	564301701	5512091-03
C4-390B.58	5512063-07	564301702	5512091-03
C5-390B.55	5512063-08	564301701	5512091-01
C5-390B.58	5512063-08	564301702	5512091-01
C6-390B.55	5512063-13	564301701	5512091-02
C6-390B.58	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Accesorii

Pentru	Prelungitor	Cheie fixă
		
C3-390.55	5680015-05	5680065-13
C3-390B.55	5680015-05	5680065-13
C3-390B.58	5680015-05	5680065-13
C4-390B.55	5680015-05	5680065-10
C4-390B.58	5680015-05	5680065-10
C5-390B.55	5680015-01	5680065-11
C5-390B.58	5680015-01	5680065-11
C6-390B.55	5680015-01	5680065-12
C6-390B.58	5680015-02	5680065-12
C8	5680015-02	5680065-12

Accesorii / Piese de schimb

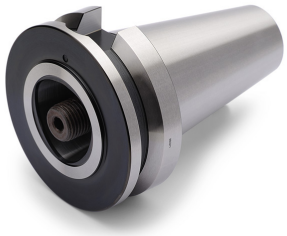


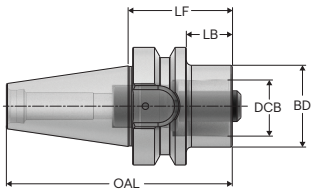
Accesorii:
4 = Cheie de extensie
5 = Cheie

Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare
3 = Dopuri (dibluri)

C 605 – Suporturi BT Mazak la Seco Capto™ – ISO 26623-2

BT Mazak



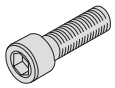


—Designul Mazak înseamnă un poligon Seco Capto™ rotit la 90° în comparaţie cu suporturile clasice BT Basic
—Pentru e-machines Mazak

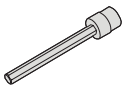
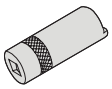
Accesorii:
3 = Cheie de extensie
4 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C5-390.605-40030	02606358	BT40 AD Mazak	C5	30,0 *1.181*	3,0 *0.118*	50,0 *1.969*	95,4 *3.756*	0	–	1,1 *2.430*
C6-390.605-50040	02606354	BT50 AD Mazak	C6	40,0 *1.575*	2,0 *0.079*	63,0 *2.480*	141,8 *5.583*	0	–	3,3 *7.280*
C8-390.605-50070	02646032	BT50 AD Mazak	C8	70,0 *2.756*	70,0 *2.756*	80,0 *3.150*	171,8 *6.764*	0	–	4,0 *8.820*

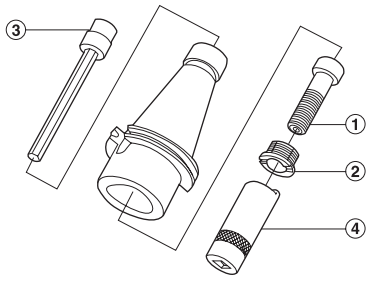
Piese de schimb, Piese incluse la livrare

Pentru	Şurub central	Piuliţă de fixare
		
C5	5512063-08	5512091-01
C6	5512063-09	5512091-02
C8	5512063-09	5512091-02

Accesorii

Pentru	Prelungitor	Cheie fixă
		
C5	5680015-01	5680065-11
C6	5680015-02	5680065-12
C8	5680015-02	5680065-12

Accesorii / Piese de schimb



Accesorii:
3 = Cheie de extensie
4 = Cheie

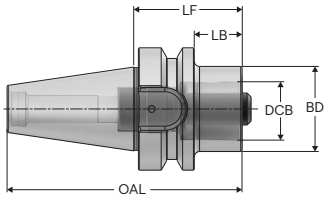
Piese de schimb:
1 = Şurub central
2 = Piuliţă de fixare

C 5191 – Seco Capto™, suporturi de bază – ISO 26623-2

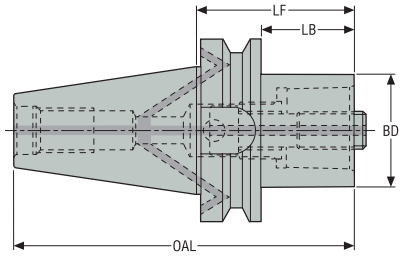
BT Taper-face-AD/ADB



Design 1



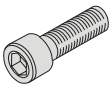
Design 2



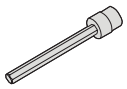
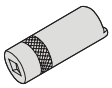
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
E400251913240	03030234	BT30 TF AD	C3	40,0 *1.575*	22,0 *0.866*	32,0 *1.260*	88,4 *3.480*	1	PB	0,454 *1.000*
E400251914060	03030235	BT30 TF AD	C4	60,0 *2.362*	22,0 *0.866*	40,0 *1.575*	108,4 *4.268*	1	PB	0,7 *1.540*
E311451914040	03030236	BT40 TF ADB	C4	40,0 *1.575*	13,0 *0.512*	40,0 *1.575*	105,4 *4.150*	0	PB	1,1 *2.430*
E311451915050	03030237	BT40 TF ADB	C5	50,0 *1.969*	23,0 *0.906*	50,0 *1.969*	115,4 *4.543*	0	PB	1,2 *2.650*
E311451916375	03030238	BT40 TF ADB	C6	75,0 *2.953*	48,0 *1.890*	63,0 *2.480*	140,4 *5.528*	0	PB	1,7 *3.750*
E311651914040	03030239	BT50 TF ADB	C4	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	1	PB	3,5 *7.720*
E311651915040	03030240	BT50 TF ADB	C5	40,0 *1.575*	2,0 *0.079*	50,0 *1.969*	141,8 *5.583*	0	PB	3,4 *7.500*
E311651916350	03030241	BT50 TF ADB	C6	50,0 *1.969*	12,0 *0.472*	63,0 *2.480*	151,8 *5.976*	0	PB	3,5 *7.720*
E3116519163100	03030242	BT50 TF ADB	C6	100,0 *3.937*	62,0 *2.441*	63,0 *2.480*	201,8 *7.945*	0	PB	4,8 *10.580*
E311651918070	03030243	BT50 TF ADB	C8	70,0 *2.756*	32,0 *1.260*	80,0 *3.150*	171,8 *6.764*	0	PB	4,0 *8.820*
E3116519180120	03030244	BT50 TF ADB	C8	120,0 *4.724*	82,0 *3.228*	80,0 *3.150*	121,8 *4.795*	1	PB	5,9 *13.010*

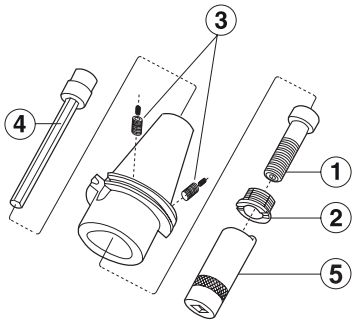
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Dop	Piuliță de fixare
			
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

Accesorii

Pentru	Prelungitor	Cheie fixă
		
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

Accesorii / Piese de schimb



Accesorii:
4 = Cheie de extensie
5 = Cheie

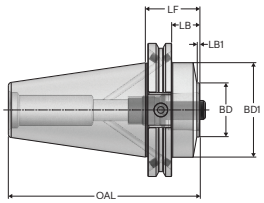
Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare
3 = Dopuri (dibluri)

C 5191 – Seco Capto™, suporturi de bază

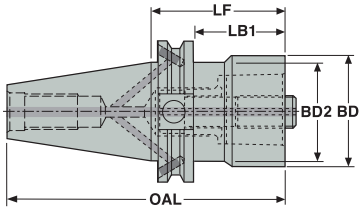
CAT TF / ASME B5.50-1994-ADB



Design 1



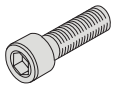
Design 2



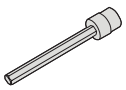
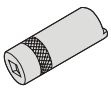
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Varianta	RFID hole	Echili-brare	Greutate
				Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*				lbs
E234251915050	03030247	CAT40 TF ADB	C5	1.969	1.220	1.220	1.969	1.750	4.660	2	1	PB	2.250
E234451914040	03030249	CAT50 TF ADB	C4	1.575	0.090	0.090	1.575	2.750	5.580	1	1	PB	6.830
E234451915040	03030250	CAT50 TF ADB	C5	1.575	0.090	0.090	1.969	2.750	5.580	1	0	-	6.610
E234451916340	03030251	CAT50 TF ADB	C6	1.575	0.120	0.120	2.480	2.750	5.580	1	0	-	6.170
E234451916390	03030252	CAT50 TF ADB	C6	3.543	2.085	2.085	2.480	2.750	7.543	1	0	-	8.600
E2344519180100	03030253	CAT50 TF ADB	C8	3.937	3.185	3.185	3.150	2.750	7.937	2	1	PB	10.140

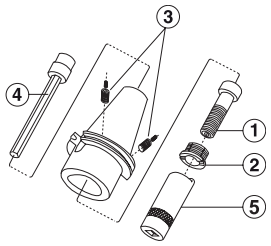
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Dop	Piuliță de fixare
			
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

Accesorii

Pentru	Prelungitor	Cheie fixă
		
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

Accesorii / Piese de schimb



Accesorii:
4 = Cheie de extensie
5 = Cheie

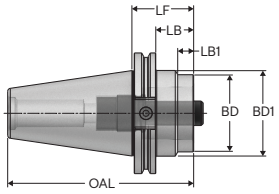
Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare
3 = Dopuri (dibluri)

C 5191 – Seco Capto™, suporturi de bază

Utilaj CAT TF Mazak™ și seria Mori Seiki NT™



Design 1

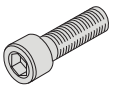


—Poligon rotit la 90°, pentru controlul precis al vârfului sculei

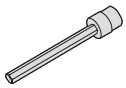
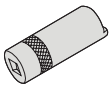
Accesorii:
4 = Cheie de extensie
5 = Cheie

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				Inci	*Inci*	*Inci*	*Inci*	*Inci*	*Inci*				lbs
E947451916350	03030255	CAT50 TF AD Mazak	C6	1.969	0.510	0.510	2.480	2.750	5.960	1	0	PB	6.830

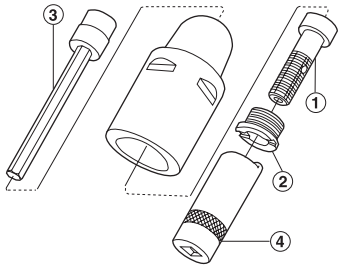
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Piuliță de fixare
		
E947451916350	5512063-09	5512091-02

Accesorii

Pentru	Prelungitor	Cheie fixă
		
E947451916350	5680015-02	5680065-12

Accesorii / Piese de schimb

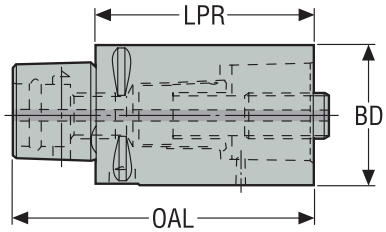


Accesorii:
3 = Cheie de extensie
4 = Cheie piuliță de fixare

Piese de schimb:
1 = Șurub central
2 = Piuliță de fixare

C 01 – Seco Capto™, extensii
ISO 26623-1

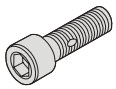




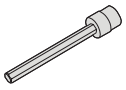
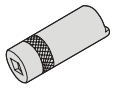
Accesorii:
3 = Cheie de extensie
4 = Cheie piuliţă de fixare

Reper Nr.	Număr reper	CTMS	CTWS	LPR	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C3-391.01-32060A	75039884	C3	C3	60,0 *2.362*	32,0 *1.260*	79,0 *3.110*	0	-	0,4 *0.880*
C3-391.01-32080A	00090847	C3	C3	80,0 *3.150*	32,0 *1.260*	99,0 *3.898*	0	-	0,5 *1.100*
C4-391.01-40060A	75039885	C4	C4	60,0 *2.362*	40,0 *1.575*	84,0 *3.307*	0	-	0,6 *1.320*
C4-391.01-40080A	02207391	C4	C4	80,0 *3.150*	40,0 *1.575*	104,0 *4.094*	0	-	0,8 *1.760*
C5-391.01-50080A	75039886	C5	C5	80,0 *3.150*	50,0 *1.969*	110,0 *4.331*	0	-	1,1 *2.430*
C5-391.01-50100A	00004773	C5	C5	100,0 *3.937*	50,0 *1.969*	130,0 *5.118*	0	-	1,4 *3.090*
C6-391.01-63100A	75039887	C6	C6	100,0 *3.937*	63,0 *2.480*	138,0 *5.433*	0	-	2,2 *4.850*
C6-391.01-63140A	00004840	C6	C6	140,0 *5.512*	63,0 *2.480*	178,0 *7.008*	0	-	3,1 *6.830*
C8-391.01-80100A	75039888	C8	C8	100,0 *3.937*	80,0 *3.150*	148,0 *5.827*	0	-	3,7 *8.160*
C8-391.01-80125A	00004841	C8	C8	125,0 *4.921*	80,0 *3.150*	173,0 *6.811*	0	-	4,6 *10.140*

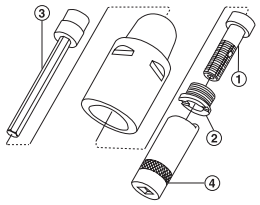
Piese de schimb, Piese incluse la livrare

Pentru	Şurub central	Piuliţă de fixare
		
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

Accesorii

Pentru	Prelungitor	Cheie fixă
		
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

Accesorii / Piese de schimb



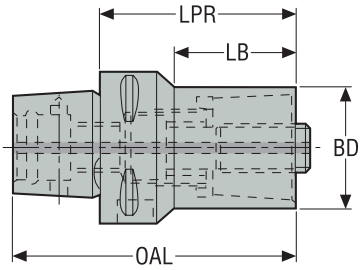
Accesorii:
3 = Cheie de extensie
4 = Cheie piuliţă de fixare

Piese de schimb:
1 = Şurub central
2 = Piuliţă de fixare

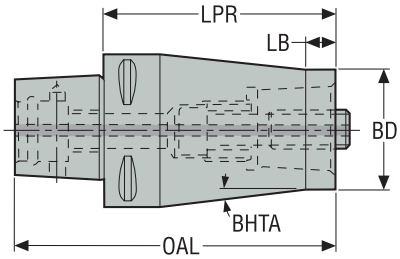
C 02 – Seco Capto™, reducţii
ISO 26623-1



Design 1



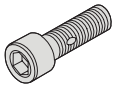
Design 2



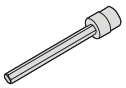
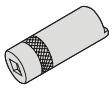
Accesorii:
3 = Cheie de extensie
4 = Cheie piuliţă de fixare

Reper Nr.	Număr reper	CTMS	CTWS	LPR	LB	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
C4-391.02-32055A	75039889	C4	C3	55,0 *2.165*	31,0 *1.220*	32,0 *1.260*	79,0 *3.110*	1	0	-	0,42 *0.930*
C4-391.02-32070A	02535687	C4	C3	70,0 *2.756*	–	32,0 *1.260*	94,0 *3.701*	2	0	-	0,56 *1.230*
C5-391.02-32060A	75039890	C5	C3	60,0 *2.362*	34,8 *1.370*	32,0 *1.260*	90,0 *3.543*	1	0	-	0,7 *1.540*
C5-391.02-40065A	75039891	C5	C4	65,0 *2.559*	40,0 *1.575*	40,0 *1.575*	95,0 *3.740*	1	0	-	0,8 *1.760*
C6-391.02-32070A	75039892	C6	C3	70,0 *2.756*	39,0 *1.535*	32,0 *1.260*	108,0 *4.252*	1	0	-	1,1 *2.430*
C6-391.02-40080A	75039893	C6	C4	80,0 *3.150*	51,4 *2.024*	40,0 *1.575*	118,0 *4.646*	1	0	-	1,2 *2.650*
C6-391.02-50080A	75039894	C6	C5	80,0 *3.150*	51,5 *2.028*	50,0 *1.969*	118,0 *4.646*	1	0	-	1,4 *3.090*
C6-391.02-50110A	02207400	C6	C5	110,0 *4.331*	12,0 *0.472*	50,0 *1.969*	148,0 *5.827*	2	0	-	2,2 *4.850*
C8-391.02-32060B	03080008	C8	C3	60,0 *2.362*	20,7 *0.815*	32,0 *1.260*	108,0 *4.252*	1	0	-	2,0 *4.410*
C8-391.02-40070B	03080009	C8	C4	70,0 *2.756*	31,4 *1.236*	40,0 *1.575*	118,0 *4.646*	1	0	-	2,1 *4.630*
C8-391.02-50080B	03080011	C8	C5	80,0 *3.150*	42,8 *1.685*	50,0 *1.969*	128,0 *5.039*	1	0	-	2,4 *5.290*
C8-391.02-63080B	02527212	C8	C6	80,0 *3.150*	44,5 *1.752*	63,0 *2.480*	128,0 *5.039*	1	0	-	2,6 *5.730*
C8-391.02-63120A	02207176	C8	C6	120,0 *4.724*	12,0 *0.472*	63,0 *2.480*	168,0 *6.614*	2	0	-	4,1 *9.040*

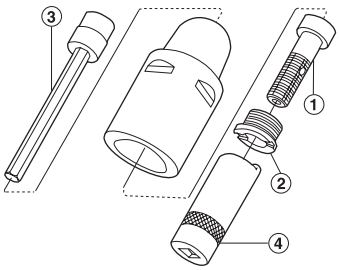
Piese de schimb, Piese incluse la livrare

Pentru	Şurub central	Piuliţă de fixare
		
C...-32	5512067-01	5512091-04
C...-40	5512067-02	5512091-03
C...-50	5512067-03	5512091-01
C...-63	5512067-04	5512091-02

Accesorii

Pentru	Prelungitor	Cheie fixă
		
C...-32	5680015-05	5680065-13
C...-40	5680015-05	5680065-10
C...-50	5680015-01	5680065-11
C...-63	5680015-02	5680065-12

Accesorii / Piese de schimb



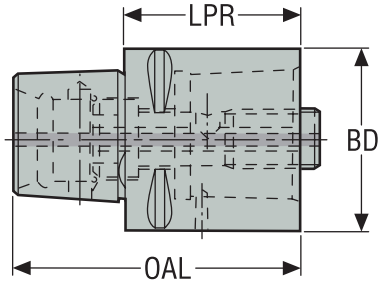
Accesorii:
3 = Cheie de extensie
4 = Cheie piuliţă de fixare

Piese de schimb:
1 = Şurub central
2 = Piuliţă de fixare

C01 Extensii Seco Capto ™, versiune scurtă, numai pentru fixare pe segment

ISO 26623-1



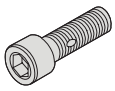


—Partea dinspre mașină Seco Capto™ a extensiilor scurte pot fi montate doar în arbori cu prindere pe segment (nu cu bolţ central de prindere).

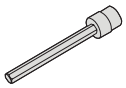
Accesorii:
3 = Cheie de extensie

Reper Nr.	Număr reper	CTMS	CTWS	LPR	BD	OAL	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*			kg *lbs*
C3-391.01-32035	02535685	C3	C3	35,0 *1.378*	32,0 *1.260*	54,0 *2.126*	0	–	0,3 *0.660*
C4-391.01-40040	02535686	C4	C4	40,0 *1.575*	40,0 *1.575*	64,0 *2.520*	0	–	0,4 *0.880*
C5-391.01-50050	02484934	C5	C5	50,0 *1.969*	50,0 *1.969*	80,0 *3.150*	0	–	0,7 *1.540*
C6-391.01-63060	02300834	C6	C6	60,0 *2.362*	63,0 *2.480*	98,0 *3.858*	0	–	1,3 *2.870*
C8-391.01-80065	02417041	C8	C8	65,0 *2.559*	80,0 *3.150*	113,0 *4.449*	0	–	2,4 *5.290*

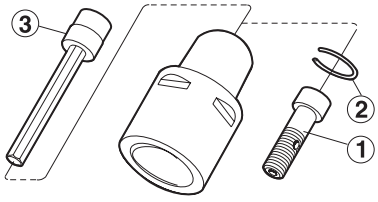
Piese de schimb, Piese incluse la livrare

Pentru	Șurub central	Inel de siguranţă
		
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

Accesorii

Pentru	Prelungitor
	
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

Accesorii / Piese de schimb



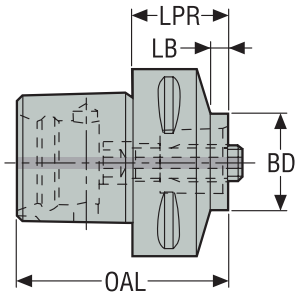
Accesorii:
3 = Cheie de extensie

Piese de schimb:
1 = Șurub central
2 = Șaibă elastică

C02 Reducţii Seco Capto ™, versiune scurtă, numai pentru fixare pe segment

ISO 26623-1



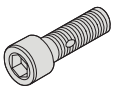


—Partea dinspre maşină Seco Capto™ a reducţiilor scurte pot fi montate doar în arbori cu prindere pe segment (nu cu bolţ central de prindere).
—* Cu 180° offset partea maşinii vs partea piesei de prelucrat

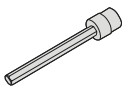
Accesorii:
3 = Cheie de extensie

Reper Nr.	Număr reper	CTMS	CTWS	LPR	LB	BD	OAL	*	RFID hole	Echili-brare	Greutate
				mm *Inci*	mm *Inci*	mm *Inci*	mm *Inci*				kg *lbs*
C5-391.02-32033A	03080025	C5	C3	33,0 *1.299*	5,0 *0.197*	32,0 *1.260*	63,0 *2.480*		0	PB	0,6 *1.320*
C5-391.02-40040A	03079983	C5	C4	40,0 *1.575*	15,0 *0.591*	40,0 *1.575*	70,0 *2.756*		0	–	0,6 *1.320*
C6-391.02-32032	02535690	C6	C3	32,0 *1.260*	6,0 *0.236*	32,0 *1.260*	70,0 *2.756*		0	–	0,85 *1.870*
C6-391.02-40040	02459467	C6	C4	40,0 *1.575*	11,0 *0.433*	40,0 *1.575*	78,0 *3.071*		0	–	0,9 *1.980*
C6-391.02-50050A	03080019	C6	C5	50,0 *1.969*	20,0 *0.787*	50,0 *1.969*	88,0 *3.465*		0	–	1,1 *2.430*
C8-391.02-50045A	03080010	C8	C5	45,0 *1.772*	5,0 *0.197*	50,0 *1.969*	93,0 *3.661*		0	–	1,9 *4.190*
C8-391.02-63055A	03080012	C8	C6	55,0 *2.165*	15,0 *0.591*	63,0 *2.480*	103,0 *4.055*		0	–	2,1 *4.630*
C8-391.02R-63055A	03080030	C8	C6	55,0 *2.165*	15,0 *0.591*	63,0 *2.480*	103,0 *4.055*	*	0	–	1,9 *4.190*

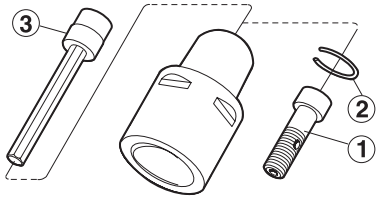
Piese de schimb, Piese incluse la livrare

Pentru	Şurub central	Inel de siguranţă
		
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

Accesorii

Prelungitor

5680015-05
5680015-05
5680015-05
5680015-05
5680015-01
5680015-01
5680015-02
5680015-02

Accesorii / Piese de schimb



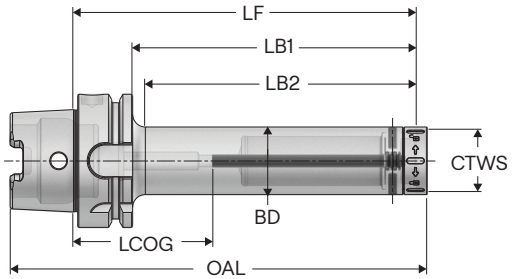
Accesorii:
3 = Cheie de extensie

Piese de schimb:
1 = Şurub central
2 = Şaibă elastică

GL – Steadyline®, suporturi HSK-T/A GL

Diametre 25, 32, 40 și 50 mm / 0.984, 1.260, 1.575 and 1.969 inch

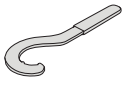




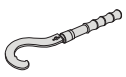
—Cu amortizare dinamică, gata de utilizare
—Cu canale pentru lichid de răcire
—* Max. RPM numai atunci când se utilizează la alezarea prin rotație

Reper Nr.	Număr reper	CTMS HSK-T/A	CTWS Mărime GL	BD	LF	LB1	LB2	OAL	LCOG	RPM max.*	RFID hole	Echili-brare	Greutate
				mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*				kg *lbs*
HSKTA63-GL25-130-K	03214283	HSK-T/A63	GL25	25,0 *0.984*	130,0 *5.118*	104,0 *4.094*	101,0 *3.976*	166,5 *6.555*	37,0 *1.457*	10000	1	–	1,4 *3.1*
HSKTA63-GL25-180-K	03214284	HSK-T/A63	GL25	25,0 *0.984*	180,0 *7.087*	154,0 *6.063*	151,0 *5.945*	216,5 *8.524*	57,7 *2.272*	8000	1	–	1,5 *3.3*
HSKTA63-GL25-230-K	03214285	HSK-T/A63	GL25	25,0 *0.984*	230,0 *9.055*	204,0 *8.031*	201,0 *7.913*	266,5 *10.492*	80,3 *3.161*	6000	1	–	1,5 *3.3*
E9374-D32-160-GL32	03029521	HSK-T/A63	GL32	32,0 *1.260*	160,0 *6.299*	134,0 *5.276*	128,0 *5.039*	197,4 *7.772*	58,92 *2.320*	10000	1	–	1,6 *3.5*
E9374-D32-224-GL32	03029522	HSK-T/A63	GL32	32,0 *1.260*	224,0 *8.819*	198,0 *7.795*	192,0 *7.559*	261,4 *10.291*	90,22 *3.552*	8000	1	–	2,0 *4.4*
E9374-D40-208-GL40	03029523	HSK-T/A63	GL40	40,0 *1.575*	208,0 *8.189*	182,0 *7.165*	176,0 *6.929*	246,4 *9.701*	92,78 *3.653*	8000	1	–	2,7 *6.0*
E9374-D40-288-GL40	03029524	HSK-T/A63	GL40	40,0 *1.575*	288,0 *11.339*	262,0 *10.315*	256,0 *10.079*	326,4 *12.850*	134,37 *5.290*	6000	1	–	3,5 *7.7*
E9374-D50-268-GL50	03029525	HSK-T/A63	GL50	50,0 *1.969*	268,0 *10.551*	242,0 *9.528*	240,5 *9.469*	307,4 *12.102*	131,8 *5.189*	6000	1	–	4,8 *10.6*
E9374-D50-368-GL50	03029526	HSK-T/A63	GL50	50,0 *1.969*	368,0 *14.488*	342,0 *13.465*	340,5 *13.406*	407,4 *16.039*	184,79 *7.275*	4000	1	–	6,4 *14.1*
E9376-D32-160-GL32	03029527	HSK-T/A100	GL32	32,0 *1.260*	160,0 *6.299*	131,0 *5.157*	125,0 *4.921*	215,4 *8.480*	32,87 *1.294*	10000	1	–	3,0 *6.6*
E9376-D32-224-GL32	03029528	HSK-T/A100	GL32	32,0 *1.260*	224,0 *8.819*	195,0 *7.677*	189,0 *7.441*	279,4 *11.000*	54,97 *2.164*	8000	1	–	3,4 *7.5*
E9376-D32-288-GL32	03029529	HSK-T/A100	GL32	32,0 *1.260*	288,0 *11.339*	259,0 *10.197*	253,0 *9.961*	343,4 *13.520*	80,51 *3.170*	6000	1	–	3,8 *8.4*
E9376-D40-208-GL40	03029530	HSK-T/A100	GL40	40,0 *1.575*	208,0 *8.189*	179,0 *7.047*	173,0 *6.811*	264,4 *10.409*	62,83 *2.474*	8000	1	–	4,1 *9.0*
E9376-D40-288-GL40	03029531	HSK-T/A100	GL40	40,0 *1.575*	288,0 *11.339*	259,0 *10.197*	253,0 *9.961*	344,4 *13.559*	98,31 *3.870*	6000	1	–	4,9 *10.8*
E9376-D40-368-GL40	03029532	HSK-T/A100	GL40	40,0 *1.575*	368,0 *14.488*	339,0 *13.346*	333,0 *13.110*	424,4 *16.709*	139,77 *5.503*	5000	1	–	5,8 *12.8*
E9376-D50-268-GL50	03029533	HSK-T/A100	GL50	50,0 *1.969*	268,0 *10.551*	239,0 *9.409*	234,0 *9.213*	325,4 *12.811*	104,26 *4.105*	6000	1	–	6,2 *13.7*
E9376-D50-368-GL50	03029534	HSK-T/A100	GL50	50,0 *1.969*	368,0 *14.488*	339,0 *13.346*	334,0 *13.150*	425,4 *16.748*	154,26 *6.073*	4000	1	–	7,8 *17.2*
E9376-D50-468-GL50	03029535	HSK-T/A100	GL50	50,0 *1.969*	468,0 *18.425*	439,0 *17.283*	434,0 *17.087*	525,4 *20.685*	211,61 *8.331*	2500	1	–	9,7 *21.4*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Cheie de blocare
	
GL25	SL25
GL32	SL32
GL40	SL40
GL50	SL50

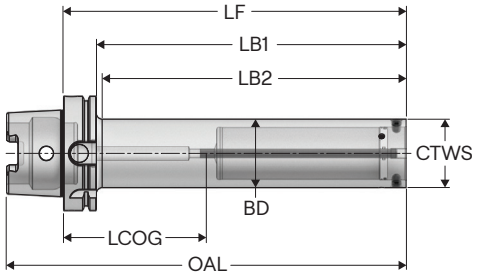
Accesorii

Capăt interschimbabil	Cheie dinamometrică
	
SL00-25	SL00-25.250
SL00-32	SL00-32.250
SL00-40	SL00-40.350
SL00-50	SL00-50.550

BA – Steadyline®, suporturi HSK-T/A-BA

Diametre 60 și 80 mm / 2.362 și 3.150 inch





—Cu amortizare dinamică, gata de utilizare
—Pentru monta adaptoarele BA la GL cu capete de strunjire GL
—Cu canale pentru lichid de răcire
—* Max. RPM numai atunci când se utilizează la alezarea prin rotaţie

Reper Nr.	Număr reper	CTMS Mărime HSK-T/A	CTWS BA connection	BD	LF	LB1	LB2	OAL	LCOG	RPM max.*	RFID hole	Echilibrare	Greutate
				mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*				kg *lbs*
E9376-D60-301-BA060	03062828	HSK-T/A100	BA060	60,0 *2.362*	301,0 *11.850*	272,0 *10.709*	267,0 *10.512*	351,0 *13.819*	133,05 *5.238*	4000	1	PB	8,9 *19.6*
E9376-D60-421-BA060	03062829	HSK-T/A100	BA060	60,0 *2.362*	421,0 *16.575*	392,0 *15.433*	387,0 *15.236*	471,0 *18.543*	197,17 *7.763*	3000	1	PB	11,8 *26.0*
E9376-D60-541-BA060	03062830	HSK-T/A100	BA060	60,0 *2.362*	541,0 *21.299*	512,0 *20.157*	507,0 *19.961*	591,0 *23.268*	260,56 *10.258*	2000	1	PB	14,5 *32.0*
E9376-D80-421-BA080	03064109	HSK-T/A100	BA080	80,0 *3.150*	421,0 *16.575*	392,0 *15.433*	387,0 *15.236*	471,0 *18.543*	209,68 *8.255*	3000	1	PB	19,4 *42.8*
E9376-D80-581-BA080	03064111	HSK-T/A100	BA080	80,0 *3.150*	581,0 *22.874*	552,0 *21.732*	547,0 *21.535*	631,0 *24.843*	295,45 *11.632*	2000	1	PB	25,6 *56.4*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub de blocare
	
BA060	90FQ4
BA080	90FQ52

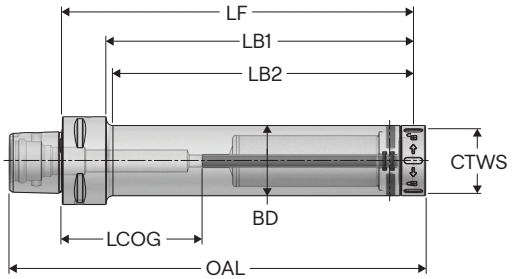
Accesorii

Pentru mărimea	Cheie de blocare
	
BA060	03H04
BA080	03H05

GL – Steadyline®, suporturi GL

Diametre 25, 32, 40 și 50 mm / 0.984, 1.260, 1.575 and 1.969 inch





—Cu amortizare dinamică, gata de utilizare
—Cu canale pentru lichid de răcire
—* Max. RPM numai atunci când se utilizează la alezarea prin rotaţie

Reper Nr.	Număr reper	CTMS Mărime Seco Capto™	CTWS Mărime GL	BD	LF	LB1	LB2	OAL	LCOG	RPM max.*	RFID hole	Echilibrare	Greutate
				mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*				kg *lbs*
C4-D25-130-GL25	03214272	C4	GL25	25,0 *0.984*	130,0 *5.118*	110,0 *4.331*	107,0 *4.213*	158,5 *6.240*	51,8 *2.039*	10000	0	PB	0,9 *2.0*
C4-D25-180-GL25	03214273	C4	GL25	25,0 *0.984*	180,0 *7.087*	160,0 *6.299*	157,0 *6.181*	208,5 *8.209*	77,2 *3.039*	8000	0	PB	1,2 *2.7*
C4-D32-160-GL32	02807837	C4	GL32	32,0 *1.260*	160,0 *6.299*	140,0 *5.512*	137,0 *5.394*	189,4 *7.457*	74,73 *2.942*	10000	0	PB	1,4 *3.1*
C4-D32-224-GL32	02807838	C4	GL32	32,0 *1.260*	224,0 *8.819*	204,0 *8.031*	201,0 *7.913*	253,4 *9.976*	109,16 *4.298*	8000	0	PB	1,7 *3.8*
C5-D25-130-GL25	03214274	C5	GL25	25,0 *0.984*	130,0 *5.118*	110,0 *4.331*	107,0 *4.213*	164,5 *6.476*	41,8 *1.646*	10000	1	PB	1,1 *2.4*
C5-D25-180-GL25	03214275	C5	GL25	25,0 *0.984*	180,0 *7.087*	160,0 *6.299*	157,0 *6.181*	214,5 *8.445*	65,1 *2.563*	8000	1	PB	1,3 *2.9*
C5-D25-230-GL25	03214276	C5	GL25	25,0 *0.984*	230,0 *9.055*	210,0 *8.268*	207,0 *8.150*	264,5 *10.413*	89,8 *3.535*	6000	1	PB	1,5 *3.3*
C5-D32-160-GL32	02807840	C5	GL32	32,0 *1.260*	160,0 *6.299*	140,0 *5.512*	136,0 *5.354*	195,4 *7.693*	65,15 *2.565*	10000	1	PB	1,6 *3.5*
C5-D32-224-GL32	02807841	C5	GL32	32,0 *1.260*	224,0 *8.819*	204,0 *8.031*	200,0 *7.874*	259,4 *10.213*	98,47 *3.877*	8000	1	PB	2,0 *4.4*
C5-D32-288-GL32	02807842	C5	GL32	32,0 *1.260*	288,0 *11.339*	268,0 *10.551*	264,0 *10.394*	323,4 *12.732*	133,61 *5.260*	6000	1	PB	2,2 *4.9*
C5-D40-208-GL40	02807843	C5	GL40	40,0 *1.575*	208,0 *8.189*	188,0 *7.402*	184,0 *7.244*	244,4 *9.622*	98,32 *3.871*	8000	1	PB	2,8 *6.2*
C5-D40-288-GL40	02807844	C5	GL40	40,0 *1.575*	288,0 *11.339*	268,0 *10.551*	264,0 *10.394*	324,4 *12.772*	140,88 *5.546*	6000	1	PB	3,3 *7.3*
C6-D25-130-GL25	03214277	C6	GL25	25,0 *0.984*	130,0 *5.118*	105,0 *4.134*	102,0 *4.016*	172,5 *6.791*	30,4 *1.197*	10000	1	PB	1,6 *3.5*
C6-D25-180-GL25	03214278	C6	GL25	25,0 *0.984*	180,0 *7.087*	155,0 *6.102*	152,0 *5.984*	222,5 *8.760*	49,3 *1.941*	8000	1	PB	1,5 *3.3*
C6-D25-230-GL25	03214279	C6	GL25	25,0 *0.984*	230,0 *9.055*	205,0 *8.071*	202,0 *7.953*	272,5 *10.728*	70,2 *2.764*	6000	1	PB	1,7 *3.8*
C6-D32-160-GL32	02807846	C6	GL32	32,0 *1.260*	160,0 *6.299*	135,0 *5.315*	129,0 *5.079*	203,4 *8.008*	52,06 *2.050*	10000	1	PB	1,8 *4.0*
C6-D32-224-GL32	02807847	C6	GL32	32,0 *1.260*	224,0 *8.819*	199,0 *7.835*	193,0 *7.598*	267,4 *10.528*	82,17 *3.235*	8000	1	PB	2,2 *4.9*
C6-D32-288-GL32	02807848	C6	GL32	32,0 *1.260*	288,0 *11.339*	263,0 *10.354*	257,0 *10.118*	331,4 *13.047*	114,87 *4.522*	6000	1	PB	2,6 *5.7*
C6-D40-208-GL40	02807849	C6	GL40	40,0 *1.575*	208,0 *8.189*	183,0 *7.205*	177,0 *6.969*	252,4 *9.937*	86,42 *3.402*	8000	1	PB	2,9 *6.4*
C6-D40-288-GL40	02807850	C6	GL40	40,0 *1.575*	288,0 *11.339*	263,0 *10.354*	257,0 *10.118*	332,4 *13.087*	127,5 *5.020*	6000	1	PB	3,7 *8.2*
C6-D40-368-GL40	02807851	C6	GL40	40,0 *1.575*	368,0 *14.488*	343,0 *13.504*	337,0 *13.268*	412,4 *16.236*	173,14 *6.817*	5000	1	PB	4,6 *10.1*
C6-D50-268-GL50	02807852	C6	GL50	50,0 *1.969*	268,0 *10.551*	243,0 *9.567*	238,0 *9.370*	313,4 *12.339*	126,6 *4.984*	6000	1	PB	5,4 *11.9*
C6-D50-368-GL50	02807853	C6	GL50	50,0 *1.969*	368,0 *14.488*	343,0 *13.504*	338,0 *13.307*	413,4 *16.276*	179,44 *7.065*	4000	1	PB	6,6 *14.6*
C6-D50-468-GL50	02807854	C6	GL50	50,0 *1.969*	468,0 *18.425*	443,0 *17.441*	438,0 *17.244*	513,4 *20.213*	238,49 *9.389*	2500	1	PB	8,5 *18.7*

Reper Nr.	Număr reper	CTMS Mărime Seco Capto™	CTWS Mărime GL	BD mm inci	LF mm inci	LB1 mm inci	LB2 mm inci	OAL mm inci	LCOG mm inci	RPM max.*	RFID hole	Echili-brare	Greutate kg lbs
C8-D32-224-GL32	03029356	C8	GL32	32,0 *1.260*	224,0 *8.819*	191,0 *7.520*	181,0 *7.126*	277,4 *10.921*	58,17 *2.290*	8000	1	PB	3,2 *7.1*
C8-D32-288-GL32	03029357	C8	GL32	32,0 *1.260*	288,0 *11.339*	255,0 *10.039*	245,0 *9.646*	341,4 *13.441*	84,7 *3.335*	6000	1	PB	3,6 *7.9*
C8-D40-288-GL40	03029358	C8	GL40	40,0 *1.575*	288,0 *11.339*	255,0 *10.039*	245,0 *9.646*	342,4 *13.480*	102,14 *4.021*	6000	1	PB	4,7 *10.4*
C8-D40-368-GL40	03029359	C8	GL40	40,0 *1.575*	368,0 *14.488*	335,0 *13.189*	325,0 *12.795*	422,4 *16.630*	144,04 *5.671*	5000	1	PB	5,6 *12.4*
C8-D50-268-GL50	03029360	C8	GL50	50,0 *1.969*	268,0 *10.551*	235,0 *9.252*	225,0 *8.858*	323,4 *12.732*	107,59 *4.236*	6000	1	PB	5,9 *13.0*
C8-D50-368-GL50	03029361	C8	GL50	50,0 *1.969*	368,0 *14.488*	335,0 *13.189*	325,0 *12.795*	423,4 *16.669*	158,08 *6.224*	4000	1	PB	7,5 *16.5*
C8-D50-468-GL50	03029362	C8	GL50	50,0 *1.969*	468,0 *18.425*	435,0 *17.126*	425,0 *16.732*	523,4 *20.606*	215,6 *8.488*	2500	1	PB	9,4 *20.7*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Cheie de blocare
	
GL25	SL25
GL32	SL32
GL40	SL40
GL50	SL50

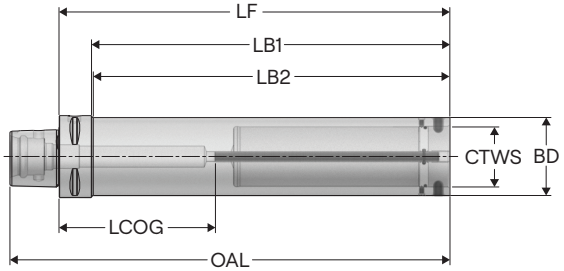
Accesorii

Pentru mărimea	Capăt interschimbabil	Cheie dinamometrică
		
GL25	SL00-25	SL00-25.250
GL32	SL00-32	SL00-32.250
GL40	SL00-40	SL00-40.350
GL50	SL00-50	SL00-50.550

BA – Steadyline®, suporturi BA

Diametre 60 și 80 mm / 2.362 și 3.150 inch





—Cu amortizare dinamică, gata de utilizare
—Pentru monta adaptoarele BA la GL cu capete de strunjire GL
—Cu canale pentru lichid de răcire
—* Max. RPM numai atunci când se utilizează la alezarea prin rotație

Reper Nr.	Număr reper	CTMS Mărime Seco Capto™	CTWS Mărime BA	BD	LF	LB1	LB2	OAL	LCOG	RPM max.*	RFID hole	Echili-brare	Greutate
				mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*	mm *inci*				kg *lbs*
C6-D60-301-BA060	03062831	C6	BA060	60,0 *2.362*	301,0 *11.850*	276,0 *10.866*	273,0 *10.748*	339,0 *13.346*	151,74 *5.974*	4000	1	PB	7,8 *17.2*
C6-D60-421-BA060	03062832	C6	BA060	60,0 *2.362*	421,0 *16.575*	396,0 *15.591*	393,0 *15.472*	459,0 *18.071*	218,63 *8.607*	3000	1	PB	10,6 *23.4*
C8-D60-301-BA060	03062833	C8	BA060	60,0 *2.362*	301,0 *11.850*	268,0 *10.551*	263,0 *10.354*	349,0 *13.740*	137,04 *5.395*	4000	1	PB	8,6 *19.0*
C8-D60-421-BA060	03062834	C8	BA060	60,0 *2.362*	421,0 *16.575*	388,0 *15.276*	383,0 *15.079*	469,0 *18.465*	202,5 *7.972*	3000	1	PB	11,4 *25.1*
C8-D60-541-BA060	03062835	C8	BA060	60,0 *2.362*	541,0 *21.299*	508,0 *20.000*	503,0 *19.803*	589,0 *23.189*	266,78 *10.503*	2000	1	PB	14,0 *30.9*
C8-D80-421-BA080	03065829	C8	BA080	80,0 *3.150*	421,0 *16.575*	388,0 *15.276*	383,0 *15.079*	469,0 *18.465*	213,89 *8.421*	3000	1	PB	18,8 *41.5*
C8-D80-581-BA080	03065830	C8	BA080	80,0 *3.150*	581,0 *22.874*	548,0 *21.575*	543,0 *21.378*	629,0 *24.764*	300,38 *11.826*	2000	1	PB	25,1 *55.3*

Piese de schimb, Piese incluse la livrare

Pentru mărimea	Șurub de blocare
	
BA060	90FQ4
BA080	90FQ52

Accesorii

Pentru mărimea	Cheie de blocare
	
BA060	03H04
BA080	03H05

Tabel de toleranţe ISO

Toleranţe ISO pentru găuri (µm)														
Gaură Ø mm (inci)	**D10**	**E9**	**F7**	**F8**	**G7**	**G9**	**H5**	**H6**	**H7**	**H8**	**H9**	**H10**	**H11**	**H12**
≤ 3 *(0.118")*	+60 +20	+39 +14	+16 +6	+20 +6	+12 +2	+27 +2	+4 0	+6 0	+10 0	+14 0	+25 0	+40 0	+60 0	+100 0
3 ≥ 6 *(0.236")*	+78 +30	+50 +20	+22 +10	+28 +10	+16 +4	+34 +4	+5 0	+8 0	+12 0	+18 0	+30 0	+48 0	+75 0	+120 0
6 ≥ 10 *(0.394")*	+98 +40	+61 +25	+28 +13	+35 +13	+20 +5	+41 +5	+6 0	+9 0	+15 0	+22 0	+36 0	+58 0	+90 0	+150 0
10 ≥ 18 *(0.708")*	+120 +50	+75 +32	+34 +16	+43 +16	+24 +6	+49 +6	+8 0	+11 0	+18 0	+27 0	+43 0	+70 0	+110 0	+180 0
18 ≥ 30 *(1.181")*	+149 +65	+92 +40	+41 +20	+53 +20	+28 +7	+59 +7	+9 0	+13 0	+21 0	+33 0	+52 0	+84 0	+130 0	+210 0
30 ≥ 50 *(1.969")*	+180 +80	+112 +50	+50 +25	+64 +25	+34 +9	+71 +9	+11 0	+16 0	+25 0	+39 0	+62 0	+100 0	+160 0	+250 0
50 ≥ 65 *(2.559")*	+220 +100	+134 +60	+60 +30	+76 +30	+40 +10	–	+13 0	+19 0	+30 0	+46 0	+74 0	+120 0	+190 0	+300 0
65 ≥ 80 *(3.150")*														
80 ≥ 100 *(3.937")*	+260 +120	+159 +72	+71 +36	+90 +36	+47 +12	–	+15 0	+22 0	+35 0	+54 0	+87 0	+140 0	+220 0	+350 0
100 ≥ 120 *(4.724")*														
120 ≥ 140 *(5.512")*	+305 +145	+185 +85	+83 +43	+106 +43	+54 +14	–	+18 0	+25 0	+40 0	+63 0	+100 0	+160 0	+250 0	+400 0
140 ≥ 160 *(6.299")*														
160 ≥ 180 *(7.087")*														
180 ≥ 200 *(7.874")*	+355 +170	+215 +110	+96 +50	+122 +50	+61 +15	–	+20 0	+29 0	+46 0	+72 0	+115 0	+185 0	+290 0	+460 0
200 ≥ 225 *(8.858")*														
225 ≥ 250 *(9.843")*														
250 ≥ 280 *(11.0236")*	+400 +190	+240 +110	+108 +56	+137 +56	+69 +17	–	+23 0	+32 0	+52 0	+81 0	+130 0	210 0	+320 0	+520 0
280 ≥ 315 *(12.402")*														
315 ≥ 355 *(13.976")*	+440 +210	+265 +125	+119 +62	+151 +62	+75 +18	–	+25 0	+36 0	+57 0	+89 0	+140 0	+230 0	+360 0	+570 0
355 ≥ 400 *(15.748")*														

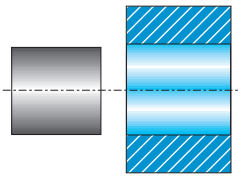
Tabel de toleranţe ISO

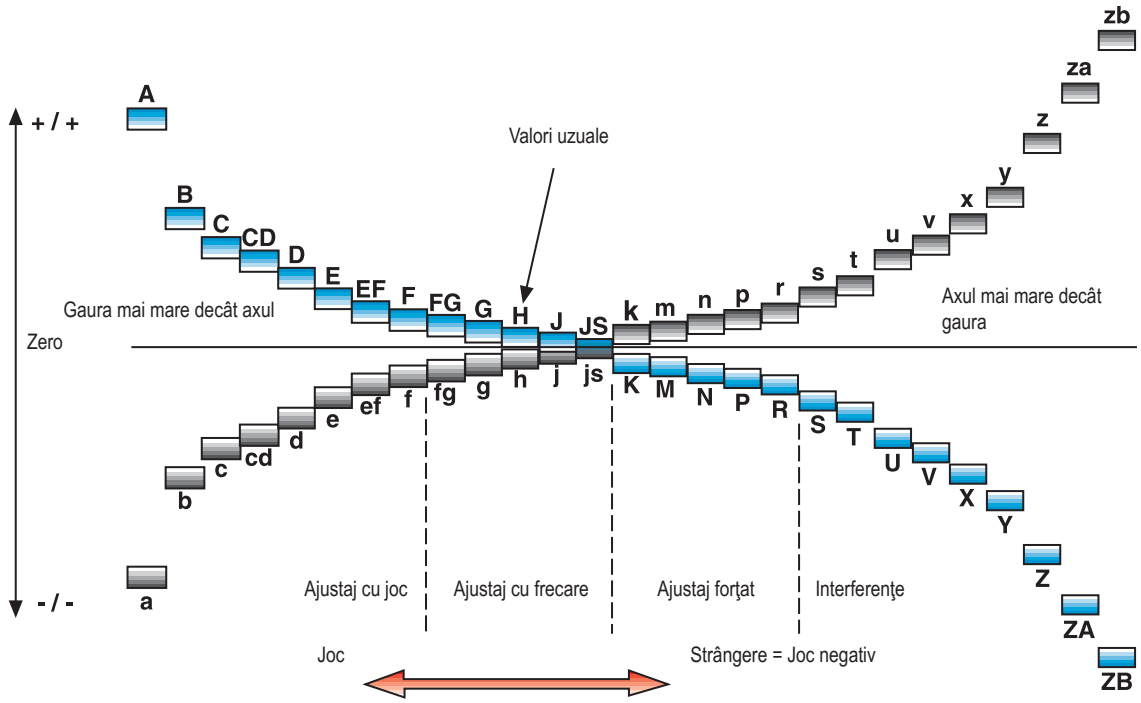
Toleranţe ISO pentru găuri (µm)												
Gaură Ø mm (inci)	**H13**	**JS7**	**JS9**	**K6**	**K7**	**M6**	**M7**	**N7**	**N9**	**P7**	**P9**	**R7**
≤ 3 *(0.118")*	+140 0	+/-5	+/-12,5	0 -6	0 -10	-2 -8	-2 -12	-4 -14	-4 -29	-6 -16	-6 -31	-10 -20
3 ≥ 6 *(0.236")*	+180 0	+/-6	+/-15	+2 -6	+3 -9	-1 -9	0 -12	-4 -16	0 -30	-8 -20	-12 -42	-11 -23
6 ≥ 10 *(0.394")*	+220 0	+/-7,5	+/-18	+2 -7	+5 -10	-3 -12	0 -15	-4 -19	0 -36	-9 -24	-15 -51	-13 -28
10 ≥ 18 *(0.708")*	+270 0	+/-9	+/-21,5	+2 -9	+6 -12	-4 -15	0 -18	-5 -23	0 -43	-11 -29	-18 -61	-16 -34
18 ≥ 30 *(1.181")*	+330 0	+/-10,5	+/-26	+2 -11	+6 -15	-4 -17	0 -21	-7 -28	0 -52	-14 -35	-22 -74	-20 -41
30 ≥ 50 *(1.969")*	+390 0	+/-12,5	+/-31	+3 -13	+7 -18	-4 -20	0 -25	-8 -33	0 -62	-17 -42	-26 -88	-25 -50
50 ≥ 65 *(2.559")*	+460 0	+/-15	+/-37	+4 -15	+9 -21	-5 -24	0 -30	-9 -39	0 -74	-21 -51	-32 -106	-30 -62
65 ≥ 80 *(3.150")*												
80 ≥ 100 *(3.937")*	+260 +120	+159 +72	+71 +36	+90 +36	+47 +12	–	+22 0	+35 0	+54 0	+87 0	+140 0	+350 0
100 ≥ 120 *(4.724")*												
120 ≥ 140 *(5.512")*	+305 +145	+185 +85	+83 +43	+106 +43	+54 +14	–	+25 0	+40 0	+63 0	+100 0	+160 0	+400 0
140 ≥ 160 *(6.299")*												
160 ≥ 180 *(7.087")*												
180 ≥ 200 *(7.874")*	+355 +170	+215 +110	+96 +50	+122 +50	+61 +15	–	+29 0	+46 0	+72 0	+115 0	+185 0	+460 0
200 ≥ 225 *(8.858")*												
225 ≥ 250 *(9.843")*												
250 ≥ 280 *(11.0236")*	+400 +190	+240 +110	+108 +56	+137 +56	+69 +17	–	+32 0	+52 0	+81 0	+130 0	210 0	+520 0
280 ≥ 315 *(12.402")*												
315 ≥ 355 *(13.976")*	+440 +210	+265 +125	+119 +62	+151 +62	+75 +18	–	+36 0	+57 0	+89 0	+140 0	+230 0	+570 0
355 ≥ 400 *(15.748")*												

Toleranţe standard ISO pentru gaură și ax – Toleranţele axului

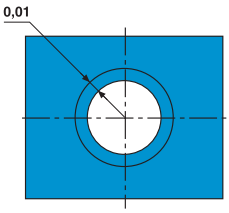
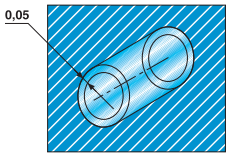
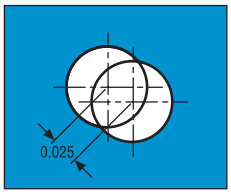
Poziţia toleranţei axului este scrisă cu **litere mici**

Poziţia toleranţa găurii este scrisă cu **MAJUSCULE**





Toleranţa geometrică

	Simbol desen	Aria de toleranţă
Circularitate	0,01 mm *(0.0004")*	
Cilindricitate	0,05 mm *(0.0020")*	
Localizarea poziţională	0,05 mm *(0.0020")*	

Oţeluri, oţeluri inoxidabile feritice și martensitice.

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
P1	Oţeluri cu așchiere ușoară	360 < R_m < 880	11 SMn30 R_m = 385 N/mm²	1500	0,14
P2	Oţeluri feritice slab aliate, C < 0.25%wt Oţeluri structurale generale slab liate	320 < R_m < 600	S235JRG2 R_m = 420 N/mm²	1600	0,23
P3	Oţeluri feritice și ferito-perlitice, C < 0.25%wt Oţeluri structurale generale Oţeluri de cementare	430 < R_m < 610	16 MnCr 5 R_m = 550 N/mm²	1800	0,14
P4	Oţeluri structurale slab aliate, 0.25% < C < 0.67%wt Oţeluri slab aliate călite și temperate	520 < R_m < 1200	C 45E R_m = 660 N/mm²	2000	0,15
P5	Oţeluri structurale, 0.25% < C < 0.67%wt Oţeluri călite și revenite	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²	2020	0,18
P6	Oţeluri căliteslab aliate, C > 0.67%wt Oţeluri pentru arcuri și bile slab aliate	520 < R_m < 1200	C 100S R_m = 600 N/mm²	2100	0,17
P7	Oţeluri călite, C > 0.67%wt Oţeluri pentru arcuri și bile	600 < R_m < 1200	100 Cr 6 R_m = 650 N/mm²	2160	0,17
P8	Oţeluri pentru scule Oţeluri rapide (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm²	2400	0,20
P11	Oţeluri inoxidabile feritice și martensitice	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm²	2000	0,15
P12	Oţeluri inoxidabile durificate prin precipitare	500 < R_m < 1200	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm²	2100	0,17

Oţeluri inoxidabile austenitice și duplex cu așchiere ușoară

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
M1	Oţeluri inoxidabile austenitice cu așchiere ușoară		X 10 CrNiS 18 9	1700	0,14
M2	Oţeluri inoxidabile austenitice slab aliate		X 5 CrNi 18 10	1920	0,18
M3	Oţeluri inoxidabile austenitice mediu aliate		X 2 CrNiMo 18 14 3	2070	0,17
M4	Oţeluri inoxidabile austenitice și duplex înalt aliate		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Oţeluri inoxidabile austenitice și duplex înalt aliate dificile		X 2 CrNiMoN 25 7 4	2510	0,13

Fonte

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
K1	Fonte cenușii (GCI)		EN-GJL-250	930	0,32
K2	Fontă cu grafit compact (CGI)		EN-GJV-400	1000	0,35
K3	Fonte maleabile (MCI)		EN-GJMB-550-4	1050	0,37
K4	Fonte cu grafit nodular (SGI)		EN-GJS-500-7	1160	0,37
K5	Fonte ductiel călite (ADI)		EN-GJS-1000-5	0	
K6	Fontă cenușie austenitică cu grafit lamelar		EN-GJLA-XNiCuCr15-6-2	0	
K7	Fontă cenușie austenitică cu grafit nodular		EN-GJSA-XNiMn23-4	0	

Metale neferoase

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
N1	Aliaje de aluminiu, Si < 9%		AW-7075	0	
N2	Aliaje de aluminiu, 9% < Si < 16%		AC-44200 Si = 12%	0	
N3	Aliaje de aluminiu, Si >16%		AlSi17Cu5	0	
N11	Aliaje de cupru		CW614N	740	0,26

Super aliaje și aliaje din titan

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
S1	Superaliaje pe bază de fier		Discalloy	0	
S2	Superaliaje pe bază de cobalt		Stellite 21	0	
S3	Superaliaje pe bază de nichel		Inconel 718	2530	0,21
S11	Titan, slab aliat, (α)		Ti	0	
S12	Titan, mediu aliat, (α+β)		TiAl6V4	1500	0,24
S13	Titan, înalt aliat, (similar β și β)		Ti10V2Fe3Al	0	

Materiale dure

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
H3	Oţeluri tratat termic	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Oţeluri călite	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Oţeluri călite și temperate Oţeluri pentru rulmenţi	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Oţeluri pentru scule Oţeluri rapide (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Oţeluri inoxidabile martensitice	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Oţeluri inoxidabile durificate prin precipitare	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Oţel manganos	23 < HRC < 64	X 120 Mn 12 50 HRC	0	
H31	Fortă albă	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC	0	

Alte materiale dificile

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
PM1	Materiale PM slab aliate		F-0008 Fe-0.7C	0	
PM2	Materiale PM mediu aliate		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C	0	
PM3	Materiale PM înalt aliate Materiale pentru scaunul supapei de evacuare, etc.			0	
HF1	Aliaje ecruisate Aliaje pe bază de fier sudate sau îmbinate cu plasmă			0	
HF2	Aliaje ecruisate Aliaje pe bază de cobalt și pe bază de nichel sudate sau îmbinate cu plasmă			0	
CC1	Carbură de tungsten sinterizată		G50	0	

Plastic și compozite

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
TS1	Polimeri termoset		Uree formaldehidică (UF)	0	
TS2	Compozite termoset din fibră de carbon		T300 T700 T800 HTA-S IMA - Epoxy (M21)...	0	
TS3	Compozite termoset din fibră de sticlă		Epoxy - HX..(42..)/E glass (7781...)...	0	
TS4	Compozite termoset din fibre aramide		Kevlar 49	0	
TP1	Polimeri termoplastici		Policarbonat (PC)	0	
TP2	Compozite termoplast din fibră de carbon		PPS/PEEK - T300..	0	
TP3	Compozite termoplast din fibră de sticlă		Sticlă PPS/PEEK - E sau sticlă A...	0	
TP4	Compozite termoplast din fibre aramide			0	

Grafit

SMG	Descriere	Proprietăţi	Reper	$k_{c1.1}$	m_c
GR1	Grafit		R 8500	0	

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
P2	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	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
P3			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
	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
			1.1740	C 60 W	Y3 55			SK 7		
P5	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
	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
P6	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		

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
	1213				Recopt	
	12 L 13				Recopt	
	1108				Recopt	
	11 L 08				Recopt	
					Recopt	
	1140	40			Recopt	
	1146				Recopt	
	1215				Recopt	
	12 L 14				Recopt	
		16D			Recopt	
	A573 Grade 58	18kp	11 378		Recopt	
	A573 Grade 70	St14kP	11 448		Recopt	
	1010	10			Recopt	
F.1110	1015	15			Recopt	
	1020, 1023	20	12 024		Recopt	
		17G1S	11 523		Recopt	
F.1511	1015	15			Recopt	
F.1120	1025	25			Recopt	
					Recopt	
	A204 Grade A		15 020		Recopt	
	4520				Recopt	
	3310, 9314	20X2H4A	16 420		Recopt	
	4320		16 220		Recopt	
					Recopt	
F.1516	5115	12KHN2	14 220		Recopt	
		18HG			Recopt	
	5120	20KH	14 221		Recopt	
	5120 H	20KH			Recopt	
	A182-F11, A182-F12	12KHM	15 121		Recopt	
	A387 Grade 12 Cl. 2				Recopt	
F.155	A182-F22	12KH8	15 313		Recopt	
F.1130	1035	35	12 040		Recopt	
F.5110	1045	45	12 050		Recopt	
	1040	40	12 041		Recopt	
F.1150	1055	55			Recopt	
	1060	60	12 061		Recopt	
	1039	40G			Recopt	
	1330	30G2			Recopt	
F.1135	1035	35			Recopt	
F.1140	1045	45	12 050		Recopt	
F.1150	1064	60			Recopt	
	1060	60			Recopt	
F.144	9255	55S2			Recopt	
F.1250	4135	35KHM			Recopt	
F.5241	S1	5KHV2S			Recopt	
	L6	5KHNV			Recopt	
	5045				Recopt	
	3135				Călit şi temperat	
	3435				Recopt	
	9840				Călit şi temperat	
F.1280	4340	38H2N2MA	16 343		Recopt	
	5132	35KH			Călit şi temperat	
	5140	40H	14 140		Călit şi temperat	
F.1251	4130	20KHM	15 130		Călit şi temperat	
F.1252	4142, 4140	38HM	15 142		Recopt	
F.1252	4142, 4140	38HM	15 142		Călit şi temperat	
					Călit şi temperat	
F.143	6150	50KHFA	15 260		Călit şi temperat	
F.1740	A355 Cl. A				Recopt	
F.5103	1070	70			Recopt	
F.5117	1095				Recopt	
F.5118	W1	U10A			Recopt	
		U10			Recopt	
	W1	U13			Recopt	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
F.520L	L2	11KHF			Recopt	
F.5220	O1	9KHVG			Recopt	
	O2	9G2F			Recopt	
F.5230	52100	SHKH15	14 109		Recopt	
F.5212	D3	KH12			Recopt	
	H11	4KH5MFS			Recopt	
F.5318	H13	4KH5MF1S			Recopt	
F.5227	A2	9KH5VF			Recopt	
	H10	3KH3M3F			Recopt	
F.5213		KH12			Recopt	
		KH12MF			Recopt	
F.520.S	L6	5KHNM			Recopt	
F.5613	M35	R6M5K5			Recopt	
	M42	R2AM9K5			Recopt	
	T4	R18K5F2			Recopt	
F.5603	M2	R6M5			Recopt	
	M7				Recopt	
	T1	R18			Recopt	
	403	08KH13			Recopt	Ferritic
F.3401	410, CA-15	12KH13, 08KH13			Recopt	Martensitic
F.3113	430	12KH17			Recopt	Feritic
F.5261	420	20KH13	17 022		Recopt	Martensitic
F.3404	420	40KH13			Recopt	Martensitic
	440 A				Recopt	Martensitic
	440 B	95KH18			Recopt	Martensitic
	440 C	95KH18			Recopt	Martensitic
	A182 F6NM			F6NM	Recopt	Martensitic
	446	15KH28			Recopt	Feritic
	XM-13			PH 13-8 Mo	Normalizat în soluţie	Austenitic
	XM-12			15-5 PH	H1150	Martensitic
	XM-12			15-5 PH	Normalizat în soluţie	Martensitic
	XM-12			15-5 PH	H1025	Martensitic
	SAE 630			17-4 PH	H1150	Martensitic
	630			17-4 PH	Normalizat în soluţie	Martensitic
	631	09KH17N7YU1		17-7 PH	Normalizat în soluţie	Austenitic/Feritic
	AMS 6515			Marage 350	Normalizat în soluţie	Martensitic
	AMS 6521			Marage 300	Normalizat în soluţie	Martensitic
	AMS 6514			Marage 300, Vascomax C300	Normalizat în soluţie	Martensitic
	AMS 6512			Marage 250	Normalizat în soluţie	Martensitic
	AMS 6512			Marage 250, Vascomax C250	Normalizat în soluţie	Martensitic
F.3508	303	12KH19N9			Recopt	Austenitic
F.3504	304 L	03KH18N11			Recopt	Austenitic
F.3504	304	08KH18N10	17 240		Recopt	Austenitic
F.3534	316	08KH17H13M2T	17 346		Recopt	Austenitic
F.3524	347	08KH18N12B			Recopt	Austenitic
F.3517	301	07KH16N6			Recopt	Austenitic
	302	12KH18N9			Recopt	Austenitic
F.3533	(316 L)	03KH17N14M3	17 349		Recopt	Austenitic
	316 LN	03KH16N15M3			Recopt	Austenitic
F.3541	304 LN	03KH18N11			Recopt	Austenitic
	317	08KH17H15M3T			Recopt	Austenitic
				253 MA	Recopt	Austenitic
	310 S	12KH25N20			Recopt	Austenitic
	329 LN			SAF 2205	Recopt	Duplex
				3RE60	Recopt	Duplex
	904L				Recopt	Super austenitic
	329				Recopt	Duplex
	660			A286	Normalizat în soluţie	Austenitic
				254 SMO	Recopt	Super austenitic
				654 SMO	Recopt	Super austenitic
				Alloy 800	Recopt	Austenitic
	F 53			SAF 2507	Recopt	Super duplex

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
K4	EN-GJS-350-22	0.7033	0.7033	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										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
N1	AW-1050A	Al99.5	3.0255	Al99.5	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
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
	A48 25 B	Sc 15	422 415			Fonte cenuşii (GCI)
	A48 30 B	Sc 20	422 420			Fonte cenuşii (GCI)
	A48 35 B	Sc 25	422 425			Fonte cenuşii (GCI)
	A48 50 B	Sc 35				Fonte cenuşii (GCI)
	G 3500					Fonte cenuşii (GCI)
	Grade 350					Fontă cu grafit vermicular (CGI)
	Grade 400					Fontă cu grafit vermicular (CGI)
	Grade 400-15					Fontă cu grafit vermicular (CGI)
	Grade 450					Fontă cu grafit vermicular (CGI)
	Grade 500					Fontă cu grafit vermicular (CGI)
	A220 60004				Temperat	Fontă maleabilă (MCI)
						Fontă cu grafit nodular (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Fontă cu grafit nodular (SGI)
	60-40-18	Vc 42-12				Fontă cu grafit nodular (SGI)
FGE 50-7	A536, 80-55-06	Vc 50-2	422 305			Fontă cu grafit nodular (SGI)
FGE 60-2	A476, 80-60-03	Vc 60-2	422 306			Fontă cu grafit nodular (SGI)
FGE 70-2	A536, 100-70-03	Vc 70-2				Fontă cu grafit nodular (SGI)
	1600/1300/-					Fontă ductilă (ADI)
	1050/700/7					Fontă ductilă (ADI)
	1200/850/4					Fontă ductilă (ADI)
	1400/1100/1					Fontă ductilă (ADI)
	850/550/10					Fontă ductilă (ADI)
	A436 Type 2			Ni-Resist 2		Fontă austenitică cu grafit lamelar
	A436 Type 3			Ni-Resist 3		Fontă austenitică cu grafit lamelar
	A436 Type 1			Ni-Resist 1		Fontă austenitică cu grafit lamelar
				Nodumag		Fontă austenitică cu grafit lamelar
	A436 Type D-2			Ni-Resist D-2		Fontă austenitică cu grafit lamelar
	A439 Type D-2M			Ni-Resist D-2M		Fontă austenitică cu grafit lamelar
	A436 Type D-3			Ni-Resist D-3		Fontă austenitică cu grafit lamelar
	A439 Type D-5			Ni-Resist D-5		Fontă austenitică cu grafit lamelar
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 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

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiţie	Structura
				Discalloy	Îmbătrânit	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Normalizat în soluţie	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Pur comercial	Ti (α)
	AMS 4919			Ti 6-2-4-2	Recopt	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Recopt	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Recopt	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Recopt	Ti (β)
F.1516	5115	12KHN2	14 220		Cementat	
F.5103	1070	70			Călit şi temperat	
F.5107	1078, 1080	75			Călit şi temperat	
F.5117	1095				Călit şi temperat	
F.5118	W1	U10A			Călit şi temperat	
	S1	5KHV2SF			Călit şi temperat	
	5155				Călit şi temperat	
F.1252	4142, 4140	38HM	15 142		Călit şi temperat	
F.520L	L2	11KHF			Călit şi temperat	
F.5220	O1	9KHVG			Călit şi temperat	
	O2	9G2F			Călit şi temperat	
F.5230	52100	SHKH15	14 109		Călit şi temperat	
F.5318	H13	4KH5MF1S			Călit şi temperat	
F.5227	A2	9KH5VF			Călit şi temperat	
F.5211	D2	KH12MF			Călit şi temperat	
F.5213		KH12			Călit şi temperat	
		KH12MF			Călit şi temperat	
F.520.S	L6	5KHNM			Călit şi temperat	
F.5613	M35	R6M5K5			Călit şi temperat	
	M42	R2AM9K5			Călit şi temperat	
	T1	R18			Călit şi temperat	
F.5261	420	20KH13	17 022		Călit şi temperat	Martensitic
	440 A				Călit şi temperat	Martensitic
	440 B	95KH18			Călit şi temperat	Martensitic
	440 C	95KH18			Călit şi temperat	Martensitic
	XM-12			15-5 PH	H900	Martensitic
	SAE 630			17-4 PH	H1025	Martensitic
	SAE 630			17-4 PH	H900	Martensitic
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitic
	632			PH 15-7 Mo	TH1050	Martensitic
	660			A286	Îmbătrânit	Austenitic
	AMS 6512			Marage 250	Îmbătrânit	Martensitic
	AMS 6521			Marage 300	Îmbătrânit	Martensitic
	AMS 6521			Marage 300	Îmbătrânit	Martensitic
	AMS 6515			Marage 350	Îmbătrânit	Martensitic
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		Fontă albă
	A532 IA (NiCr-HC)			Ni-Hard 1		Fontă albă
	A532 ID (Ni-HiCr)			Ni-Hard 4		Fontă albă

Plăcuţe amovibile și scule din carbură cementată

Plăcuţele amovibile cementate și sculele din carbură solidă de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerinţe. Cu toate acestea, Seco Tools poate face următoarea declaraţie:
Aceste produse întrunesc toate cerinţele în RoHS “Restriction of the use of certain Hazardous Substances in electrical and electronic equipment” (Restricţionarea utilizării de anumite Substanţe Periculoase în echipamentele electronice și electrice) WEEE “Waste Electrical & Electronic Equipment” (Deșeuri Electrice și Electronice)și ELV “End of Life Vehicles” (Sfârșitul duratei de viaţă a autovehiculelor)
Produsele nu conţin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenţi în concentraţii care depășesc limitele legale.

Rectificare:
Rectificarea umedă sau uscată poate produce nori de praf și ceaţă care pot fi dăunătoare și pot irita pielea, ochii, nasul gâtul care poate rezulta în afecţiuni ale plămânilor. Pentru a evita acestea folosiţi echipamente și măsuri de protecţie.

Reciclare:
Seco Tools va cumpăra inapoi plăcuţele amovibile și sculele din carbură folosite, pentru reciclare. Plăcuţele amovibile trebuie să fie separate de alte reziduri de metale (oţel, aluminiu, cupru,etc).
Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

Plăcuţe amovibile CBN și PCD

Plăcuţele amovibile de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerinţe. Cu toate acestea, Seco Tools poate face următoarea declaraţie:
Aceste produse întrunesc toate cerinţele în RoHS “Restriction of the use of certain Hazardous Substances in electrical and electronic equipment” (Restricţionarea utilizării de anumite Substanţe Periculoase în echipamentele electronice și electrice) WEEE “Waste Electrical & Electronic Equipment” (Deșeuri Electrice și Electronice)și ELV “End of Life Vehicles” (Sfârșitul duratei de viaţă a autovehiculelor)
Produsele nu conţin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenţi în concentraţii care depășesc limitele legale.

Rectificare:
Rectificarea umedă sau uscată poate produce nori de praf și ceaţă care pot fi dăunătoare și pot irita pielea, ochii, nasul gâtul care poate rezulta în afecţiuni ale plămânilor. Pentru a evita acestea folosiţi echipamente și măsuri de protecţie.

Reciclare:
Seco Tools va cumpăra inapoi plăcuţele amovibile CBN și PCD folosite, pentru reciclare. Plăcuţele amovibile trebuie să fie separate de alte reziduri de metale (oţel, aluminiu, cupru,etc). Plăcuţele solide CBN pot fi prelucrate ca deșeuri ordinare.
Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

Suporţi pentru plăcuţe din oxid negru

Sculele de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerinţe. Cu toate acestea, Seco Tools poate face următoarea declaraţie:
Aceste produse întrunesc toate cerinţele în RoHS “Restriction of the use of certain Hazardous Substances in electrical and electronic equipment” (Restricţionarea utilizării de anumite Substanţe Periculoase în echipamentele electronice și electrice) WEEE “Waste Electrical & Electronic Equipment” (Deșeuri Electrice și Electronice)și ELV “End of Life Vehicles” (Sfârșitul duratei de viaţă a autovehiculelor)
Produsele nu conţin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenţi în concentraţii care depășesc limitele legale.

Reciclare:
Sculele pot fi trimise spre reciclare împreună cu alte reziduuri din oţel.
Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

Plăcuţe amovibile Cermet

Plăcuţele amovibile de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerinţe. Cu toate acestea, Seco Tools poate face următoarea declaraţie:
Aceste produse întrunesc toate cerinţele în RoHS “Restriction of the use of certain Hazardous Substances in electrical and electronic equipment” (Restricţionarea utilizării de anumite Substanţe Periculoase în echipamentele electronice și electrice) WEEE “Waste Electrical & Electronic Equipment” (Deșeuri Electrice și Electronice)și ELV “End of Life Vehicles” (Sfârșitul duratei de viaţă a autovehiculelor)
Plăcuţele cermet C15M conţin nichel și vor lăsa pete în contact cu pielea. Concentraţia de nichel este mai mare decât cea specificată în norma SS-EN-1811, metoda de referintă pentru produsele ce conţin nichel și sunt destinate pentru a veni în contact cu pielea în mod direct și prelungit. Aceste norme sunt destinate pentru produsele care vin în contact direct și prelungit cu pielea și de accea nu sunt aplicabile pentru plăcuţele amovibile cermet. Persoanele care știu că au reacţii alergice la contactul cu nichelul sunt sfătuiţi să poarte mănuși protectoare când manipulează plăcuţele amovibile din cermet.

Rectificare:
Rectificarea umedă sau uscată poate produce nori de praf și ceaţă care pot fi dăunătoare și pot irita pielea, ochii, nasul gâtul care poate rezulta în afecţiuni ale plămânilor. Pentru a evita acestea folosiţi echipamente și măsuri de protecţie.

Reciclare:
Plăcuţele amovibile folosite pot fi reciclate. Plăcuţele amovibile trebuie să fie separate de alte reziduri de metale (oţel, aluminiu, cupru,etc) inclusiv plăcuţele din carbură.
Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

Scule acoperite cu nichel

Sculele de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerinţe. Cu toate acestea, Seco Tools poate face următoarea declaraţie:
Aceste produse întrunesc toate cerinţele în RoHS “Restriction of the use of certain Hazardous Substances in electrical and electronic equipment” (Restricţionarea utilizării de anumite Substanţe Periculoase în echipamentele electronice și electrice) WEEE “Waste Electrical & Electronic Equipment” (Deșeuri Electrice și Electronice)și ELV “End of Life Vehicles” (Sfârșitul duratei de viaţă a autovehiculelor)
Produsele nu conţin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenţi în concentraţii care depășesc limitele legale.
Scule conţin nichel și vor lăsa pete în contact cu pielea. Concentraţia de nichel este mai mare decât cea specificată în norma SS-EN-1811, metoda de referintă pentru produsele ce conţin nichel și sunt destinate pentru a veni în contact cu pielea în mod direct și prelungit.
Aceste norme sunt destinate pentru produsele care vin în contact direct și prelungit cu pielea și de accea nu sunt aplicabile pentru sculele acoperite cu nichel. Persoanele care știu că au reacţii alergice la contactul cu nichelul sunt sfătuiţi să poarte mănuși protectoare când manipulează sculele acoperite cu nichel.

Reciclare:
Sculele pot fi trimise spre reciclare împreună cu alte reziduuri din oţel.
Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

Materialele din compoziţia plăcuţelor amovibile

Calitate	Carbură cementată											Acoperirea						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
CP20	■				■				■			■			■			
CP200	■				■	■			■			■	■		■			
CP300	■	■	■	■	■				■			■	■		■			
CP500	■				■	■			■			■	■		■			
CP600	■				■	■			■			■	■		■			
C15M	■	■	■	■	■		■	■	■	■								
CF	■		■		■		■	■	■									
CM	■		■		■		■	■	■									
DP2000	■		■	■	■				■			■	■	■	■	■		
DP2501	■	■	■	■	■				■	■		■	■	■	■	■		
DP3000	■	■	■	■	■				■	■		■	■	■	■	■		
DS2050	■				■	■			■			■	■		■			■
DS4050	■				■	■			■			■	■		■			■
F15M	■				■	■			■			■	■		■			
F25M	■	■	■	■	■				■			■	■		■			
F30M	■				■	■			■			■	■		■			
F40M	■				■	■			■			■	■		■			
HX	■		■		■				■									
H02	■		■		■	■			■									
H15	■				■	■			■									
H25	■				■	■			■									
KX	■				■	■			■									
MH1000	■				■	■			■			■	■		■			
MH1051	■				■	■			■			■	■		■		■	
MK1500	■		■		■				■			■	■	■	■	■		
MK1501	■		■		■				■			■	■	■	■	■		
MK2050	■		■		■	■			■			■	■		■		■	
MM4500	■				■	■			■			■	■	■	■	■		
MP1501	■		■	■	■				■			■	■	■	■	■		
MP2050	■				■						■	■	■		■		■	
MP2051	■				■	■			■			■	■		■		■	
MP2501	■		■	■	■				■			■	■	■	■	■		
MP3000	■				■	■			■			■	■		■			
MP3501	■		■	■	■				■			■	■	■	■	■		
MS2500	■		■	■	■				■			■	■	■	■	■		
MS2050	■				■	■			■			■	■		■			■
RX1500	■		■		■		■	■	■			■	■		■			
RX2000	■		■		■	■			■			■	■		■			
RM2020	■				■				■			■						
RM2090	■				■	■			■			■	■				■	
RN2010	■				■	■			■									
RS2090	■				■	■			■			■	■				■	
T350M	■		■	■	■				■			■	■	■	■	■		
T25M	■		■	■	■				■			■		■	■			
TGH1050	■				■	■			■			■	■		■		■	
TGK1500	■		■		■				■			■	■	■	■	■		
TGP25	■	■	■	■	■				■			■	■	■	■	■		
TGP35	■		■	■	■				■			■	■	■	■	■		
TGP45	■		■	■	■				■			■	■	■	■	■		
TGS2050	■				■	■			■			■	■		■		■	
TH1000	■				■	■			■			■	■		■		■	
TH1500	■				■	■			■			■	■	■	■	■		
TK0501	■				■	■			■			■	■	■	■	■		
TK1501	■		■		■	■			■			■	■	■	■	■		
TM1501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TM2000	■	■	■	■	■				■	■		■	■	■	■	■		
TM2501	■	■	■	■	■				■	■		■	■	■	■	■		

Calitate	Carbură cementată											Acoperirea						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
TM3501	■				■				■			■	■	■	■	■		
TM4000	■	■	■	■	■				■	■		■	■	■	■	■		
TP0501	■	■	■	■	■	■			■			■	■	■	■	■		
TP1020	■	■	■	■	■				■	■								
TP1030	■	■	■	■	■				■	■		■	■		■		■	
TP1501	■	■	■	■	■				■	■		■	■	■	■	■		
TP25	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP200	■	■	■	■	■				■	■		■	■	■	■	■		
TP2501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP3501	■	■	■	■	■				■	■		■	■	■	■	■		
TP40	■		■	■	■				■			■		■	■			
TS2000	■				■	■			■			■	■		■			
TS2050	■				■	■			■			■	■		■		■	
TS2500	■		■		■				■			■	■		■			
TTP2050	■				■	■			■			■	■		■		■	
T250D	■				■	■			■			■	■		■			
T400D	■				■	■			■			■	■		■			
T100R	■		■		■	■			■			■	■		■			
T60M	■	■	■	■	■				■			■	■		■			
883	■		■		■				■									
890	■				■	■			■									

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