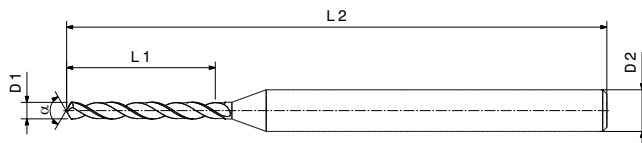


DR0101-NR01101

Bohrer für Diathread
Drill for Diathread



P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	



D1	L1	D2	L2	α	DWS Art. N°
0.23	1.50	3	39	130°	439665
0.28	1.80	3	39	130°	439787
0.32	1.80	3	39	130°	439788
0.41	2.70	3	39	130°	439789
0.44	2.70	3	39	130°	455743
0.50	3.20	3	39	130°	439790
0.53	3.20	3	39	130°	455744
0.58	3.60	3	39	130°	439791
0.62	3.90	3	39	130°	455745
0.66	3.90	3	39	130°	439792
0.71	4.50	3	39	130°	455746
0.74	4.50	3	39	130°	439793
0.75	4.50	3	39	130°	439794
0.80	5.00	3	39	130°	455747
0.82	5.00	3	39	130°	439795
0.88	5.70	3	39	130°	455748
0.95	5.70	3	39	130°	439796
1.02	6.50	3	39	130°	439797
1.08	7.30	3	39	130°	455749
1.10	7.30	3	39	130°	439798
1.18	8.20	3	39	130°	439799
1.25	8.20	3	39	130°	456100
1.30	8.20	3	39	130°	439800
1.45	9.20	3	39	130°	456101
1.50	9.20	3	39	130°	439801
1.65	11.20	3	39	130°	439802
1.75	11.20	3	39	130°	443382
1.80	11.20	3	39	130°	443383
1.90	11.20	3	39	130°	439803
2.10	12.50	3	39	130°	439804
2.15	12.50	3	39	130°	439805
2.25	12.50	3	39	130°	443384
2.30	12.50	3	39	130°	443385
2.40	12.00	3	39	130°	455750
2.55	14.00	3	39	130°	439806
2.65	14.00	3	39	130°	443386
2.80	14.00	3	39	130°	455751
2.90	15.00	6	66	140°	443387
3.30	17.00	6	66	140°	443388
3.50	18.00	6	66	140°	443389
4.20	21.00	6	74	140°	443390
4.50	23.00	6	74	140°	443391
5.00	25.00	6	82	140°	443392
5.30	27.00	6	82	140°	443393

Weitere Beschichtungen oder kundenspezifische Lösungen auf Anfrage
Other coatings or customized solutions are available on request

DR0101-NR01101

Schnittparameter
Cutting parameters

ISO	V _C [m/min]				f _U [mm]			
	Ø 0.23 - 0.50	Ø 0.51 - 1.00	Ø 1.01 - 2.55	Ø 2.90 - 5.30	Ø 0.23 - 0.50	Ø 0.51 - 1.00	Ø 1.01 - 2.55	Ø 2.90 - 5.30
P1	6 - 12	12 - 35	35 - 60	60 - 110	0.004 - 0.008	0.008 - 0.015	0.015 - 0.030	0.070 - 0.130
P2	6 - 12	12 - 35	35 - 60	60 - 110	0.004 - 0.008	0.008 - 0.015	0.015 - 0.030	0.070 - 0.130
P3	6 - 12	12 - 35	35 - 60	60 - 110	0.004 - 0.008	0.008 - 0.015	0.015 - 0.030	0.070 - 0.130
P4	4 - 9	9 - 25	25 - 50	50 - 90	0.003 - 0.006	0.006 - 0.014	0.014 - 0.028	0.060 - 0.120
P5	3 - 6	6 - 20	20 - 40	40 - 60	0.002 - 0.005	0.005 - 0.011	0.011 - 0.023	0.050 - 0.100
M1	4 - 9	9 - 25	25 - 50	40 - 60	0.002 - 0.005	0.005 - 0.012	0.012 - 0.024	0.050 - 0.080
M2	4 - 9	9 - 25	25 - 50	40 - 60	0.002 - 0.005	0.005 - 0.012	0.012 - 0.024	0.050 - 0.080
M3	3 - 6	6 - 20	20 - 35	40 - 60	0.002 - 0.004	0.004 - 0.009	0.009 - 0.022	0.050 - 0.080
K1	6 - 12	12 - 35	35 - 60	60 - 90	0.004 - 0.008	0.008 - 0.015	0.015 - 0.030	0.100 - 0.150
N1	7 - 19	19 - 45	45 - 80	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N2	6 - 15	15 - 35	35 - 65	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N3	7 - 18	18 - 40	40 - 70	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N4	6 - 15	15 - 35	35 - 65	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N5	6 - 15	15 - 35	35 - 65	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N6	5 - 10	10 - 25	25 - 50	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N7	5 - 10	10 - 25	25 - 50	90 - 170	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.090 - 0.150
N8	6 - 12	12 - 35	35 - 60	90 - 170	0.004 - 0.008	0.008 - 0.016	0.016 - 0.032	0.090 - 0.150
S1	5 - 9	9 - 18	18 - 35	35 - 55	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.030 - 0.060
S2	5 - 9	9 - 18	18 - 35	35 - 55	0.003 - 0.006	0.006 - 0.012	0.012 - 0.024	0.030 - 0.060
S3	3 - 6	6 - 12	12 - 20	35 - 55	0.002 - 0.005	0.005 - 0.009	0.009 - 0.015	0.030 - 0.060
H1	3 - 6	6 - 12	12 - 20	25 - 40	0.002 - 0.005	0.005 - 0.009	0.009 - 0.015	0.030 - 0.060
H2								

Richtwerte
Indicative values