

DORMER  **PRAMET**

HUL FREMSTILLING

2024



 **DORMER**

 **PRAMET**

HUL FREMSTILLING GENERELT INDHOLD

HUL FREMSTILLING	Værktøj til grundlæggende fremstilling, konstruktion, vedligeholdelse, reparation og eftersyn. Bruges typisk med elværktøj og konventionelle maskiner. Velegnet til lave skæreparametre.		Stub – og punktøvelser	< 2.5 x D	7
			Arbejdsbor	< 4 x D	17
			Lange og ekstra lange bor	< 10 x D	35
			Luft – og rumfartsbor	NAS 907	41
			Forsænkninger		59
			Reifer		73
			Boresæt og tilbehør		90
	Værktøjer til blandet produktion. Bruges typisk sammen med konventionelle maskiner med maskinfremføring og CNC. Velegnet til moderate skæreparametre.		Stubbor	< 3 x D	103
			Arbejdsbor	< 5 x D	115
			Lange og ekstra lange bor	< 25 x D	125
			Trinbor og undersækningsbor		135
			Center bor		147
			Forsænkninger		157
			Reifer		167
	Værktøjer til processikkerhed og produktivitet. Bruges typisk til CNC og automatiseret produktion. Velegnet til høje skæreparametre.		Solid bor i massivt hårdmetal		181
			Bor i massivt hårdmetal	< 8 x D	187
			Hydra-bor (løst hoved)	1.5 – 12 x D	217
			Indekserbare bor (U-bor)	2 – 5 x D	235
			Refræsere af hårdmetal		249
INSTRUKTIONER	Hvordan læser man katalogdata? (ISO 13399, ikoner, navigation)				258
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	Materialegrupper til arbejdsemner (WMG)				291



SOLID ROUND TOOLS – CONTENT (ALPHABETICAL)

PRODUCT FAMILY		PRODUCT FAMILY		PRODUCT FAMILY		PRODUCT FAMILY	
0		A295	95	B660	85	G705	141
2ACO	57	A296	156	B670	86	G706	142
500-6/501-6/502-6	48	A321	18	B680	87	H	
500-12/501-12/502-12	50	A400	143	B690	64	H851	218
A		A402	144	B901	168	H853	219
A002	30	A412	146	B903	82	H855	221
A002S	32	A413	145	B952	83	H858	223
A022	14	A510	120	B953	81	H860	229
A080	99	A520	105	B954	175	H861	229
A087	93	A553	122	C		H8512	224
A088	92	A620	107	CO500-6/CO501-6	55	M	
A089	92	A720	104	CO500-12/CO501-12	56	M900	98
A094	93	A723	8	E		M901	99
A095	94	A777	116	EP	247	M902	99
A099 Drillboy	94	A900	126	E		R	
A100	19	A920	110	G106	67	R003	123
A101	23	A940	128	G107	69	R10A/R15A/R18A	44
A108	33	A952	133	G125	137	R10B/R15B/R18B	46
A110	36	A976	130	G129	62	R10CO/R15CO/R18CO	53
A117	108	A977	131	G132	63	R023	112
A119	10	A978	132	G135	60	R40C/R41C/R42C	42
A120	12	B		G136	66	R88CO/R89CO	52
A122	9	B100	74	G137	164	R122	184
A123	11	B101	174	G138	165	R123	182
A125	38	B121	176	G142	65	R125	185
A130	26	B122	88	G149	159	R200	156
A147	118	B161	173	G154	61	R453	203
A170	24	B170	171	G171	163	R454	199
A188	95	B180	169	G236	71	R457	195
A190	96	B301	80	G314	136	R458	191
A191	97	B400	250	G335	158	R459	207
A191_2	97	B411	254	G338	166	R463	213
A200	148	B441	253	G400	162	R467	210
A201	153	B442	255	G506	68	R510	190
A205	149	B481	251	G560	160	R520	188
A206	150	B610	76	G570	161	R950	225
A210	152	B620	78	G600	70	R960	227
A225	154	B630	84	G702	138	R6011	183
A242	155	B640	177	G703	139	R7131	216
A266	151	B650	79	G704	140		



INDEXABLE TOOLS – CONTENT (ALPHABETICAL)

PRODUCT FAMILY	
0	
802D	236
803D	238
804D	241
805D	243

INDEXABLE INSERTS

– CONTENT (ALPHABETICAL)

PRODUCT FAMILY	
S	
SCET	245
XPET	246



VÆRKTØJ TIL GRUNDLÆGGENDE FREMSTILLING, KONSTRUKTION, VEDLIGEHOLDELSE, REPARATION OG EFTERSYN. BRUGES TYPISK MED ELVÆRKTØJ OG KONVENTIONELLE MASKINER.

Materiale kode (BMC)	HSS-E	HSS	HSS	HSS	HSS	HSS								
Grundlæggende standard-gruppe (BSG)		DIN 1897	DIN 1897	DIN 1897	DIN 1897	DIN ANSI								
Brugbar længde (ULDR)	1×D	1×D	1.25×D	1.5×D	2.5×D	2.5×D								
Anvendelsesvinkel														
Belægning														
Skaft														
Spiral form														
Hånd (skæreretning)														
Produktfamiliekode	A723	A122	A119	A123	A120	A022								
PSF skærediametre række-vidde	6.00 - 8.00	6.00 - 20.00	3.30 - 5.10	3/32 - 1/4	0.50 - 25.00	0.50 - 16.00								
	8	9	10	11	12	14								
P	P1	■	■	■	■	■								
	P2	■	■	■	■	■								
	P3	■	■	■	■	■								
	P4	■	■	■	■	■								
M	M1		■	■	■	■								
	M2		■	■	■	■								
	M3		■	■	■	■								
	M4		■	■	■	■								
K	K1		■			■								
	K2		■			■								
	K3		■			■								
	K4		■			■								
	K5		■			■								
N	N1		■	■	■	■								
	N2		■	■	■	■								
	N3		■	■	■	■								
	N4		■	■	■	■								
	N5													
S	S1		■	■	■	■								
	S2		■	■	■	■								
	S3		■	■	■	■								
	S4		■	■	■	■								
H	H1													
	H2													
	H3													
	H4													

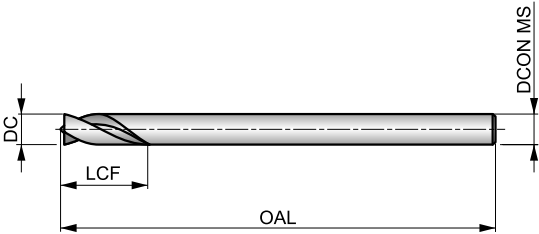
A723





HSS-E (5% kobolt) punktsvejsningsbor, Bronzehærdet finish

Bor med specialdesignet læbe- og spids for at fjerne eller “bore ud” punktsvejsede områder, ofte til fjernelse af svejsninger i et bilværksted. Kort skærlængde gør det mere robust og mindre tilbøjeligt til at knuses, når det bruges i en håndholdt enhed Bronzefinishen er et tyndt oxidlag og en indikation for kobolt.



HSS-E		1×D
		 λ 20-35°
	DC h8	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

	P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P4.1
	■ 33 D	■ 37 D	■ 38 D	■ 28 D	▣ 25 C	▣ 20 C	▣ 20 C	▣ 20 C
Product	DC	DC	LCF	OAL	DCON MS			
	(mm)	(inch)	(mm)	(mm)	(mm)			
A7236.0X66	6.00	0.2362	18.0	66.0	6.00			
A7236.0X93	6.00	0.2362	18.0	93.0	6.00			
A7238.0X79	8.00	0.3150	24.0	79.0	8.00			
A7238.0X117	8.00	0.3150	24.0	117.0	8.00			

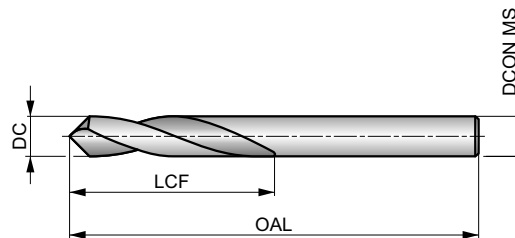
A122

 DORMER



HSS Centrerbør, Blank Finish

Bruges til at skabe et hul i materialet, der skal bores for at sikre, at startpunktet er nøjagtigt. Leveres med enten en 90 ° eller 120 ° vinkel, hvilket giver dig to muligheder for forsækning. Blank overfladefinish. Velegnet til boring i mange materialer.



HSS	DIN 1897	1xD
90°/120°	Bright	
λ 20-35°	R	DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 36 E	P1.2 ■ 40 E	P1.3 ■ 41 E	P2.1 ■ 31 E	P2.2 ■ 27 C	P2.3 ■ 24 C	P3.1 ■ 21 C	P3.2 ■ 17 C	P3.3 ■ 14 C	P4.1 ■ 12 C	P4.2 ■ 10 C	P4.3 ■ 9 B	M1.1 ■ 22 C	M1.2 ■ 19 C
M2.1 ■ 20 C	M2.2 ■ 16 C	M3.1 ■ 10 D	M3.2 ■ 9 D	M3.3 ■ 8 D	M4.1 ■ 10 B	K1.1 ■ 32 E	K1.2 ■ 24 C	K1.3 ■ 18 C	K2.1 ■ 25 C	K2.2 ■ 20 C	K2.3 ■ 16 B	K3.1 ■ 22 C	K3.2 ■ 17 C
K3.3 ■ 13 B	K4.1 ■ 20 C	K4.2 ■ 15 C	K4.3 ■ 11 B	K4.4 ■ 10 B	K4.5 ■ 8 B	K5.1 ■ 23 C	K5.2 ■ 17 C	K5.3 ■ 13 B	N1.1 ■ 33 E	N1.2 ■ 25 E	N1.3 ■ 17 E	N2.1 ■ 46 D	N2.2 ■ 42 D
N2.3 ■ 30 D	N3.1 ■ 56 D	N3.2 ■ 33 E	N3.3 ■ 17 D	N4.1 ■ 30 F	N4.2 ■ 35 E	N4.3 ■ 17 D	S1.1 ■ 27 C	S1.2 ■ 12 B	S1.3 ■ 7 A	S2.1 ■ 11 C	S2.2 ■ 6 A	S3.1 ■ 8 C	S3.2 ■ 4 A
S4.1 ■ 6 C	S4.2 ■ 3 A												

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
A1226.0X90	6.00	0.2362	30.0	66.0	6.00
A1226.0X120	6.00	0.2362	30.0	66.0	6.00
A1228.0X90	8.00	0.3150	33.0	79.0	8.00
A1228.0X120	8.00	0.3150	33.0	79.0	8.00
A12210.0X90	10.00	0.3937	35.0	89.0	10.00
A12210.0X120	10.00	0.3937	35.0	89.0	10.00
A12212.0X90	12.00	0.4724	40.0	102.0	12.00
A12212.0X120	12.00	0.4724	40.0	102.0	12.00
A12216.0X90	16.00	0.6299	40.0	115.0	16.00
A12216.0X120	16.00	0.6299	40.0	115.0	16.00
A12220.0X90	20.00	0.7874	55.0	131.0	20.00

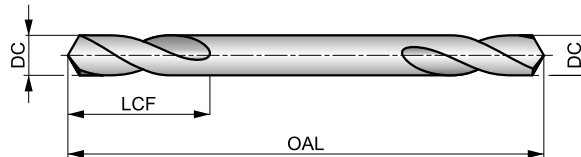
A119

 DORMER



HSS dobbeltsidet bor, damphærdet finish

En kort dobbeltbor designet til at bore huller gennem metalplader. Det er muligt at bruge begge ender, hvilket giver dobbelt så lang levetid. Et konventionelt spids på 120 ° for at hjælpe med selvcentrering. Velegnet til boring i mange materialer. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj.



HSS	DIN 1897	1.25×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 31 C	P1.2 ■ 34 C	P1.3 ■ 35 C	P2.1 ■ 26 C	P2.2 ■ 23 C	P2.3 ■ 20 C	P3.1 ■ 12 C	P3.2 ■ 9 C	P3.3 ■ 8 C	P4.1 ■ 7 C	P4.2 ■ 6 C	P4.3 ■ 5 A	M1.1 ■ 21 A	M1.2 ■ 17 A
M2.1 ■ 18 A	M2.2 ■ 15 A	M3.1 ■ 8 C	M3.2 ■ 7 C	M3.3 ■ 6 C	M4.1 ■ 10 A	N1.1 ■ 33 C	N1.2 ■ 25 C	N1.3 ■ 17 C	N2.1 ■ 46 C	N2.2 ■ 42 C	N2.3 ■ 30 C	N3.1 ■ 56 C	N3.2 ■ 33 C
N3.3 ■ 17 A	N4.1 ■ 30 I	N4.2 ■ 35 C	S1.1 ■ 27 A	S1.2 ■ 12 A	S1.3 ■ 7 A	S2.1 ■ 5 C	S2.2 ■ 4 C	S3.1 ■ 4 C	S3.2 ■ 3 C	S4.1 ■ 3 C	S4.2 ■ 2 C		

Pladebor.

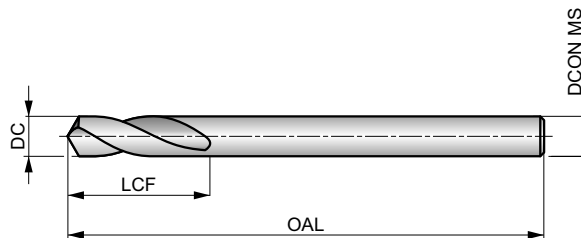
Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)			
A1193.3	3.30	0.1299	11.0	49.0	3.30
A1193.6	3.60	0.1417	12.0	52.0	3.60
A1194.1	4.10	0.1614	14.0	55.0	4.10
A1194.2	4.20	0.1654	14.0	55.0	4.20
A1194.9	4.90	0.1929	17.0	62.0	4.90
A1195.1	5.10	0.2008	17.0	62.0	5.10

A123

 DORMER

HSS stubbor, damphærdet finish, til metalplader

Specielt designet til boring af tynde materialer og metalplader. Et 120 ° spids og en damphærdet finish, der forhindrer emnet i at klæbe til forkant, hvilket giver en bedre hulfinish og mere nøjagtig diameter. Velegnet til boring i mange materialer.



HSS	DIN 1897	1.5×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 36 E	P1.2 ■ 40 E	P1.3 ■ 41 E	P2.1 ■ 31 E	P2.2 ■ 27 C	P2.3 ■ 24 C	P3.1 ■ 21 C	P3.2 ■ 17 C	P3.3 ■ 14 C	P4.1 ■ 12 C	P4.2 ■ 10 C	P4.3 ■ 9 B	M1.1 ■ 22 C	M1.2 ■ 19 C
M2.1 ■ 20 C	M2.2 ■ 16 C	M3.1 ■ 10 D	M3.2 ■ 9 D	M3.3 ■ 8 D	M4.1 ■ 10 B	N1.1 ■ 33 E	N1.2 ■ 25 E	N1.3 ■ 17 E	N2.1 ■ 46 D	N2.2 ■ 42 D	N2.3 ■ 30 D	N3.1 ■ 56 D	N3.2 ■ 33 E
N3.3 ■ 17 D	N4.1 ■ 30 F	N4.2 ■ 35 E	N4.3 ■ 17 D	S1.1 ■ 27 C	S1.2 ■ 12 B	S1.3 ■ 7 A	S2.1 ■ 11 C	S2.2 ■ 6 A	S3.1 ■ 8 C	S3.2 ■ 4 A	S4.1 ■ 6 C	S4.2 ■ 3 A	

Pladebør.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1233/32S	3/32	2.38	0.0937	14.0	43.0	2.38
A1232.5S	–	2.50	0.0984	14.0	43.0	2.50
A1233.0S	–	3.00	0.1181	16.0	46.0	3.00
A1231/8S	1/8	3.18	0.1250	18.0	49.0	3.18
A1233.2S	–	3.20	0.1260	18.0	49.0	3.20
A1233.3S	–	3.30	0.1299	18.0	49.0	3.30
A1233.5S	–	3.50	0.1378	18.0	52.0	3.50
A1233.7S	–	3.70	0.1457	18.0	52.0	3.70
A1235/32S	5/32	3.97	0.1563	18.0	55.0	3.97
A1234.0S	–	4.00	0.1575	18.0	55.0	4.00
A1234.1S	–	4.10	0.1614	18.0	55.0	4.10
A1234.2S	–	4.20	0.1654	18.0	55.0	4.20
A1234.5S	–	4.50	0.1772	18.0	58.0	4.50
A1233/16S	3/16	4.76	0.1875	18.0	62.0	4.76
A1234.8S	–	4.80	0.1890	18.0	62.0	4.80
A1234.9S	–	4.90	0.1929	18.0	62.0	4.90
A1235.0S	–	5.00	0.1969	18.0	62.0	5.00
A1235.5S	–	5.50	0.2165	18.0	66.0	5.50
A1237/32S	7/32	5.56	0.2188	18.0	66.0	5.56
A1236.0S	–	6.00	0.2362	18.0	66.0	6.00
A1231/4S	1/4	6.35	0.2500	19.0	70.0	6.35

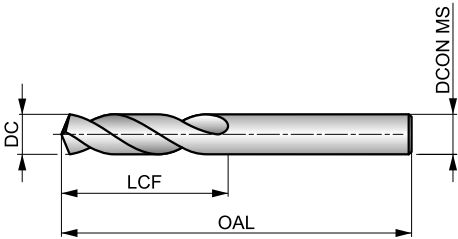
A120

 DORMER



HSS stub bor, damphærdet finish

Alsidig bor med damphærdet finish. En spids på 135° reducerer kræfterne under boring og forhindrer boret i at vandre over materialets overflade. Damphærdet finish bevarer skærevæske og forhindrer svejsning fra spån til værktøj. Velegnet til håndholdt og maskinboring af mange materialer.



HSS	DIN 1897	2.5×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 36 J	P1.2 ■ 40 J	P1.3 ■ 41 J	P2.1 ■ 31 J	P2.2 ■ 27 G	P2.3 ■ 24 F	P3.1 ■ 21 G	P3.2 ■ 17 G	P3.3 ■ 14 F	P4.1 ■ 12 G	P4.2 ■ 10 F	P4.3 ■ 9 E	M1.1 ■ 22 F	M1.2 ■ 19 F
M2.1 ■ 20 F	M2.2 ■ 16 F	M3.1 ■ 10 H	M3.2 ■ 9 H	M3.3 ■ 8 H	M4.1 ■ 10 D	K1.1 ■ 32 J	K1.2 ■ 24 G	K1.3 ■ 18 G	K2.1 ■ 25 F	K2.2 ■ 20 F	K2.3 ■ 16 F	K3.1 ■ 22 F	K3.2 ■ 17 F
K3.3 ■ 13 F	K4.1 ■ 20 F	K4.2 ■ 15 F	K4.3 ■ 11 F	K4.4 ■ 10 F	K4.5 ■ 8 F	K5.1 ■ 23 F	K5.2 ■ 17 F	K5.3 ■ 13 F	N1.1 ■ 33 K	N1.2 ■ 25 K	N1.3 ■ 17 J	N2.1 ■ 46 I	N2.2 ■ 42 I
N2.3 ■ 30 I	N3.1 ■ 64 I	N3.2 ■ 38 J	N3.3 ■ 19 H	N4.1 ■ 30 K	N4.2 ■ 35 I	N4.3 ■ 17 G	S1.1 ■ 27 G	S1.2 ■ 16 E	S1.3 ■ 8 C	S2.1 ■ 11 F	S2.2 ■ 6 B	S3.1 ■ 8 F	S3.2 ■ 4 B
S4.1 ■ 6 F	S4.2 ■ 3 B												

DC < 1mm Blank; 2.9mm => DC > 13.0mm 118° Spids.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A120.5	—	0.50	0.0197	3.0	20.0	0.50
A120.6	—	0.60	0.0236	3.5	21.0	0.60
A120.7	—	0.70	0.0276	4.5	23.0	0.70
A1201/32	1/32	0.79	0.0313	5.0	24.0	0.79
A120.8	—	0.80	0.0315	5.0	24.0	0.80
A120.9	—	0.90	0.0354	5.5	25.0	0.90
A1201.0	—	1.00	0.0394	6.0	26.0	1.00
A1201.1	—	1.10	0.0433	7.0	28.0	1.10
A1201.2	—	1.20	0.0472	8.0	30.0	1.20
A1201.3	—	1.30	0.0512	8.0	30.0	1.30
A1201.4	—	1.40	0.0551	9.0	32.0	1.40
A1201.5	—	1.50	0.0591	9.0	32.0	1.50
A1201/16	1/16	1.59	0.0625	10.0	34.0	1.59
A1201.6	—	1.60	0.0630	10.0	34.0	1.60
A1201.7	—	1.70	0.0669	10.0	34.0	1.70
A1201.8	—	1.80	0.0709	11.0	36.0	1.80
A1201.9	—	1.90	0.0748	11.0	36.0	1.90
A1205/64	5/64	1.98	0.0781	12.0	38.0	1.98
A1202.0	—	2.00	0.0787	12.0	38.0	2.00
A1202.1	—	2.10	0.0827	12.0	38.0	2.10
A1202.2	—	2.20	0.0866	13.0	40.0	2.20
A1202.25	—	2.25	0.0886	13.0	40.0	2.25
A1202.3	—	2.30	0.0906	13.0	40.0	2.30

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1203/32	3/32	2.38	0.0938	14.0	43.0	2.38
A1202.4	—	2.40	0.0945	14.0	43.0	2.40
A1202.5	—	2.50	0.0984	14.0	43.0	2.50
A1202.6	—	2.60	0.1024	14.0	43.0	2.60
A1202.7	—	2.70	0.1063	16.0	46.0	2.70
A1207/64	7/64	2.78	0.1094	16.0	46.0	2.78
A1202.8	—	2.80	0.1102	16.0	46.0	2.80
A1202.9	—	2.90	0.1142	16.0	46.0	2.90
A1203.0	—	3.00	0.1181	16.0	46.0	3.00
A1203.1	—	3.10	0.1220	18.0	49.0	3.10
A1201/8	1/8	3.18	0.1250	18.0	49.0	3.18
A1203.2	—	3.20	0.1260	18.0	49.0	3.20
A1203.25	—	3.25	0.1280	18.0	49.0	3.25
A1203.3	—	3.30	0.1299	18.0	49.0	3.30
A1203.4	—	3.40	0.1339	20.0	52.0	3.40
A1203.5	—	3.50	0.1378	20.0	52.0	3.50
A1209/64	9/64	3.57	0.1406	20.0	52.0	3.57
A1203.6	—	3.60	0.1417	20.0	52.0	3.60
A1203.7	—	3.70	0.1457	20.0	52.0	3.70
A1203.8	—	3.80	0.1496	22.0	55.0	3.80
A1203.9	—	3.90	0.1535	22.0	55.0	3.90
A1205/32	5/32	3.97	0.1563	22.0	55.0	3.97
A1204.0	—	4.00	0.1575	22.0	55.0	4.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1204.1	—	4.10	0.1614	22.0	55.0	4.10
A1204.2	—	4.20	0.1654	22.0	55.0	4.20
A1204.3	—	4.30	0.1693	24.0	58.0	4.30
A12011/64	11/64	4.37	0.1719	24.0	58.0	4.37
A1204.4	—	4.40	0.1732	24.0	58.0	4.40
A1204.5	—	4.50	0.1772	24.0	58.0	4.50
A1204.6	—	4.60	0.1811	24.0	58.0	4.60
A1204.7	—	4.70	0.1850	24.0	58.0	4.70
A1203/16	3/16	4.76	0.1875	26.0	62.0	4.76
A1204.8	—	4.80	0.1890	26.0	62.0	4.80
A1204.9	—	4.90	0.1929	26.0	62.0	4.90
A1205.0	—	5.00	0.1969	26.0	62.0	5.00
A1205.1	—	5.10	0.2008	26.0	62.0	5.10
A12013/64	13/64	5.16	0.2031	26.0	62.0	5.16
A1205.2	—	5.20	0.2047	26.0	62.0	5.20
A1205.3	—	5.30	0.2087	26.0	62.0	5.30
A1205.4	—	5.40	0.2126	28.0	66.0	5.40
A1205.5	—	5.50	0.2165	28.0	66.0	5.50
A1207/32	7/32	5.56	0.2188	28.0	66.0	5.56
A1205.6	—	5.60	0.2205	28.0	66.0	5.60
A1205.7	—	5.70	0.2244	28.0	66.0	5.70
A1205.8	—	5.80	0.2283	28.0	66.0	5.80
A1205.9	—	5.90	0.2323	28.0	66.0	5.90
A12015/64	15/64	5.95	0.2344	28.0	66.0	5.95
A1206.0	—	6.00	0.2362	28.0	66.0	6.00
A1206.1	—	6.10	0.2402	31.0	70.0	6.10
A1206.2	—	6.20	0.2441	31.0	70.0	6.20
A1206.3	—	6.30	0.2480	31.0	70.0	6.30
A1201/4	1/4	6.35	0.2500	31.0	70.0	6.35
A1206.4	—	6.40	0.2520	31.0	70.0	6.40
A1206.5	—	6.50	0.2559	31.0	70.0	6.50
A1206.6	—	6.60	0.2598	31.0	70.0	6.60
A1206.7	—	6.70	0.2638	31.0	70.0	6.70
A1206.8	—	6.80	0.2677	34.0	74.0	6.80
A1206.9	—	6.90	0.2717	34.0	74.0	6.90
A1207.0	—	7.00	0.2756	34.0	74.0	7.00
A1207.1	—	7.10	0.2795	34.0	74.0	7.10
A1209/32	9/32	7.14	0.2813	34.0	74.0	7.14
A1207.2	—	7.20	0.2835	34.0	74.0	7.20
A1207.3	—	7.30	0.2874	34.0	74.0	7.30
A1207.4	—	7.40	0.2913	34.0	74.0	7.40
A1207.5	—	7.50	0.2953	34.0	74.0	7.50
A1207.6	—	7.60	0.2992	37.0	79.0	7.60
A1207.7	—	7.70	0.3031	37.0	79.0	7.70
A1207.8	—	7.80	0.3071	37.0	79.0	7.80
A1207.9	—	7.90	0.3110	37.0	79.0	7.90
A1205/16	5/16	7.94	0.3125	37.0	79.0	7.94
A1208.0	—	8.00	0.3150	37.0	79.0	8.00
A1208.1	—	8.10	0.3189	37.0	79.0	8.10
A1208.2	—	8.20	0.3228	37.0	79.0	8.20
A1208.3	—	8.30	0.3268	37.0	79.0	8.30
A1208.4	—	8.40	0.3307	37.0	79.0	8.40
A1208.5	—	8.50	0.3346	37.0	79.0	8.50
A1208.6	—	8.60	0.3386	40.0	84.0	8.60

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1208.7	—	8.70	0.3425	40.0	84.0	8.70
A12011/32	11/32	8.73	0.3438	40.0	84.0	8.73
A1208.8	—	8.80	0.3465	40.0	84.0	8.80
A1208.9	—	8.90	0.3504	40.0	84.0	8.90
A1209.0	—	9.00	0.3543	40.0	84.0	9.00
A1209.1	—	9.10	0.3583	40.0	84.0	9.10
A1209.2	—	9.20	0.3622	40.0	84.0	9.20
A1209.3	—	9.30	0.3661	40.0	84.0	9.30
A1209.4	—	9.40	0.3701	40.0	84.0	9.40
A1209.5	—	9.50	0.3740	40.0	84.0	9.50
A1203/8	3/8	9.52	0.3750	43.0	89.0	9.52
A1209.6	—	9.60	0.3780	43.0	89.0	9.60
A1209.7	—	9.70	0.3819	43.0	89.0	9.70
A1209.8	—	9.80	0.3858	43.0	89.0	9.80
A1209.9	—	9.90	0.3898	43.0	89.0	9.90
A12010.0	—	10.00	0.3937	43.0	89.0	10.00
A12010.1	—	10.10	0.3976	43.0	89.0	10.10
A12010.2	—	10.20	0.4016	43.0	89.0	10.20
A12010.3	—	10.30	0.4055	43.0	89.0	10.30
A12010.5	—	10.50	0.4134	43.0	89.0	10.50
A12010.8	—	10.80	0.4252	47.0	95.0	10.80
A12011.0	—	11.00	0.4331	47.0	95.0	11.00
A1207/16	7/16	11.11	0.4375	47.0	95.0	11.11
A12011.3	—	11.30	0.4449	47.0	95.0	11.30
A12011.5	—	11.50	0.4528	47.0	95.0	11.50
A12011.7	—	11.70	0.4606	47.0	95.0	11.70
A12011.8	—	11.80	0.4646	47.0	95.0	11.80
A12012.0	—	12.00	0.4724	51.0	102.0	12.00
A12012.1	—	12.10	0.4764	51.0	102.0	12.10
A12012.2	—	12.20	0.4803	51.0	102.0	12.20
A12012.5	—	12.50	0.4921	51.0	102.0	12.50
A1201/2	1/2	12.70	0.5000	51.0	102.0	12.70
A12013.0	—	13.00	0.5118	51.0	102.0	13.00
A12013.5	—	13.50	0.5315	54.0	107.0	13.50
A12014.0	—	14.00	0.5512	54.0	107.0	14.00
A1209/16	9/16	14.29	0.5625	56.0	111.0	14.29
A12014.5	—	14.50	0.5709	56.0	111.0	14.50
A12015.0	—	15.00	0.5906	56.0	111.0	15.00
A12015.5	—	15.50	0.6102	58.0	115.0	15.50
A1205/8	5/8	15.88	0.6250	58.0	115.0	15.88
A12016.0	—	16.00	0.6299	58.0	115.0	16.00
A12016.5	—	16.50	0.6496	60.0	119.0	16.50
A12017.0	—	17.00	0.6693	60.0	119.0	17.00
A12011/16	11/16	17.46	0.6875	62.0	123.0	17.46
A12017.5	—	17.50	0.6890	62.0	123.0	17.50
A12018.0	—	18.00	0.7087	62.0	123.0	18.00
A12018.5	—	18.50	0.7283	64.0	127.0	18.50
A12019.0	—	19.00	0.7480	64.0	127.0	19.00
A12020.0	—	20.00	0.7874	66.0	131.0	20.00
A12020.5	—	20.50	0.8071	68.0	136.0	20.50
A12013/16	13/16	20.64	0.8125	68.0	136.0	20.64
A12021.0	—	21.00	0.8268	68.0	136.0	21.00
A12022.0	—	22.00	0.8661	70.0	141.0	22.00
A12025.0	—	25.00	0.9843	75.0	151.0	25.00

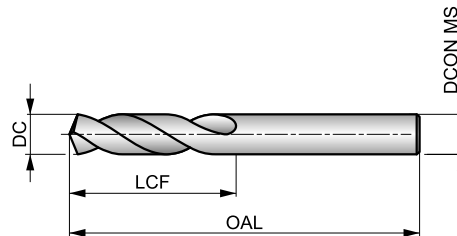
A022

 DORMER



HSS stub bor, TiN-Tip belagt

Alsiddig bor med et specielt designet 135 ° spids, der hjælper med selvcentrering, når man borer i hånden og i maskiner, giver et mere nøjagtigt hul med en bedre kvalitet af finish. Velegnet til boring af mange materialer. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.



HSS	DIN ANSI	2.5×D
 135°	 TiN-Tip	
 20-35°	 R	DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 K	P1.2 ■ 37 K	P1.3 ■ 38 K	P2.1 ■ 28 K	P2.2 ■ 25 I	P2.3 ■ 22 G	P3.1 ■ 24 H	P3.2 ■ 19 H	P3.3 ■ 16 G	P4.1 ■ 14 H	P4.2 ■ 12 G	P4.3 ▣ 10 E	M1.1 ■ 21 G	M1.2 ■ 17 G
M2.1 ■ 18 G	M2.2 ■ 15 G	M3.1 ▣ 9 I	M3.2 ▣ 8 I	M3.3 ▣ 7 I	M4.1 ▣ 9 E	K1.1 ■ 32 K	K1.2 ■ 24 I	K1.3 ■ 18 I	K2.1 ■ 25 G	K2.2 ■ 20 G	K2.3 ▣ 16 G	K3.1 ■ 22 G	K3.2 ■ 17 G
K3.3 ▣ 13 G	K4.1 ■ 20 G	K4.2 ■ 15 G	K4.3 ▣ 11 G	K4.4 ▣ 10 G	K4.5 ▣ 8 G	K5.1 ■ 23 G	K5.2 ■ 17 G	K5.3 ▣ 13 G	N1.1 ■ 40 F	N1.2 ■ 30 F	N1.3 ■ 20 K	N2.1 ■ 49 J	N2.2 ■ 44 J
N2.3 ■ 32 J	N3.1 ▣ 64 I	N3.2 ▣ 38 K	N3.3 ▣ 19 H	N4.1 ▣ 30 K	N4.2 ▣ 35 I	N4.3 ▣ 17 G	S1.1 ■ 25 I	S1.2 ▣ 14 F	S1.3 ▣ 8 C	S2.1 ▣ 11 F	S2.2 ▣ 6 B	S3.1 ▣ 8 F	S3.2 ▣ 4 B
S4.1 ▣ 6 F	S4.2 ▣ 3 B												

DC <2 mm lys; DC> = 2 mm TiN belagt og krydsslebet.
Produkter fra denne serie fås også i sæt. Se venligst A088.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A022.5	—	0.50	0.0197	3.0	20.0	0.50
A022.6	—	0.60	0.0236	3.5	21.0	0.60
A022.7	—	0.70	0.0276	4.5	23.0	0.70
A0221/32	1/32	0.79	0.0313	13.0	35.0	0.79
A022.8	—	0.80	0.0315	5.0	24.0	0.80
A022.9	—	0.90	0.0354	5.5	25.0	0.90
A0221.0	—	1.00	0.0394	6.0	26.0	1.00
A0221.1	—	1.10	0.0433	7.0	28.0	1.10
A0223/64	3/64	1.19	0.0469	13.0	35.0	1.19
A0221.2	—	1.20	0.0472	8.0	30.0	1.20
A0221.3	—	1.30	0.0512	8.0	30.0	1.30
A0221.4	—	1.40	0.0551	9.0	32.0	1.40
A0221.5	—	1.50	0.0591	9.0	32.0	1.50
A0221/16	1/16	1.59	0.0625	16.0	41.0	1.59
A0221.6	—	1.60	0.0630	10.0	34.0	1.60
A0221.7	—	1.70	0.0669	10.0	34.0	1.70
A0221.8	—	1.80	0.0709	11.0	36.0	1.80
A0221.9	—	1.90	0.0748	11.0	36.0	1.90
A0225/64	5/64	1.98	0.0781	17.0	43.0	1.98
A0222.0	—	2.00	0.0787	12.0	38.0	2.00
A0222.1	—	2.10	0.0827	12.0	38.0	2.10
A0222.2	—	2.20	0.0866	13.0	40.0	2.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A0222.25	—	2.25	0.0886	13.0	40.0	2.25
A0222.3	—	2.30	0.0906	13.0	40.0	2.30
A0223/32	3/32	2.38	0.0938	20.0	45.0	2.38
A0222.4	—	2.40	0.0945	14.0	43.0	2.40
A0222.5	—	2.50	0.0984	14.0	43.0	2.50
A0222.6	—	2.60	0.1024	14.0	43.0	2.60
A0222.65	—	2.65	0.1043	14.0	43.0	2.65
A0222.7	—	2.70	0.1063	16.0	46.0	2.70
A0227/64	7/64	2.78	0.1094	22.0	47.0	2.78
A0222.8	—	2.80	0.1102	16.0	46.0	2.80
A0222.9	—	2.90	0.1142	16.0	46.0	2.90
A0223.0	—	3.00	0.1181	16.0	46.0	3.00
A0223.1	—	3.10	0.1220	18.0	49.0	3.10
A0221/8	1/8	3.18	0.1250	23.0	49.0	3.18
A0223.2	—	3.20	0.1260	18.0	49.0	3.20
A0223.25	—	3.25	0.1280	18.0	49.0	3.25
A0223.3	—	3.30	0.1299	18.0	49.0	3.30
A0223.4	—	3.40	0.1339	20.0	52.0	3.40
A0223.5	—	3.50	0.1378	20.0	52.0	3.50
A0229/64	9/64	3.57	0.1406	25.0	50.0	3.57
A0223.6	—	3.60	0.1417	20.0	52.0	3.60
A0223.7	—	3.70	0.1457	20.0	52.0	3.70

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A0223.8	—	3.80	0.1496	22.0	55.0	3.80
A0223.9	—	3.90	0.1535	22.0	55.0	3.90
A0225/32	5/32	3.97	0.1563	26.0	53.0	3.97
A0224.0	—	4.00	0.1575	22.0	55.0	4.00
A0224.1	—	4.10	0.1614	22.0	55.0	4.10
A0224.2	—	4.20	0.1654	22.0	55.0	4.20
A0224.3	—	4.30	0.1693	24.0	58.0	4.30
A02211/64	11/64	4.37	0.1719	28.0	55.0	4.37
A0224.4	—	4.40	0.1732	24.0	58.0	4.40
A0224.5	—	4.50	0.1772	24.0	58.0	4.50
A0224.6	—	4.60	0.1811	24.0	58.0	4.60
A0224.7	—	4.70	0.1850	24.0	58.0	4.70
A0223/16	3/16	4.76	0.1875	30.0	57.0	4.76
A0224.8	—	4.80	0.1890	26.0	62.0	4.80
A0224.9	—	4.90	0.1929	26.0	62.0	4.90
A0225.0	—	5.00	0.1969	26.0	62.0	5.00
A0225.1	—	5.10	0.2008	26.0	62.0	5.10
A02213/64	13/64	5.16	0.2031	31.0	58.0	5.16
A0225.2	—	5.20	0.2047	26.0	62.0	5.20
A0225.3	—	5.30	0.2087	26.0	62.0	5.30
A0225.4	—	5.40	0.2126	28.0	66.0	5.40
A0225.5	—	5.50	0.2165	28.0	66.0	5.50
A0227/32	7/32	5.56	0.2188	33.0	61.0	5.56
A0225.6	—	5.60	0.2205	28.0	66.0	5.60
A0225.7	—	5.70	0.2244	28.0	66.0	5.70
A0225.8	—	5.80	0.2283	28.0	66.0	5.80
A0225.9	—	5.90	0.2323	28.0	66.0	5.90
A02215/64	15/64	5.95	0.2344	34.0	63.0	5.95
A0226.0	—	6.00	0.2362	28.0	66.0	6.00
A0226.1	—	6.10	0.2402	31.0	70.0	6.10
A0226.2	—	6.20	0.2441	31.0	70.0	6.20
A0226.3	—	6.30	0.2480	31.0	70.0	6.30
A0221/4	1/4	6.35	0.2500	36.0	65.0	6.35
A0226.4	—	6.40	0.2520	31.0	70.0	6.40
A0226.5	—	6.50	0.2559	31.0	70.0	6.50
A0226.6	—	6.60	0.2598	31.0	70.0	6.60
A0226.7	—	6.70	0.2638	31.0	70.0	6.70
A0226.8	—	6.80	0.2677	34.0	74.0	6.80
A0226.9	—	6.90	0.2717	34.0	74.0	6.90
A0227.0	—	7.00	0.2756	34.0	74.0	7.00
A0227.1	—	7.10	0.2795	34.0	74.0	7.10
A0229/32	9/32	7.14	0.2813	40.0	70.0	7.14
A0227.2	—	7.20	0.2835	34.0	74.0	7.20
A0227.3	—	7.30	0.2874	34.0	74.0	7.30
A0227.4	—	7.40	0.2913	34.0	74.0	7.40
A0227.5	—	7.50	0.2953	34.0	74.0	7.50
A0227.6	—	7.60	0.2992	37.0	79.0	7.60
A0227.7	—	7.70	0.3031	37.0	79.0	7.70
A0227.8	—	7.80	0.3071	37.0	79.0	7.80
A0227.9	—	7.90	0.3110	37.0	79.0	7.90
A0225/16	5/16	7.94	0.3125	43.0	73.0	7.94
A0228.0	—	8.00	0.3150	37.0	79.0	8.00
A0228.1	—	8.10	0.3189	37.0	79.0	8.10

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A0228.2	—	8.20	0.3228	37.0	79.0	8.20
A0228.3	—	8.30	0.3268	37.0	79.0	8.30
A0228.4	—	8.40	0.3307	37.0	79.0	8.40
A0228.5	—	8.50	0.3346	37.0	79.0	8.50
A0228.6	—	8.60	0.3386	40.0	84.0	8.60
A0228.7	—	8.70	0.3425	40.0	84.0	8.70
A02211/32	11/32	8.73	0.3438	45.0	78.0	8.73
A0228.8	—	8.80	0.3465	40.0	84.0	8.80
A0228.9	—	8.90	0.3504	40.0	84.0	8.90
A0229.0	—	9.00	0.3543	40.0	84.0	9.00
A0229.1	—	9.10	0.3583	40.0	84.0	9.10
A0229.2	—	9.20	0.3622	40.0	84.0	9.20
A0229.3	—	9.30	0.3661	40.0	84.0	9.30
A0229.4	—	9.40	0.3701	40.0	84.0	9.40
A0229.5	—	9.50	0.3740	40.0	84.0	9.50
A0223/8	3/8	9.52	0.3750	48.0	81.0	9.52
A0229.6	—	9.60	0.3780	43.0	89.0	9.60
A0229.7	—	9.70	0.3819	43.0	89.0	9.70
A0229.8	—	9.80	0.3858	43.0	89.0	9.80
A0229.9	—	9.90	0.3898	43.0	89.0	9.90
A02210.0	—	10.00	0.3937	43.0	89.0	10.00
A02210.1	—	10.10	0.3976	43.0	89.0	10.10
A02210.2	—	10.20	0.4016	43.0	89.0	10.20
A02210.3	—	10.30	0.4055	43.0	89.0	10.30
A02213/32	13/32	10.32	0.4063	51.0	86.0	10.32
A02210.4	—	10.40	0.4094	43.0	89.0	10.40
A02210.5	—	10.50	0.4134	43.0	89.0	10.50
A02210.6	—	10.60	0.4173	43.0	89.0	10.60
A02210.8	—	10.80	0.4252	47.0	95.0	10.80
A02211.0	—	11.00	0.4331	47.0	95.0	11.00
A02211.1	—	11.10	0.4370	47.0	95.0	11.10
A0227/16	7/16	11.11	0.4375	54.0	89.0	11.11
A02211.2	—	11.20	0.4409	47.0	95.0	11.20
A02211.3	—	11.30	0.4449	47.0	95.0	11.30
A02211.5	—	11.50	0.4528	47.0	95.0	11.50
A02211.7	—	11.70	0.4606	47.0	95.0	11.70
A02211.8	—	11.80	0.4646	47.0	95.0	11.80
A02211.9	—	11.90	0.4685	51.0	102.0	11.90
A02212.0	—	12.00	0.4724	51.0	102.0	12.00
A02212.1	—	12.10	0.4764	51.0	102.0	12.10
A02212.2	—	12.20	0.4803	51.0	102.0	12.20
A02212.5	—	12.50	0.4921	51.0	102.0	12.50
A0221/2	1/2	12.70	0.5000	60.0	98.0	12.70
A02213.0	—	13.00	0.5118	51.0	102.0	13.00
A02213.5	—	13.50	0.5315	54.0	107.0	13.50
A02214.0	—	14.00	0.5512	54.0	107.0	14.00
A0229/16	9/16	14.29	0.5625	67.0	105.0	14.29
A02214.5	—	14.50	0.5709	56.0	111.0	14.50
A02215.0	—	15.00	0.5906	56.0	111.0	15.00
A02215.5	—	15.50	0.6102	58.0	115.0	15.50
A0225/8	5/8	15.88	0.6250	73.0	111.0	15.88
A02216.0	—	16.00	0.6299	58.0	115.0	16.00

Materiale kode (BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS									
Grundlæggende standard-gruppe (BSG)		DIN 338	DIN 338		DIN 345	DIN 338	DIN 338	DIN 338									
Brugbar længde (ULDR)	3.5×D	4×D	4×D	4×D	4×D	4×D	4×D	4×D									
Anvendelsesvinkel																	
Belægning																	
Skaft																	
Spiral form																	
Hånd (skæreretning)																	
Produktfamiliekode	A321	A100	A101	A170	A130	A002	A002S	A108									
PSF skærediametre række-vidde	3.0 - 13.0	0.20 - 20.00	1.00 - 12.00	13.00 - 1.1/4	3.00 - 2"	1.00 - 16.00	2.00 - 13.00	1.00 - 16.00									
	18	19	23	24	26	30	32	33									
P	P1	■	■	■	■	■	■	■									
	P2	■	■	■	■	■	■	■									
	P3	■	■	■	■	■	■	■									
	P4	■	■	■	■	■	■	■									
M	M1	■	■	■	■	■	■	■									
	M2	■	■	■	■	■	■	■									
	M3	■	■	■	■	■	■	■									
	M4	■	■	■	■	■	■	■									
K	K1	■	■	■	■	■	■	■									
	K2	■	■	■	■	■	■	■									
	K3	■	■	■	■	■	■	■									
	K4	■	■	■	■	■	■	■									
	K5	■	■	■	■	■	■	■									
N	N1	■	■	■	■	■	■	■									
	N2	■	■	■	■	■	■	■									
	N3	■	■	■	■	■	■	■									
	N4	■	■	■	■	■	■	■									
	N5	■	■	■	■	■	■	■									
S	S1	■	■	■	■	■	■	■									
	S2	■	■	■	■	■	■	■									
	S3	■	■	■	■	■	■	■									
	S4	■	■	■	■	■	■	■									
H	H1																
	H2																
	H3																
	H4																

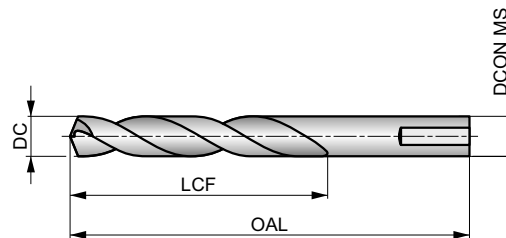
A321

 DORMER



HSS bor i mellem længde med overflade i damp og bronze hærdet overflade

Kraftig design bor med tre flader på skaft til mellem dybde huller. Primært velegnet til håndholdte operationer og boremaskiner Tre flader for sikker opspænding Det selvcentrerende 135° splitpunkt reducerer trykkraften, og den damp- og bronzehærdede overflade finish forbedre smøreevnen.



HSS	 DORMER	3.5xD
 135°	 ST Bronze	
 R	DC h8	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 H	P1.2 ■ 37 H	P1.3 ■ 38 H	P2.1 ■ 28 H	P2.2 ■ 25 F	P2.3 ■ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ■ 13 E	P4.1 ■ 11 F	P4.2 ■ 10 E	P4.3 ■ 8 D	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 9 G	M3.2 ■ 8 G	M3.3 ■ 7 G	M4.1 ■ 9 C	K1.1 ■ 30 H	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E
K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E	K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N1.1 ■ 33 J	N1.2 ■ 25 J	N1.3 ■ 17 I	N2.1 ■ 42 H	N2.2 ■ 37 H
N2.3 ■ 27 H	N3.1 ■ 59 H	N3.2 ■ 35 I	N3.3 ■ 18 G	N4.1 ■ 30 J	N4.2 ■ 28 H	N4.3 ■ 14 F	S1.1 ■ 23 E	S1.2 ■ 12 D	S1.3 ■ 6 B	S2.1 ■ 8 E	S2.2 ■ 4 A	S3.1 ■ 6 E	S3.2 ■ 3 A
S4.1 ■ 5 E	S4.2 ■ 2 A												

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A3213.0	3.00	0.1180	37.0	64.0	3.00
A3213.3	3.30	0.1300	40.0	67.0	3.30
A3213.4	3.40	0.1340	40.0	67.0	3.40
A3213.5	3.50	0.1380	40.0	67.0	3.50
A3214.0	4.00	0.1580	47.0	74.0	4.00
A3214.1	4.10	0.1610	47.0	74.0	4.10
A3214.2	4.20	0.1650	47.0	74.0	4.20
A3214.3	4.30	0.1690	47.0	74.0	4.30
A3214.5	4.50	0.1770	49.0	77.0	4.50
A3214.9	4.90	0.1930	50.0	80.0	4.90
A3215.0	5.00	0.1970	50.0	80.0	5.00
A3215.1	5.10	0.2010	50.0	80.0	5.10
A3215.3	5.30	0.2090	52.0	84.0	5.30
A3215.5	5.50	0.2170	52.0	84.0	5.50
A3216.0	6.00	0.2360	52.0	90.0	6.00
A3216.3	6.30	0.2480	52.0	90.0	6.30
A3216.5	6.50	0.2560	55.0	93.0	6.50

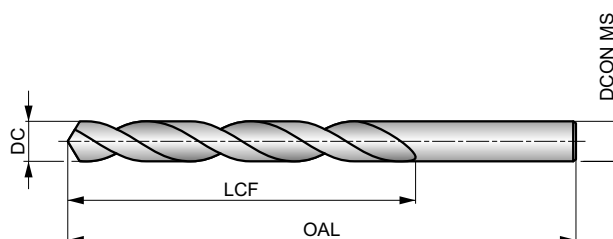
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A3216.8	6.80	0.2680	59.0	97.0	6.80
A3217.0	7.00	0.2760	59.0	97.0	7.00
A3217.3	7.30	0.2870	62.0	100.0	7.30
A3217.5	7.50	0.2950	62.0	100.0	7.50
A3218.0	8.00	0.3150	67.0	105.0	8.00
A3218.5	8.50	0.3350	68.0	107.0	8.50
A3219.0	9.00	0.3540	70.0	108.0	9.00
A3219.5	9.50	0.3740	70.0	110.0	9.50
A32110.0	10.00	0.3940	74.0	113.0	10.00
A32110.3	10.30	0.4060	74.0	113.0	10.30
A32110.5	10.50	0.4130	75.0	115.0	10.50
A32111.0	11.00	0.4330	77.0	117.0	11.00
A32111.5	11.50	0.4530	79.0	120.0	11.50
A32112.0	12.00	0.4720	85.0	126.0	12.00
A32112.5	12.50	0.4920	88.0	130.0	12.50
A32113.0	13.00	0.5120	88.0	130.0	13.00

A100

 DORMER

HSS bor, damphærdet finish

En stor og alsidigt allroundbor med et konventionelt spids på 118 °, der giver styrke og er let at genopskære med, hvilket gør det meget omkostningseffektivt. Anvendelig til håndboring og maskinboring. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spåner. Velegnet til mange materialer.



HSS	DIN 338	4×D
 118°	 ST	
 λ 20-35°	 R	DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 H	P1.2 ■ 37 H	P1.3 ■ 38 H	P2.1 ■ 28 H	P2.2 ■ 25 F	P2.3 ■ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ■ 13 E	P4.1 ■ 11 F	P4.2 ■ 10 E	P4.3 ■ 8 D	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 9 G	M3.2 ■ 8 G	M3.3 ■ 7 G	M4.1 ■ 9 C	K1.1 ■ 30 H	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E
K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E	K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N1.1 ■ 33 J	N1.2 ■ 25 J	N1.3 ■ 17 I	N2.1 ■ 42 H	N2.2 ■ 37 H
N2.3 ■ 27 H	N3.1 ■ 59 H	N3.2 ■ 35 I	N3.3 ■ 18 G	N4.1 ■ 30 J	N4.2 ■ 28 H	N4.3 ■ 14 F	S1.1 ■ 23 E	S1.2 ■ 12 D	S1.3 ■ 6 B	S2.1 ■ 8 E	S2.2 ■ 4 A	S3.1 ■ 6 E	S3.2 ■ 3 A
S4.1 ■ 5 E	S4.2 ■ 2 A												

DC <= 1mm; 3/64"; N60. Blank.
Produkter fra denne serie fås også i sæt. Se A190 eller A191.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100.2	—	0.20	0.0079	2.5	19.0	0.20
A100.25	—	0.25	0.0098	3.0	19.0	0.25
A100.3	—	0.30	0.0118	3.0	19.0	0.30
A100.32	—	0.32	0.0126	4.0	19.0	0.32
A100N80	N80	0.34	0.0135	4.0	19.0	0.34
A100.35	—	0.35	0.0138	4.0	19.0	0.35
A100N79	N79	0.37	0.0145	4.0	19.0	0.37
A100.38	—	0.38	0.0150	4.0	19.0	0.38
A1001/64	1/64	0.40	0.0156	5.0	20.0	0.40
A100.4	—	0.40	0.0157	5.0	20.0	0.40
A100N78	N78	0.41	0.0160	5.0	20.0	0.41
A100.42	—	0.42	0.0165	5.0	20.0	0.42
A100.45	—	0.45	0.0177	5.0	20.0	0.45
A100N77	N77	0.46	0.0180	5.0	20.0	0.46
A100.48	—	0.48	0.0189	5.0	20.0	0.48
A100.5	—	0.50	0.0197	6.0	22.0	0.50
A100N76	N76	0.51	0.0200	6.0	22.0	0.51
A100.52	—	0.52	0.0205	6.0	22.0	0.52
A100N75	N75	0.53	0.0210	6.0	22.0	0.53
A100.55	—	0.55	0.0217	7.0	24.0	0.55
A100N74	N74	0.57	0.0225	7.0	24.0	0.57
A100.58	—	0.58	0.0228	7.0	24.0	0.58

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100.6	—	0.60	0.0236	7.0	24.0	0.60
A100N73	N73	0.61	0.0240	8.0	26.0	0.61
A100.62	—	0.62	0.0244	8.0	26.0	0.62
A100N72	N72	0.64	0.0250	8.0	26.0	0.64
A100.65	—	0.65	0.0256	8.0	26.0	0.65
A100N71	N71	0.66	0.0260	8.0	26.0	0.66
A100.68	—	0.68	0.0268	9.0	28.0	0.68
A100.7	—	0.70	0.0276	9.0	28.0	0.70
A100N70	N70	0.71	0.0280	9.0	28.0	0.71
A100.72	—	0.72	0.0283	9.0	28.0	0.72
A100N69	N69	0.74	0.0292	9.0	28.0	0.74
A100.75	—	0.75	0.0295	9.0	28.0	0.75
A100.78	—	0.78	0.0307	10.0	30.0	0.78
A1001/32	1/32	0.79	0.0313	10.0	30.0	0.79
A100N68	N68	0.79	0.0310	10.0	30.0	0.79
A100.8	—	0.80	0.0315	10.0	30.0	0.80
A100N67	N67	0.81	0.0320	10.0	30.0	0.81
A100.82	—	0.82	0.0323	10.0	30.0	0.82
A100N66	N66	0.84	0.0330	10.0	30.0	0.84
A100.85	—	0.85	0.0335	10.0	30.0	0.85
A100.88	—	0.88	0.0346	11.0	32.0	0.88
A100N65	N65	0.89	0.0350	11.0	32.0	0.89

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A100.9	—	0.90	0.0354	11.0	32.0	0.90
A100N64	N64	0.91	0.0360	11.0	32.0	0.91
A100.92	—	0.92	0.0362	11.0	32.0	0.92
A100N63	N63	0.94	0.0370	11.0	32.0	0.94
A100.95	—	0.95	0.0374	11.0	32.0	0.95
A100N62	N62	0.97	0.0380	12.0	34.0	0.97
A100.98	—	0.98	0.0386	12.0	34.0	0.98
A100N61	N61	0.99	0.0390	12.0	34.0	0.99
A1001.0	—	1.00	0.0394	12.0	34.0	1.00
A100N60	N60	1.02	0.0400	12.0	34.0	1.02
A100N59	N59	1.04	0.0410	12.0	34.0	1.04
A1001.05	—	1.05	0.0413	12.0	34.0	1.05
A100N58	N58	1.07	0.0420	14.0	36.0	1.07
A100N57	N57	1.09	0.0430	14.0	36.0	1.09
A1001.1	—	1.10	0.0433	14.0	36.0	1.10
A1001.15	—	1.15	0.0453	14.0	36.0	1.15
A100N56	N56	1.18	0.0465	14.0	36.0	1.18
A1003/64	3/64	1.19	0.0469	16.0	38.0	1.19
A1001.2	—	1.20	0.0472	16.0	38.0	1.20
A1001.25	—	1.25	0.0492	16.0	38.0	1.25
A1001.3	—	1.30	0.0512	16.0	38.0	1.30
A100N55	N55	1.32	0.0520	16.0	38.0	1.32
A1001.35	—	1.35	0.0531	18.0	40.0	1.35
A1001.4	—	1.40	0.0551	18.0	40.0	1.40
A100N54	N54	1.40	0.0550	18.0	40.0	1.40
A1001.45	—	1.45	0.0571	18.0	40.0	1.45
A1001.5	—	1.50	0.0591	18.0	40.0	1.50
A100N53	N53	1.51	0.0595	20.0	43.0	1.51
A1001.55	—	1.55	0.0610	20.0	43.0	1.55
A1001/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1001.6	—	1.60	0.0630	20.0	43.0	1.60
A100N52	N52	1.61	0.0635	20.0	43.0	1.61
A1001.65	—	1.65	0.0650	20.0	43.0	1.65
A1001.7	—	1.70	0.0669	20.0	43.0	1.70
A100N51	N51	1.70	0.0670	22.0	46.0	1.70
A1001.75	—	1.75	0.0689	22.0	46.0	1.75
A100N50	N50	1.78	0.0700	22.0	46.0	1.78
A1001.8	—	1.80	0.0709	22.0	46.0	1.80
A1001.85	—	1.85	0.0728	22.0	46.0	1.85
A100N49	N49	1.85	0.0730	22.0	46.0	1.85
A1001.9	—	1.90	0.0748	22.0	46.0	1.90
A100N48	N48	1.93	0.0760	24.0	49.0	1.93
A1001.95	—	1.95	0.0768	24.0	49.0	1.95
A1005/64	5/64	1.98	0.0781	24.0	49.0	1.98
A100N47	N47	1.99	0.0785	24.0	49.0	1.99
A1002.0	—	2.00	0.0787	24.0	49.0	2.00
A1002.05	—	2.05	0.0807	24.0	49.0	2.05
A100N46	N46	2.06	0.0810	24.0	49.0	2.06
A100N45	N45	2.08	0.0820	24.0	49.0	2.08
A1002.1	—	2.10	0.0827	24.0	49.0	2.10
A1002.15	—	2.15	0.0846	27.0	53.0	2.15
A100N44	N44	2.18	0.0860	27.0	53.0	2.18
A1002.2	—	2.20	0.0866	27.0	53.0	2.20
A1002.25	—	2.25	0.0886	27.0	53.0	2.25
A100N43	N43	2.26	0.0890	27.0	53.0	2.26
A1002.3	—	2.30	0.0906	27.0	53.0	2.30
A1002.35	—	2.35	0.0925	27.0	53.0	2.35
A1003/32	3/32	2.38	0.0938	30.0	57.0	2.38
A100N42	N42	2.38	0.0935	30.0	57.0	2.38
A1002.4	—	2.40	0.0945	30.0	57.0	2.40
A100N41	N41	2.44	0.0960	30.0	57.0	2.44
A1002.45	—	2.45	0.0965	30.0	57.0	2.45

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A100N40	N40	2.49	0.0980	30.0	57.0	2.49
A1002.5	—	2.50	0.0984	30.0	57.0	2.50
A100N39	N39	2.53	0.0995	30.0	57.0	2.53
A1002.55	—	2.55	0.1004	30.0	57.0	2.55
A100N38	N38	2.58	0.1015	30.0	57.0	2.58
A1002.6	—	2.60	0.1024	30.0	57.0	2.60
A100N37	N37	2.64	0.1040	30.0	57.0	2.64
A1002.65	—	2.65	0.1043	30.0	57.0	2.65
A1002.7	—	2.70	0.1063	33.0	61.0	2.70
A100N36	N36	2.71	0.1065	33.0	61.0	2.71
A1002.75	—	2.75	0.1083	33.0	61.0	2.75
A1007/64	7/64	2.78	0.1094	33.0	61.0	2.78
A100N35	N35	2.79	0.1100	33.0	61.0	2.79
A1002.8	—	2.80	0.1102	33.0	61.0	2.80
A100N34	N34	2.82	0.1110	33.0	61.0	2.82
A1002.85	—	2.85	0.1122	33.0	61.0	2.85
A100N33	N33	2.87	0.1130	33.0	61.0	2.87
A1002.9	—	2.90	0.1142	33.0	61.0	2.90
A1002.95	—	2.95	0.1161	33.0	61.0	2.95
A100N32	N32	2.95	0.1160	33.0	61.0	2.95
A1003.0	—	3.00	0.1181	33.0	61.0	3.00
A100N31	N31	3.05	0.1200	36.0	65.0	3.05
A1003.1	—	3.10	0.1220	36.0	65.0	3.10
A1003.15	—	3.15	0.1240	36.0	65.0	3.15
A1001/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1003.2	—	3.20	0.1260	36.0	65.0	3.20
A1003.25	—	3.25	0.1280	36.0	65.0	3.25
A100N30	N30	3.26	0.1285	36.0	65.0	3.26
A1003.3	—	3.30	0.1299	36.0	65.0	3.30
A1003.4	—	3.40	0.1339	39.0	70.0	3.40
A100N29	N29	3.45	0.1360	39.0	70.0	3.45
A1003.5	—	3.50	0.1378	39.0	70.0	3.50
A1009/64	9/64	3.57	0.1406	39.0	70.0	3.57
A100N28	N28	3.57	0.1405	39.0	70.0	3.57
A1003.6	—	3.60	0.1417	39.0	70.0	3.60
A100N27	N27	3.66	0.1440	39.0	70.0	3.66
A1003.7	—	3.70	0.1457	39.0	70.0	3.70
A100N26	N26	3.73	0.1470	39.0	70.0	3.73
A1003.75	—	3.75	0.1476	39.0	70.0	3.75
A1003.8	—	3.80	0.1496	43.0	75.0	3.80
A100N25	N25	3.80	0.1495	43.0	75.0	3.80
A100N24	N24	3.86	0.1520	43.0	75.0	3.86
A1003.9	—	3.90	0.1535	43.0	75.0	3.90
A100N23	N23	3.91	0.1540	43.0	75.0	3.91
A1005/32	5/32	3.97	0.1563	43.0	75.0	3.97
A100N22	N22	3.99	0.1570	43.0	75.0	3.99
A1004.0	—	4.00	0.1575	43.0	75.0	4.00
A100N21	N21	4.04	0.1590	43.0	75.0	4.04
A100N20	N20	4.09	0.1610	43.0	75.0	4.09
A1004.1	—	4.10	0.1614	43.0	75.0	4.10
A1004.2	—	4.20	0.1654	43.0	75.0	4.20
A100N19	N19	4.22	0.1660	43.0	75.0	4.22
A1004.25	—	4.25	0.1673	43.0	75.0	4.25
A1004.3	—	4.30	0.1693	47.0	80.0	4.30
A100N18	N18	4.31	0.1695	47.0	80.0	4.31
A10011/64	11/64	4.37	0.1719	47.0	80.0	4.37
A100N17	N17	4.39	0.1730	47.0	80.0	4.39
A1004.4	—	4.40	0.1732	47.0	80.0	4.40
A1004.5	—	4.50	0.1772	47.0	80.0	4.50
A100N16	N16	4.50	0.1770	47.0	80.0	4.50
A100N15	N15	4.57	0.1800	47.0	80.0	4.57
A1004.6	—	4.60	0.1811	47.0	80.0	4.60

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A100N14	N14	4.62	0.1820	47.0	80.0	4.62
A1004.7	—	4.70	0.1850	47.0	80.0	4.70
A100N13	N13	4.70	0.1850	47.0	80.0	4.70
A1004.75	—	4.75	0.1870	47.0	80.0	4.75
A1003/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1004.8	—	4.80	0.1890	52.0	86.0	4.80
A100N12	N12	4.80	0.1890	52.0	86.0	4.80
A100N11	N11	4.85	0.1910	52.0	86.0	4.85
A1004.9	—	4.90	0.1929	52.0	86.0	4.90
A100N10	N10	4.92	0.1935	52.0	86.0	4.92
A100N9	N9	4.98	0.1960	52.0	86.0	4.98
A1005.0	—	5.00	0.1969	52.0	86.0	5.00
A100N8	N8	5.06	0.1990	52.0	86.0	5.06
A1005.1	—	5.10	0.2008	52.0	86.0	5.10
A100N7	N7	5.11	0.2010	52.0	86.0	5.11
A10013/64	13/64	5.16	0.2031	52.0	86.0	5.16
A100N6	N6	5.18	0.2040	52.0	86.0	5.18
A1005.2	—	5.20	0.2047	52.0	86.0	5.20
A100N5	N5	5.22	0.2055	52.0	86.0	5.22
A1005.25	—	5.25	0.2067	52.0	86.0	5.25
A1005.3	—	5.30	0.2087	52.0	86.0	5.30
A100N4	N4	5.31	0.2090	57.0	93.0	5.31
A1005.4	—	5.40	0.2126	57.0	93.0	5.40
A100N3	N3	5.41	0.2130	57.0	93.0	5.41
A1005.5	—	5.50	0.2165	57.0	93.0	5.50
A1007/32	7/32	5.56	0.2188	57.0	93.0	5.56
A1005.6	—	5.60	0.2205	57.0	93.0	5.60
A100N2	N2	5.61	0.2210	57.0	93.0	5.61
A1005.7	—	5.70	0.2244	57.0	93.0	5.70
A1005.75	—	5.75	0.2264	57.0	93.0	5.75
A100N1	1	5.79	0.2280	57.0	93.0	5.79
A1005.8	—	5.80	0.2283	57.0	93.0	5.80
A1005.9	—	5.90	0.2323	57.0	93.0	5.90
A100A	A	5.94	0.2340	57.0	93.0	5.94
A10015/64	15/64	5.95	0.2344	57.0	93.0	5.95
A1006.0	—	6.00	0.2362	57.0	93.0	6.00
A100B	B	6.03	0.2380	63.0	101.0	6.03
A1006.1	—	6.10	0.2402	63.0	101.0	6.10
A100C	C	6.15	0.2420	63.0	101.0	6.15
A1006.2	—	6.20	0.2441	63.0	101.0	6.20
A1006.25	—	6.25	0.2461	63.0	101.0	6.25
A100D	D	6.25	0.2460	63.0	101.0	6.25
A1006.3	—	6.30	0.2480	63.0	101.0	6.30
A1001/4	1/4	6.35	0.2500	63.0	101.0	6.35
A100E	E	6.35	0.2500	63.0	101.0	6.35
A1006.4	—	6.40	0.2520	63.0	101.0	6.40
A1006.5	—	6.50	0.2559	63.0	101.0	6.50
A100F	F	6.53	0.2570	63.0	101.0	6.53
A1006.6	—	6.60	0.2598	63.0	101.0	6.60
A100G	G	6.63	0.2610	63.0	101.0	6.63
A1006.7	—	6.70	0.2638	63.0	101.0	6.70
A10017/64	17/64	6.75	0.2656	69.0	109.0	6.75
A1006.75	—	6.75	0.2657	69.0	109.0	6.75
A100H	H	6.76	0.2660	69.0	109.0	6.76
A1006.8	—	6.80	0.2677	69.0	109.0	6.80
A1006.9	—	6.90	0.2717	69.0	109.0	6.90
A100I	I	6.91	0.2720	69.0	109.0	6.91
A1007.0	—	7.00	0.2756	69.0	109.0	7.00
A100J	J	7.04	0.2770	69.0	109.0	7.04
A1007.1	—	7.10	0.2795	69.0	109.0	7.10
A1009/32	9/32	7.14	0.2813	69.0	109.0	7.14
A1007.2	—	7.20	0.2835	69.0	109.0	7.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1007.25	—	7.25	0.2854	69.0	109.0	7.25
A1007.3	—	7.30	0.2874	69.0	109.0	7.30
A100L	L	7.37	0.2900	69.0	109.0	7.37
A1007.4	—	7.40	0.2913	69.0	109.0	7.40
A1007.5	—	7.50	0.2953	69.0	109.0	7.50
A10019/64	19/64	7.54	0.2969	75.0	117.0	7.54
A1007.6	—	7.60	0.2992	75.0	117.0	7.60
A100N	N	7.67	0.3020	75.0	117.0	7.67
A1007.7	—	7.70	0.3031	75.0	117.0	7.70
A1007.75	—	7.75	0.3051	75.0	117.0	7.75
A1007.8	—	7.80	0.3071	75.0	117.0	7.80
A1007.9	—	7.90	0.3110	75.0	117.0	7.90
A1005/16	5/16	7.94	0.3125	75.0	117.0	7.94
A1008.0	—	8.00	0.3150	75.0	117.0	8.00
A1000	0	8.03	0.3160	75.0	117.0	8.03
A1008.1	—	8.10	0.3189	75.0	117.0	8.10
A1008.2	—	8.20	0.3228	75.0	117.0	8.20
A1008.25	—	8.25	0.3248	75.0	117.0	8.25
A1008.3	—	8.30	0.3268	75.0	117.0	8.30
A10021/64	21/64	8.33	0.3281	75.0	117.0	8.33
A1008.4	—	8.40	0.3307	75.0	117.0	8.40
A100Q	Q	8.43	0.3320	75.0	117.0	8.43
A1008.5	—	8.50	0.3346	75.0	117.0	8.50
A1008.6	—	8.60	0.3386	81.0	125.0	8.60
A1008.7	—	8.70	0.3425	81.0	125.0	8.70
A10011/32	11/32	8.73	0.3438	81.0	125.0	8.73
A1008.75	—	8.75	0.3445	81.0	125.0	8.75
A1008.8	—	8.80	0.3465	81.0	125.0	8.80
A1008.9	—	8.90	0.3504	81.0	125.0	8.90
A1009.0	—	9.00	0.3543	81.0	125.0	9.00
A1009.1	—	9.10	0.3583	81.0	125.0	9.10
A10023/64	23/64	9.13	0.3594	81.0	125.0	9.13
A1009.2	—	9.20	0.3622	81.0	125.0	9.20
A1009.25	—	9.25	0.3642	81.0	125.0	9.25
A1009.3	—	9.30	0.3661	81.0	125.0	9.30
A100U	U	9.35	0.3680	81.0	125.0	9.35
A1009.4	—	9.40	0.3701	81.0	125.0	9.40
A1009.5	—	9.50	0.3740	81.0	125.0	9.50
A1003/8	3/8	9.52	0.3750	87.0	133.0	9.52
A1009.6	—	9.60	0.3780	87.0	133.0	9.60
A1009.7	—	9.70	0.3819	87.0	133.0	9.70
A1009.75	—	9.75	0.3839	87.0	133.0	9.75
A1009.8	—	9.80	0.3858	87.0	133.0	9.80
A1009.9	—	9.90	0.3898	87.0	133.0	9.90
A10025/64	25/64	9.92	0.3906	87.0	133.0	9.92
A10010.0	—	10.00	0.3937	87.0	133.0	10.00
A10010.1	—	10.10	0.3976	87.0	133.0	10.10
A10010.2	—	10.20	0.4016	87.0	133.0	10.20
A10010.25	—	10.25	0.4035	87.0	133.0	10.25
A10010.3	—	10.30	0.4055	87.0	133.0	10.30
A10013/32	13/32	10.32	0.4063	87.0	133.0	10.32
A10010.4	—	10.40	0.4094	87.0	133.0	10.40
A10010.5	—	10.50	0.4134	87.0	133.0	10.50
A10010.6	—	10.60	0.4173	87.0	133.0	10.60
A10010.7	—	10.70	0.4213	94.0	142.0	10.70
A10027/64	27/64	10.72	0.4219	94.0	142.0	10.72
A10010.75	—	10.75	0.4232	94.0	142.0	10.75
A10010.8	—	10.80	0.4252	94.0	142.0	10.80
A10010.9	—	10.90	0.4291	94.0	142.0	10.90
A10011.0	—	11.00	0.4331	94.0	142.0	11.00
A10011.1	—	11.10	0.4370	94.0	142.0	11.10
A1007/16	7/16	11.11	0.4375	94.0	142.0	11.11

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A10011.2	–	11.20	0.4409	94.0	142.0	11.20
A10011.25	–	11.25	0.4429	94.0	142.0	11.25
A10011.3	–	11.30	0.4449	94.0	142.0	11.30
A10011.4	–	11.40	0.4488	94.0	142.0	11.40
A10011.5	–	11.50	0.4528	94.0	142.0	11.50
A10029/64	29/64	11.51	0.4531	94.0	142.0	11.51
A10011.6	–	11.60	0.4567	94.0	142.0	11.60
A10011.7	–	11.70	0.4606	94.0	142.0	11.70
A10011.75	–	11.75	0.4626	94.0	142.0	11.75
A10011.8	–	11.80	0.4646	94.0	142.0	11.80
A10011.9	–	11.90	0.4685	101.0	151.0	11.90
A10015/32	15/32	11.91	0.4688	101.0	151.0	11.91
A10012.0	–	12.00	0.4724	101.0	151.0	12.00
A10012.1	–	12.10	0.4764	101.0	151.0	12.10
A10012.2	–	12.20	0.4803	101.0	151.0	12.20
A10012.25	–	12.25	0.4823	101.0	151.0	12.25
A10012.3	–	12.30	0.4843	101.0	151.0	12.30
A10031/64	31/64	12.30	0.4844	101.0	151.0	12.30
A10012.4	–	12.40	0.4882	101.0	151.0	12.40
A10012.5	–	12.50	0.4921	101.0	151.0	12.50
A10012.6	–	12.60	0.4961	101.0	151.0	12.60
A10012.7	–	12.70	0.5000	101.0	151.0	12.70
A1001/2	1/2	12.70	0.5000	101.0	151.0	12.70
A10012.75	–	12.75	0.5020	101.0	151.0	12.75
A10012.8	–	12.80	0.5039	101.0	151.0	12.80
A10012.9	–	12.90	0.5079	101.0	151.0	12.90
A10013.0	–	13.00	0.5118	101.0	151.0	13.00
A10033/64	33/64	13.10	0.5156	101.0	151.0	13.10
A10013.1	–	13.10	0.5157	101.0	151.0	13.10
A10013.2	–	13.20	0.5197	101.0	151.0	13.20
A10013.25	–	13.25	0.5217	108.0	160.0	13.25
A10013.3	–	13.30	0.5236	108.0	160.0	13.30
A10013.4	–	13.40	0.5276	108.0	160.0	13.40

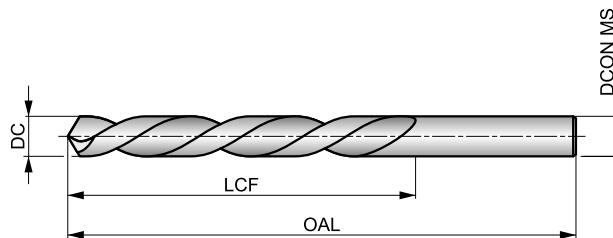
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A10017/32	17/32	13.49	0.5313	108.0	160.0	13.49
A10013.5	–	13.50	0.5315	108.0	160.0	13.50
A10013.6	–	13.60	0.5354	108.0	160.0	13.60
A10013.7	–	13.70	0.5394	108.0	160.0	13.70
A10013.75	–	13.75	0.5413	108.0	160.0	13.75
A10013.8	–	13.80	0.5433	108.0	160.0	13.80
A10035/64	35/64	13.89	0.5469	108.0	160.0	13.89
A10013.9	–	13.90	0.5472	108.0	160.0	13.90
A10014.0	–	14.00	0.5512	108.0	160.0	14.00
A10014.25	–	14.25	0.5610	114.0	169.0	14.25
A1009/16	9/16	14.29	0.5625	114.0	169.0	14.29
A10014.5	–	14.50	0.5709	114.0	169.0	14.50
A10037/64	37/64	14.68	0.5781	114.0	169.0	14.68
A10014.75	–	14.75	0.5807	114.0	169.0	14.75
A10015.0	–	15.00	0.5906	114.0	169.0	15.00
A10019/32	19/32	15.08	0.5938	120.0	178.0	15.08
A10015.25	–	15.25	0.6004	120.0	178.0	15.25
A10015.5	–	15.50	0.6102	120.0	178.0	15.50
A10015.75	–	15.75	0.6201	120.0	178.0	15.75
A1005/8	5/8	15.88	0.6250	120.0	178.0	15.88
A10016.0	–	16.00	0.6299	120.0	178.0	16.00
A10041/64	41/64	16.27	0.6406	125.0	184.0	16.27
A10016.5	–	16.50	0.6496	125.0	184.0	16.50
A10021/32	21/32	16.67	0.6563	125.0	184.0	16.67
A10017.0	–	17.00	0.6693	125.0	184.0	17.00
A10011/16	11/16	17.46	0.6875	130.0	191.0	17.46
A10017.5	–	17.50	0.6890	130.0	191.0	17.50
A10018.0	–	18.00	0.7087	130.0	191.0	18.00
A10018.5	–	18.50	0.7283	135.0	198.0	18.50
A10019.0	–	19.00	0.7480	135.0	198.0	19.00
A10019.5	–	19.50	0.7677	140.0	205.0	19.50
A10020.0	–	20.00	0.7874	140.0	205.0	20.00

A101

 DORMER

HSS venstre bor, damphærdet finish

Alsidig venstrehåndsbør med damphærdet finish til håndholdt og maskinboring. Konventionelt 118 ° spids giver styrke og er let at genopslibe, hvilket gør det meget omkostningseffektivt. Damphærdet finish bevarer skærevæske og forhindrer svejsning fra spån til værktøj. Velegnet til boring af mange materialer.



HSS	DIN 338	4×D
 118°	 ST	
 20-35°	 L	DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 H	P1.2 ■ 37 H	P1.3 ■ 38 H	P2.1 ■ 28 H	P2.2 ■ 25 F	P2.3 ■ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ■ 13 E	P4.1 ■ 11 F	P4.2 ■ 10 E	P4.3 ■ 8 D	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 9 G	M3.2 ■ 8 G	M3.3 ■ 7 G	M4.1 ■ 9 C	K1.1 ■ 30 H	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E
K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E	K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N1.1 ■ 33 J	N1.2 ■ 25 J	N1.3 ■ 17 I	N2.1 ■ 42 H	N2.2 ■ 37 H
N2.3 ■ 27 H	N3.1 ■ 59 H	N3.2 ■ 35 I	N3.3 ■ 18 G	N4.1 ■ 30 J	N4.2 ■ 28 H	N4.3 ■ 14 F	S1.1 ■ 23 E	S1.2 ■ 12 D	S1.3 ■ 6 B	S2.1 ■ 8 E	S2.2 ■ 4 A	S3.1 ■ 6 E	S3.2 ■ 3 A
S4.1 ■ 5 E	S4.2 ■ 2 A												

DC <= 3mm Blank.

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1011.0	1.00	0.0394	12.0	34.0	1.00
A1011.1	1.10	0.0433	14.0	36.0	1.10
A1011.2	1.20	0.0472	16.0	38.0	1.20
A1011.25	1.25	0.0492	16.0	38.0	1.25
A1011.3	1.30	0.0512	16.0	38.0	1.30
A1011.4	1.40	0.0551	18.0	40.0	1.40
A1011.5	1.50	0.0591	18.0	40.0	1.50
A1011.6	1.60	0.0630	20.0	43.0	1.60
A1011.7	1.70	0.0669	20.0	43.0	1.70
A1011.8	1.80	0.0709	22.0	46.0	1.80
A1011.9	1.90	0.0748	22.0	46.0	1.90
A1012.0	2.00	0.0787	24.0	49.0	2.00
A1012.1	2.10	0.0827	24.0	49.0	2.10
A1012.2	2.20	0.0866	27.0	53.0	2.20
A1012.4	2.40	0.0945	30.0	57.0	2.40
A1012.5	2.50	0.0984	30.0	57.0	2.50
A1012.6	2.60	0.1024	30.0	57.0	2.60
A1012.7	2.70	0.1063	33.0	61.0	2.70
A1012.8	2.80	0.1102	33.0	61.0	2.80
A1012.9	2.90	0.1142	33.0	61.0	2.90
A1013.0	3.00	0.1181	33.0	61.0	3.00
A1013.2	3.20	0.1260	36.0	65.0	3.20

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1013.3	3.30	0.1299	36.0	65.0	3.30
A1013.5	3.50	0.1378	39.0	70.0	3.50
A1013.8	3.80	0.1496	43.0	75.0	3.80
A1014.0	4.00	0.1575	43.0	75.0	4.00
A1014.2	4.20	0.1654	43.0	75.0	4.20
A1014.5	4.50	0.1772	47.0	80.0	4.50
A1014.8	4.80	0.1890	52.0	86.0	4.80
A1015.0	5.00	0.1969	52.0	86.0	5.00
A1015.1	5.10	0.2008	52.0	86.0	5.10
A1015.2	5.20	0.2047	52.0	86.0	5.20
A1015.5	5.50	0.2165	57.0	93.0	5.50
A1016.0	6.00	0.2362	57.0	93.0	6.00
A1016.5	6.50	0.2559	63.0	101.0	6.50
A1017.0	7.00	0.2756	69.0	109.0	7.00
A1017.5	7.50	0.2953	69.0	109.0	7.50
A1018.0	8.00	0.3150	75.0	117.0	8.00
A1018.5	8.50	0.3346	75.0	117.0	8.50
A1019.0	9.00	0.3543	81.0	125.0	9.00
A10110.0	10.00	0.3937	87.0	133.0	10.00
A10111.0	11.00	0.4331	94.0	142.0	11.00
A10112.0	12.00	0.4724	101.0	151.0	12.00

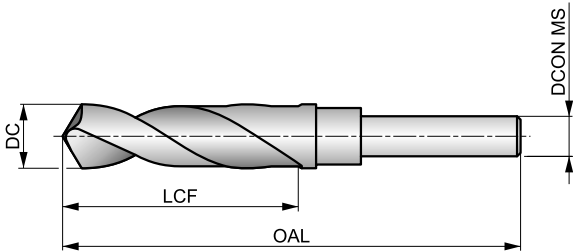
A170





HSS reduceret skaft bior, damphærdet finish

Et ½ tomme parallel skaft gør det muligt at fastspænde dette bor, selv med en stor skærediameter, i konventionelle, håndholdte elværktøjer. Et 118 ° spids gør det let at genopslibe. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Velegnet til boring af mange materialer.



HSS		4×D
		
		DC h8

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 33 H	■ 37 H	■ 38 H	■ 28 H	■ 25 F	■ 22 D	■ 19 E	■ 15 E	■ 13 D	■ 11 E	■ 10 D	■ 8 C	■ 21 D	■ 17 D
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 18 D	■ 15 D	■ 8 F	■ 7 F	■ 6 F	■ 7 B	■ 27 H	■ 20 E	■ 15 E	■ 23 D	■ 19 D	■ 15 D	■ 21 D	■ 16 D
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 13 D	■ 19 D	■ 14 D	■ 11 D	■ 9 D	■ 8 D	■ 22 D	■ 16 D	■ 13 D	■ 33 I	■ 25 I	■ 17 H	■ 42 G	■ 37 G
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 27 G	■ 56 G	■ 33 H	■ 17 F	■ 30 I	■ 28 G	■ 14 E	■ 17 E	■ 9 C	■ 5 A	■ 5 D	■ 4 A	■ 4 D	■ 3 A
S4.1	S4.2												
■ 3 D	■ 2 A												

Product	DC	DC	DC	LCF	OAL	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(inch)	(inch)	(mm)	(mm)	(mm)
A17013.0	—	13.00	0.5118	—	—	83.0	156.0	12.70
A17033/64	33/64	13.10	0.5156	3.1/8	6"	79.4	152.4	12.70
A17017/32	17/32	13.49	0.5313	3.1/8	6"	79.4	152.4	12.70
A17013.5	—	13.50	0.5315	—	—	83.0	156.0	12.70
A17035/64	35/64	13.89	0.5469	3.1/8	6"	79.4	152.4	12.70
A17014.0	—	14.00	0.5512	—	—	83.0	156.0	12.70
A1709/16	9/16	14.29	0.5625	3.1/8	6"	79.4	152.4	12.70
A17014.5	—	14.50	0.5709	—	—	83.0	156.0	12.70
A17037/64	37/64	14.68	0.5781	3.1/8	6"	79.4	152.4	12.70
A17015.0	—	15.00	0.5906	—	—	83.0	156.0	12.70
A17019/32	19/32	15.08	0.5938	3.1/8	6"	79.4	152.4	12.70
A17039/64	39/64	15.48	0.6094	3.1/8	6"	79.4	152.4	12.70
A17015.5	—	15.50	0.6102	—	—	83.0	156.0	12.70
A1705/8	5/8	15.88	0.6250	3.1/8	6"	79.4	152.4	12.70
A17016.0	—	16.00	0.6299	—	—	84.0	157.0	12.70
A17041/64	41/64	16.27	0.6406	3.1/8	6"	79.4	152.4	12.70
A17016.5	—	16.50	0.6496	—	—	84.0	157.0	12.70
A17021/32	21/32	16.67	0.6563	3.1/8	6"	79.4	152.4	12.70
A17017.0	—	17.00	0.6693	—	—	84.0	157.0	12.70
A17043/64	43/64	17.07	0.6719	3.1/8	6"	79.4	152.4	12.70
A17011/16	11/16	17.46	0.6875	3.1/8	6"	79.4	152.4	12.70
A17017.5	—	17.50	0.6890	—	—	84.0	157.0	12.70
A17045/64	45/64	17.86	0.7031	3.1/8	6"	79.4	152.4	12.70
A17018.0	—	18.00	0.7087	—	—	84.0	157.0	12.70

Product	DC	DC	DC	LCF	OAL	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(inch)	(inch)	(mm)	(mm)	(mm)
A17023/32	23/32	18.26	0.7188	3.1/8	6"	79.4	152.4	12.70
A17018.5	—	18.50	0.7283	—	—	84.0	157.0	12.70
A17047/64	47/64	18.65	0.7344	3.1/8	6"	79.4	152.4	12.70
A17019.0	—	19.00	0.7480	—	—	84.0	157.0	12.70
A1703/4	3/4	19.05	0.7500	3.1/8	6"	79.4	152.4	12.70
A17049/64	49/64	19.45	0.7656	3"	6"	76.2	152.4	12.70
A17019.5	—	19.50	0.7677	—	—	81.0	158.0	12.70
A17025/32	25/32	19.84	0.7813	3"	6"	76.2	152.4	12.70
A17020.0	—	20.00	0.7874	—	—	81.0	158.0	12.70
A17051/64	51/64	20.24	0.7969	3"	6"	76.2	152.4	12.70
A17013/16	13/16	20.64	0.8125	3"	6"	76.2	152.4	12.70
A17021.0	—	21.00	0.8268	—	—	82.0	158.0	12.70
A17053/64	53/64	21.03	0.8281	3"	6"	76.2	152.4	12.70
A17027/32	27/32	21.43	0.8437	3"	6"	76.2	152.4	12.70
A17055/64	55/64	21.83	0.8594	3"	6"	76.2	152.4	12.70
A17022.0	—	22.00	0.8661	—	—	82.0	158.0	12.70
A1707/8	7/8	22.22	0.8750	3"	6"	76.2	152.4	12.70
A17023.0	—	23.00	0.9055	—	—	82.0	158.0	12.70
A17029/32	29/32	23.02	0.9063	3"	6"	76.2	152.4	12.70
A17059/64	59/64	23.42	0.9219	3"	6"	76.2	152.4	12.70
A17015/16	15/16	23.81	0.9375	3"	6"	76.2	152.4	12.70
A17024.0	—	24.00	0.9449	—	—	83.0	159.0	12.70
A17031/32	31/32	24.61	0.9688	3"	6"	76.2	152.4	12.70
A17025.0	—	25.00	0.9843	—	—	83.0	159.0	12.70
A1701	1"	25.40	1.0000	3"	6"	76.2	152.4	12.70
A1701.1/32	1.1/32	26.19	1.0313	3"	6"	76.2	152.4	12.70
A1701.1/16	1.1/16	26.99	1.0625	3"	6"	76.2	152.4	12.70
A1701.1/8	1.1/8	28.58	1.1250	3"	6"	76.2	152.4	12.70
A1701.3/16	1.3/16	30.16	1.1875	3"	6"	76.2	152.4	12.70
A1701.1/4	1.1/4	31.75	1.2500	3"	6"	76.2	152.4	12.70

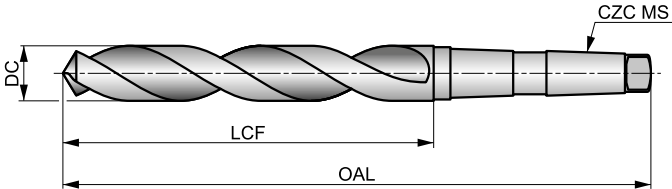
A130





HSS MK bor, damphærdet finish

Alsided bor med større diameter - op til 50,80 mm (2 tommer). MK skaft giver bedre greb til at holde det i maskinen. Konventionelt 118 ° spids giver styrke og gør det let at genopslibe. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Velegnet til boring af mange materialer.



HSS	DIN 345	4xD
		
		DC h8

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 I	P1.2 ■ 37 I	P1.3 ■ 38 I	P2.1 ■ 28 I	P2.2 ■ 25 F	P2.3 ■ 22 E	P3.1 ■ 18 F	P3.2 ■ 14 F	P3.3 ■ 12 E	P4.1 ■ 11 F	P4.2 ■ 9 E	P4.3 ■ 7 D	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 10 G	M3.2 ■ 9 G	M3.3 ■ 8 G	M4.1 ■ 10 C	K1.1 ■ 30 I	K1.2 ■ 22 E	K1.3 ■ 17 E	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E
K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E	K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N1.1 ■ 26 J	N1.2 ■ 20 J	N1.3 ■ 13 I	N2.1 ■ 43 H	N2.2 ■ 39 H
N2.3 ■ 28 H	N3.1 ■ 59 H	N3.2 ■ 35 I	N3.3 ■ 18 F	N4.1 ■ 30 K	N4.2 ■ 28 J	N4.3 ■ 14 H	S1.1 ■ 23 F	S1.2 ■ 13 D	S1.3 ■ 7 B	S2.1 ■ 9 E	S2.2 ■ 6 A	S3.1 ■ 7 E	S3.2 ■ 4 A
S4.1 ■ 5 E	S4.2 ■ 3 A												

DC> 14 mm udspidsede.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A1303.0	—	3.00	0.1181	33.0	114.0	MK 1
A1301/8	1/8	3.18	0.1250	36.0	117.0	MK 1
A1303.3	—	3.30	0.1299	36.0	117.0	MK 1
A1303.5	—	3.50	0.1378	39.0	120.0	MK 1
A1304.0	—	4.00	0.1575	43.0	124.0	MK 1
A1304.2	—	4.20	0.1654	43.0	124.0	MK 1
A1304.25	—	4.25	0.1673	43.0	124.0	MK 1
A1304.5	—	4.50	0.1772	47.0	128.0	MK 1
A1303/16	3/16	4.76	0.1875	52.0	133.0	MK 1
A1305.0	—	5.00	0.1969	52.0	133.0	MK 1
A1305.1	—	5.10	0.2008	52.0	133.0	MK 1
A13013/64	13/64	5.16	0.2031	52.0	133.0	MK 1
A1305.2	—	5.20	0.2047	52.0	133.0	MK 1
A1305.5	—	5.50	0.2165	57.0	138.0	MK 1
A1306.0	—	6.00	0.2362	57.0	138.0	MK 1
A1301/4	1/4	6.35	0.2500	63.0	144.0	MK 1
A1306.5	—	6.50	0.2559	63.0	144.0	MK 1
A1306.7	—	6.70	0.2638	63.0	144.0	MK 1
A13017/64	17/64	6.75	0.2656	69.0	150.0	MK 1
A1306.75	—	6.75	0.2657	69.0	150.0	MK 1
A1306.8	—	6.80	0.2677	69.0	150.0	MK 1
A1307.0	—	7.00	0.2756	69.0	150.0	MK 1
A1309/32	9/32	7.14	0.2813	69.0	150.0	MK 1

Product	DC	DC	DC	LCF	OAL	CZC MS
	(inch)	(mm)	(inch)	(mm)	(mm)	
A1307.5	–	7.50	0.2953	69.0	150.0	MK 1
A1305/16	5/16	7.94	0.3125	75.0	156.0	MK 1
A1308.0	–	8.00	0.3150	75.0	156.0	MK 1
A1308.2	–	8.20	0.3228	75.0	156.0	MK 1
A1308.5	–	8.50	0.3346	75.0	156.0	MK 1
A1308.6	–	8.60	0.3386	81.0	162.0	MK 1
A1308.7	–	8.70	0.3425	81.0	162.0	MK 1
A13011/32	11/32	8.73	0.3438	81.0	162.0	MK 1
A1308.75	–	8.75	0.3445	81.0	162.0	MK 1
A1309.0	–	9.00	0.3543	81.0	162.0	MK 1
A1309.5	–	9.50	0.3740	81.0	162.0	MK 1
A1303/8	3/8	9.52	0.3750	87.0	168.0	MK 1
A13010.0	–	10.00	0.3937	87.0	168.0	MK 1
A13010.2	–	10.20	0.4016	87.0	168.0	MK 1
A13010.25	–	10.25	0.4035	87.0	168.0	MK 1
A13010.3	–	10.30	0.4055	87.0	168.0	MK 1
A13013/32	13/32	10.32	0.4063	87.0	168.0	MK 1
A13010.5	–	10.50	0.4134	87.0	168.0	MK 1
A13027/64	27/64	10.72	0.4219	94.0	175.0	MK 1
A13010.75	–	10.75	0.4232	94.0	175.0	MK 1
A13010.8	–	10.80	0.4252	94.0	175.0	MK 1
A13011.0	–	11.00	0.4331	94.0	175.0	MK 1
A1307/16	7/16	11.11	0.4375	94.0	175.0	MK 1
A13011.2	–	11.20	0.4409	94.0	175.0	MK 1
A13011.5	–	11.50	0.4528	94.0	175.0	MK 1
A13011.75	–	11.75	0.4626	94.0	175.0	MK 1
A13011.8	–	11.80	0.4646	94.0	175.0	MK 1
A13012.0	–	12.00	0.4724	101.0	182.0	MK 1
A13012.2	–	12.20	0.4803	101.0	182.0	MK 1
A13012.25	–	12.25	0.4823	101.0	182.0	MK 1
A13031/64	31/64	12.30	0.4844	101.0	182.0	MK 1
A13012.5	–	12.50	0.4921	101.0	182.0	MK 1
A13012.7	–	12.70	0.5000	101.0	182.0	MK 1
A1301/2	1/2	12.70	0.5000	101.0	182.0	MK 1
A13012.75	–	12.75	0.5020	101.0	182.0	MK 1
A13012.8	–	12.80	0.5039	101.0	182.0	MK 1
A13013.0	–	13.00	0.5118	101.0	182.0	MK 1
A13033/64	33/64	13.10	0.5156	101.0	182.0	MK 1
A13013.2	–	13.20	0.5197	101.0	182.0	MK 1
A13013.25	–	13.25	0.5217	108.0	189.0	MK 1
A13017/32	17/32	13.49	0.5313	108.0	189.0	MK 1
A13013.5	–	13.50	0.5315	108.0	189.0	MK 1
A13013.75	–	13.75	0.5413	108.0	189.0	MK 1
A13013.8	–	13.80	0.5433	108.0	189.0	MK 1
A13013.9	–	13.90	0.5472	108.0	189.0	MK 1
A13014.0	–	14.00	0.5512	108.0	189.0	MK 1
A13014.1	–	14.10	0.5551	114.0	212.0	MK 2
A13014.2	–	14.20	0.5591	114.0	212.0	MK 2
A13014.25	–	14.25	0.5610	114.0	212.0	MK 2
A1309/16	9/16	14.29	0.5625	114.0	212.0	MK 2
A13014.3	–	14.30	0.5630	114.0	212.0	MK 2
A13014.5	–	14.50	0.5709	114.0	212.0	MK 2
A13037/64	37/64	14.68	0.5781	114.0	212.0	MK 2
A13014.75	–	14.75	0.5807	114.0	212.0	MK 2
A13014.8	–	14.80	0.5827	114.0	212.0	MK 2
A13014.9	–	14.90	0.5866	114.0	212.0	MK 2
A13015.0	–	15.00	0.5906	114.0	212.0	MK 2
A13015.1	–	15.10	0.5945	120.0	218.0	MK 2
A13015.2	–	15.20	0.5984	120.0	218.0	MK 2
A13015.25	–	15.25	0.6004	120.0	218.0	MK 2
A13039/64	39/64	15.48	0.6094	120.0	218.0	MK 2
A13015.5	–	15.50	0.6102	120.0	218.0	MK 2

Product	DC	DC	DC	LCF	OAL	CZC MS
	(inch)	(mm)	(inch)	(mm)	(mm)	
A13015.7	–	15.70	0.6181	120.0	218.0	MK 2
A13015.75	–	15.75	0.6201	120.0	218.0	MK 2
A13015.8	–	15.80	0.6220	120.0	218.0	MK 2
A1305/8	5/8	15.88	0.6250	120.0	218.0	MK 2
A13015.9	–	15.90	0.6260	120.0	218.0	MK 2
A13016.0	–	16.00	0.6299	120.0	218.0	MK 2
A13016.1	–	16.10	0.6339	125.0	223.0	MK 2
A13016.2	–	16.20	0.6378	125.0	223.0	MK 2
A13016.25	–	16.25	0.6398	125.0	223.0	MK 2
A13041/64	41/64	16.27	0.6406	125.0	223.0	MK 2
A13016.5	–	16.50	0.6496	125.0	223.0	MK 2
A13021/32	21/32	16.67	0.6563	125.0	223.0	MK 2
A13016.75	–	16.75	0.6594	125.0	223.0	MK 2
A13017.0	–	17.00	0.6693	125.0	223.0	MK 2
A13043/64	43/64	17.07	0.6719	130.0	228.0	MK 2
A13017.25	–	17.25	0.6791	130.0	228.0	MK 2
A13011/16	11/16	17.46	0.6875	130.0	228.0	MK 2
A13017.5	–	17.50	0.6890	130.0	228.0	MK 2
A13017.75	–	17.75	0.6988	130.0	228.0	MK 2
A13045/64	45/64	17.86	0.7031	130.0	228.0	MK 2
A13018.0	–	18.00	0.7087	130.0	228.0	MK 2
A13018.25	–	18.25	0.7185	135.0	233.0	MK 2
A13023/32	23/32	18.26	0.7188	135.0	233.0	MK 2
A13018.5	–	18.50	0.7283	135.0	233.0	MK 2
A13047/64	47/64	18.65	0.7344	135.0	233.0	MK 2
A13018.75	–	18.75	0.7382	135.0	233.0	MK 2
A13019.0	–	19.00	0.7480	135.0	233.0	MK 2
A1303/4	3/4	19.05	0.7500	140.0	238.0	MK 2
A13019.25	–	19.25	0.7579	140.0	238.0	MK 2
A13019.5	–	19.50	0.7677	140.0	238.0	MK 2
A13019.75	–	19.75	0.7776	140.0	238.0	MK 2
A13025/32	25/32	19.84	0.7813	140.0	238.0	MK 2
A13020.0	–	20.00	0.7874	140.0	238.0	MK 2
A13020.25	–	20.25	0.7972	145.0	243.0	MK 2
A13020.5	–	20.50	0.8071	145.0	243.0	MK 2
A13013/16	13/16	20.64	0.8125	145.0	243.0	MK 2
A13020.75	–	20.75	0.8169	145.0	243.0	MK 2
A13021.0	–	21.00	0.8268	145.0	243.0	MK 2
A13021.25	–	21.25	0.8366	150.0	248.0	MK 2
A13021.5	–	21.50	0.8465	150.0	248.0	MK 2
A13021.75	–	21.75	0.8563	150.0	248.0	MK 2
A13022.0	–	22.00	0.8661	150.0	248.0	MK 2
A1307/8	7/8	22.22	0.8750	150.0	248.0	MK 2
A13022.25	–	22.25	0.8760	150.0	248.0	MK 2
A13022.5	–	22.50	0.8858	155.0	253.0	MK 2
A13057/64	57/64	22.62	0.8906	155.0	253.0	MK 2
A13022.75	–	22.75	0.8957	155.0	253.0	MK 2
A13023.0	–	23.00	0.9055	155.0	253.0	MK 2
A13029/32	29/32	23.02	0.9063	155.0	253.0	MK 2
A13023.25	–	23.25	0.9154	155.0	276.0	MK 3
A13023.5	–	23.50	0.9252	155.0	276.0	MK 3
A13023.75	–	23.75	0.9350	160.0	281.0	MK 3
A13015/16	15/16	23.81	0.9375	160.0	281.0	MK 3
A13024.0	–	24.00	0.9449	160.0	281.0	MK 3
A13061/64	61/64	24.21	0.9531	160.0	281.0	MK 3
A13024.5	–	24.50	0.9646	160.0	281.0	MK 3
A13024.75	–	24.75	0.9744	160.0	281.0	MK 3
A13025.0	–	25.00	0.9843	160.0	281.0	MK 3
A13025.25	–	25.25	0.9941	165.0	286.0	MK 3
A1301	1"	25.40	1.0000	165.0	286.0	MK 3
A13025.5	–	25.50	1.0039	165.0	286.0	MK 3
A13025.75	–	25.75	1.0138	165.0	286.0	MK 3

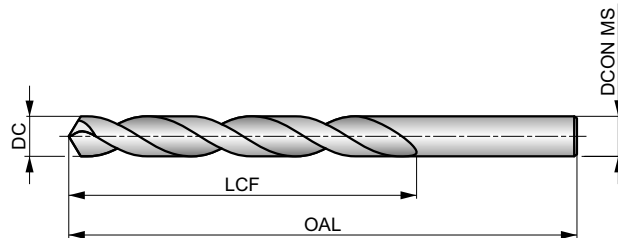
Product	DC	DC	DC	LCF	OAL	CZC MS
	(inch)	(mm)	(inch)	(mm)	(mm)	
A13026.0	–	26.00	1.0236	165.0	286.0	MK 3
A13026.25	–	26.25	1.0335	165.0	286.0	MK 3
A13026.5	–	26.50	1.0433	165.0	286.0	MK 3
A1301.1/16	1.1/16	26.99	1.0625	170.0	291.0	MK 3
A13027.0	–	27.00	1.0630	170.0	291.0	MK 3
A13027.5	–	27.50	1.0827	170.0	291.0	MK 3
A13028.0	–	28.00	1.1024	170.0	291.0	MK 3
A13028.5	–	28.50	1.1220	175.0	296.0	MK 3
A1301.1/8	1.1/8	28.58	1.1250	175.0	296.0	MK 3
A13029.0	–	29.00	1.1417	175.0	296.0	MK 3
A13029.5	–	29.50	1.1614	175.0	296.0	MK 3
A13030.0	–	30.00	1.1811	175.0	296.0	MK 3
A1301.3/16	1.3/16	30.16	1.1875	180.0	301.0	MK 3
A13030.5	–	30.50	1.2008	180.0	301.0	MK 3
A13031.0	–	31.00	1.2205	180.0	301.0	MK 3
A13031.5	–	31.50	1.2402	180.0	301.0	MK 3
A1301.1/4	1.1/4	31.75	1.2500	185.0	306.0	MK 3
A13032.0	–	32.00	1.2598	185.0	334.0	MK 4
A13032.5	–	32.50	1.2795	185.0	334.0	MK 4
A13033.0	–	33.00	1.2992	185.0	334.0	MK 4
A13033.5	–	33.50	1.3189	185.0	334.0	MK 4
A13034.0	–	34.00	1.3386	190.0	339.0	MK 4
A13034.5	–	34.50	1.3583	190.0	339.0	MK 4
A1301.3/8	1.3/8	34.93	1.3750	190.0	339.0	MK 4
A13035.0	–	35.00	1.3780	190.0	339.0	MK 4
A13035.5	–	35.50	1.3976	190.0	339.0	MK 4
A13036.0	–	36.00	1.4173	195.0	344.0	MK 4
A13037.0	–	37.00	1.4567	195.0	344.0	MK 4
A13037.5	–	37.50	1.4764	195.0	344.0	MK 4
A13038.0	–	38.00	1.4961	200.0	349.0	MK 4
A1301.1/2	1.1/2	38.10	1.5000	200.0	349.0	MK 4
A13038.5	–	38.50	1.5157	200.0	349.0	MK 4
A13039.0	–	39.00	1.5354	200.0	349.0	MK 4
A13039.5	–	39.50	1.5551	200.0	349.0	MK 4
A13040.0	–	40.00	1.5748	200.0	349.0	MK 4
A13041.0	–	41.00	1.6142	205.0	354.0	MK 4
A13042.0	–	42.00	1.6535	205.0	354.0	MK 4
A13043.0	–	43.00	1.6929	210.0	359.0	MK 4
A13044.0	–	44.00	1.7323	210.0	359.0	MK 4
A1301.3/4	1.3/4	44.45	1.7500	210.0	359.0	MK 4
A13045.0	–	45.00	1.7717	210.0	359.0	MK 4
A13046.0	–	46.00	1.8110	215.0	364.0	MK 4
A13048.0	–	48.00	1.8898	220.0	369.0	MK 4
A13049.0	–	49.00	1.9291	220.0	369.0	MK 4
A13050.0	–	50.00	1.9685	220.0	369.0	MK 4
A1302	2"	50.80	2.0000	225.0	374.0	MK 4

A002

 DORMER

HSS bor, TiN-Tip belagt

Alsidig bor til både håndboring og maskinboring. Et specielt designet 118 ° spids, der hjælper med at centrere boret selv ved boring i hånden og giver et mere nøjagtigt hul i størrelse. Velegnet til mange materialer. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.



HSS	DIN 338	4×D
 118°	 TiN-Tip	
 20-35°	 R	DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 46 J	P1.2 ■ 52 J	P1.3 ■ 54 J	P2.1 ■ 40 J	P2.2 ■ 35 F	P2.3 ■ 31 F	P3.1 ■ 27 F	P3.2 ■ 21 F	P3.3 ■ 18 F	P4.1 ■ 16 F	P4.2 ■ 13 F	P4.3 ■ 11 E	M1.1 ■ 27 F	M1.2 ■ 23 F
M2.1 ■ 24 F	M2.2 ■ 20 F	M3.1 ■ 14 G	M3.2 ■ 12 G	M3.3 ■ 11 G	M4.1 ■ 16 C	K1.1 ■ 40 J	K1.2 ■ 30 E	K1.3 ■ 22 E	K2.1 ■ 34 E	K2.2 ■ 28 E	K2.3 ■ 22 E	K3.1 ■ 30 E	K3.2 ■ 23 E
K3.3 ■ 19 E	K4.1 ■ 28 E	K4.2 ■ 21 E	K4.3 ■ 16 E	K4.4 ■ 13 E	K4.5 ■ 11 E	K5.1 ■ 32 E	K5.2 ■ 24 E	K5.3 ■ 19 E	N1.1 ■ 41 K	N1.2 ■ 31 K	N1.3 ■ 21 J	N2.1 ■ 51 I	N2.2 ■ 46 I
N2.3 ■ 33 I	N3.1 ■ 56 H	N3.2 ■ 33 I	N3.3 ■ 17 G	N4.1 ■ 30 I	N4.2 ■ 50 H	N4.3 ■ 35 F	S1.1 ■ 23 F	S1.2 ■ 13 D	S1.3 ■ 7 B	S2.1 ■ 9 E	S2.2 ■ 4 A	S3.1 ■ 7 E	S3.2 ■ 3 A
S4.1 ■ 5 E	S4.2 ■ 2 A												

DC <2 mm lys; DC> = 2 mm TiN belagt og krydsslebet.

Produkter fra denne serie fås også i sæt. Se A087, A089 A094, A095 eller A099.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0021.0	—	1.00	0.0394	12.0	34.0	1.00
A0021.1	—	1.10	0.0433	14.0	36.0	1.10
A0023/64	3/64	1.19	0.0469	16.0	38.0	1.19
A0021.2	—	1.20	0.0472	16.0	38.0	1.20
A0021.3	—	1.30	0.0512	16.0	38.0	1.30
A0021.4	—	1.40	0.0551	18.0	40.0	1.40
A0021.5	—	1.50	0.0591	18.0	40.0	1.50
A0021/16	1/16	1.59	0.0625	20.0	43.0	1.59
A0021.6	—	1.60	0.0630	20.0	43.0	1.60
A0021.7	—	1.70	0.0669	20.0	43.0	1.70
A0021.8	—	1.80	0.0709	22.0	46.0	1.80
A0021.9	—	1.90	0.0748	22.0	46.0	1.90
A0025/64	5/64	1.98	0.0781	24.0	49.0	1.98
A0022.0	—	2.00	0.0787	24.0	49.0	2.00
A0022.1	—	2.10	0.0827	24.0	49.0	2.10
A0022.2	—	2.20	0.0866	27.0	53.0	2.20
A0022.3	—	2.30	0.0906	27.0	53.0	2.30
A0023/32	3/32	2.38	0.0938	30.0	57.0	2.38
A0022.4	—	2.40	0.0945	30.0	57.0	2.40
A0022.5	—	2.50	0.0984	30.0	57.0	2.50
A0022.6	—	2.60	0.1024	30.0	57.0	2.60
A0022.7	—	2.70	0.1063	33.0	61.0	2.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0027/64	7/64	2.78	0.1094	33.0	61.0	2.78
A0022.8	—	2.80	0.1102	33.0	61.0	2.80
A0022.9	—	2.90	0.1142	33.0	61.0	2.90
A0023.0	—	3.00	0.1181	33.0	61.0	3.00
A0023.1	—	3.10	0.1220	36.0	65.0	3.10
A0021/8	1/8	3.18	0.1250	36.0	65.0	3.18
A0023.2	—	3.20	0.1260	36.0	65.0	3.20
A0023.25	—	3.25	0.1280	36.0	65.0	3.25
A0023.3	—	3.30	0.1299	36.0	65.0	3.30
A0023.4	—	3.40	0.1339	39.0	70.0	3.40
A0023.5	—	3.50	0.1378	39.0	70.0	3.50
A0029/64	9/64	3.57	0.1406	39.0	70.0	3.57
A0023.6	—	3.60	0.1417	39.0	70.0	3.60
A0023.7	—	3.70	0.1457	39.0	70.0	3.70
A0023.8	—	3.80	0.1496	43.0	75.0	3.80
A0023.9	—	3.90	0.1535	43.0	75.0	3.90
A0025/32	5/32	3.97	0.1563	43.0	75.0	3.97
A0024.0	—	4.00	0.1575	43.0	75.0	4.00
A0024.1	—	4.10	0.1614	43.0	75.0	4.10
A0024.2	—	4.20	0.1654	43.0	75.0	4.20
A0024.3	—	4.30	0.1693	47.0	80.0	4.30
A00211/64	11/64	4.37	0.1719	47.0	80.0	4.37

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A0024.4	—	4.40	0.1732	47.0	80.0	4.40
A0024.5	—	4.50	0.1772	47.0	80.0	4.50
A0024.6	—	4.60	0.1811	47.0	80.0	4.60
A0024.7	—	4.70	0.1850	47.0	80.0	4.70
A0023/16	3/16	4.76	0.1875	52.0	86.0	4.76
A0024.8	—	4.80	0.1890	52.0	86.0	4.80
A0024.9	—	4.90	0.1929	52.0	86.0	4.90
A0025.0	—	5.00	0.1969	52.0	86.0	5.00
A0025.1	—	5.10	0.2008	52.0	86.0	5.10
A00213/64	13/64	5.16	0.2031	52.0	86.0	5.16
A0025.2	—	5.20	0.2047	52.0	86.0	5.20
A0025.3	—	5.30	0.2087	52.0	86.0	5.30
A0025.4	—	5.40	0.2126	57.0	93.0	5.40
A0025.5	—	5.50	0.2165	57.0	93.0	5.50
A0027/32	7/32	5.56	0.2188	57.0	93.0	5.56
A0025.6	—	5.60	0.2205	57.0	93.0	5.60
A0025.7	—	5.70	0.2244	57.0	93.0	5.70
A0025.8	—	5.80	0.2283	57.0	93.0	5.80
A0025.9	—	5.90	0.2323	57.0	93.0	5.90
A00215/64	15/64	5.95	0.2344	57.0	93.0	5.95
A0026.0	—	6.00	0.2362	57.0	93.0	6.00
A0026.1	—	6.10	0.2402	63.0	101.0	6.10
A0026.2	—	6.20	0.2441	63.0	101.0	6.20
A0026.3	—	6.30	0.2480	63.0	101.0	6.30
A0021/4	1/4	6.35	0.2500	63.0	101.0	6.35
A0026.4	—	6.40	0.2520	63.0	101.0	6.40
A0026.5	—	6.50	0.2559	63.0	101.0	6.50
A0026.6	—	6.60	0.2598	63.0	101.0	6.60
A0026.7	—	6.70	0.2638	63.0	101.0	6.70
A00217/64	17/64	6.75	0.2656	69.0	109.0	6.75
A0026.8	—	6.80	0.2677	69.0	109.0	6.80
A0026.9	—	6.90	0.2717	69.0	109.0	6.90
A0027.0	—	7.00	0.2756	69.0	109.0	7.00
A0027.1	—	7.10	0.2795	69.0	109.0	7.10
A0029/32	9/32	7.14	0.2813	69.0	109.0	7.14
A0027.2	—	7.20	0.2835	69.0	109.0	7.20
A0027.3	—	7.30	0.2874	69.0	109.0	7.30
A0027.4	—	7.40	0.2913	69.0	109.0	7.40
A0027.5	—	7.50	0.2953	69.0	109.0	7.50
A00219/64	19/64	7.54	0.2969	75.0	117.0	7.54
A0027.6	—	7.60	0.2992	75.0	117.0	7.60
A0027.7	—	7.70	0.3031	75.0	117.0	7.70
A0027.8	—	7.80	0.3071	75.0	117.0	7.80
A0027.9	—	7.90	0.3110	75.0	117.0	7.90
A0025/16	5/16	7.94	0.3125	75.0	117.0	7.94
A0028.0	—	8.00	0.3150	75.0	117.0	8.00
A0028.1	—	8.10	0.3189	75.0	117.0	8.10
A0028.2	—	8.20	0.3228	75.0	117.0	8.20
A0028.3	—	8.30	0.3268	75.0	117.0	8.30
A00221/64	21/64	8.33	0.3281	75.0	117.0	8.33
A0028.4	—	8.40	0.3307	75.0	117.0	8.40
A0028.5	—	8.50	0.3346	75.0	117.0	8.50
A0028.6	—	8.60	0.3386	81.0	125.0	8.60
A0028.7	—	8.70	0.3425	81.0	125.0	8.70
A00211/32	11/32	8.73	0.3438	81.0	125.0	8.73
A0028.8	—	8.80	0.3465	81.0	125.0	8.80
A0028.9	—	8.90	0.3504	81.0	125.0	8.90
A0029.0	—	9.00	0.3543	81.0	125.0	9.00
A0029.1	—	9.10	0.3583	81.0	125.0	9.10
A00223/64	23/64	9.13	0.3594	81.0	125.0	9.13
A0029.2	—	9.20	0.3622	81.0	125.0	9.20
A0029.3	—	9.30	0.3661	81.0	125.0	9.30
A0029.4	—	9.40	0.3701	81.0	125.0	9.40
A0029.5	—	9.50	0.3740	81.0	125.0	9.50
A0023/8	3/8	9.52	0.3750	87.0	133.0	9.52
A0029.6	—	9.60	0.3780	87.0	133.0	9.60
A0029.7	—	9.70	0.3819	87.0	133.0	9.70

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A0029.8	—	9.80	0.3858	87.0	133.0	9.80
A0029.9	—	9.90	0.3898	87.0	133.0	9.90
A00225/64	25/64	9.92	0.3906	87.0	133.0	9.92
A00210.0	—	10.00	0.3937	87.0	133.0	10.00
A00210.1	—	10.10	0.3976	87.0	133.0	10.10
A00210.2	—	10.20	0.4016	87.0	133.0	10.20
A00210.3	—	10.30	0.4055	87.0	133.0	10.30
A00213/32	13/32	10.32	0.4063	87.0	133.0	10.32
A00210.4	—	10.40	0.4094	87.0	133.0	10.40
A00210.5	—	10.50	0.4134	87.0	133.0	10.50
A00210.6	—	10.60	0.4173	87.0	133.0	10.60
A00210.7	—	10.70	0.4213	94.0	142.0	10.70
A00227/64	27/64	10.72	0.4219	94.0	142.0	10.72
A00210.8	—	10.80	0.4252	94.0	142.0	10.80
A00210.9	—	10.90	0.4291	94.0	142.0	10.90
A00211.0	—	11.00	0.4331	94.0	142.0	11.00
A00211.1	—	11.10	0.4370	94.0	142.0	11.10
A0027/16	7/16	11.11	0.4375	94.0	142.0	11.11
A00211.2	—	11.20	0.4409	94.0	142.0	11.20
A00211.3	—	11.30	0.4449	94.0	142.0	11.30
A00211.4	—	11.40	0.4488	94.0	142.0	11.40
A00211.5	—	11.50	0.4528	94.0	142.0	11.50
A00229/64	29/64	11.51	0.4531	94.0	142.0	11.51
A00211.6	—	11.60	0.4567	94.0	142.0	11.60
A00211.7	—	11.70	0.4606	94.0	142.0	11.70
A00211.8	—	11.80	0.4646	94.0	142.0	11.80
A00211.9	—	11.90	0.4685	101.0	151.0	11.90
A00215/32	15/32	11.91	0.4688	101.0	151.0	11.91
A00212.0	—	12.00	0.4724	101.0	151.0	12.00
A00212.1	—	12.10	0.4764	101.0	151.0	12.10
A00212.2	—	12.20	0.4803	101.0	151.0	12.20
A00212.3	—	12.30	0.4843	101.0	151.0	12.30
A00231/64	31/64	12.30	0.4844	101.0	151.0	12.30
A00212.4	—	12.40	0.4882	101.0	151.0	12.40
A00212.5	—	12.50	0.4921	101.0	151.0	12.50
A00212.6	—	12.60	0.4961	101.0	151.0	12.60
A00212.7	—	12.70	0.5000	101.0	151.0	12.70
A0021/2	1/2	12.70	0.5000	101.0	151.0	12.70
A00212.8	—	12.80	0.5039	101.0	151.0	12.80
A00212.9	—	12.90	0.5079	101.0	151.0	12.90
A00213.0	—	13.00	0.5118	101.0	151.0	13.00
A00233/64	33/64	13.10	0.5156	101.0	151.0	13.10
A00213.1	—	13.10	0.5157	101.0	151.0	13.10
A00213.2	—	13.20	0.5197	101.0	151.0	13.20
A00213.25	—	13.25	0.5217	108.0	160.0	13.25
A00213.3	—	13.30	0.5236	108.0	160.0	13.30
A00213.4	—	13.40	0.5276	108.0	160.0	13.40
A00217/32	17/32	13.49	0.5313	108.0	160.0	13.49
A00213.5	—	13.50	0.5315	108.0	160.0	13.50
A00213.6	—	13.60	0.5354	108.0	160.0	13.60
A00213.7	—	13.70	0.5394	108.0	160.0	13.70
A00213.75	—	13.75	0.5413	108.0	160.0	13.75
A00213.8	—	13.80	0.5433	108.0	160.0	13.80
A00213.9	—	13.90	0.5472	108.0	160.0	13.90
A00214.0	—	14.00	0.5512	108.0	160.0	14.00
A00214.25	—	14.25	0.5610	114.0	169.0	14.25
A0029/16	9/16	14.29	0.5625	114.0	169.0	14.29
A00214.5	—	14.50	0.5709	114.0	169.0	14.50
A00214.75	—	14.75	0.5807	114.0	169.0	14.75
A00215.0	—	15.00	0.5906	114.0	169.0	15.00
A00219/32	19/32	15.08	0.5938	120.0	178.0	15.08
A00215.25	—	15.25	0.6004	120.0	178.0	15.25
A00215.5	—	15.50	0.6102	120.0	178.0	15.50
A00215.75	—	15.75	0.6201	120.0	178.0	15.75
A0025/8	5/8	15.88	0.6250	120.0	178.0	15.88
A00216.0	—	16.00	0.6299	120.0	178.0	16.00

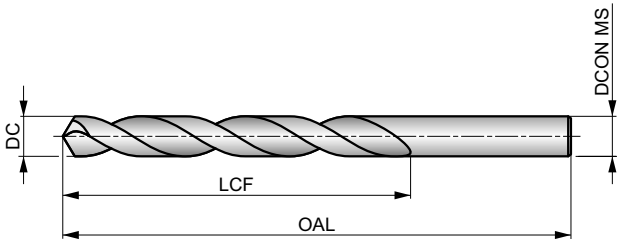
A002S





HSS bor, TiN-Tip belagt

Alsidig bor til både håndboring og maskinboring. Et specielt designet 118 ° spids, der hjælper med at centrere boret selv ved boring i hånden og giver et mere nøjagtigt hul i størrelse. Velegnet til mange materialer. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.



HSS	DIN 338	4×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 46 J	P1.2 ■ 52 J	P1.3 ■ 54 J	P2.1 ■ 40 J	P2.2 ■ 35 F	P2.3 ▣ 31 F	P3.1 ■ 27 F	P3.2 ■ 21 F	P3.3 ▣ 18 F	P4.1 ■ 16 F	P4.2 ▣ 13 F	P4.3 ▣ 11 E	M1.1 ▣ 27 F	M1.2 ▣ 23 F
M2.1 ▣ 24 F	M2.2 ▣ 20 F	M3.1 ▣ 14 G	M3.2 ▣ 12 G	M3.3 ▣ 11 G	M4.1 ▣ 16 C	K1.1 ■ 40 J	K1.2 ■ 30 E	K1.3 ■ 22 E	K2.1 ▣ 34 E	K2.2 ▣ 28 E	K2.3 ▣ 22 E	K3.1 ▣ 30 E	K3.2 ▣ 23 E
K3.3 ▣ 19 E	K4.1 ▣ 28 E	K4.2 ▣ 21 E	K4.3 ▣ 16 E	K4.4 ▣ 13 E	K4.5 ▣ 11 E	K5.1 ▣ 32 E	K5.2 ▣ 24 E	K5.3 ▣ 19 E	N1.1 ■ 41 K	N1.2 ■ 31 K	N1.3 ■ 21 J	N2.1 ▣ 51 I	N2.2 ▣ 46 I
N2.3 ▣ 33 I	N3.1 ▣ 56 H	N3.2 ▣ 33 I	N3.3 ▣ 17 G	N4.1 ■ 30 I	N4.2 ■ 50 H	N4.3 ▣ 35 F	S1.1 ▣ 23 F	S1.2 ▣ 13 D	S1.3 ▣ 7 B	S2.1 ▣ 9 E	S2.2 ▣ 4 A	S3.1 ▣ 7 E	S3.2 ▣ 3 A
S4.1 ▣ 5 E	S4.2 ▣ 2 A												

DC <= 5mm Salges i pakker med 2 stk.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A002S2.0	—	2.00	0.0787	24.0	49.0	2.00
A002S2.5	—	2.50	0.0984	30.0	57.0	2.50
A002S3.0	—	3.00	0.1181	33.0	61.0	3.00
A002S1/8	1/8	3.18	0.1250	36.0	65.0	3.18
A002S3.2	—	3.20	0.1260	36.0	65.0	3.20
A002S3.3	—	3.30	0.1299	36.0	65.0	3.30
A002S3.5	—	3.50	0.1378	39.0	70.0	3.50
A002S5/32	5/32	3.97	0.1563	43.0	75.0	3.97
A002S4.0	—	4.00	0.1575	43.0	75.0	4.00
A002S4.1	—	4.10	0.1614	43.0	75.0	4.10
A002S4.2	—	4.20	0.1654	43.0	75.0	4.20
A002S4.5	—	4.50	0.1772	47.0	80.0	4.50
A002S3/16	3/16	4.76	0.1875	52.0	86.0	4.76
A002S5.0	—	5.00	0.1969	52.0	86.0	5.00
A002S13/64	13/64	5.16	0.2031	52.0	86.0	5.16
A002S5.5	—	5.50	0.2165	57.0	93.0	5.50
A002S7/32	7/32	5.56	0.2188	57.0	93.0	5.56
A002S6.0	—	6.00	0.2362	57.0	93.0	6.00
A002S1/4	1/4	6.35	0.2500	63.0	101.0	6.35
A002S6.5	—	6.50	0.2559	63.0	101.0	6.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A002S6.8	—	6.80	0.2677	69.0	109.0	6.80
A002S7.0	—	7.00	0.2756	69.0	109.0	7.00
A002S7.5	—	7.50	0.2953	69.0	109.0	7.50
A002S5/16	5/16	7.94	0.3125	75.0	117.0	7.94
A002S8.0	—	8.00	0.3150	75.0	117.0	8.00
A002S8.2	—	8.20	0.3228	75.0	117.0	8.20
A002S8.5	—	8.50	0.3346	75.0	117.0	8.50
A002S9.0	—	9.00	0.3543	81.0	125.0	9.00
A002S9.5	—	9.50	0.3740	81.0	125.0	9.50
A002S3/8	3/8	9.52	0.3750	87.0	133.0	9.52
A002S10.0	—	10.00	0.3937	87.0	133.0	10.00
A002S10.2	—	10.20	0.4016	87.0	133.0	10.20
A002S10.5	—	10.50	0.4134	87.0	133.0	10.50
A002S11.0	—	11.00	0.4331	94.0	142.0	11.00
A002S11.5	—	11.50	0.4528	94.0	142.0	11.50
A002S12.0	—	12.00	0.4724	101.0	151.0	12.00
A002S12.5	—	12.50	0.4921	101.0	151.0	12.50
A002S1/2	1/2	12.70	0.5000	101.0	151.0	12.70
A002S13.0	—	13.00	0.5118	101.0	151.0	13.00

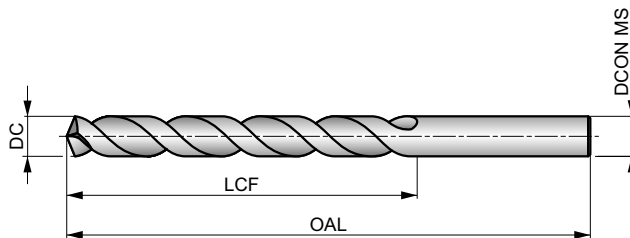
A108

 DORMER



HSS bor, damphærdet finish (designet til rustfrit stål)

Første valg ved boring af rustfrit stål med håndholdte applikationer, men kan også bruges effektivt i maskiner. Spidspå 135 ° hjælper med at centrere sig selv og reducerer skærekrafterne. Damphærdet finish hjælper med at forhindre emnet i at klæbe til forkant.



HSS	DIN 338	4×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ▣33 I	P1.2 ▣37 I	P1.3 ▣38 I	P2.1 ▣28 I	P2.2 ▣25 G	P2.3 ▣22 E	P3.1 ▣19 F	P3.2 ▣15 F	P3.3 ▣13 E	P4.1 ▣11 F	P4.2 ▣10 E	P4.3 ▣8 D	M1.1 ▣21 E	M1.2 ▣17 E
M2.1 ▣18 E	M2.2 ▣15 E	M3.1 ▣10 G	M3.2 ▣9 G	M3.3 ▣8 G	M4.1 ▣10 D	K1.1 ▣30 H	K1.2 ▣22 F	K1.3 ▣17 F	K2.1 ▣25 E	K2.2 ▣20 E	K2.3 ▣16 E	K3.1 ▣22 E	K3.2 ▣17 E
K3.3 ▣13 E	K4.1 ▣20 E	K4.2 ▣15 E	K4.3 ▣11 E	K4.4 ▣10 E	K4.5 ▣8 E	K5.1 ▣23 E	K5.2 ▣17 E	K5.3 ▣13 E	N1.1 ▣33 J	N1.2 ▣25 J	N1.3 ▣17 I	N2.1 ▣42 H	N2.2 ▣37 H
N2.3 ▣27 H	N3.1 ▣59 H	N3.2 ▣35 I	N3.3 ▣18 G	N4.1 ▣30 J	N4.2 ▣28 H	N4.3 ▣14 F	S1.1 ▣25 G	S1.2 ▣16 E	S1.3 ▣7 B	S2.1 ▣9 G	S2.2 ▣8 E	S3.1 ▣7 G	S3.2 ▣6 E
S4.1 ▣5 G	S4.2 ▣5 E												

C> 1,5 mm (1/16") krydspids.
Produkter fra denne serie fås også i sæt. Se venligst A188.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1081.0	—	1.00	0.0394	12.0	34.0	1.00
A1081.1	—	1.10	0.0433	14.0	36.0	1.10
A1081.2	—	1.20	0.0472	16.0	38.0	1.20
A1081.3	—	1.30	0.0512	16.0	38.0	1.30
A1081.4	—	1.40	0.0551	18.0	40.0	1.40
A1081.5	—	1.50	0.0591	18.0	40.0	1.50
A1081/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1081.6	—	1.60	0.0630	20.0	43.0	1.60
A1081.7	—	1.70	0.0669	20.0	43.0	1.70
A1081.8	—	1.80	0.0709	22.0	46.0	1.80
A1081.9	—	1.90	0.0748	22.0	46.0	1.90
A1085/64	5/64	1.98	0.0781	24.0	49.0	1.98
A1082.0	—	2.00	0.0787	24.0	49.0	2.00
A1082.1	—	2.10	0.0827	24.0	49.0	2.10
A1082.2	—	2.20	0.0866	27.0	53.0	2.20
A1082.3	—	2.30	0.0906	27.0	53.0	2.30
A1083/32	3/32	2.38	0.0938	30.0	57.0	2.38
A1082.4	—	2.40	0.0945	30.0	57.0	2.40
A1082.5	—	2.50	0.0984	30.0	57.0	2.50
A1082.6	—	2.60	0.1024	30.0	57.0	2.60
A1082.7	—	2.70	0.1063	33.0	61.0	2.70
A1087/64	7/64	2.78	0.1094	33.0	61.0	2.78

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1082.8	—	2.80	0.1102	33.0	61.0	2.80
A1082.9	—	2.90	0.1142	33.0	61.0	2.90
A1083.0	—	3.00	0.1181	33.0	61.0	3.00
A1083.1	—	3.10	0.1220	36.0	65.0	3.10
A1081/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1083.2	—	3.20	0.1260	36.0	65.0	3.20
A1083.3	—	3.30	0.1299	36.0	65.0	3.30
A1083.4	—	3.40	0.1339	39.0	70.0	3.40
A1083.5	—	3.50	0.1378	39.0	70.0	3.50
A1089/64	9/64	3.57	0.1406	39.0	70.0	3.57
A1083.6	—	3.60	0.1417	39.0	70.0	3.60
A1083.7	—	3.70	0.1457	39.0	70.0	3.70
A1083.8	—	3.80	0.1496	43.0	75.0	3.80
A1083.9	—	3.90	0.1535	43.0	75.0	3.90
A1085/32	5/32	3.97	0.1563	43.0	75.0	3.97
A1084.0	—	4.00	0.1575	43.0	75.0	4.00
A1084.1	—	4.10	0.1614	43.0	75.0	4.10
A1084.2	—	4.20	0.1654	43.0	75.0	4.20
A1084.3	—	4.30	0.1693	47.0	80.0	4.30
A10811/64	11/64	4.37	0.1719	47.0	80.0	4.37
A1084.4	—	4.40	0.1732	47.0	80.0	4.40
A1084.5	—	4.50	0.1772	47.0	80.0	4.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1084.6	—	4.60	0.1811	47.0	80.0	4.60
A1084.7	—	4.70	0.1850	47.0	80.0	4.70
A1083/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1084.8	—	4.80	0.1890	52.0	86.0	4.80
A1084.9	—	4.90	0.1929	52.0	86.0	4.90
A108N10	N10	4.92	0.1935	52.0	86.0	4.92
A1085.0	—	5.00	0.1969	52.0	86.0	5.00
A1085.1	—	5.10	0.2008	52.0	86.0	5.10
A10813/64	13/64	5.16	0.2031	52.0	86.0	5.16
A1085.2	—	5.20	0.2047	52.0	86.0	5.20
A1085.3	—	5.30	0.2087	52.0	86.0	5.30
A1085.4	—	5.40	0.2126	57.0	93.0	5.40
A1085.5	—	5.50	0.2165	57.0	93.0	5.50
A1087/32	7/32	5.56	0.2188	57.0	93.0	5.56
A1085.6	—	5.60	0.2205	57.0	93.0	5.60
A1085.7	—	5.70	0.2244	57.0	93.0	5.70
A1085.8	—	5.80	0.2283	57.0	93.0	5.80
A1085.9	—	5.90	0.2323	57.0	93.0	5.90
A10815/64	15/64	5.95	0.2344	57.0	93.0	5.95
A1086.0	—	6.00	0.2362	57.0	93.0	6.00
A1086.1	—	6.10	0.2402	63.0	101.0	6.10
A1086.2	—	6.20	0.2441	63.0	101.0	6.20
A1086.3	—	6.30	0.2480	63.0	101.0	6.30
A1081/4	1/4	6.35	0.2500	63.0	101.0	6.35
A1086.4	—	6.40	0.2520	63.0	101.0	6.40
A1086.5	—	6.50	0.2559	63.0	101.0	6.50
A1086.6	—	6.60	0.2598	63.0	101.0	6.60
A1086.7	—	6.70	0.2638	63.0	101.0	6.70
A10817/64	17/64	6.75	0.2656	69.0	109.0	6.75
A1086.8	—	6.80	0.2677	69.0	109.0	6.80
A1086.9	—	6.90	0.2717	69.0	109.0	6.90
A1087.0	—	7.00	0.2756	69.0	109.0	7.00
A1087.1	—	7.10	0.2795	69.0	109.0	7.10
A1089/32	9/32	7.14	0.2813	69.0	109.0	7.14
A1087.2	—	7.20	0.2835	69.0	109.0	7.20
A1087.3	—	7.30	0.2874	69.0	109.0	7.30
A1087.4	—	7.40	0.2913	69.0	109.0	7.40
A1087.5	—	7.50	0.2953	69.0	109.0	7.50
A10819/64	19/64	7.54	0.2969	75.0	117.0	7.54
A1087.6	—	7.60	0.2992	75.0	117.0	7.60
A1087.7	—	7.70	0.3031	75.0	117.0	7.70
A1087.8	—	7.80	0.3071	75.0	117.0	7.80
A1087.9	—	7.90	0.3110	75.0	117.0	7.90
A1085/16	5/16	7.94	0.3125	75.0	117.0	7.94
A1088.0	—	8.00	0.3150	75.0	117.0	8.00
A1088.1	—	8.10	0.3189	75.0	117.0	8.10
A1088.2	—	8.20	0.3228	75.0	117.0	8.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1088.3	—	8.30	0.3268	75.0	117.0	8.30
A10821/64	21/64	8.33	0.3281	75.0	117.0	8.33
A1088.4	—	8.40	0.3307	75.0	117.0	8.40
A1088.5	—	8.50	0.3346	75.0	117.0	8.50
A1088.6	—	8.60	0.3386	81.0	125.0	8.60
A1088.7	—	8.70	0.3425	81.0	125.0	8.70
A10811/32	11/32	8.73	0.3438	81.0	125.0	8.73
A1088.8	—	8.80	0.3465	81.0	125.0	8.80
A1088.9	—	8.90	0.3504	81.0	125.0	8.90
A1089.0	—	9.00	0.3543	81.0	125.0	9.00
A1089.1	—	9.10	0.3583	81.0	125.0	9.10
A10823/64	23/64	9.13	0.3594	81.0	125.0	9.13
A1089.2	—	9.20	0.3622	81.0	125.0	9.20
A1089.3	—	9.30	0.3661	81.0	125.0	9.30
A1089.4	—	9.40	0.3701	81.0	125.0	9.40
A1089.5	—	9.50	0.3740	81.0	125.0	9.50
A1083/8	3/8	9.52	0.3750	87.0	133.0	9.52
A1089.6	—	9.60	0.3780	87.0	133.0	9.60
A1089.7	—	9.70	0.3819	87.0	133.0	9.70
A1089.8	—	9.80	0.3858	87.0	133.0	9.80
A1089.9	—	9.90	0.3898	87.0	133.0	9.90
A10825/64	25/64	9.92	0.3906	87.0	133.0	9.92
A10810.0	—	10.00	0.3937	87.0	133.0	10.00
A10810.2	—	10.20	0.4016	87.0	133.0	10.20
A10813/32	13/32	10.32	0.4063	87.0	133.0	10.32
A10810.5	—	10.50	0.4134	87.0	133.0	10.50
A10827/64	27/64	10.72	0.4219	94.0	142.0	10.72
A10810.8	—	10.80	0.4252	94.0	142.0	10.80
A10811.0	—	11.00	0.4331	94.0	142.0	11.00
A1087/16	7/16	11.11	0.4375	94.0	142.0	11.11
A10811.5	—	11.50	0.4528	94.0	142.0	11.50
A10829/64	29/64	11.51	0.4531	94.0	142.0	11.51
A10811.8	—	11.80	0.4646	94.0	142.0	11.80
A10815/32	15/32	11.91	0.4688	101.0	151.0	11.91
A10812.0	—	12.00	0.4724	101.0	151.0	12.00
A10812.2	—	12.20	0.4803	101.0	151.0	12.20
A10831/64	31/64	12.30	0.4844	101.0	151.0	12.30
A10812.5	—	12.50	0.4921	101.0	151.0	12.50
A1081/2	1/2	12.70	0.5000	101.0	151.0	12.70
A10812.8	—	12.80	0.5039	101.0	151.0	12.80
A10813.0	—	13.00	0.5118	101.0	151.0	13.00
A10813.5	—	13.50	0.5315	108.0	160.0	13.50
A10814.0	—	14.00	0.5512	108.0	160.0	14.00
A10814.5	—	14.50	0.5709	114.0	169.0	14.50
A10815.0	—	15.00	0.5906	114.0	169.0	15.00
A10815.25	—	15.25	0.6004	120.0	178.0	15.25
A10816.0	—	16.00	0.6299	120.0	178.0	16.00

Materiale kode (BMC)		HSS	HSS																
Grundlæggende standard-gruppe (BSG)		DIN 340	BS 328																
Brugbar længde (ULDR)		6×D	10×D																
Anvendelsesvinkel																			
Belægning																			
Skaft																			
Spiral form																			
Hånd (skæreretning)																			
Produktfamiliekode		A110	A125																
PSF skærediametre række-vidde		0.50 - 1"	1.40 - 3/4																
		36	38																
P	P1																		
	P2																		
	P3																		
	P4																		
M	M1																		
	M2																		
	M3																		
	M4																		
K	K1																		
	K2																		
	K3																		
	K4																		
	K5																		
N	N1																		
	N2																		
	N3																		
	N4																		
	N5																		
S	S1																		
	S2																		
	S3																		
	S4																		
H	H1																		
	H2																		
	H3																		
	H4																		

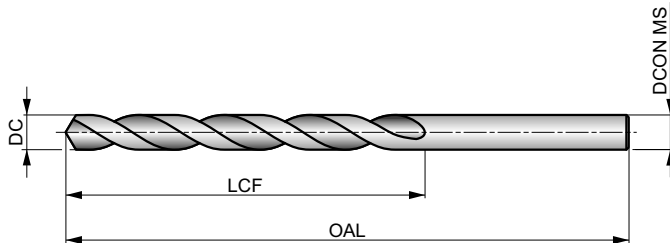
A110

 **DORMER**



HSS Lang Serie Bor, damphærdet finish

Til boring af dybere huller. Konventionelt 118 ° -spids giver styrke og betyder en let boring, hvilket gør det meget omkostningseffektivt. Velegnet til boring af mange materialer. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Til håndboring og maskinboring.



HSS	DIN 340	6×D
 118°	 ST	
 20-35°	 R	DC h8

DC <= 1mm; 1/16" Blank.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A110.5	—	0.50	0.0197	12.0	32.0	0.50
A110.6	—	0.60	0.0236	15.0	35.0	0.60
A110.7	—	0.70	0.0276	21.0	42.0	0.70
A1101/32	1/32	0.79	0.0313	25.0	46.0	0.79
A110.8	—	0.80	0.0315	25.0	46.0	0.80
A110.9	—	0.90	0.0354	29.0	51.0	0.90
A1101.0	—	1.00	0.0394	33.0	56.0	1.00
A1101.1	—	1.10	0.0433	37.0	60.0	1.10
A1101.2	—	1.20	0.0472	41.0	65.0	1.20
A1101.3	—	1.30	0.0512	41.0	65.0	1.30
A1101.4	—	1.40	0.0551	45.0	70.0	1.40
A1101.5	—	1.50	0.0591	45.0	70.0	1.50
A1101/16	1/16	1.59	0.0625	50.0	76.0	1.59
A1101.6	—	1.60	0.0630	50.0	76.0	1.60
A1101.7	—	1.70	0.0669	50.0	76.0	1.70
A1101.75	—	1.75	0.0689	53.0	80.0	1.75
A1101.8	—	1.80	0.0709	53.0	80.0	1.80
A1101.9	—	1.90	0.0748	53.0	80.0	1.90
A1105/64	5/64	1.98	0.0781	56.0	85.0	1.98
A1102.0	—	2.00	0.0787	56.0	85.0	2.00
A1102.05	—	2.05	0.0807	56.0	85.0	2.05
A1102.1	—	2.10	0.0827	56.0	85.0	2.10
A1102.2	—	2.20	0.0866	59.0	90.0	2.20
A1102.25	—	2.25	0.0886	59.0	90.0	2.25
A1102.3	—	2.30	0.0906	59.0	90.0	2.30
A1103/32	3/32	2.38	0.0938	62.0	95.0	2.38
A1102.4	—	2.40	0.0945	62.0	95.0	2.40
A1102.5	—	2.50	0.0984	62.0	95.0	2.50
A1102.6	—	2.60	0.1024	62.0	95.0	2.60
A1102.7	—	2.70	0.1063	66.0	100.0	2.70
A1107/64	7/64	2.78	0.1094	66.0	100.0	2.78
A1102.8	—	2.80	0.1102	66.0	100.0	2.80
A1102.9	—	2.90	0.1142	66.0	100.0	2.90

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1103.0	—	3.00	0.1181	66.0	100.0	3.00
A1103.1	—	3.10	0.1220	69.0	106.0	3.10
A1101/8	1/8	3.18	0.1250	69.0	106.0	3.18
A1103.2	—	3.20	0.1260	69.0	106.0	3.20
A1103.25	—	3.25	0.1280	69.0	106.0	3.25
A1103.3	—	3.30	0.1299	69.0	106.0	3.30
A1103.4	—	3.40	0.1339	73.0	112.0	3.40
A1103.5	—	3.50	0.1378	73.0	112.0	3.50
A1109/64	9/64	3.57	0.1406	73.0	112.0	3.57
A1103.6	—	3.60	0.1417	73.0	112.0	3.60
A1103.7	—	3.70	0.1457	73.0	112.0	3.70
A1103.75	—	3.75	0.1476	73.0	112.0	3.75
A1103.8	—	3.80	0.1496	78.0	119.0	3.80
A1103.9	—	3.90	0.1535	78.0	119.0	3.90
A1105/32	5/32	3.97	0.1563	78.0	119.0	3.97
A1104.0	—	4.00	0.1575	78.0	119.0	4.00
A1104.1	—	4.10	0.1614	78.0	119.0	4.10
A1104.2	—	4.20	0.1654	78.0	119.0	4.20
A1104.25	—	4.25	0.1673	78.0	119.0	4.25
A1104.3	—	4.30	0.1693	82.0	126.0	4.30
A11011/64	11/64	4.37	0.1719	82.0	126.0	4.37
A1104.4	—	4.40	0.1732	82.0	126.0	4.40
A1104.5	—	4.50	0.1772	82.0	126.0	4.50
A1104.6	—	4.60	0.1811	82.0	126.0	4.60
A1104.7	—	4.70	0.1850	82.0	126.0	4.70
A1104.75	—	4.75	0.1870	82.0	126.0	4.75
A1103/16	3/16	4.76	0.1875	87.0	132.0	4.76
A1104.8	—	4.80	0.1890	87.0	132.0	4.80
A1104.9	—	4.90	0.1929	87.0	132.0	4.90
A1105.0	—	5.00	0.1969	87.0	132.0	5.00
A1105.1	—	5.10	0.2008	87.0	132.0	5.10
A11013/64	13/64	5.16	0.2031	87.0	132.0	5.16
A1105.2	—	5.20	0.2047	87.0	132.0	5.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1105.25	—	5.25	0.2067	87.0	132.0	5.25
A1105.3	—	5.30	0.2087	87.0	132.0	5.30
A1105.4	—	5.40	0.2126	91.0	139.0	5.40
A1105.5	—	5.50	0.2165	91.0	139.0	5.50
A1107/32	7/32	5.56	0.2188	91.0	139.0	5.56
A1105.6	—	5.60	0.2205	91.0	139.0	5.60
A1105.7	—	5.70	0.2244	91.0	139.0	5.70
A1105.75	—	5.75	0.2264	91.0	139.0	5.75
A1105.8	—	5.80	0.2283	91.0	139.0	5.80
A1105.9	—	5.90	0.2323	91.0	139.0	5.90
A11015/64	15/64	5.95	0.2344	91.0	139.0	5.95
A1106.0	—	6.00	0.2362	91.0	139.0	6.00
A1106.1	—	6.10	0.2402	97.0	148.0	6.10
A1106.2	—	6.20	0.2441	97.0	148.0	6.20
A1106.25	—	6.25	0.2461	97.0	148.0	6.25
A1106.3	—	6.30	0.2480	97.0	148.0	6.30
A1101/4	1/4	6.35	0.2500	97.0	148.0	6.35
A1106.4	—	6.40	0.2520	97.0	148.0	6.40
A1106.5	—	6.50	0.2559	97.0	148.0	6.50
A1106.6	—	6.60	0.2598	97.0	148.0	6.60
A1106.7	—	6.70	0.2638	97.0	148.0	6.70
A11017/64	17/64	6.75	0.2656	102.0	156.0	6.75
A1106.75	—	6.75	0.2657	102.0	156.0	6.75
A1106.8	—	6.80	0.2677	102.0	156.0	6.80
A1106.9	—	6.90	0.2717	102.0	156.0	6.90
A1107.0	—	7.00	0.2756	102.0	156.0	7.00
A1107.1	—	7.10	0.2795	102.0	156.0	7.10
A1109/32	9/32	7.14	0.2813	102.0	156.0	7.14
A1107.2	—	7.20	0.2835	102.0	156.0	7.20
A1107.25	—	7.25	0.2854	102.0	156.0	7.25
A1107.3	—	7.30	0.2874	102.0	156.0	7.30
A1107.4	—	7.40	0.2913	102.0	156.0	7.40
A1107.5	—	7.50	0.2953	102.0	156.0	7.50
A1107.6	—	7.60	0.2992	109.0	165.0	7.60
A1107.7	—	7.70	0.3031	109.0	165.0	7.70
A1107.75	—	7.75	0.3051	109.0	165.0	7.75
A1107.8	—	7.80	0.3071	109.0	165.0	7.80
A1107.9	—	7.90	0.3110	109.0	165.0	7.90
A1105/16	5/16	7.94	0.3125	109.0	165.0	7.94
A1108.0	—	8.00	0.3150	109.0	165.0	8.00
A1108.1	—	8.10	0.3189	109.0	165.0	8.10
A1108.2	—	8.20	0.3228	109.0	165.0	8.20
A1108.25	—	8.25	0.3248	109.0	165.0	8.25
A1108.3	—	8.30	0.3268	109.0	165.0	8.30
A1108.4	—	8.40	0.3307	109.0	165.0	8.40
A1108.5	—	8.50	0.3346	109.0	165.0	8.50
A1108.6	—	8.60	0.3386	115.0	175.0	8.60
A1108.7	—	8.70	0.3425	115.0	175.0	8.70
A11011/32	11/32	8.73	0.3438	115.0	175.0	8.73
A1108.75	—	8.75	0.3445	115.0	175.0	8.75
A1108.8	—	8.80	0.3465	115.0	175.0	8.80

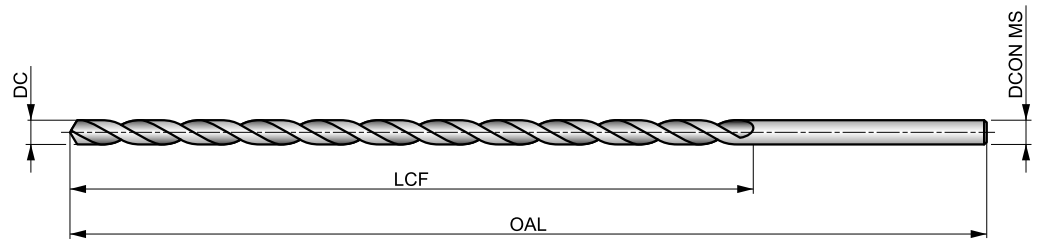
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1109.0	—	9.00	0.3543	115.0	175.0	9.00
A1109.1	—	9.10	0.3583	115.0	175.0	9.10
A1109.2	—	9.20	0.3622	115.0	175.0	9.20
A1109.3	—	9.30	0.3661	115.0	175.0	9.30
A1109.5	—	9.50	0.3740	115.0	175.0	9.50
A1103/8	3/8	9.52	0.3750	121.0	184.0	9.52
A1109.6	—	9.60	0.3780	121.0	184.0	9.60
A1109.7	—	9.70	0.3819	121.0	184.0	9.70
A1109.8	—	9.80	0.3858	121.0	184.0	9.80
A1109.9	—	9.90	0.3898	121.0	184.0	9.90
A11010.0	—	10.00	0.3937	121.0	184.0	10.00
A11010.1	—	10.10	0.3976	121.0	184.0	10.10
A11010.2	—	10.20	0.4016	121.0	184.0	10.20
A11010.25	—	10.25	0.4035	121.0	184.0	10.25
A11010.3	—	10.30	0.4055	121.0	184.0	10.30
A11013/32	13/32	10.32	0.4063	121.0	184.0	10.32
A11010.5	—	10.50	0.4134	121.0	184.0	10.50
A11010.75	—	10.75	0.4232	128.0	195.0	10.75
A11010.8	—	10.80	0.4252	128.0	195.0	10.80
A11011.0	—	11.00	0.4331	128.0	195.0	11.00
A1107/16	7/16	11.11	0.4375	128.0	195.0	11.11
A11011.5	—	11.50	0.4528	128.0	195.0	11.50
A11011.75	—	11.75	0.4626	128.0	195.0	11.75
A11012.0	—	12.00	0.4724	134.0	205.0	12.00
A11012.1	—	12.10	0.4764	134.0	205.0	12.10
A11012.25	—	12.25	0.4823	134.0	205.0	12.25
A11012.5	—	12.50	0.4921	134.0	205.0	12.50
A1101/2	1/2	12.70	0.5000	134.0	205.0	12.70
A11013.0	—	13.00	0.5118	134.0	205.0	13.00
A11017/32	17/32	13.49	0.5313	140.0	214.0	13.49
A11013.5	—	13.50	0.5315	140.0	214.0	13.50
A11014.0	—	14.00	0.5512	140.0	214.0	14.00
A1109/16	9/16	14.29	0.5625	144.0	220.0	14.29
A11014.5	—	14.50	0.5709	144.0	220.0	14.50
A11015.0	—	15.00	0.5906	144.0	220.0	15.00
A11015.5	—	15.50	0.6102	149.0	227.0	15.50
A1105/8	5/8	15.88	0.6250	149.0	227.0	15.88
A11016.0	—	16.00	0.6299	149.0	227.0	16.00
A11016.5	—	16.50	0.6496	154.0	235.0	16.50
A11017.0	—	17.00	0.6693	154.0	235.0	17.00
A11017.5	—	17.50	0.6890	158.0	241.0	17.50
A11018.0	—	18.00	0.7087	158.0	241.0	18.00
A11018.5	—	18.50	0.7283	162.0	247.0	18.50
A11019.0	—	19.00	0.7480	162.0	247.0	19.00
A1103/4	3/4	19.05	0.7500	166.0	254.0	19.05
A11019.5	—	19.50	0.7677	166.0	254.0	19.50
A11020.0	—	20.00	0.7874	166.0	254.0	20.00
A11021.0	—	21.00	0.8268	171.0	261.0	21.00
A11022.0	—	22.00	0.8661	176.0	268.0	22.00
A1107/8	7/8	22.22	0.8750	176.0	268.0	22.22
A1101	1"	25.40	1.0000	190.0	290.0	25.40

A125

 DORMER

HSS ekstra langt bor, damphærdet finish

Med damphærdet finish, anbefales til meget dybe eller vanskelige huller. Konventionelt 118 ° spids, der giver styrke og sparer penge på let genopretning. Velegnet til mange materialer. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Mindre egnet til håndholdt boring.



HSS	BS 328	10×D
 118°	 ST	
 λ 20-35°	 R	 DC h8

DC <= 2.2mm; 5/64" Blank.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1251.4X160	—	1.40	0.0551	100.0	160.0	1.40
A1251.5X125	—	1.50	0.0591	80.0	125.0	1.50
A1251.5X160	—	1.50	0.0591	100.0	160.0	1.50
A1251/16X125	1/16	1.59	0.0625	80.0	125.0	1.59
A1251/16X160	1/16	1.59	0.0625	100.0	160.0	1.59
A1251.8X160	—	1.80	0.0709	100.0	160.0	1.80
A1255/64X125	5/64	1.98	0.0781	80.0	125.0	1.98
A1255/64X160	5/64	1.98	0.0781	100.0	160.0	1.98
A1252.0X125	—	2.00	0.0787	80.0	125.0	2.00
A1252.0X160	—	2.00	0.0787	100.0	160.0	2.00
A1252.2X160	—	2.20	0.0866	100.0	160.0	2.20
A1253/32X125	3/32	2.38	0.0938	80.0	125.0	2.38
A1253/32X160	3/32	2.38	0.0938	100.0	160.0	2.38
A1252.5X125	—	2.50	0.0984	80.0	125.0	2.50
A1252.5X160	—	2.50	0.0984	100.0	160.0	2.50
A1257/64X125	7/64	2.78	0.1094	80.0	125.0	2.78
A1257/64X160	7/64	2.78	0.1094	100.0	160.0	2.78
A1253.0X160	—	3.00	0.1181	100.0	160.0	3.00
A1253.0X200	—	3.00	0.1181	150.0	200.0	3.00
A1253.0X250	—	3.00	0.1181	200.0	250.0	3.00
A1251/8X160	1/8	3.18	0.1250	100.0	160.0	3.18
A1251/8X200	1/8	3.18	0.1250	150.0	200.0	3.18
A1251/8X250	1/8	3.18	0.1250	200.0	250.0	3.18
A1251/8X315	1/8	3.18	0.1250	250.0	310.0	3.18
A1253.3X160	—	3.30	0.1299	100.0	160.0	3.30
A1253.5X160	—	3.50	0.1378	100.0	160.0	3.50
A1253.5X200	—	3.50	0.1378	150.0	200.0	3.50
A1253.5X250	—	3.50	0.1378	200.0	250.0	3.50
A1259/64X160	9/64	3.57	0.1406	100.0	160.0	3.57
A1259/64X200	9/64	3.57	0.1406	150.0	200.0	3.57
A1259/64X315	9/64	3.57	0.1406	250.0	310.0	3.57
A1255/32X160	5/32	3.97	0.1563	100.0	160.0	3.97
A1255/32X200	5/32	3.97	0.1563	150.0	200.0	3.97

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1255/32X250	5/32	3.97	0.1563	200.0	250.0	3.97
A1255/32X315	5/32	3.97	0.1563	250.0	310.0	3.97
A1254.0X160	—	4.00	0.1575	100.0	160.0	4.00
A1254.0X200	—	4.00	0.1575	150.0	200.0	4.00
A1254.0X250	—	4.00	0.1575	200.0	250.0	4.00
A1254.0X315	—	4.00	0.1575	250.0	310.0	4.00
A12511/64X160	11/64	4.37	0.1719	100.0	160.0	4.37
A12511/64X200	11/64	4.37	0.1719	150.0	200.0	4.37
A12511/64X315	11/64	4.37	0.1719	250.0	310.0	4.37
A1254.5X160	—	4.50	0.1772	100.0	160.0	4.50
A1254.5X200	—	4.50	0.1772	150.0	200.0	4.50
A1254.5X250	—	4.50	0.1772	200.0	250.0	4.50
A1254.5X315	—	4.50	0.1772	250.0	310.0	4.50
A1253/16X160	3/16	4.76	0.1875	100.0	160.0	4.76
A1253/16X200	3/16	4.76	0.1875	150.0	200.0	4.76
A1253/16X250	3/16	4.76	0.1875	200.0	250.0	4.76
A1253/16X315	3/16	4.76	0.1875	250.0	310.0	4.76
A1253/16X400	3/16	4.76	0.1875	300.0	400.0	4.76
A1255.0X160	—	5.00	0.1969	100.0	160.0	5.00
A1255.0X200	—	5.00	0.1969	150.0	200.0	5.00
A1255.0X250	—	5.00	0.1969	200.0	250.0	5.00
A1255.0X315	—	5.00	0.1969	250.0	310.0	5.00
A1255.0X400	—	5.00	0.1969	300.0	400.0	5.00
A12513/64X200	13/64	5.16	0.2031	150.0	200.0	5.16
A12513/64X250	13/64	5.16	0.2031	200.0	250.0	5.16
A12513/64X315	13/64	5.16	0.2031	250.0	310.0	5.16
A1255.5X200	—	5.50	0.2165	150.0	200.0	5.50
A1255.5X250	—	5.50	0.2165	200.0	250.0	5.50
A1255.5X315	—	5.50	0.2165	250.0	310.0	5.50
A1257/32X200	7/32	5.56	0.2188	150.0	200.0	5.56
A1257/32X250	7/32	5.56	0.2188	200.0	250.0	5.56
A12515/64X200	15/64	5.95	0.2344	150.0	200.0	5.95
A12515/64X315	15/64	5.95	0.2344	250.0	310.0	5.95

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1256.0X200	—	6.00	0.2362	150.0	200.0	6.00
A1256.0X250	—	6.00	0.2362	200.0	250.0	6.00
A1256.0X315	—	6.00	0.2362	250.0	310.0	6.00
A1256.0X400	—	6.00	0.2362	300.0	400.0	6.00
A1251/4X200	1/4	6.35	0.2500	150.0	200.0	6.35
A1251/4X250	1/4	6.35	0.2500	200.0	250.0	6.35
A1251/4X315	1/4	6.35	0.2500	250.0	310.0	6.35
A1251/4X400	1/4	6.35	0.2500	300.0	400.0	6.35
A1251/4X500	1/4	6.35	0.2500	400.0	460.0	6.35
A1256.5X200	—	6.50	0.2559	150.0	200.0	6.50
A1256.5X250	—	6.50	0.2559	200.0	250.0	6.50
A1256.5X315	—	6.50	0.2559	250.0	310.0	6.50
A12517/64X200	17/64	6.75	0.2656	150.0	200.0	6.75
A12517/64X250	17/64	6.75	0.2656	200.0	250.0	6.75
A12517/64X500	17/64	6.75	0.2656	400.0	460.0	6.75
A1257.0X200	—	7.00	0.2756	150.0	200.0	7.00
A1257.0X250	—	7.00	0.2756	200.0	250.0	7.00
A1257.0X315	—	7.00	0.2756	250.0	310.0	7.00
A1257.5X200	—	7.50	0.2953	150.0	200.0	7.50
A1257.5X250	—	7.50	0.2953	200.0	250.0	7.50
A1257.5X315	—	7.50	0.2953	250.0	310.0	7.50
A1255/16X200	5/16	7.94	0.3125	150.0	200.0	7.94
A1255/16X250	5/16	7.94	0.3125	200.0	250.0	7.94
A1255/16X315	5/16	7.94	0.3125	250.0	310.0	7.94
A1255/16X500	5/16	7.94	0.3125	400.0	460.0	7.94
A1258.0X250	—	8.00	0.3150	200.0	250.0	8.00
A1258.0X315	—	8.00	0.3150	250.0	310.0	8.00
A1258.0X400	—	8.00	0.3150	300.0	400.0	8.00
A12521/64X315	21/64	8.33	0.3281	250.0	310.0	8.33
A1258.5X250	—	8.50	0.3346	200.0	250.0	8.50
A1258.5X315	—	8.50	0.3346	250.0	310.0	8.50
A12511/32X250	11/32	8.73	0.3438	200.0	250.0	8.73
A12511/32X315	11/32	8.73	0.3438	250.0	310.0	8.73
A12511/32X400	11/32	8.73	0.3438	300.0	400.0	8.73
A12511/32X500	11/32	8.73	0.3438	400.0	460.0	8.73
A1259.0X250	—	9.00	0.3543	200.0	250.0	9.00
A1259.0X315	—	9.00	0.3543	250.0	310.0	9.00
A1259.0X400	—	9.00	0.3543	300.0	400.0	9.00
A1259.5X250	—	9.50	0.3740	200.0	250.0	9.50
A1259.5X315	—	9.50	0.3740	250.0	310.0	9.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1253/8X250	3/8	9.52	0.3750	200.0	250.0	9.52
A1253/8X315	3/8	9.52	0.3750	250.0	310.0	9.52
A1253/8X400	3/8	9.52	0.3750	300.0	400.0	9.52
A1253/8X500	3/8	9.52	0.3750	400.0	460.0	9.52
A12510.0X250	—	10.00	0.3937	200.0	250.0	10.00
A12510.0X315	—	10.00	0.3937	250.0	310.0	10.00
A12510.0X400	—	10.00	0.3937	300.0	400.0	10.00
A12513/32X250	13/32	10.32	0.4063	200.0	250.0	10.32
A12513/32X315	13/32	10.32	0.4063	250.0	310.0	10.32
A12510.5X250	—	10.50	0.4134	200.0	250.0	10.50
A12510.5X315	—	10.50	0.4134	250.0	310.0	10.50
A12510.5X400	—	10.50	0.4134	300.0	400.0	10.50
A12511.0X250	—	11.00	0.4331	200.0	250.0	11.00
A12511.0X315	—	11.00	0.4331	250.0	310.0	11.00
A12511.0X400	—	11.00	0.4331	300.0	400.0	11.00
A1257/16X250	7/16	11.11	0.4375	200.0	250.0	11.11
A1257/16X315	7/16	11.11	0.4375	250.0	310.0	11.11
A1257/16X400	7/16	11.11	0.4375	300.0	400.0	11.11
A12529/64X315	29/64	11.51	0.4531	250.0	310.0	11.51
A12512.0X250	—	12.00	0.4724	200.0	250.0	12.00
A12512.0X315	—	12.00	0.4724	250.0	310.0	12.00
A12512.0X400	—	12.00	0.4724	300.0	400.0	12.00
A12531/64X315	31/64	12.30	0.4844	250.0	310.0	12.30
A1251/2X250	1/2	12.70	0.5000	200.0	250.0	12.70
A1251/2X315	1/2	12.70	0.5000	250.0	310.0	12.70
A1251/2X400	1/2	12.70	0.5000	300.0	400.0	12.70
A12513.0X315	—	13.00	0.5118	250.0	310.0	13.00
A12513.0X400	—	13.00	0.5118	300.0	400.0	13.00
A12517/32X315	17/32	13.49	0.5313	250.0	310.0	13.49
A12514.0X315	—	14.00	0.5512	250.0	310.0	14.00
A12514.0X400	—	14.00	0.5512	300.0	400.0	14.00
A1259/16X315	9/16	14.29	0.5625	250.0	310.0	14.29
A12537/64X315	37/64	14.68	0.5781	250.0	310.0	14.68
A12519/32X315	19/32	15.08	0.5938	250.0	310.0	15.08
A12519/32X500	19/32	15.08	0.5938	400.0	460.0	15.08
A1255/8X315	5/8	15.88	0.6250	250.0	310.0	15.88
A1255/8X500	5/8	15.88	0.6250	400.0	460.0	15.88
A12511/16X315	11/16	17.46	0.6875	250.0	310.0	17.46
A1253/4X315	3/4	19.05	0.7500	250.0	310.0	19.05
A1253/4X500	3/4	19.05	0.7500	400.0	460.0	19.05

Materiale kode (BMC)	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E			
Grundlæggende standard-gruppe (BSG)	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	DIN 338			
Brugbar længde (ULDR)	2.5xD	4xD	4xD	4xD	4xD	3xD	4xD	4xD	4xD	4xD			
Anvendelsesvinkel													
Belægning													
Skaft													
Spiral form													
Hånd (skæreretning)													
	R40C R41C R42C	R10A R15A R18A	R10B R15B R18B	500-6 501-6 502-6	500-12 501-12 502-12	R88CO R89CO	R10CO R15CO R18CO	CO500-6 CO501-6	CO500-12 CO501-12	2ACO			
	N60 - 1/2	1/16 - 1/2	1/16 - 1/2	N60 - 1/2	3/64 - 1/2	1/16 - 1/2	N80 - 11/16	1/16 - 1/4	1/16 - 1/4	1.00 - 13.00			
P	P1	■	■	■		■	■	■	■	■			
	P2	■	■	■	■	■	■	■	■	■			
	P3	■	■	■	■	■	■	■	■	■			
	P4	■	■	■	■	■	■	■	■	■			
M	M1	■	■	■	■	■	■	■	■	■			
	M2	■	■	■	■	■	■	■	■	■			
	M3	■	■	■	■	■	■	■	■	■			
	M4	■	■	■	■	■	■	■	■	■			
K	K1	■	■	■	■	■	■	■	■	■			
	K2	■	■	■	■	■	■	■	■	■			
	K3	■	■	■	■	■	■	■	■	■			
	K4	■	■	■	■	■	■	■	■	■			
	K5	■	■	■	■	■	■	■	■	■			
N	N1	■	■	■		■	■	■	■	■			
	N2	■	■	■	■	■	■	■	■	■			
	N3	■	■	■	■	■	■	■	■	■			
	N4	■						■	■				
	N5												
S	S1	■	■	■	■	■	■			■			
	S2	■	■	■	■	■	■	■	■	■			
	S3	■	■	■	■	■	■	■	■	■			
	S4	■	■	■	■	■	■	■	■	■			
H	H1												
	H2												
	H3												
	H4												

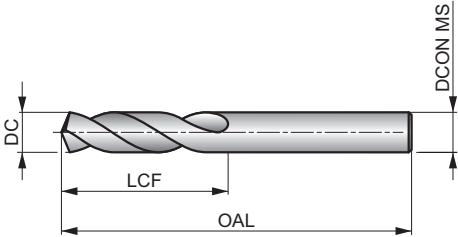
R40C/R41C/R42C

PRECISION



NAS 907 Type C HSS Stub Length Drill, damphærdet

Kraftigt, alsidigt bor med damphærdet finish. Et 135° selvcentrerende splitpunkt reducerer skærekrafterne og forhindrer boret i at gå, når det kommer i kontakt med emnet. Det tykkere bånd og den korte længde gør dette bor meget stift og velegnet til håndholdt boring og maskinboring i mange materialer.



HSS	NAS 907	2.5xD
		
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 36 J	P1.2 ■ 40 J	P1.3 ■ 41 J	P2.1 ■ 31 J	P2.2 ■ 27 G	P2.3 ■ 24 F	P3.1 ■ 21 G	P3.2 ■ 17 G	P3.3 ■ 14 F	P4.1 ■ 12 G	P4.2 ▣ 10 F	P4.3 ▣ 9 E	M1.1 ■ 22 F	M1.2 ■ 19 F
M2.1 ■ 20 F	M2.2 ■ 16 F	M3.1 ▣ 10 H	M3.2 ▣ 9 H	M3.3 ▣ 8 D	M4.1 ▣ 10 D	K1.1 ■ 32 J	K1.2 ■ 24 G	K1.3 ■ 18 G	K2.1 ■ 25 F	K2.2 ■ 20 F	K2.3 ■ 16 F	K3.1 ■ 22 F	K3.2 ■ 17 F
K3.3 ■ 13 F	K4.1 ■ 20 F	K4.2 ■ 15 F	K4.3 ▣ 11 F	K4.4 ▣ 10 F	K4.5 ▣ 8 F	K5.1 ■ 23 F	K5.2 ■ 17 F	K5.3 ▣ 13 F	N1.1 ▣ 33 K	N1.2 ▣ 25 K	N1.3 ▣ 17 J	N2.1 ▣ 46 I	N2.2 ▣ 42 I
N2.3 ▣ 30 I	N3.1 ▣ 64 I	N3.2 ▣ 38 J	N3.3 ▣ 19 H	N4.1 ▣ 30 K	N4.2 ▣ 35 I	N4.3 ▣ 17 G	S1.1 ■ 27 G	S1.2 ▣ 16 E	S1.3 ▣ 8 C	S2.1 ▣ 11 F	S2.2 ▣ 6 B	S3.1 ▣ 8 F	S3.2 ▣ 4 B
S4.1 ▣ 6 F	S4.2 ▣ 3 B												

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R41CN60 ¹⁾	—	N60	—	0.0400	0.500	1.375	0.040
R41CN59 ¹⁾	—	N59	—	0.0410	0.500	1.375	0.041
R41CN58 ¹⁾	—	N58	—	0.0420	0.500	1.375	0.042
R41CN57 ¹⁾	—	N57	—	0.0430	0.500	1.375	0.043
R41CN56 ¹⁾	—	N56	—	0.0465	0.500	1.375	0.046
R41CN55 ¹⁾	—	N55	—	0.0520	0.625	1.625	0.052
R41CN54 ¹⁾	—	N54	—	0.0550	0.625	1.625	0.055
R41CN53 ¹⁾	—	N53	—	0.0595	0.625	1.625	0.059
R40C1/16	1/16	—	—	0.0625	0.625	1.625	0.063
R41CN52	—	N52	—	0.0635	0.688	1.688	0.064
R41CN51	—	N51	—	0.0670	0.688	1.688	0.067
R41CN50	—	N50	—	0.0700	0.688	1.688	0.070
R41CN49	—	N49	—	0.0730	0.688	1.688	0.073
R41CN48	—	N48	—	0.0760	0.688	1.688	0.076
R40C5/64	5/64	—	—	0.0781	0.688	1.688	0.078
R41CN47	—	N47	—	0.0785	0.688	1.688	0.079
R41CN46	—	N46	—	0.0810	0.750	1.750	0.081
R41CN45	—	N45	—	0.0820	0.750	1.750	0.082
R41CN44	—	N44	—	0.0860	0.750	1.750	0.086
R41CN43	—	N43	—	0.0890	0.750	1.750	0.089
R41CN42	—	N42	—	0.0935	0.750	1.750	0.093
R40C3/32	3/32	—	—	0.0938	0.750	1.750	0.094
R41CN41	—	N41	—	0.0960	0.813	1.813	0.096
R41CN40	—	N40	—	0.0980	0.813	1.813	0.098

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R41CN39	—	N39	—	0.0995	0.813	1.813	0.100
R41CN38	—	N38	—	0.1015	0.813	1.813	0.102
R41CN37	—	N37	—	0.1040	0.813	1.813	0.104
R41CN36	—	N36	—	0.1065	0.813	1.813	0.106
R40C7/64	7/64	—	—	0.1094	0.813	1.813	0.109
R41CN35	—	N35	—	0.1100	0.875	1.875	0.110
R41CN34	—	N34	—	0.1110	0.875	1.875	0.111
R41CN33	—	N33	—	0.1130	0.875	1.875	0.113
R41CN32	—	N32	—	0.1160	0.875	1.875	0.116
R41CN31	—	N31	—	0.1200	0.875	1.875	0.120
R40C1/8	1/8	—	—	0.1250	0.875	1.875	0.125
R41CN30	—	N30	—	0.1285	0.938	1.938	0.129
R41CN29	—	N29	—	0.1360	0.938	1.938	0.136
R41CN28	—	N28	—	0.1405	0.938	1.938	0.141
R40C9/64	9/64	—	—	0.1406	0.938	1.938	0.141
R41CN27	—	N27	—	0.1440	1.000	2.063	0.144
R41CN26	—	N26	—	0.1470	1.000	2.063	0.147
R41CN25	—	N25	—	0.1495	1.000	2.063	0.149
R41CN24	—	N24	—	0.1520	1.000	2.063	0.152
R41CN23	—	N23	—	0.1540	1.000	2.063	0.154
R40C5/32	5/32	—	—	0.1563	1.000	2.063	0.156
R41CN22	—	N22	—	0.1570	1.063	2.125	0.157
R41CN21	—	N21	—	0.1590	1.063	2.125	0.159
R41CN20	—	N20	—	0.1610	1.063	2.125	0.161

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R41CN19	–	N19	–	0.1660	1.063	2.125	0.166
R41CN18	–	N18	–	0.1695	1.063	2.125	0.170
R40C11/64	11/64	–	–	0.1719	1.063	2.125	0.172
R41CN17	–	N17	–	0.1730	1.125	2.188	0.173
R41CN16	–	N16	–	0.1770	1.125	2.188	0.177
R41CN15	–	N15	–	0.1800	1.125	2.188	0.180
R41CN14	–	N14	–	0.1820	1.125	2.188	0.182
R41CN13	–	N13	–	0.1850	1.125	2.188	0.185
R40C3/16	3/16	–	–	0.1875	1.125	2.188	0.188
R41CN12	–	N12	–	0.1890	1.188	2.250	0.189
R41CN11	–	N11	–	0.1910	1.188	2.250	0.191
R41CN10	–	N10	–	0.1935	1.188	2.250	0.194
R41CN9	–	N9	–	0.1960	1.188	2.250	0.196
R41CN8	–	N8	–	0.1990	1.188	2.250	0.199
R41CN7	–	N7	–	0.2010	1.188	2.250	0.201
R40C13/64	13/64	–	–	0.2031	1.188	2.250	0.203
R41CN6	–	N6	–	0.2040	1.250	2.375	0.204
R41CN5	–	N5	–	0.2055	1.250	2.375	0.205
R41CN4	–	N4	–	0.2090	1.250	2.375	0.209
R41CN3	–	N3	–	0.2130	1.250	2.375	0.213
R40C7/32	7/32	–	–	0.2188	1.250	2.375	0.219
R41CN2	–	N2	–	0.2210	1.313	2.438	0.221
R41CN1	–	N1	–	0.2280	1.313	2.438	0.228
R42CA	–	–	A	0.2340	1.313	2.438	0.234
R40C15/64	15/64	–	–	0.2344	1.313	2.438	0.234
R42CB	–	–	B	0.2380	1.375	2.500	0.238
R42CC	–	–	C	0.2420	1.375	2.500	0.242
R42CD	–	–	D	0.2460	1.375	2.500	0.246
R40C1/4	1/4	–	–	0.2500	1.375	2.500	0.250
R42CF	–	–	F	0.2570	1.438	2.625	0.257
R42CG	–	–	G	0.2610	1.438	2.625	0.261
R40C17/64	17/64	–	–	0.2656	1.438	2.625	0.266
R42CH	–	–	H	0.2660	1.500	2.688	0.266

¹⁾ Intet splitpunkt.

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R42CI	–	–	I	0.2720	1.500	2.688	0.272
R42CJ	–	–	J	0.2770	1.500	2.688	0.277
R42CK	–	–	K	0.2810	1.500	2.688	0.281
R40C9/32	9/32	–	–	0.2813	1.500	2.688	0.281
R42CM	–	–	M	0.2950	1.563	2.750	0.295
R40C19/64	19/64	–	–	0.2969	1.563	2.750	0.297
R42CL	–	–	L	0.2990	1.563	2.750	0.299
R42CN	–	–	N	0.3020	1.625	2.813	0.302
R40C5/16	5/16	–	–	0.3125	1.625	2.813	0.313
R42CO	–	–	O	0.3160	1.688	2.938	0.316
R42CP	–	–	P	0.3230	1.688	2.938	0.323
R40C21/64	21/64	–	–	0.3281	1.688	2.938	0.328
R42CQ	–	–	Q	0.3320	1.688	3.000	0.332
R42CR	–	–	R	0.3390	1.688	3.000	0.339
R40C11/32	11/32	–	–	0.3438	1.688	3.000	0.344
R42CS	–	–	S	0.3480	1.750	3.063	0.348
R42CT	–	–	T	0.3580	1.750	3.063	0.358
R40C23/64	23/64	–	–	0.3594	1.750	3.063	0.359
R42CU	–	–	U	0.3680	1.813	3.125	0.368
R40C3/8	3/8	–	–	0.3750	1.813	3.125	0.375
R42CV	–	–	V	0.3770	1.875	3.250	0.377
R42CW	–	–	W	0.3860	1.875	3.250	0.386
R40C25/64	25/64	–	–	0.3906	1.875	3.250	0.391
R42CX	–	–	X	0.3970	1.938	3.313	0.397
R42CY	–	–	Y	0.4040	1.938	3.313	0.404
R40C13/32	13/32	–	–	0.4063	1.938	3.313	0.406
R42CZ	–	–	Z	0.4130	2.000	3.375	0.413
R40C27/64	27/64	–	–	0.4219	2.000	3.375	0.422
R40C7/16	7/16	–	–	0.4375	2.063	3.438	0.438
R40C29/64	29/64	–	–	0.4531	2.125	3.563	0.453
R40C15/32	15/32	–	–	0.4688	2.125	3.625	0.469
R40C31/64	31/64	–	–	0.4844	2.188	3.688	0.484
R40C1/2	1/2	–	–	0.5000	2.250	3.750	0.500

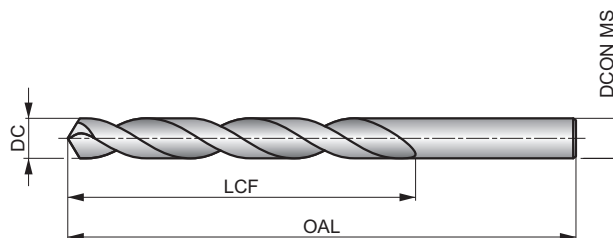
R10A/R15A/R18A

PRECISION



NAS 907 Type A HSS Jobberbor, damphærdet finish

Et meget velfungerende bor med 118° selvcentrerende splitspids for lettere indtrængning og lavt tryk. Damphærdet finish for øget slidstyrke og smøreevne. Fremstillet i henhold til NAS 907 Type A Aerospace Standards.



HSS	NAS 907	4×D
 118°	 ST	
 20-35°		

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 36 H	P1.2 ■ 40 H	P1.3 ■ 41 H	P2.1 ■ 31 H	P2.2 ■ 27 G	P2.3 ■ 24 E	P3.1 ■ 25 F	P3.2 ■ 20 F	P3.3 ■ 17 E	P4.1 ■ 15 F	P4.2 ■ 13 E	P4.3 ■ 10 D	M1.1 ■ 30 E	M1.2 ■ 26 E
M2.1 ■ 27 E	M2.2 ■ 22 E	M2.3 ■ 18 C	M3.1 ■ 13 G	M3.2 ■ 11 G	M3.3 ■ 10 C	M4.1 ■ 15 C	M4.2 ■ 13 C	K1.1 ■ 35 H	K1.2 ■ 26 D	K1.3 ■ 19 D	K2.1 ■ 27 E	K2.2 ■ 22 E	K2.3 ■ 18 E
K3.1 ■ 24 E	K3.2 ■ 18 E	K3.3 ■ 15 E	K4.1 ■ 22 E	K4.2 ■ 17 E	K4.3 ■ 12 E	K4.4 ■ 11 E	K4.5 ■ 9 E	K5.1 ■ 25 E	K5.2 ■ 19 E	K5.3 ■ 15 E	N1.1 ■ 33 J	N1.2 ■ 25 J	N1.3 ■ 17 I
N2.1 ■ 46 H	N2.2 ■ 42 H	N2.3 ■ 30 H	N3.1 ■ 68 H	N3.2 ■ 40 F	N3.3 ■ 20 H	S1.1 ■ 28 F	S1.2 ■ 20 D	S1.3 ■ 11 C	S2.1 ■ 9 E	S2.2 ■ 8 B	S3.1 ■ 7 E	S3.2 ■ 6 B	S4.1 ■ 5 E
S4.2 ■ 5 B													

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R10A1/16	1/16	—	—	0.0625	7/8	1.7/8	0.063
R18AN52	—	N52	—	0.0635	7/8	1.7/8	0.064
R18AN51	—	N51	—	0.0670	1"	2"	0.067
R18AN50	—	N50	—	0.0700	1"	2"	0.070
R18AN49	—	N49	—	0.0730	1"	2"	0.073
R18AN48	—	N48	—	0.0760	1"	2"	0.076
R10A5/64	5/64	—	—	0.0781	1"	2"	0.078
R18AN47	—	N47	—	0.0785	1"	2"	0.079
R18AN46	—	N46	—	0.0810	1.1/8	2.1/8	0.081
R18AN45	—	N45	—	0.0820	1.1/8	2.1/8	0.082
R18AN44	—	N44	—	0.0860	1.1/8	2.1/8	0.086
R18AN43	—	N43	—	0.0890	1.1/4	2.1/4	0.089
R18AN42	—	N42	—	0.0935	1.1/4	2.1/4	0.093
R10A3/32	3/32	—	—	0.0938	1.1/4	2.1/4	0.094
R18AN41	—	N41	—	0.0960	1.3/8	2.3/8	0.096
R18AN40	—	N40	—	0.0980	1.3/8	2.3/8	0.098
R18AN39	—	N39	—	0.0995	1.3/8	2.3/8	0.100
R18AN38	—	N38	—	0.1015	1.7/16	2.1/2	0.102
R18AN37	—	N37	—	0.1040	1.7/16	2.1/2	0.104
R18AN36	—	N36	—	0.1065	1.7/16	2.1/2	0.106
R10A7/64	7/64	—	—	0.1094	1.1/2	2.5/8	0.109
R18AN35	—	N35	—	0.1100	1.1/2	2.5/8	0.110
R18AN34	—	N34	—	0.1110	1.1/2	2.5/8	0.111
R18AN33	—	N33	—	0.1130	1.1/2	2.5/8	0.113

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R18AN32	—	N32	—	0.1160	1.5/8	2.3/4	0.116
R18AN31	—	N31	—	0.1200	1.5/8	2.3/4	0.120
R10A1/8	1/8	—	—	0.1250	1.5/8	2.3/4	0.125
R18AN30	—	N30	—	0.1285	1.5/8	2.3/4	0.129
R18AN29	—	N29	—	0.1360	1.3/4	2.7/8	0.136
R18AN28	—	N28	—	0.1405	1.3/4	2.7/8	0.141
R10A9/64	9/64	—	—	0.1406	1.3/4	2.7/8	0.141
R18AN27	—	N27	—	0.1440	1.7/8	3"	0.144
R18AN26	—	N26	—	0.1470	1.7/8	3"	0.147
R18AN25	—	N25	—	0.1495	1.7/8	3"	0.149
R18AN24	—	N24	—	0.1520	2"	3.1/8	0.152
R18AN23	—	N23	—	0.1540	2"	3.1/8	0.154
R10A5/32	5/32	—	—	0.1563	2"	3.1/8	0.156
R18AN22	—	N22	—	0.1570	2"	3.1/8	0.157
R18AN21	—	N21	—	0.1590	2.1/8	3.1/4	0.159
R18AN20	—	N20	—	0.1610	2.1/8	3.1/4	0.161
R18AN19	—	N19	—	0.1660	2.1/8	3.1/4	0.166
R18AN18	—	N18	—	0.1695	2.1/8	3.1/4	0.170
R10A11/64	11/64	—	—	0.1719	2.1/8	3.1/4	0.172
R18AN17	—	N17	—	0.1730	2.3/16	3.3/8	0.173
R18AN16	—	N16	—	0.1770	2.3/16	3.3/8	0.177
R18AN15	—	N15	—	0.1800	2.3/16	3.3/8	0.180
R18AN14	—	N14	—	0.1820	2.3/16	3.3/8	0.182
R18AN13	—	N13	—	0.1850	2.5/16	3.1/2	0.185

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R10A3/16	3/16	—	—	0.1875	2.5/16	3.1/2	0.188
R18AN12	—	N12	—	0.1890	2.5/16	3.1/2	0.189
R18AN11	—	N11	—	0.1910	2.5/16	3.1/2	0.191
R18AN10	—	N10	—	0.1935	2.7/16	3.5/8	0.194
R18AN9	—	N9	—	0.1960	2.7/16	3.5/8	0.196
R18AN8	—	N8	—	0.1990	2.7/16	3.5/8	0.199
R18AN7	—	N7	—	0.2010	2.7/16	3.5/8	0.201
R10A13/64	13/64	—	—	0.2031	2.7/16	3.5/8	0.203
R18AN6	—	N6	—	0.2040	2.1/2	3.3/4	0.204
R18AN5	—	N5	—	0.2055	2.1/2	3.3/4	0.205
R18AN4	—	N4	—	0.2090	2.1/2	3.3/4	0.209
R18AN3	—	N3	—	0.2130	2.1/2	3.3/4	0.213
R10A7/32	7/32	—	—	0.2188	2.1/2	3.3/4	0.219
R18AN2	—	N2	—	0.2210	2.5/8	3.7/8	0.221
R18AN1	—	N1	—	0.2280	2.5/8	3.7/8	0.228
R15AA	—	—	A	0.2340	2.5/8	3.7/8	0.234
R10A15/64	15/64	—	—	0.2344	2.5/8	3.7/8	0.234
R15AB	—	—	B	0.2380	2.3/4	4"	0.238
R15AC	—	—	C	0.2420	2.3/4	4"	0.242
R15AD	—	—	D	0.2460	2.3/4	4"	0.246
R10A1/4	1/4	—	—	0.2500	2.3/4	4"	0.250
R15AF	—	—	F	0.2570	2.7/8	4.1/8	0.257
R15AG	—	—	G	0.2610	2.7/8	4.1/8	0.261
R10A17/64	17/64	—	—	0.2656	2.7/8	4.1/8	0.266
R15AH	—	—	H	0.2660	2.7/8	4.1/8	0.266
R15AI	—	—	I	0.2720	2.7/8	4.1/8	0.272
R15AJ	—	—	J	0.2770	2.7/8	4.1/8	0.277
R15AK	—	—	K	0.2810	2.15/16	4.1/4	0.281
R10A9/32	9/32	—	—	0.2813	2.15/16	4.1/4	0.281

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R15AL	—	—	L	0.2900	2.15/16	4.1/4	0.290
R15AM	—	—	M	0.2950	3.1/16	4.3/8	0.295
R10A19/64	19/64	—	—	0.2969	3.1/16	4.3/8	0.297
R15AN	—	—	N	0.3020	3.1/16	4.3/8	0.302
R10A5/16	5/16	—	—	0.3125	3.3/16	4.1/2	0.313
R15AO	—	—	O	0.3160	3.3/16	4.1/2	0.316
R15AP	—	—	P	0.3230	3.5/16	4.5/8	0.323
R10A21/64	21/64	—	—	0.3281	3.5/16	4.5/8	0.328
R15AQ	—	—	Q	0.3320	3.7/16	4.3/4	0.332
R15AR	—	—	R	0.3390	3.7/16	4.3/4	0.339
R10A11/32	11/32	—	—	0.3438	3.7/16	4.3/4	0.344
R15AS	—	—	S	0.3480	3.1/2	4.7/8	0.348
R15AT	—	—	T	0.3580	3.1/2	4.7/8	0.358
R10A23/64	23/64	—	—	0.3594	3.1/2	4.7/8	0.359
R15AU	—	—	U	0.3680	3.5/8	5"	0.368
R10A3/8	3/8	—	—	0.3750	3.5/8	5"	0.375
R15AV	—	—	V	0.3770	3.5/8	5"	0.377
R15AW	—	—	W	0.3860	3.3/4	5.1/8	0.386
R10A25/64	25/64	—	—	0.3906	3.3/4	5.1/8	0.391
R15AX	—	—	X	0.3970	3.3/4	5.1/8	0.397
R15AY	—	—	Y	0.4040	3.7/8	5.1/4	0.404
R10A13/32	13/32	—	—	0.4063	3.7/8	5.1/4	0.406
R15AZ	—	—	Z	0.4130	3.7/8	5.1/4	0.413
R10A27/64	27/64	—	—	0.4219	3.15/16	5.3/8	0.422
R10A7/16	7/16	—	—	0.4375	4.1/16	5.1/2	0.438
R10A29/64	29/64	—	—	0.4531	4.3/16	5.5/8	0.453
R10A15/32	15/32	—	—	0.4688	4.5/16	5.3/4	0.469
R10A31/64	31/64	—	—	0.4844	4.3/8	5.7/8	0.484
R10A1/2	1/2	—	—	0.5000	4.1/2	6"	0.500

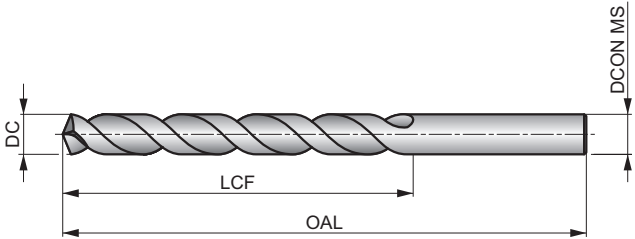
R10B/R15B/R18B

PRECISION



NAS 907 Type B HSS-borehoved, damphærdet

Kraftigt bor med Low Thrust 135° selvcentrerende splitspids for lettere gennemtrængning. Damphærdet finish for øget slidstyrke og smøreevne. Fremstillet i henhold til NAS 907 Type B Aerospace Standard.



HSS	NAS 907	4×D
135°	ST	
λ 20-35°	R	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
36 H	40 H	41 H	31 H	27 G	24 E	25 F	20 F	17 E	15 F	13 E	10 D	30 E	26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
27 E	22 E	18 C	13 G	11 G	10 C	15 C	13 C	35 H	26 D	19 D	27 E	22 E	18 E
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
24 E	18 E	15 E	22 E	17 E	12 E	11 E	9 E	25 E	19 E	15 E	33 J	25 J	17 I
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
46 H	42 H	30 H	68 H	40 F	20 H	28 F	20 D	11 C	9 E	8 B	7 E	6 B	5 E
S4.2													
5 B													

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R10B1/16	1/16	—	—	0.0625	7/8	1.7/8	0.063
R18BN52	—	N52	—	0.0635	7/8	1.7/8	0.064
R18BN51	—	N51	—	0.0670	1"	2"	0.067
R18BN50	—	N50	—	0.0700	1"	2"	0.070
R18BN49	—	N49	—	0.0730	1"	2"	0.073
R18BN48	—	N48	—	0.0760	1"	2"	0.076
R10B5/64	5/64	—	—	0.0781	1"	2"	0.078
R18BN47	—	N47	—	0.0785	1"	2"	0.079
R18BN46	—	N46	—	0.0810	1.1/8	2.1/8	0.081
R18BN45	—	N45	—	0.0820	1.1/8	2.1/8	0.082
R18BN44	—	N44	—	0.0860	1.1/8	2.1/8	0.086
R18BN43	—	N43	—	0.0890	1.1/4	2.1/4	0.089
R18BN42	—	N42	—	0.0935	1.1/4	2.1/4	0.093
R10B3/32	3/32	—	—	0.0938	1.1/4	2.1/4	0.094
R18BN41	—	N41	—	0.0960	1.3/8	2.3/8	0.096
R18BN40	—	N40	—	0.0980	1.3/8	2.3/8	0.098
R18BN39	—	N39	—	0.0995	1.3/8	2.3/8	0.100
R18BN38	—	N38	—	0.1015	1.7/16	2.1/2	0.102
R18BN37	—	N37	—	0.1040	1.7/16	2.1/2	0.104
R18BN36	—	N36	—	0.1065	1.7/16	2.1/2	0.106
R10B7/64	7/64	—	—	0.1094	1.1/2	2.5/8	0.109
R18BN35	—	N35	—	0.1100	1.1/2	2.5/8	0.110
R18BN34	—	N34	—	0.1110	1.1/2	2.5/8	0.111
R18BN33	—	N33	—	0.1130	1.1/2	2.5/8	0.113

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R18BN32	—	N32	—	0.1160	1.5/8	2.3/4	0.116
R18BN31	—	N31	—	0.1200	1.5/8	2.3/4	0.120
R10B1/8	1/8	—	—	0.1250	1.5/8	2.3/4	0.125
R18BN30	—	N30	—	0.1285	1.5/8	2.3/4	0.129
R18BN29	—	N29	—	0.1360	1.3/4	2.7/8	0.136
R18BN28	—	N28	—	0.1405	1.3/4	2.7/8	0.141
R10B9/64	9/64	—	—	0.1406	1.3/4	2.7/8	0.141
R18BN27	—	N27	—	0.1440	1.7/8	3"	0.144
R18BN26	—	N26	—	0.1470	1.7/8	3"	0.147
R18BN25	—	N25	—	0.1495	1.7/8	3"	0.149
R18BN24	—	N24	—	0.1520	2"	3.1/8	0.152
R18BN23	—	N23	—	0.1540	2"	3.1/8	0.154
R10B5/32	5/32	—	—	0.1563	2"	3.1/8	0.156
R18BN22	—	N22	—	0.1570	2"	3.1/8	0.157
R18BN21	—	N21	—	0.1590	2.1/8	3.1/4	0.159
R18BN20	—	N20	—	0.1610	2.1/8	3.1/4	0.161
R18BN19	—	N19	—	0.1660	2.1/8	3.1/4	0.166
R18BN18	—	N18	—	0.1695	2.1/8	3.1/4	0.170
R10B11/64	11/64	—	—	0.1719	2.1/8	3.1/4	0.172
R18BN17	—	N17	—	0.1730	2.3/16	3.3/8	0.173
R18BN16	—	N16	—	0.1770	2.3/16	3.3/8	0.177
R18BN15	—	N15	—	0.1800	2.3/16	3.3/8	0.180
R18BN14	—	N14	—	0.1820	2.3/16	3.3/8	0.182
R18BN13	—	N13	—	0.1850	2.5/16	3.1/2	0.185

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R10B3/16	3/16	—	—	0.1875	2.5/16	3.1/2	0.188
R18BN12	—	N12	—	0.1890	2.5/16	3.1/2	0.189
R18BN11	—	N11	—	0.1910	2.5/16	3.1/2	0.191
R18BN10	—	N10	—	0.1935	2.7/16	3.5/8	0.194
R18BN9	—	N9	—	0.1960	2.7/16	3.5/8	0.196
R18BN8	—	N8	—	0.1990	2.7/16	3.5/8	0.199
R18BN7	—	N7	—	0.2010	2.7/16	3.5/8	0.201
R10B13/64	13/64	—	—	0.2031	2.7/16	3.5/8	0.203
R18BN6	—	N6	—	0.2040	2.1/2	3.3/4	0.204
R18BN5	—	N5	—	0.2055	2.1/2	3.3/4	0.205
R18BN4	—	N4	—	0.2090	2.1/2	3.3/4	0.209
R18BN3	—	N3	—	0.2130	2.1/2	3.3/4	0.213
R10B7/32	7/32	—	—	0.2188	2.1/2	3.3/4	0.219
R18BN2	—	N2	—	0.2210	2.5/8	3.7/8	0.221
R18BN1	—	N1	—	0.2280	2.5/8	3.7/8	0.228
R15BA	—	—	A	0.2340	2.5/8	3.7/8	0.234
R10B15/64	15/64	—	—	0.2344	2.5/8	3.7/8	0.234
R15BB	—	—	B	0.2380	2.3/4	4"	0.238
R15BC	—	—	C	0.2420	2.3/4	4"	0.242
R15BD	—	—	D	0.2460	2.3/4	4"	0.246
R10B1/4	1/4	—	—	0.2500	2.3/4	4"	0.250
R15BF	—	—	F	0.2570	2.7/8	4.1/8	0.257
R15BG	—	—	G	0.2610	2.7/8	4.1/8	0.261
R10B17/64	17/64	—	—	0.2656	2.7/8	4.1/8	0.266
R15BH	—	—	H	0.2660	2.7/8	4.1/8	0.266
R15BI	—	—	I	0.2720	2.7/8	4.1/8	0.272
R15BJ	—	—	J	0.2770	2.7/8	4.1/8	0.277
R15BK	—	—	K	0.2810	2.15/16	4.1/4	0.281
R10B9/32	9/32	—	—	0.2813	2.15/16	4.1/4	0.281

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R15BL	—	—	L	0.2900	2.15/16	4.1/4	0.290
R15BM	—	—	M	0.2950	3.1/16	4.3/8	0.295
R10B19/64	19/64	—	—	0.2969	3.1/16	4.3/8	0.297
R15BN	—	—	N	0.3020	3.1/16	4.3/8	0.302
R10B5/16	5/16	—	—	0.3125	3.3/16	4.1/2	0.313
R15B0	—	—	O	0.3160	3.3/16	4.1/2	0.316
R15BP	—	—	P	0.3230	3.5/16	4.5/8	0.323
R10B21/64	21/64	—	—	0.3281	3.5/16	4.5/8	0.328
R15BQ	—	—	Q	0.3320	3.7/16	4.3/4	0.332
R15BR	—	—	R	0.3390	3.7/16	4.3/4	0.339
R10B11/32	11/32	—	—	0.3438	3.7/16	4.3/4	0.344
R15BS	—	—	S	0.3480	3.1/2	4.7/8	0.348
R15BT	—	—	T	0.3580	3.1/2	4.7/8	0.358
R10B23/64	23/64	—	—	0.3594	3.1/2	4.7/8	0.359
R15BU	—	—	U	0.3680	3.5/8	5"	0.368
R10B3/8	3/8	—	—	0.3750	3.5/8	5"	0.375
R15BV	—	—	V	0.3770	3.5/8	5"	0.377
R15BW	—	—	W	0.3860	3.3/4	5.1/8	0.386
R10B25/64	25/64	—	—	0.3906	3.3/4	5.1/8	0.391
R15BX	—	—	X	0.3970	3.3/4	5.1/8	0.397
R15BY	—	—	Y	0.4040	3.7/8	5.1/4	0.404
R10B13/32	13/32	—	—	0.4063	3.7/8	5.1/4	0.406
R15BZ	—	—	Z	0.4130	3.7/8	5.1/4	0.413
R10B27/64	27/64	—	—	0.4219	3.15/16	5.3/8	0.422
R10B7/16	7/16	—	—	0.4375	4.1/16	5.1/2	0.438
R10B29/64	29/64	—	—	0.4531	4.3/16	5.5/8	0.453
R10B15/32	15/32	—	—	0.4688	4.5/16	5.3/4	0.469
R10B31/64	31/64	—	—	0.4844	4.3/8	5.7/8	0.484
R10B1/2	1/2	—	—	0.5000	4.1/2	6"	0.500

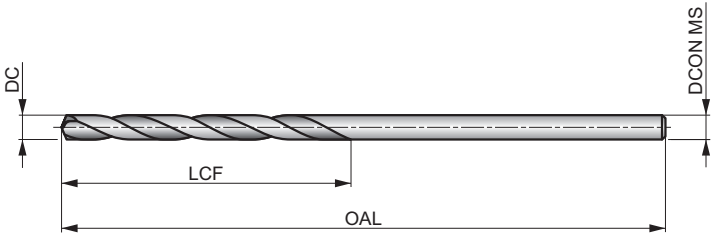
500-6/501-6/502-6

PRECISION



NAS 907 Type B HSS-forlængerbor til fly, 6" OAL

Lange seriebor fremstillet i henhold til National Aerospace Standards med lang total længde kombineret med kort spånlængde gør dem ideelle til boring i svært tilgængelige områder. Det 135° selvcentrerende splitpunkt og den damphærdede overfladefinish gør det velegnet til boring i de fleste materialer.



HSS	NAS 907	4×D
		
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P2.2 ■ 25 F	P2.3 ■ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ■ 13 E	P4.1 ■ 11 F	P4.2 ■ 10 E	P4.3 ■ 8 D	M1.1 ■ 21 E	M1.2 ■ 17 E	M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 9 G	M3.2 ■ 8 G
M3.3 ■ 7 C	M4.1 ■ 9 C	K1.1 ■ 30 I	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E	K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E
K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N2.2 ■ 27 G	N2.3 ■ 24 F	N3.1 ■ 27 H	N3.2 ■ 21 H	N3.3 ■ 16 G	S1.1 ■ 23 F	S1.2 ■ 12 D	S1.3 ■ 6 B	S2.1 ■ 8 E
S2.2 ■ 4 A	S3.1 ■ 6 E	S3.2 ■ 3 A	S4.1 ■ 5 E	S4.2 ■ 2 A									

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
501-6N60 ¹⁾	—	N60	—	0.0400	11/16	6"	0.040
501-6N59 ¹⁾	—	N59	—	0.0410	11/16	6"	0.041
501-6N58 ¹⁾	—	N58	—	0.0420	11/16	6"	0.042
501-6N57 ¹⁾	—	N57	—	0.0430	3/4	6"	0.043
501-6N56 ¹⁾	—	N56	—	0.0465	3/4	6"	0.046
500-63/64 ¹⁾	3/64	—	—	0.0469	3/4	6"	0.047
501-6N55 ¹⁾	—	N55	—	0.0520	7/8	6"	0.052
501-6N54 ¹⁾	—	N54	—	0.0550	7/8	6"	0.055
501-6N53 ¹⁾	—	N53	—	0.0595	7/8	6"	0.059
500-61/16	1/16	—	—	0.0625	7/8	6"	0.063
501-6N52	—	N52	—	0.0635	7/8	6"	0.064
501-6N51	—	N51	—	0.0670	1"	6"	0.067
501-6N50	—	N50	—	0.0700	1"	6"	0.070
501-6N49	—	N49	—	0.0730	1"	6"	0.073
501-6N48	—	N48	—	0.0760	1"	6"	0.076
500-65/64	5/64	—	—	0.0781	1"	6"	0.078
501-6N47	—	N47	—	0.0785	1"	6"	0.079
501-6N46	—	N46	—	0.0810	1.1/8	6"	0.081
501-6N45	—	N45	—	0.0820	1.1/8	6"	0.082
501-6N44	—	N44	—	0.0860	1.1/8	6"	0.086
501-6N43	—	N43	—	0.0890	1.1/4	6"	0.089
501-6N42	—	N42	—	0.0935	1.1/4	6"	0.093
500-63/32	3/32	—	—	0.0938	1.1/4	6"	0.094
501-6N41	—	N41	—	0.0960	1.3/8	6"	0.096
501-6N40	—	N40	—	0.0980	1.3/8	6"	0.098
501-6N39	—	N39	—	0.0995	1.3/8	6"	0.100

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
501-6N38	—	N38	—	0.1015	1.7/16	6"	0.102
501-6N37	—	N37	—	0.1040	1.7/16	6"	0.104
501-6N36	—	N36	—	0.1065	1.7/16	6"	0.106
500-67/64	7/64	—	—	0.1094	1.1/2	6"	0.109
501-6N35	—	N35	—	0.1100	1.1/2	6"	0.110
501-6N34	—	N34	—	0.1110	1.1/2	6"	0.111
501-6N33	—	N33	—	0.1130	1.1/2	6"	0.113
501-6N32	—	N32	—	0.1160	1.5/8	6"	0.116
501-6N31	—	N31	—	0.1200	1.5/8	6"	0.120
500-61/8	1/8	—	—	0.1250	1.5/8	6"	0.125
501-6N30	—	N30	—	0.1285	1.5/8	6"	0.129
501-6N29	—	N29	—	0.1360	1.3/4	6"	0.136
501-6N28	—	N28	—	0.1405	1.3/4	6"	0.141
500-69/64	9/64	—	—	0.1406	1.3/4	6"	0.141
501-6N27	—	N27	—	0.1440	1.7/8	6"	0.144
501-6N26	—	N26	—	0.1470	1.7/8	6"	0.147
501-6N25	—	N25	—	0.1495	1.7/8	6"	0.149
501-6N24	—	N24	—	0.1520	2"	6"	0.152
501-6N23	—	N23	—	0.1540	2"	6"	0.154
500-65/32	5/32	—	—	0.1563	2"	6"	0.156
501-6N22	—	N22	—	0.1570	2"	6"	0.157
501-6N21	—	N21	—	0.1590	2.1/8	6"	0.159
501-6N20	—	N20	—	0.1610	2.1/8	6"	0.161
501-6N19	—	N19	—	0.1660	2.1/8	6"	0.166
501-6N18	—	N18	—	0.1695	2.1/8	6"	0.170
500-611/64	11/64	—	—	0.1719	2.1/8	6"	0.172

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
501-6N17	—	N17	—	0.1730	2.3/16	6"	0.173
501-6N16	—	N16	—	0.1770	2.3/16	6"	0.177
501-6N15	—	N15	—	0.1800	2.3/16	6"	0.180
501-6N14	—	N14	—	0.1820	2.3/16	6"	0.182
501-6N13	—	N13	—	0.1850	2.5/16	6"	0.185
500-63/16	3/16	—	—	0.1875	2.5/16	6"	0.188
501-6N12	—	N12	—	0.1890	2.5/16	6"	0.189
501-6N11	—	N11	—	0.1910	2.5/16	6"	0.191
501-6N10	—	N10	—	0.1935	2.7/16	6"	0.194
501-6N9	—	N9	—	0.1960	2.7/16	6"	0.196
501-6N8	—	N8	—	0.1990	2.7/16	6"	0.199
501-6N7	—	N7	—	0.2010	2.7/16	6"	0.201
500-613/64	13/64	—	—	0.2031	2.7/16	6"	0.203
501-6N6	—	N6	—	0.2040	2.1/2	6"	0.204
501-6N5	—	N5	—	0.2055	2.1/2	6"	0.205
501-6N4	—	N4	—	0.2090	2.1/2	6"	0.209
501-6N3	—	N3	—	0.2130	2.1/2	6"	0.213
500-67/32	7/32	—	—	0.2188	2.1/2	6"	0.219
501-6N2	—	N2	—	0.2210	2.5/8	6"	0.221
501-6N1	—	N1	—	0.2280	2.5/8	6"	0.228
502-6A	—	—	A	0.2340	2.5/8	6"	0.234
500-615/64	15/64	—	—	0.2344	2.5/8	6"	0.234
502-6B	—	—	B	0.2380	2.3/4	6"	0.238
502-6C	—	—	C	0.2420	2.3/4	6"	0.242
502-6D	—	—	D	0.2460	2.3/4	6"	0.246
500-61/4	1/4	—	—	0.2500	2.3/4	6"	0.250
502-6F	—	—	F	0.2570	2.7/8	6"	0.257
502-6G	—	—	G	0.2610	2.7/8	6"	0.261
500-617/64	17/64	—	—	0.2656	2.7/8	6"	0.266
502-6H	—	—	H	0.2660	2.7/8	6"	0.266
502-6I	—	—	I	0.2720	2.7/8	6"	0.272
502-6J	—	—	J	0.2770	2.7/8	6"	0.277

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
502-6K	—	—	K	0.2810	2.15/16	6"	0.281
500-69/32	9/32	—	—	0.2813	2.15/16	6"	0.281
502-6L	—	—	L	0.2900	2.15/16	6"	0.290
502-6M	—	—	M	0.2950	3.1/16	6"	0.295
500-619/64	19/64	—	—	0.2969	3.1/16	6"	0.297
502-6N	—	—	N	0.3020	3.1/16	6"	0.302
500-65/16	5/16	—	—	0.3125	3.3/16	6"	0.313
502-6O	—	—	O	0.3160	3.3/16	6"	0.316
502-6P	—	—	P	0.3230	3.5/16	6"	0.323
500-621/64	21/64	—	—	0.3281	3.5/16	6"	0.328
502-6Q	—	—	Q	0.3320	3.7/16	6"	0.332
502-6R	—	—	R	0.3390	3.7/16	6"	0.339
500-611/32	11/32	—	—	0.3438	3.7/16	6"	0.344
502-6S	—	—	S	0.3480	3.1/2	6"	0.348
502-6T	—	—	T	0.3580	3.1/2	6"	0.358
500-623/64	23/64	—	—	0.3594	3.1/2	6"	0.359
502-6U	—	—	U	0.3680	3.5/8	6"	0.368
500-63/8	3/8	—	—	0.3750	3.5/8	6"	0.375
502-6V	—	—	V	0.3772	3.5/8	6"	0.377
502-6W	—	—	W	0.3860	3.3/4	6"	0.386
500-625/64	25/64	—	—	0.3906	3.3/4	6"	0.391
502-6X	—	—	X	0.3970	3.3/4	6"	0.397
502-6Y	—	—	Y	0.4040	3.7/8	6"	0.404
500-613/32	13/32	—	—	0.4063	3.7/8	6"	0.406
502-6Z	—	—	Z	0.4130	3.7/8	6"	0.413
500-627/64	27/64	—	—	0.4219	3.15/16	6"	0.422
500-67/16	7/16	—	—	0.4375	4.1/16	6"	0.438
500-629/64	29/64	—	—	0.4531	4.3/16	6"	0.453
500-615/32	15/32	—	—	0.4688	4.5/16	6"	0.469
500-631/64	31/64	—	—	0.4844	4.3/8	6"	0.484
500-61/2	1/2	—	—	0.5000	4.1/2	6"	0.500

¹⁾ Intet splitpunkt.

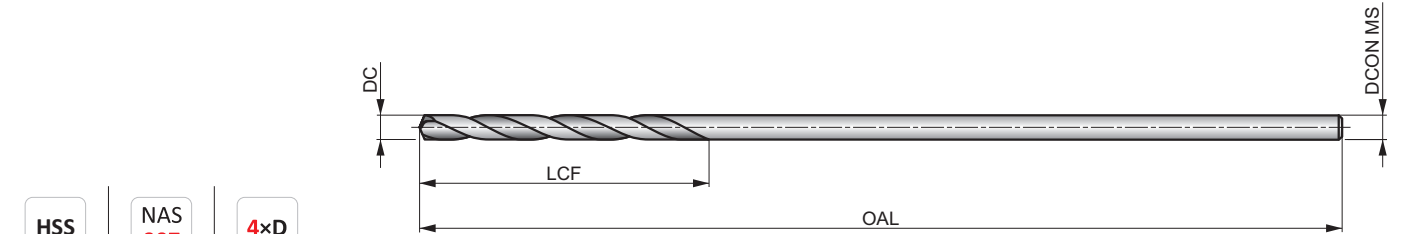
500-12/501-12/502-12

PRECISION



NAS 907 Type B HSS-forlængerbor til fly, 12\'' OAL

Ekstra lange seriebor fremstillet i henhold til National Aerospace Standards med ekstra lang totallængde kombineret med kort spånlængde gør dem ideelle til boring i svært tilgængelige områder. Det 135° selvcenterende splitpunkt og den dampphædede overfladefinish gør det velegnet til boring i de fleste materialer.



HSS	NAS 907	4×D
		
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2
25 F	22 E	19 F	15 F	13 E	11 F	10 E	8 D	21 E	17 E	18 E	15 E	9 G	8 G
M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
7 C	9 C	30 I	22 F	17 F	25 E	20 E	16 E	22 E	17 E	13 E	20 E	15 E	11 E
K4.4	K4.5	K5.1	K5.2	K5.3	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1
10 E	8 E	23 E	17 E	13 E	27 G	24 F	27 H	21 H	16 G	23 F	12 D	6 B	8 E
S2.2	S3.1	S3.2	S4.1	S4.2									
4 A	6 E	3 A	5 E	2 A									

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
500-123/64	3/64	—	—	0.0469	3/4	12"	0.047
500-121/16	1/16	—	—	0.0625	7/8	12"	0.063
501-12N50	—	N50	—	0.0700	1"	12"	0.070
501-12N49	—	N49	—	0.0730	1"	12"	0.073
500-125/64	5/64	—	—	0.0781	1"	12"	0.078
501-12N47	—	N47	—	0.0785	1"	12"	0.079
501-12N46	—	N46	—	0.0810	1.1/8	12"	0.081
501-12N45	—	N45	—	0.0820	1.1/8	12"	0.082
501-12N44	—	N44	—	0.0860	1.1/8	12"	0.086
501-12N43	—	N43	—	0.0890	1.1/4	12"	0.089
501-12N42	—	N42	—	0.0935	1.1/4	12"	0.093
500-123/32	3/32	—	—	0.0938	1.1/4	12"	0.094
501-12N41	—	N41	—	0.0960	1.3/8	12"	0.096
501-12N40	—	N40	—	0.0980	1.3/8	12"	0.098
501-12N37	—	N37	—	0.1040	1.7/16	12"	0.104
501-12N36	—	N36	—	0.1065	1.7/16	12"	0.106
500-127/64	7/64	—	—	0.1094	1.1/2	12"	0.109
501-12N31	—	N31	—	0.1200	1.5/8	12"	0.120
500-121/8	1/8	—	—	0.1250	1.5/8	12"	0.125
501-12N30	—	N30	—	0.1285	1.5/8	12"	0.129
501-12N29	—	N29	—	0.1360	1.3/4	12"	0.136
500-129/64	9/64	—	—	0.1406	1.3/4	12"	0.141
501-12N27	—	N27	—	0.1440	1.7/8	12"	0.144
501-12N26	—	N26	—	0.1470	1.7/8	12"	0.147
501-12N25	—	N25	—	0.1495	1.7/8	12"	0.149
501-12N23	—	N23	—	0.1540	2"	12"	0.154

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
500-125/32	5/32	—	—	0.1563	2"	12"	0.156
501-12N22	—	N22	—	0.1570	2"	12"	0.157
501-12N21	—	N21	—	0.1590	2.1/8	12"	0.159
501-12N20	—	N20	—	0.1610	2.1/8	12"	0.161
501-12N19	—	N19	—	0.1660	2.1/8	12"	0.166
501-12N18	—	N18	—	0.1695	2.1/8	12"	0.170
500-1211/64	11/64	—	—	0.1719	2.1/8	12"	0.172
501-12N17	—	N17	—	0.1730	2.3/16	12"	0.173
501-12N16	—	N16	—	0.1770	2.3/16	12"	0.177
501-12N13	—	N13	—	0.1850	2.5/16	12"	0.185
500-123/16	3/16	—	—	0.1875	2.5/16	12"	0.188
501-12N12	—	N12	—	0.1890	2.5/16	12"	0.189
501-12N11	—	N11	—	0.1910	2.5/16	12"	0.191
501-12N10	—	N10	—	0.1935	2.7/16	12"	0.194
501-12N9	—	N9	—	0.1960	2.7/16	12"	0.196
501-12N7	—	N7	—	0.2010	2.7/16	12"	0.201
500-1213/64	13/64	—	—	0.2031	2.7/16	12"	0.203
501-12N5	—	N5	—	0.2055	2.1/2	12"	0.205
501-12N4	—	N4	—	0.2090	2.1/2	12"	0.209
501-12N3	—	N3	—	0.2130	2.1/2	12"	0.213
500-127/32	7/32	—	—	0.2188	2.1/2	12"	0.219
501-12N1	—	N1	—	0.2280	2.5/8	12"	0.228
502-12A	—	—	A	0.2340	2.5/8	12"	0.234
500-1215/64	15/64	—	—	0.2344	2.5/8	12"	0.234
502-12B	—	—	B	0.2380	2.3/4	12"	0.238
502-12C	—	—	C	0.2420	2.3/4	12"	0.242

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
502-12D	—	—	D	0.2460	2.3/4	12"	0.246
500-121/4	1/4	—	—	0.2500	2.3/4	12"	0.250
502-12F	—	—	F	0.2570	2.7/8	12"	0.257
502-12G	—	—	G	0.2610	2.7/8	12"	0.261
500-1217/64	17/64	—	—	0.2656	2.7/8	12"	0.266
502-12H	—	—	H	0.2660	2.7/8	12"	0.266
502-12I	—	—	I	0.2720	2.7/8	12"	0.272
502-12J	—	—	J	0.2770	2.7/8	12"	0.277
502-12K	—	—	K	0.2810	2.15/16	12"	0.281
500-129/32	9/32	—	—	0.2813	2.15/16	12"	0.281
502-12L	—	—	L	0.2900	2.15/16	12"	0.290
502-12M	—	—	M	0.2950	3.1/16	12"	0.295
500-1219/64	19/64	—	—	0.2969	3.1/16	12"	0.297
502-12N	—	—	N	0.3020	3.1/16	12"	0.302
500-125/16	5/16	—	—	0.3125	3.3/16	12"	0.313
502-12O	—	—	O	0.3160	3.3/16	12"	0.316
502-12P	—	—	P	0.3230	3.5/16	12"	0.323
500-1221/64	21/64	—	—	0.3281	3.5/16	12"	0.328
502-12Q	—	—	Q	0.3320	3.7/16	12"	0.332
502-12R	—	—	R	0.3390	3.7/16	12"	0.339

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
500-1211/32	11/32	—	—	0.3438	3.7/16	12"	0.344
502-12S	—	—	S	0.3480	3.1/2	12"	0.348
502-12T	—	—	T	0.3580	3.1/2	12"	0.358
500-1223/64	23/64	—	—	0.3594	3.1/2	12"	0.359
502-12U	—	—	U	0.3680	3.5/8	12"	0.368
500-123/8	3/8	—	—	0.3750	3.5/8	12"	0.375
502-12V	—	—	V	0.3770	3.5/8	12"	0.377
502-12W	—	—	W	0.3860	3.3/4	12"	0.386
500-1225/64	25/64	—	—	0.3906	3.3/4	12"	0.391
502-12X	—	—	X	0.3970	3.3/4	12"	0.397
502-12Y	—	—	Y	0.4040	3.7/8	12"	0.404
500-1213/32	13/32	—	—	0.4063	3.7/8	12"	0.406
502-12Z	—	—	Z	0.4130	3.7/8	12"	0.413
500-1227/64	27/64	—	—	0.4219	3.15/16	12"	0.422
500-127/16	7/16	—	—	0.4375	4.1/16	12"	0.438
500-1229/64	29/64	—	—	0.4531	4.3/16	12"	0.453
500-1215/32	15/32	—	—	0.4688	4.5/16	12"	0.469
500-1231/64	31/64	—	—	0.4844	4.3/8	12"	0.484
500-121/2	1/2	—	—	0.5000	4.1/2	12"	0.500

R88CO/R89CO

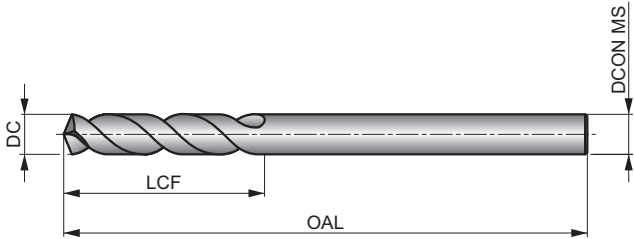
PRECISION



NAS 907 Type D HSS-E (8 %) Kobolt, kraftig boremaskine

Et bor med kortere spindellængde og længere skaft for større stivhed. Godt bor, når der er brug for større rækkevidde til boring af overfladiske huller eller tyndere materialer. Bronzehærdet overfladefinish med 135° selvcentrerende splitpunkt med lavt tryk for lettere gennemtrængning. Fremstillet i henhold til NAS 907 Type D Aerospace Standards.

HSS-E	NAS 907	3×D
		
		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
36 H	40 H	41 H	31 H	27 G	24 E	25 F	20 F	17 E	15 F	13 E	10 D	30 E	26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1
27 E	22 E	18 C	13 G	11 G	10 C	15 C	35 H	26 D	19 D	27 E	22 E	18 E	24 E
K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1
18 E	15 E	22 E	17 E	12 E	11 E	9 E	25 E	19 E	15 E	33 J	25 J	17 I	46 H
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
42 H	30 H	68 H	40 F	20 H	28 F	20 D	11 C	9 E	8 B	7 E	6 B	5 E	5 B

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)
R88C01/16	1/16	—	0.0625	7/16	1.7/8	0.063
R89CON52	—	N52	0.0635	7/16	1.7/8	0.064
R89CON51	—	N51	0.0670	1/2	2"	0.067
R89CON50	—	N50	0.0700	1/2	2"	0.070
R89CON49	—	N49	0.0730	1/2	2"	0.073
R88C05/64	5/64	—	0.0781	1/2	2"	0.078
R89CON46	—	N46	0.0810	9/16	2.1/8	0.081
R89CON45	—	N45	0.0820	9/16	2.1/8	0.082
R89CON44	—	N44	0.0860	9/16	2.1/8	0.086
R89CON43	—	N43	0.0890	5/8	2.1/4	0.089
R89CON42	—	N42	0.0935	5/8	2.1/4	0.093
R88C03/32	3/32	—	0.0938	5/8	2.1/4	0.094
R89CON41	—	N41	0.0960	5/8	2.3/8	0.096
R89CON40	—	N40	0.0980	13/16	2.3/8	0.098
R89CON39	—	N39	0.0995	13/16	2.3/8	0.100
R89CON36	—	N36	0.1065	13/16	2.1/2	0.106
R88C07/64	7/64	—	0.1094	13/16	2.5/8	0.109
R89CON31	—	N31	0.1200	7/8	2.3/4	0.120
R88C01/8	1/8	—	0.1250	7/8	2.3/4	0.125
R89CON30	—	N30	0.1285	15/16	2.3/4	0.129
R89CON29	—	N29	0.1360	15/16	2.7/8	0.136
R88C09/64	9/64	—	0.1406	15/16	2.7/8	0.141
R89CON27	—	N27	0.1440	1"	3"	0.144
R89CON26	—	N26	0.1470	1"	3"	0.147
R89CON25	—	N25	0.1495	1"	3"	0.149
R89CON24	—	N24	0.1520	1"	3.1/8	0.152
R88C05/32	5/32	—	0.1563	1"	3.1/8	0.156
R89CON22	—	N22	0.1570	1.1/16	3.1/8	0.157
R89CON21	—	N21	0.1590	1.1/16	3.1/4	0.159
R89CON20	—	N20	0.1610	1.1/16	3.1/4	0.161
R88C011/64	11/64	—	0.1719	1.1/16	3.1/4	0.172
R89CON16	—	N16	0.1770	1.1/8	3.3/8	0.177

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)
R89CON13	—	N13	0.1850	1.1/8	3.1/2	0.185
R88C03/16	3/16	—	0.1875	1.1/8	3.1/2	0.188
R89CON12	—	N12	0.1890	1.1/8	3.1/2	0.189
R89CON11	—	N11	0.1910	1.3/16	3.1/2	0.191
R89CON10	—	N10	0.1935	1.3/16	3.5/8	0.194
R89CON9	—	N9	0.1960	1.3/16	3.5/8	0.196
R89CON8	—	N8	0.1990	1.3/16	3.5/8	0.199
R89CON7	—	N7	0.2010	1.3/16	3.5/8	0.201
R88C013/64	13/64	—	0.2031	1.3/16	3.5/8	0.203
R89CON6	—	N6	0.2040	1.1/4	3.3/4	0.204
R89CON5	—	N5	0.2055	1.1/4	3.3/4	0.205
R89CON3	—	N3	0.2130	1.1/4	3.3/4	0.213
R88C07/32	7/32	—	0.2188	1.1/4	3.3/4	0.219
R88C015/64	15/64	—	0.2344	1.5/16	3.7/8	0.234
R88C01/4	1/4	—	0.2500	1.3/8	4"	0.250
R88C017/64	17/64	—	0.2656	1.7/16	4.1/8	0.266
R88C09/32	9/32	—	0.2813	1.1/2	4.1/4	0.281
R88C019/64	19/64	—	0.2969	1.9/16	4.3/8	0.297
R88C05/16	5/16	—	0.3125	1.5/8	4.1/2	0.313
R88C021/64	21/64	—	0.3281	1.11/16	4.5/8	0.328
R88C011/32	11/32	—	0.3438	1.11/16	4.3/4	0.344
R88C023/64	23/64	—	0.3594	1.3/4	4.7/8	0.359
R88C03/8	3/8	—	0.3750	1.13/16	5"	0.375
R88C025/64	25/64	—	0.3906	1.7/8	5.1/8	0.391
R88C013/32	13/32	—	0.4063	1.15/16	5.1/4	0.406
R88C027/64	27/64	—	0.4219	2"	5.3/8	0.422
R88C07/16	7/16	—	0.4375	2.1/16	5.1/2	0.438
R88C029/64	29/64	—	0.4531	2.1/8	5.5/8	0.453
R88C015/32	15/32	—	0.4688	2.1/8	5.3/4	0.469
R88C031/64	31/64	—	0.4844	2.3/16	5.7/8	0.484
R88C01/2	1/2	—	0.5000	2.1/4	6"	0.500

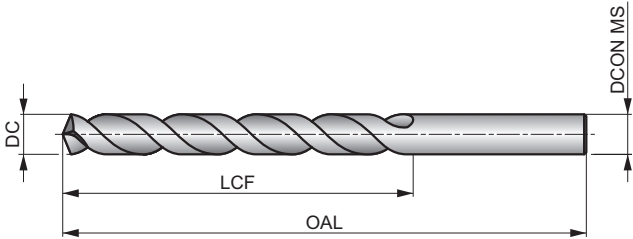
R10CO/R15CO/R18CO

PRECISION



NAS 907 Type J HSS-E (8 %) kobolt, kraftig boremaskine

En virkelig god præstation, der producerer huller af præcis størrelse med en bedre finish. 135° selvcentrerende spaltespids med lavt tryk for lettere gennembrængning. Bronzehærdet overfladefinish forhindrer, at materiale fra arbejdsområdet klæber til borets skærekanter. Fremstillet i henhold til NAS 907 Type J Aerospace Standards.



HSS-E	NAS 907	4xD
135°	Bronze	
λ 20-35°	R	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
36 H	40 H	41 H	31 H	27 G	24 E	25 F	20 F	17 E	15 F	13 E	10 D	30 E	26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1
27 E	22 E	18 C	13 G	11 G	10 C	15 C	35 H	26 D	19 D	27 E	22 E	18 E	24 E
K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1
18 E	15 E	22 E	17 E	12 E	11 E	9 E	25 E	19 E	15 E	33 J	25 J	17 I	46 H
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
42 H	30 H	68 H	40 F	20 H	28 F	20 D	11 C	9 E	8 B	7 E	6 B	5 E	5 B

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R18CON80 ¹⁾	—	N80	—	0.0135	1/8	3/4	0.013
R18CON79 ¹⁾	—	N79	—	0.0145	1/8	3/4	0.015
R10C01/64 ¹⁾	1/64	—	—	0.0156	3/16	3/4	0.016
R18CON78 ¹⁾	—	N78	—	0.0160	3/16	7/8	0.016
R18CON77 ¹⁾	—	N77	—	0.0180	3/16	7/8	0.018
R18CON76 ¹⁾	—	N76	—	0.0200	3/16	7/8	0.020
R18CON75 ¹⁾	—	N75	—	0.0210	1/4	1"	0.021
R18CON74 ¹⁾	—	N74	—	0.0225	1/4	1"	0.022
R18CON73 ¹⁾	—	N73	—	0.0240	5/16	1.1/8	0.024
R18CON72 ¹⁾	—	N72	—	0.0250	5/16	1.1/8	0.025
R18CON71 ¹⁾	—	N71	—	0.0260	3/8	1.1/4	0.026
R18CON70 ¹⁾	—	N70	—	0.0280	3/8	1.1/4	0.028
R18CON69 ¹⁾	—	N69	—	0.0292	1/2	1.3/8	0.029
R18CON68 ¹⁾	—	N68	—	0.0310	1/2	1.3/8	0.031
R10C01/32 ¹⁾	1/32	—	—	0.0313	1/2	1.3/8	0.031
R18CON67 ¹⁾	—	N67	—	0.0320	1/2	1.3/8	0.032
R18CON66 ¹⁾	—	N66	—	0.0330	1/2	1.3/8	0.033
R18CON65 ¹⁾	—	N65	—	0.0350	5/8	1.1/2	0.035
R18CON64 ¹⁾	—	N64	—	0.0360	5/8	1.1/2	0.036
R18CON63 ¹⁾	—	N63	—	0.0370	5/8	1.1/2	0.037
R18CON62 ¹⁾	—	N62	—	0.0380	5/8	1.1/2	0.038
R18CON61 ¹⁾	—	N61	—	0.0390	11/16	1.5/8	0.039
R18CON60	—	N60	—	0.0400	11/16	1.5/8	0.040
R18CON59	—	N59	—	0.0410	11/16	1.5/8	0.041
R18CON58	—	N58	—	0.0420	11/16	1.5/8	0.042
R18CON57	—	N57	—	0.0430	3/4	1.3/4	0.043

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R18CON56	—	N56	—	0.0465	3/4	1.3/4	0.046
R10C03/64	3/64	—	—	0.0469	3/4	1.3/4	0.047
R18CON55	—	N55	—	0.0520	7/8	1.7/8	0.052
R18CON54	—	N54	—	0.0550	7/8	1.7/8	0.055
R18CON53	—	N53	—	0.0595	7/8	1.7/8	0.059
R10C01/16	1/16	—	—	0.0625	7/8	1.7/8	0.063
R18CON52	—	N52	—	0.0635	7/8	1.7/8	0.064
R18CON51	—	N51	—	0.0670	1"	2"	0.067
R18CON50	—	N50	—	0.0700	1"	2"	0.070
R18CON49	—	N49	—	0.0730	1"	2"	0.073
R18CON48	—	N48	—	0.0760	1"	2"	0.076
R10C05/64	5/64	—	—	0.0781	1"	2"	0.078
R18CON47	—	N47	—	0.0785	1"	2"	0.079
R18CON46	—	N46	—	0.0810	1.1/8	2.1/8	0.081
R18CON45	—	N45	—	0.0820	1.1/8	2.1/8	0.082
R18CON44	—	N44	—	0.0860	1.1/8	2.1/8	0.086
R18CON43	—	N43	—	0.0890	1.1/4	2.1/4	0.089
R18CON42	—	N42	—	0.0935	1.1/4	2.1/4	0.093
R10C03/32	3/32	—	—	0.0938	1.1/4	2.1/4	0.094
R18CON41	—	N41	—	0.0960	1.3/8	2.3/8	0.096
R18CON40	—	N40	—	0.0980	1.3/8	2.3/8	0.098
R18CON39	—	N39	—	0.0995	1.3/8	2.3/8	0.100
R18CON38	—	N38	—	0.1015	1.7/16	2.1/2	0.102
R18CON37	—	N37	—	0.1040	1.7/16	2.1/2	0.104
R18CON36	—	N36	—	0.1065	1.7/16	2.1/2	0.106
R10C07/64	7/64	—	—	0.1094	1.1/2	2.5/8	0.109

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R18CON35	–	N35	–	0.1100	1.1/2	2.5/8	0.110
R18CON34	–	N34	–	0.1110	1.1/2	2.5/8	0.111
R18CON33	–	N33	–	0.1130	1.1/2	2.5/8	0.113
R18CON32	–	N32	–	0.1160	1.5/8	2.3/4	0.116
R18CON31	–	N31	–	0.1200	1.5/8	2.3/4	0.120
R10C01/8	1/8	–	–	0.1250	1.5/8	2.3/4	0.125
R18CON30	–	N30	–	0.1285	1.5/8	2.3/4	0.129
R18CON29	–	N29	–	0.1360	1.3/4	2.7/8	0.136
R18CON28	–	N28	–	0.1405	1.3/4	2.7/8	0.141
R10C09/64	9/64	–	–	0.1406	1.3/4	2.7/8	0.141
R18CON27	–	N27	–	0.1440	1.7/8	3"	0.144
R18CON26	–	N26	–	0.1470	1.7/8	3"	0.147
R18CON25	–	N25	–	0.1495	1.7/8	3"	0.149
R18CON24	–	N24	–	0.1520	2"	3.1/8	0.152
R18CON23	–	N23	–	0.1540	2"	3.1/8	0.154
R10C05/32	5/32	–	–	0.1563	2"	3.1/8	0.156
R18CON22	–	N22	–	0.1570	2"	3.1/8	0.157
R18CON21	–	N21	–	0.1590	2.1/8	3.1/4	0.159
R18CON20	–	N20	–	0.1610	2.1/8	3.1/4	0.161
R18CON19	–	N19	–	0.1660	2.1/8	3.1/4	0.166
R18CON18	–	N18	–	0.1695	2.1/8	3.1/4	0.170
R10C011/64	11/64	–	–	0.1719	2.1/8	3.1/4	0.172
R18CON17	–	N17	–	0.1730	2.3/16	3.3/8	0.173
R18CON16	–	N16	–	0.1770	2.3/16	3.3/8	0.177
R18CON15	–	N15	–	0.1800	2.3/16	3.3/8	0.180
R18CON14	–	N14	–	0.1820	2.3/16	3.3/8	0.182
R18CON13	–	N13	–	0.1850	2.5/16	3.1/2	0.185
R10C03/16	3/16	–	–	0.1875	2.5/16	3.1/2	0.188
R18CON12	–	N12	–	0.1890	2.5/16	3.1/2	0.189
R18CON11	–	N11	–	0.1910	2.5/16	3.1/2	0.191
R18CON10	–	N10	–	0.1935	2.7/16	3.5/8	0.194
R18CON9	–	N9	–	0.1960	2.7/16	3.5/8	0.196
R18CON8	–	N8	–	0.1990	2.7/16	3.5/8	0.199
R18CON7	–	N7	–	0.2010	2.7/16	3.5/8	0.201
R10C013/64	13/64	–	–	0.2031	2.7/16	3.5/8	0.203
R18CON6	–	N6	–	0.2040	2.1/2	3.3/4	0.204
R18CON5	–	N5	–	0.2055	2.1/2	3.3/4	0.205
R18CON4	–	N4	–	0.2090	2.1/2	3.3/4	0.209
R18CON3	–	N3	–	0.2130	2.1/2	3.3/4	0.213
R10C07/32	7/32	–	–	0.2188	2.1/2	3.3/4	0.219
R18CON2	–	N2	–	0.2210	2.5/8	3.7/8	0.221
R18CON1	–	N1	–	0.2280	2.5/8	3.7/8	0.228
R15COA	–	–	A	0.2340	2.5/8	3.7/8	0.234
R10C015/64	15/64	–	–	0.2344	2.5/8	3.7/8	0.234
R15COB	–	–	B	0.2380	2.3/4	4"	0.238
R15COC	–	–	C	0.2420	2.3/4	4"	0.242
R15COD	–	–	D	0.2460	2.3/4	4"	0.246
R10C01/4	1/4	–	–	0.2500	2.3/4	4"	0.250
R15COF	–	–	F	0.2570	2.7/8	4.1/8	0.257

¹⁾ Intet splitpunkt.

Product	DC	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(Letter size)	(inch)	(inch)	(inch)	(inch)
R15COG	–	–	G	0.2610	2.7/8	4.1/8	0.261
R10C017/64	17/64	–	–	0.2656	2.7/8	4.1/8	0.266
R15COH	–	–	H	0.2660	2.7/8	4.1/8	0.266
R15COI	–	–	I	0.2720	2.7/8	4.1/8	0.272
R15COJ	–	–	J	0.2770	2.7/8	4.1/8	0.277
R15COK	–	–	K	0.2810	2.15/16	4.1/4	0.281
R10C09/32	9/32	–	–	0.2813	2.15/16	4.1/4	0.281
R15COL	–	–	L	0.2900	2.15/16	4.1/4	0.290
R15COM	–	–	M	0.2950	3.1/16	4.3/8	0.295
R10C019/64	19/64	–	–	0.2969	3.1/16	4.3/8	0.297
R15CON	–	–	N	0.3020	3.1/16	4.3/8	0.302
R10C05/16	5/16	–	–	0.3125	3.3/16	4.1/2	0.313
R15COO	–	–	O	0.3160	3.3/16	4.1/2	0.316
R15COP	–	–	P	0.3230	3.5/16	4.5/8	0.323
R10C021/64	21/64	–	–	0.3281	3.5/16	4.5/8	0.328
R15COQ	–	–	Q	0.3320	3.7/16	4.3/4	0.332
R15COR	–	–	R	0.3390	3.7/16	4.3/4	0.339
R10C011/32	11/32	–	–	0.3438	3.7/16	4.3/4	0.344
R15COS	–	–	S	0.3480	3.1/2	4.7/8	0.348
R15COT	–	–	T	0.3580	3.1/2	4.7/8	0.358
R10C023/64	23/64	–	–	0.3594	3.1/2	4.7/8	0.359
R15COU	–	–	U	0.3680	3.5/8	5"	0.368
R10C03/8	3/8	–	–	0.3750	3.5/8	5"	0.375
R15COV	–	–	V	0.3770	3.5/8	5"	0.377
R15COW	–	–	W	0.3860	3.3/4	5.1/8	0.386
R10C025/64	25/64	–	–	0.3906	3.3/4	5.1/8	0.391
R15COX	–	–	X	0.3970	3.3/4	5.1/8	0.397
R15COY	–	–	Y	0.4040	3.7/8	5.1/4	0.404
R10C013/32	13/32	–	–	0.4063	3.7/8	5.1/4	0.406
R15COZ	–	–	Z	0.4130	3.7/8	5.1/4	0.413
R10C027/64	27/64	–	–	0.4219	3.15/16	5.3/8	0.422
R10C07/16	7/16	–	–	0.4375	4.1/16	5.1/2	0.438
R10C029/64	29/64	–	–	0.4531	4.3/16	5.5/8	0.453
R10C015/32	15/32	–	–	0.4688	4.5/16	5.3/4	0.469
R10C031/64	31/64	–	–	0.4844	4.3/8	5.7/8	0.484
R10C01/2	1/2	–	–	0.5000	4.1/2	6"	0.500
R10C033/64	33/64	–	–	0.5156	4.13/16	6.5/8	0.516
R10C017/32	17/32	–	–	0.5313	4.13/16	6.5/8	0.531
R10C035/64	35/64	–	–	0.5469	4.13/16	6.5/8	0.547
R10C09/16	9/16	–	–	0.5625	4.13/16	6.5/8	0.563
R10C037/64	37/64	–	–	0.5781	4.13/16	6.5/8	0.578
R10C019/32	19/32	–	–	0.5938	5.3/16	7.1/8	0.594
R10C039/64	39/64	–	–	0.6094	5.3/16	7.1/8	0.609
R10C05/8	5/8	–	–	0.6250	5.3/16	7.1/8	0.625
R10C041/64	41/64	–	–	0.6406	5.3/16	7.1/8	0.641
R10C021/32	21/32	–	–	0.6563	5.3/16	7.1/8	0.656
R10C043/64	43/64	–	–	0.6719	5.5/8	7.5/8	0.672
R10C011/16	11/16	–	–	0.6875	5.5/8	7.5/8	0.688

CO500-6/CO501-6

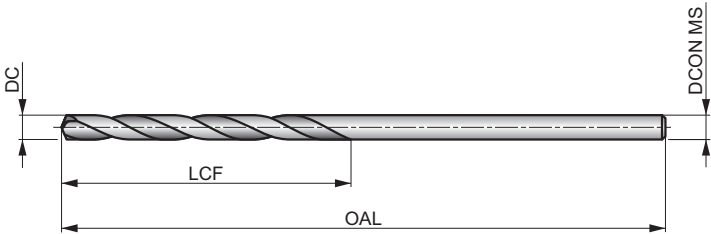
PRECISION



NAS 907 Type B HSS-E flyforlængerbor, 6" OAL

Bor i lange serier fremstillet i henhold til National Aerospace Standards med lang totallængde kombineret med kort spånlængde gør dem ideelle til boring i svært tilgængelige områder. Koboltmaterialet, 135° spaltespids og bronzehærdet overfladefinish forbedrer værktøjets levetid ved boring i de fleste materialer.

HSS-E	NAS 907	4xD
		
		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
36 G	40 G	41 G	31 G	27 E	24 D	25 E	20 E	17 D	15 E	13 D	10 B	30 H	26 H
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
27 H	22 H	18 D	13 F	11 F	10 D	15 D	13 D	35 H	26 H	19 H	27 F	22 F	18 D
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
24 F	18 F	15 D	22 F	17 F	12 D	11 D	9 D	25 F	19 F	15 D	32 I	24 I	16 H
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.3	S2.1	S2.2	S3.1	S3.2
42 G	37 G	27 G	54 G	32 H	16 E	35 I	26 G	12 E	6 D	8 B	7 B	6 B	5 B
S4.1	S4.2												
5 B	4 B												

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)
CO500-61/16	1/16	—	0.0625	7/8	6"	0.063
CO501-6N52	—	N52	0.0635	7/8	6"	0.064
CO501-6N51	—	N51	0.0670	1"	6"	0.067
CO501-6N50	—	N50	0.0700	1"	6"	0.070
CO501-6N49	—	N49	0.0730	1"	6"	0.073
CO501-6N48	—	N48	0.0760	1"	6"	0.076
CO500-65/64	5/64	—	0.0781	1"	6"	0.078
CO501-6N47	—	N47	0.0785	1"	6"	0.079
CO501-6N46	—	N46	0.0810	1.1/8	6"	0.081
CO501-6N45	—	N45	0.0820	1.1/8	6"	0.082
CO501-6N44	—	N44	0.0860	1.1/8	6"	0.086
CO501-6N43	—	N43	0.0890	1.1/4	6"	0.089
CO501-6N42	—	N42	0.0935	1.1/4	6"	0.093
CO500-63/32	3/32	—	0.0938	1.1/4	6"	0.094
CO501-6N41	—	N41	0.0960	1.3/8	6"	0.096
CO501-6N40	—	N40	0.0980	1.3/8	6"	0.098
CO501-6N39	—	N39	0.0995	1.3/8	6"	0.100
CO501-6N38	—	N38	0.1015	1.7/16	6"	0.102
CO501-6N37	—	N37	0.1040	1.7/16	6"	0.104
CO501-6N36	—	N36	0.1065	1.7/16	6"	0.106
CO500-67/64	7/64	—	0.1094	1.1/2	6"	0.109
CO501-6N35	—	N35	0.1100	1.1/2	6"	0.110
CO501-6N34	—	N34	0.1110	1.1/2	6"	0.111
CO501-6N33	—	N33	0.1130	1.1/2	6"	0.113
CO501-6N32	—	N32	0.1160	1.5/8	6"	0.116
CO501-6N31	—	N31	0.1200	1.5/8	6"	0.120
CO500-61/8	1/8	—	0.1250	1.5/8	6"	0.125
CO501-6N30	—	N30	0.1285	1.5/8	6"	0.129
CO501-6N29	—	N29	0.1360	1.3/4	6"	0.136
CO501-6N28	—	N28	0.1405	1.3/4	6"	0.141
CO500-69/64	9/64	—	0.1406	1.3/4	6"	0.141
CO501-6N27	—	N27	0.1440	1.7/8	6"	0.144
CO501-6N26	—	N26	0.1470	1.7/8	6"	0.147

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)
CO501-6N25	—	N25	0.1495	1.7/8	6"	0.149
CO501-6N24	—	N24	0.1520	2"	6"	0.152
CO501-6N23	—	N23	0.1540	2"	6"	0.154
CO500-65/32	5/32	—	0.1563	2"	6"	0.156
CO501-6N22	—	N22	0.1570	2"	6"	0.157
CO501-6N21	—	N21	0.1590	2.1/8	6"	0.159
CO501-6N20	—	N20	0.1610	2.1/8	6"	0.161
CO501-6N19	—	N19	0.1660	2.1/8	6"	0.166
CO501-6N18	—	N18	0.1695	2.1/8	6"	0.170
CO500-611/64	11/64	—	0.1719	2.1/8	6"	0.172
CO501-6N17	—	N17	0.1730	2.3/16	6"	0.173
CO501-6N16	—	N16	0.1770	2.3/16	6"	0.177
CO501-6N15	—	N15	0.1800	2.3/16	6"	0.180
CO501-6N14	—	N14	0.1820	2.3/16	6"	0.182
CO501-6N13	—	N13	0.1850	2.5/16	6"	0.185
CO500-63/16	3/16	—	0.1875	2.5/16	6"	0.188
CO501-6N12	—	N12	0.1890	2.5/16	6"	0.189
CO501-6N11	—	N11	0.1910	2.5/16	6"	0.191
CO501-6N10	—	N10	0.1935	2.7/16	6"	0.194
CO501-6N9	—	N9	0.1960	2.7/16	6"	0.196
CO501-6N8	—	N8	0.1990	2.7/16	6"	0.199
CO501-6N7	—	N7	0.2010	2.7/16	6"	0.201
CO500-613/64	13/64	—	0.2031	2.7/16	6"	0.203
CO501-6N6	—	N6	0.2040	2.1/2	6"	0.204
CO501-6N5	—	N5	0.2055	2.1/2	6"	0.205
CO501-6N4	—	N4	0.2090	2.1/2	6"	0.209
CO501-6N3	—	N3	0.2130	2.1/2	6"	0.213
CO500-67/32	7/32	—	0.2188	2.1/2	6"	0.219
CO501-6N2	—	N2	0.2210	2.5/8	6"	0.221
CO501-6N1	—	N1	0.2280	2.5/8	6"	0.228
CO500-615/64	15/64	—	0.2344	2.5/8	6"	0.234
CO500-61/4	1/4	—	0.2500	2.3/4	6"	0.250

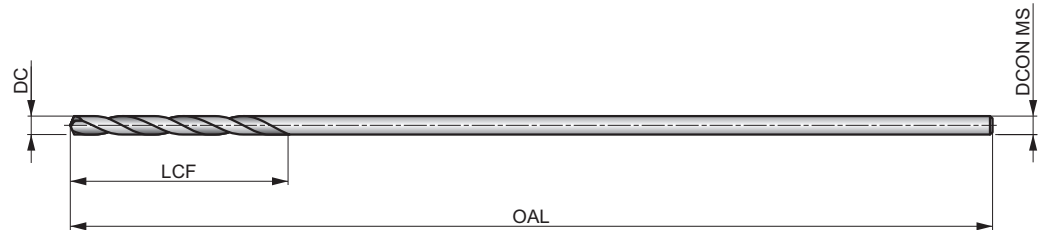
CO500-12/CO501-12

PRECISION



NAS 907 Type B HSS-E flyforlængerbor, 12 1/4" OAL

Ekstra lange seriebor fremstillet i henhold til National Aerospace Standards med ekstra lang totallængde kombineret med kort spånlængde gør dem ideelle til boring i svært tilgængelige områder. Koboltmaterialet, 135° spaltespids og bronzehærdet overfladefinish forbedrer værktøjets levetid ved boring i de fleste materialer.



HSS-E	NAS 907	4xD
135°	Bronze	
λ 20-35°	R	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 36 G	P1.2 40 G	P1.3 41 G	P2.1 31 G	P2.2 27 E	P2.3 24 D	P3.1 25 E	P3.2 20 E	P3.3 17 D	P4.1 15 E	P4.2 13 D	P4.3 10 B	M1.1 30 H	M1.2 26 H
M2.1 27 H	M2.2 22 H	M2.3 18 D	M3.1 13 F	M3.2 11 F	M3.3 10 D	M4.1 15 D	M4.2 13 D	K1.1 35 H	K1.2 26 H	K1.3 19 H	K2.1 27 F	K2.2 22 F	K2.3 18 D
K3.1 24 F	K3.2 18 F	K3.3 15 D	K4.1 22 F	K4.2 17 F	K4.3 12 D	K4.4 11 D	K4.5 9 D	K5.1 25 F	K5.2 19 F	K5.3 15 D	N1.1 32 I	N1.2 24 I	N1.3 16 H
N2.1 42 G	N2.2 37 G	N2.3 27 G	N3.1 54 G	N3.2 32 H	N3.3 16 E	N4.1 35 I	N4.2 26 G	N4.3 12 E	S1.3 6 D	S2.1 8 B	S2.2 7 B	S3.1 6 B	S3.2 5 B
S4.1 5 B	S4.2 4 B												

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
CO500-121/16	1/16	—	0.0625	7/8	12"	0.063
CO500-125/64	5/64	—	0.0781	1"	12"	0.078
CO500-123/32	3/32	—	0.0938	1.1/4	12"	0.094
CO501-12N40	—	N40	0.0980	1.3/8	12"	0.098
CO500-127/64	7/64	—	0.1094	1.1/2	12"	0.109
CO500-121/8	1/8	—	0.1250	1.5/8	12"	0.125
CO501-12N30	—	N30	0.1285	1.5/8	12"	0.129
CO501-12N29	—	N29	0.1360	1.3/4	12"	0.136
CO500-129/64	9/64	—	0.1406	1.3/4	12"	0.141
CO500-125/32	5/32	—	0.1563	2"	12"	0.156
CO501-12N21	—	N21	0.1590	2.1/8	12"	0.159

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
CO501-12N20	—	N20	0.1610	2.1/8	12"	0.161
CO500-1211/64	11/64	—	0.1719	2.1/8	12"	0.172
CO501-12N16	—	N16	0.1770	2.3/16	12"	0.177
CO500-123/16	3/16	—	0.1875	2.5/16	12"	0.188
CO501-12N11	—	N11	0.1910	2.5/16	12"	0.191
CO501-12N10	—	N10	0.1935	2.7/16	12"	0.194
CO500-1213/64	13/64	—	0.2031	2.7/16	12"	0.203
CO500-127/32	7/32	—	0.2188	2.1/2	12"	0.219
CO501-12N2	—	N2	0.2210	2.5/8	12"	0.221
CO500-1215/64	15/64	—	0.2344	2.5/8	12"	0.234
CO500-121/4	1/4	—	0.2500	2.3/4	12"	0.250

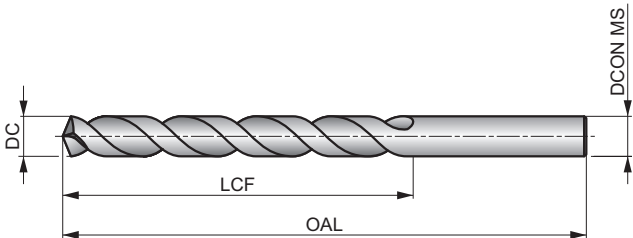
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PRECISION



NAS 907 Type J HSS-E Heavy Duty Jobber Drill, bronzehærdet overfladefinish, metriske størrelser

En virkelig god præstation, der producerer huller af præcis størrelse med en bedre finish. 135° selvcentrerende splitspids med lavt tryk for lettere gennemtrængning. Bronzehærdet overfladefinish forhindrer, at materiale fra arbejdsområdet klæber til boret skærekanten. Fremstillet i henhold til NAS 907 Type J Aerospace Standards.



HSS-E	DIN 338	4×D
135°	Bronze	
λ 20-35°	R	

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
36 H	40 H	41 H	31 H	27 G	24 E	25 F	20 F	17 E	15 F	13 E	10 D	30 E	26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1
27 E	22 E	18 C	13 G	11 G	10 C	15 C	35 H	26 D	19 D	27 E	22 E	18 E	24 E
K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1
18 E	15 E	22 E	17 E	12 E	11 E	9 E	25 E	19 E	15 E	33 J	25 J	17 I	46 H
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
42 H	30 H	68 H	40 F	20 H	28 F	20 D	11 C	9 E	8 B	7 E	6 B	5 E	5 B

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
2AC01.0	1.00	0.0394	12.0	34.0	1.00
2AC01.05	1.05	0.0413	12.0	34.0	1.05
2AC01.1	1.10	0.0433	14.0	36.0	1.10
2AC01.15	1.15	0.0453	14.0	36.0	1.15
2AC01.2	1.20	0.0472	16.0	38.0	1.20
2AC01.25	1.25	0.0492	16.0	38.0	1.25
2AC01.3	1.30	0.0512	16.0	38.0	1.30
2AC01.35	1.35	0.0531	18.0	40.0	1.35
2AC01.4	1.40	0.0551	18.0	40.0	1.40
2AC01.45	1.45	0.0571	18.0	40.0	1.45
2AC01.5	1.50	0.0591	18.0	40.0	1.50
2AC01.55	1.55	0.0610	20.0	43.0	1.55
2AC01.6	1.60	0.0630	20.0	43.0	1.60
2AC01.65	1.65	0.0650	20.0	43.0	1.65
2AC01.7	1.70	0.0669	20.0	43.0	1.70
2AC01.75	1.75	0.0689	22.0	46.0	1.75
2AC01.8	1.80	0.0709	22.0	46.0	1.80
2AC01.85	1.85	0.0728	22.0	46.0	1.85
2AC01.9	1.90	0.0748	22.0	46.0	1.90
2AC01.95	1.95	0.0768	24.0	49.0	1.95
2AC02.0	2.00	0.0787	24.0	49.0	2.00
2AC02.05	2.05	0.0807	24.0	49.0	2.05
2AC02.1	2.10	0.0827	24.0	49.0	2.10
2AC02.2	2.20	0.0866	27.0	53.0	2.20
2AC02.3	2.30	0.0906	27.0	53.0	2.30
2AC02.35	2.35	0.0925	27.0	53.0	2.35

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
2AC02.4	2.40	0.0945	30.0	57.0	2.40
2AC02.5	2.50	0.0984	30.0	57.0	2.50
2AC02.6	2.60	0.1024	30.0	57.0	2.60
2AC02.7	2.70	0.1063	33.0	61.0	2.70
2AC02.8	2.80	0.1102	33.0	61.0	2.80
2AC02.9	2.90	0.1142	33.0	61.0	2.90
2AC03.0	3.00	0.1181	33.0	61.0	3.00
2AC03.1	3.10	0.1220	36.0	65.0	3.10
2AC03.2	3.20	0.1260	36.0	65.0	3.20
2AC03.25	3.25	0.1280	36.0	65.0	3.25
2AC03.3	3.30	0.1299	36.0	65.0	3.30
2AC03.4	3.40	0.1339	39.0	70.0	3.40
2AC03.5	3.50	0.1378	39.0	70.0	3.50
2AC03.6	3.60	0.1417	39.0	70.0	3.60
2AC03.7	3.70	0.1457	39.0	70.0	3.70
2AC03.75	3.75	0.1476	39.0	70.0	3.75
2AC03.8	3.80	0.1496	43.0	75.0	3.80
2AC04.0	4.00	0.1575	43.0	75.0	4.00
2AC04.1	4.10	0.1614	43.0	75.0	4.10
2AC04.2	4.20	0.1654	43.0	75.0	4.20
2AC04.25	4.25	0.1673	43.0	75.0	4.25
2AC04.3	4.30	0.1693	47.0	80.0	4.30
2AC04.4	4.40	0.1732	47.0	80.0	4.40
2AC04.5	4.50	0.1772	47.0	80.0	4.50
2AC04.7	4.70	0.1850	47.0	80.0	4.70
2AC04.8	4.80	0.1890	52.0	86.0	4.80

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
2AC05.0	5.00	0.1969	52.0	86.0	5.00
2AC05.1	5.10	0.2008	52.0	86.0	5.10
2AC05.2	5.20	0.2047	52.0	86.0	5.20
2AC05.25	5.25	0.2067	52.0	86.0	5.25
2AC05.3	5.30	0.2087	52.0	86.0	5.30
2AC05.5	5.50	0.2165	57.0	93.0	5.50
2AC05.6	5.60	0.2205	57.0	93.0	5.60
2AC05.7	5.70	0.2244	57.0	93.0	5.70
2AC05.9	5.90	0.2323	57.0	93.0	5.90
2AC06.0	6.00	0.2362	57.0	93.0	6.00
2AC06.1	6.10	0.2402	63.0	101.0	6.10
2AC06.2	6.20	0.2441	63.0	101.0	6.20
2AC06.3	6.30	0.2480	63.0	101.0	6.30
2AC06.4	6.40	0.2520	63.0	101.0	6.40
2AC06.5	6.50	0.2559	63.0	101.0	6.50
2AC06.6	6.60	0.2598	63.0	101.0	6.60
2AC06.7	6.70	0.2638	63.0	101.0	6.70
2AC06.8	6.80	0.2677	69.0	109.0	6.80
2AC06.9	6.90	0.2717	69.0	109.0	6.90
2AC07.0	7.00	0.2756	69.0	109.0	7.00
2AC07.1	7.10	0.2795	69.0	109.0	7.10
2AC07.2	7.20	0.2835	69.0	109.0	7.20
2AC07.25	7.25	0.2854	69.0	109.0	7.25
2AC07.3	7.30	0.2874	69.0	109.0	7.30
2AC07.5	7.50	0.2953	69.0	109.0	7.50
2AC07.8	7.80	0.3071	75.0	117.0	7.80
2AC07.9	7.90	0.3110	75.0	117.0	7.90

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
2AC08.0	8.00	0.3150	75.0	117.0	8.00
2AC08.2	8.20	0.3228	75.0	117.0	8.20
2AC08.4	8.40	0.3307	75.0	117.0	8.40
2AC08.5	8.50	0.3346	75.0	117.0	8.50
2AC08.8	8.80	0.3465	81.0	125.0	8.80
2AC08.9	8.90	0.3504	81.0	125.0	8.90
2AC09.0	9.00	0.3543	81.0	125.0	9.00
2AC09.1	9.10	0.3583	81.0	125.0	9.10
2AC09.2	9.20	0.3622	81.0	125.0	9.20
2AC09.3	9.30	0.3661	81.0	125.0	9.30
2AC09.4	9.40	0.3701	81.0	125.0	9.40
2AC09.5	9.50	0.3740	81.0	125.0	9.50
2AC09.6	9.60	0.3780	87.0	133.0	9.60
2AC09.7	9.70	0.3819	87.0	133.0	9.70
2AC09.8	9.80	0.3858	87.0	133.0	9.80
2AC010.0	10.00	0.3937	87.0	133.0	10.00
2AC010.2	10.20	0.4016	87.0	133.0	10.20
2AC010.5	10.50	0.4134	87.0	133.0	10.50
2AC010.8	10.80	0.4252	94.0	142.0	10.80
2AC011.0	11.00	0.4331	94.0	142.0	11.00
2AC011.2	11.20	0.4409	94.0	142.0	11.20
2AC011.5	11.50	0.4528	94.0	142.0	11.50
2AC011.8	11.80	0.4646	94.0	142.0	11.80
2AC012.0	12.00	0.4724	101.0	151.0	12.00
2AC012.2	12.20	0.4803	101.0	151.0	12.20
2AC012.5	12.50	0.4921	101.0	151.0	12.50
2AC013.0	13.00	0.5118	101.0	151.0	13.00

Materiale kode (BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS	
Belægning	Bright	Bright	Bright	Bright	Bright	Bright	Bright	Bright	TiAlN	Bright	Bright	
Grundlæggende standard-gruppe (BSG)	DIN 334C	DIN 335C	DORMER	DIN 335A	ANSI	DIN 335C	DIN 335C	DIN 335C	DIN 335C	DORMER	DORMER	
Hånd (skæreretning)	R	R	R	R	R	R	R	R	R	R	R	
Skaft												
Anvendelsesvinkel	60°	82°	90°	90°		90°	90°	90°	90°	90°	90°	90°
Produktfamiliekode	G135	G154	G129	G132	B690	G142	G136	G106	G506	G107	G600	G236
PSF skærediametre række-vidde	6.30 - 25.00	6.30 - 25.00	6.00 - 31.50	8.00 - 20.00	1/4 - 1"	5.00 - 31.00	4.30 - 31.00	6.30 - 50.00	6.30 - 50.00	6.30 - 20.50	6.30 - 25.00	Set
	60	61	62	63	64	65	66	67	68	69	70	71
P	P1	■	■	■		■	■	■	■	■	■	
	P2	■	■	■	■	■	■	■	■	■	■	
	P3	■	■	■	■	■	■	■	■	■	■	
	P4	■	■		■		■	■	■	■	■	■
M	M1	■	■	■		■	■	■	■	■	■	
	M2	■	■	■		■	■	■	■	■	■	
	M3				■		■					
	M4				■		■					
K	K1	■	■	■	■	■		■	■	■	■	■
	K2	■	■	■	■	■		■	■	■	■	■
	K3	■	■	■	■	■		■	■	■	■	■
	K4				■				■	■	■	
	K5	■	■		■			■	■	■	■	■
N	N1	■	■	■	■	■	■	■	■	■	■	
	N2	■	■	■	■	■	■	■	■	■	■	
	N3	■	■	■	■	■	■	■	■	■	■	
	N4	■	■	■	■	■	■	■	■	■	■	
	N5											
S	S1											
	S2											
	S3											
	S4											
H	H1											
	H2											
	H3											
	H4											

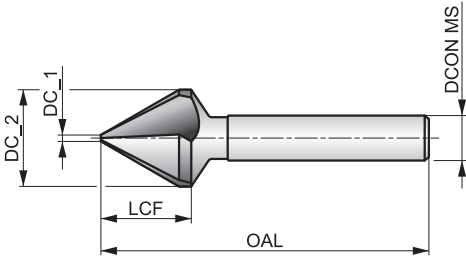
G135

DORMER



HSS lige skaft 60 ° forsænker, blank finish

Med en 60 ° vinkel til reifning af huller til fjernelse af grater fra borede huller i diametre op til 25,0 mm. Til brug i både maskine og håndholdt drift. Velegnet til reifning af huller i mange materialer.



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 23 E	P1.2 ■ 26 E	P1.3 ■ 27 E	P2.1 ■ 20 E	P2.2 ■ 18 D	P2.3 ▣ 16 B	P3.1 ■ 16 D	P3.2 ▣ 13 D	P3.3 ▣ 11 B	P4.1 ■ 10 D	P4.2 ▣ 8 B	M1.1 ▣ 8 C	M1.2 ▣ 6 C	M2.1 ▣ 7 C
M2.2 ▣ 6 C	K1.1 ▣ 20 F	K1.2 ▣ 15 D	K2.1 ▣ 21 C	K2.2 ▣ 17 C	K3.1 ▣ 18 C	K3.2 ▣ 14 C	K5.1 ▣ 19 C	K5.2 ▣ 15 C	N1.1 ▣ 40 G	N1.2 ■ 30 G	N1.3 ▣ 20 F	N2.1 ■ 20 F	N2.2 ▣ 18 F
N3.1 ■ 21 F	N3.2 ■ 12 F	N3.3 ▣ 6 D	N4.1 ▣ 40 G	N4.2 ▣ 35 G									

DCON MS tolerance h9.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1356.3	6.30	1.60	6.8	45.0	5.00	3
G1358.0	8.00	2.00	8.5	50.0	6.00	3
G13510.0	10.00	2.50	7.6	50.0	6.00	3
G13512.5	12.50	3.20	11.7	56.0	8.00	3
G13516.0	16.00	4.00	14.5	63.0	10.00	3
G13520.0	20.00	5.00	17.5	67.0	10.00	3
G13525.0	25.00	6.30	20.5	71.0	10.00	3

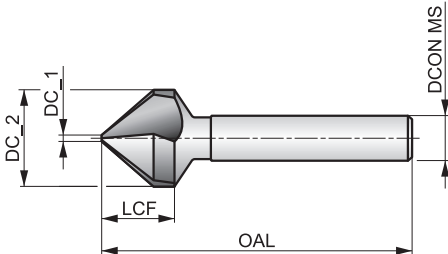
G154

DORMER



HSS lige skaft 82 ° forsænker, blank finish

En 82 ° forsænker til flade hovedskruer og til affasningshuller. Alsidigt værktøj, der kan bruges i både håndholdte og maskinapplikationer. Velegnet til affasning af huller i mange materialer.



HSS	Bright	DIN 335C
R		82°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 23 E	P1.2 ■ 26 E	P1.3 ■ 27 E	P2.1 ■ 20 E	P2.2 ■ 18 D	P2.3 ▣ 16 B	P3.1 ■ 16 D	P3.2 ■ 13 D	P3.3 ▣ 11 B	P4.1 ■ 10 D	P4.2 ▣ 8 B	M1.1 ▣ 8 C	M1.2 ▣ 6 C	M2.1 ▣ 7 C
M2.2 ▣ 6 C	K1.1 ▣ 20 F	K1.2 ▣ 15 D	K2.1 ▣ 21 C	K2.2 ▣ 17 C	K3.1 ▣ 18 C	K3.2 ▣ 14 C	K5.1 ▣ 14 C	K5.2 ▣ 10 C	N1.1 ▣ 40 G	N1.2 ■ 30 G	N1.3 ▣ 20 F	N2.1 ■ 20 F	N2.2 ▣ 18 F
N3.1 ■ 21 F	N3.2 ■ 12 F	N3.3 ▣ 6 D	N4.1 ▣ 40 G	N4.2 ▣ 35 G									

DCON MS tolerance h9.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1546.3	6.30	1.50	5.5	45.0	5.00	3
G1548.3	8.30	2.00	6.5	50.0	6.00	3
G15410.4	10.40	2.50	7.6	50.0	6.00	3
G15412.4	12.40	2.80	8.5	56.0	8.00	3
G15416.5	16.50	3.20	10.5	60.0	10.00	3
G15420.5	20.50	3.50	13.0	63.0	10.00	3
G15425.0	25.00	3.80	15.5	67.0	10.00	3

G129

DORMER



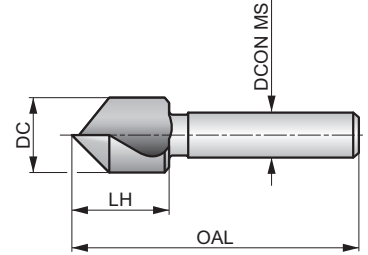
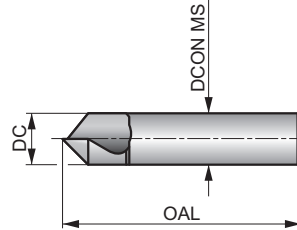
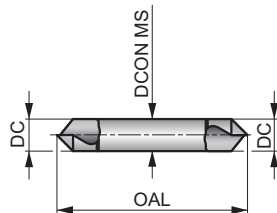
HSS lige skaft Enkelt skær 90 ° Forsænker, Blank Finish

En 90 ° forsænker med blank finish til reifning og til fjernelse af grater fra borede huller. Designet med et skær reducerer vibrationer og larm for en jævn affasningsoperation. Velegnet til reifning af huller i blødt stål og ikke-jernholdige materialer med mellemstyrke, såsom aluminium.

DC = 6 mm

DC = 8 mm

DC ≥ 10 mm



HSS	Bright	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 21 D	P1.2 ■ 24 D	P1.3 ■ 25 D	P2.1 ■ 18 D	P2.2 ■ 16 C	P2.3 ▣ 14 A	P3.1 ■ 13 B	P3.2 ▣ 11 B	M1.1 ▣ 8 B	M1.2 ▣ 6 B	M2.1 ▣ 7 B	K1.1 ▣ 18 D	K1.2 ▣ 13 C	K2.1 ▣ 19 A
K2.2 ▣ 15 A	K3.1 ▣ 16 A	K3.2 ▣ 12 A	N1.1 ■ 34 D	N1.2 ■ 25 D	N1.3 ▣ 16 C	N2.1 ▣ 16 C	N2.2 ▣ 14 C	N3.1 ■ 17 C	N3.2 ■ 9 C	N3.3 ▣ 5 B	N4.1 ▣ 35 D	N4.2 ▣ 30 D	

DCON MS tolerance h9.

Product	DC	LH	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	
G1296.0	6.00	—	45.0	6.00	1
G1298.0	8.00	—	50.0	8.00	1
G12910.0	10.00	17.0	49.0	8.00	1
G12912.5	12.50	17.0	49.0	8.00	1
G12916.0	16.00	20.0	56.0	10.00	1
G12920.0	20.00	24.0	60.0	10.00	1
G12925.0	25.00	25.0	75.0	12.00	1
G12931.5	31.50	29.0	80.0	12.00	1

G132

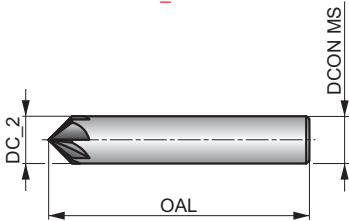
DORMER



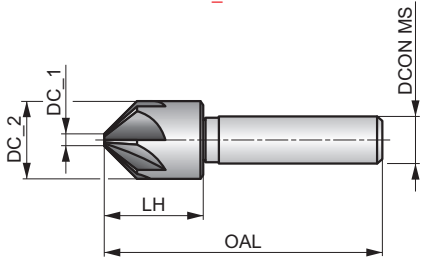
HSS Lige skaft Multi-Flute 90 ° forsænker, blank finish

En 90 ° forsænker designet til reifning af huller og rense grater fra borede huller. Flere skær for at reducere larm og vibrationer, hvilket giver en jævn reifning. Alsidigt værktøj til brug i håndholdte applikationer og maskiner. Velegnet til reifning af huller i mange materialer.

DC_2 = 8 mm



DC_2 ≥ 12.5 mm



HSS

Bright

DIN 335A

R

90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P2.2 18 E	P2.3 16 D	P3.2 13 D	P3.3 11 B	P4.1 10 D	P4.2 8 C	P4.3 7 B	M3.3 3 A	M4.1 4 A	K1.1 20 F	K1.2 15 D	K1.3 11 D	K2.2 17 C	K2.3 14 D
K3.1 18 E	K3.2 14 E	K3.3 11 D	K4.1 17 C	K4.2 13 C	K5.1 19	K5.2 15	K5.3 11 D	N1.3 20 F	N2.3 13 F	N3.2 12 F	N4.3 5 G		

DCON MS tolerance h9.

Product	DC_2	DC_1	LH	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1328.0	8.00	—	—	48.0	8.00	5
G13212.5	12.50	2.00	15.5	48.0	8.00	5
G13216.0	16.00	3.20	19.5	56.0	10.00	7
G13220.0	20.00	5.00	23.0	60.0	10.00	7

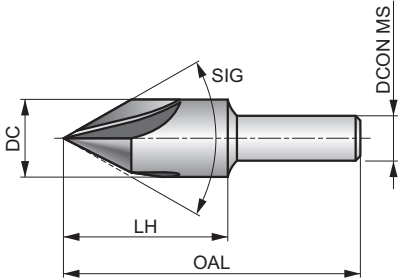
B690





HSS-fræser med lige skaft, 60°, 82°, 90° eller 100° undersækningsvinkler

Bruges primært til at remme centerborede huller, drejecentre i aksler og undersækningsvinkler til skruehoveder og nitter. Fås i 60°, 82°, 90° eller 100° undersækningsvinkler. Det ujævne antal riller fremmer en glat finish ved at eliminere slør og samtidig forbedre nøjagtigheden.



HSS	Bright	ANSI
R		60-100°

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	M1.1	M1.2	M2.1	K1.1	K1.2	K2.1
■ 21 D	■ 24 D	■ 25 D	■ 18 D	■ 16 C	▣ 14 A	■ 13 B	▣ 11 B	▣ 8 B	▣ 6 B	▣ 7 B	▣ 18 D	▣ 13 C	▣ 19 A
▣ 15 A	▣ 16 A	▣ 12 A	■ 34 D	■ 25 D	■ 16 C	▣ 16 C	▣ 14 C	■ 17 C	■ 9 C	▣ 5 B	▣ 35 D	▣ 30 D	

Product	DC	DC	SIG	DCON MS	OAL	NOF
	(inch)	(inch)	(°)	(inch)	(inch)	
B6901/4X60	1/4	0.2500	60	3/16	1.1/2	3
B6901/4X82	1/4	0.2500	82	3/16	1.1/2	3
B6901/4X90	1/4	0.2500	90	3/16	1.1/2	3
B6901/4X100	1/4	0.2500	100	3/16	1.1/2	3
B6903/8X60	3/8	0.3750	60	1/4	1.3/4	3
B6903/8X82	3/8	0.3750	82	1/4	1.3/4	3
B6903/8X90	3/8	0.3750	90	1/4	1.3/4	3
B6903/8X100	3/8	0.3750	100	1/4	1.3/4	3
B6901/2X60	1/2	0.5000	60	3/8	2"	3
B6901/2X82	1/2	0.5000	82	3/8	2"	3
B6901/2X90	1/2	0.5000	90	3/8	2"	3
B6901/2X100	1/2	0.5000	100	3/8	2"	3

Product	DC	DC	SIG	DCON MS	OAL	NOF
	(inch)	(inch)	(°)	(inch)	(inch)	
B6905/8X60	5/8	0.6250	60	3/8	2.1/4	3
B6905/8X82	5/8	0.6250	82	3/8	2.1/4	3
B6905/8X90	5/8	0.6250	90	3/8	2.1/4	3
B6905/8X100	5/8	0.6250	100	3/8	2.1/4	3
B6903/4X60	3/4	0.7500	60	1/2	2.5/8	3
B6903/4X82	3/4	0.7500	82	1/2	2.5/8	3
B6903/4X90	3/4	0.7500	90	1/2	2.5/8	3
B6903/4X100	3/4	0.7500	100	1/2	2.5/8	3
B6901X60	1"	1.0000	60	1/2	3"	3
B6901X82	1"	1.0000	82	1/2	3"	3
B6901X90	1"	1.0000	90	1/2	3"	3
B6901X100	1"	1.0000	100	1/2	3"	3

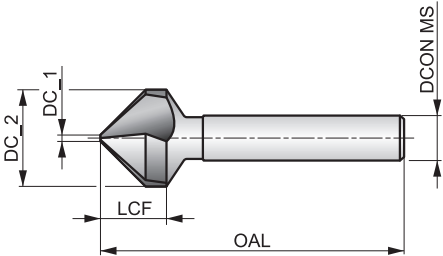
G142





HSS lige skaft, 90 ° forsænker, blank finish, til rustfrit stål

En 90 ° forsænker designet til reifning af huller og til rengøring af grater fra borede huller. Ekstra radiel frigang for at give en skarpere kant, hvilket forbedrer ydeevnen ved bearbejdning af klæbrige materialer, såsom rustfrit stål og ikke-jernholdige materialer. Kan bruges i håndholdte applikationer og maskiner.



HSS	Bright	DIN 335C
R		90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	▣ 16 B	■ 16 D	■ 13 D	▣ 11 B	■ 10 D	▣ 8 B	■ 11 C	■ 9 C	■ 10 C
M2.2	M3.1	M3.2	M4.1	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1
▣ 8 C	■ 7 B	▣ 6 B	▣ 4 A	■ 40 G	■ 30 G	▣ 20 F	▣ 20 F	▣ 18 F	▣ 20 F	■ 34 F	■ 20 F	■ 10 D	■ 40 G
N4.2													
■ 35 G													

DCON MS tolerance h9.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1425.0	5.00	1.50	4.5	40.0	4.00	3
G1426.3	6.30	1.50	5.5	45.0	5.00	3
G1428.0	8.00	2.00	6.1	50.0	6.00	3
G1428.3	8.30	2.00	6.5	50.0	6.00	3
G14210.0	10.00	2.50	7.6	50.0	6.00	3
G14210.4	10.40	2.50	7.6	50.0	6.00	3
G14212.4	12.40	2.80	8.5	56.0	8.00	3
G14215.0	15.00	3.20	9.5	60.0	10.00	3
G14216.5	16.50	3.20	10.5	60.0	10.00	3
G14220.5	20.50	3.50	13.0	63.0	10.00	3
G14223.0	23.00	3.80	13.7	67.0	10.00	3
G14225.0	25.00	3.80	15.5	67.0	10.00	3
G14231.0	31.00	4.20	18.5	71.0	12.00	3

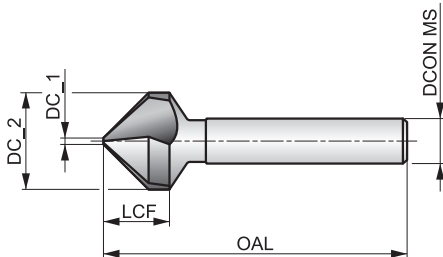
G136

 DORMER



HSS lige skaft 90 ° forsænker, blank finish

En 90 ° forsænker designet til at reife huller og til at fjerne grater fra borede huller. Reduceret skaft muliggør forsænkninger med større diameter i standardholdere og borepatroner. Alsidigt værktøj, som kan bruges i håndholdte applikationer og maskiner. Velegnet til reifning af huller i mange materialer.



HSS	Bright	DIN 335C
R		90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 23 E	P1.2 ■ 26 E	P1.3 ■ 27 E	P2.1 ■ 20 E	P2.2 ■ 18 D	P2.3 ▣ 16 B	P3.1 ■ 16 D	P3.2 ■ 13 D	P3.3 ▣ 11 B	P4.1 ■ 10 D	P4.2 ▣ 8 B	M1.1 ▣ 8 C	M1.2 ▣ 6 C	M2.1 ▣ 7 C
M2.2 ▣ 6 C	K1.1 ▣ 20 F	K1.2 ▣ 15 D	K2.1 ▣ 21 C	K2.2 ▣ 17 C	K3.1 ▣ 18 C	K3.2 ▣ 14 C	K5.1 ▣ 19 C	K5.2 ▣ 15 C	N1.1 ▣ 40 G	N1.2 ■ 30 G	N1.3 ▣ 20 F	N2.1 ■ 20 F	N2.2 ▣ 18 F
N3.1 ■ 21 F	N3.2 ■ 12 F	N3.3 ▣ 6 D	N4.1 ▣ 40 G	N4.2 ▣ 35 G									

DCON MS tolerance h9.
Produkter fra denne serie fås også i sæt. Se G236.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1364.3	4.30	1.30	4.0	40.0	4.00	3
G1365.0	5.00	1.50	4.5	40.0	4.00	3
G1365.3	5.30	1.50	4.5	40.0	4.00	3
G1365.8	5.80	1.50	5.0	45.0	5.00	3
G1366.0	6.00	1.50	5.0	45.0	5.00	3
G1366.3	6.30	1.50	5.5	45.0	5.00	3
G1367.0	7.00	1.80	5.5	50.0	6.00	3
G1367.3	7.30	1.80	6.1	50.0	6.00	3
G1368.0	8.00	2.00	6.1	50.0	6.00	3
G1368.3	8.30	2.00	6.5	50.0	6.00	3
G1369.4	9.40	2.20	7.2	50.0	6.00	3
G13610.0	10.00	2.50	7.6	50.0	6.00	3
G13610.4	10.40	2.50	7.6	50.0	6.00	3

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G13611.5	11.50	2.80	8.0	56.0	8.00	3
G13612.4	12.40	2.80	8.5	56.0	8.00	3
G13613.4	13.40	2.90	9.0	56.0	8.00	3
G13615.0	15.00	3.20	9.5	60.0	10.00	3
G13616.5	16.50	3.20	10.5	60.0	10.00	3
G13619.0	19.00	3.50	11.7	63.0	10.00	3
G13620.5	20.50	3.50	13.0	63.0	10.00	3
G13623.0	23.00	3.80	13.7	67.0	10.00	3
G13625.0	25.00	3.80	15.5	67.0	10.00	3
G13626.0	26.00	3.80	15.5	67.0	10.00	3
G13628.0	28.00	4.00	16.5	71.0	12.00	3
G13630.0	30.00	4.20	18.5	71.0	12.00	3
G13631.0	31.00	4.20	18.5	71.0	12.00	3

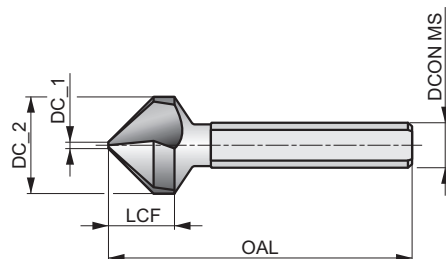
G106

DORMER



HSS 3-fladet lige skaft 90° forsænker, Blank finish

En 90° forsænker designet til reifning af huller og fjernelse af grater fra borede huller. Skaft med tre flader giver forbedret fastgørelse i borepatron. Velegnet til reifning af huller i mange materialer.



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

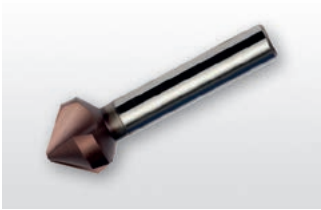
P1.1 ■ 23 E	P1.2 ■ 26 E	P1.3 ■ 27 E	P2.1 ■ 20 E	P2.2 ■ 18 D	P2.3 ▣ 16 B	P3.1 ■ 16 D	P3.2 ■ 13 D	P3.3 ▣ 11 B	P4.1 ■ 10 D	P4.2 ▣ 8 B	M1.1 ▣ 8 C	M1.2 ▣ 6 C	M2.1 ▣ 7 C
M2.2 ▣ 6 C	K1.1 ■ 20 F	K1.2 ■ 15 D	K2.1 ▣ 21 C	K2.2 ▣ 17 C	K3.1 ▣ 18 C	K3.2 ▣ 14 C	K5.1 ▣ 19 C	K5.2 ▣ 15 C	N1.1 ▣ 40 G	N1.2 ■ 30 G	N1.3 ▣ 20 F	N2.1 ▣ 20 F	N2.2 ▣ 18 F
N3.1 ■ 21 F	N3.2 ▣ 12 F	N3.3 ▣ 6 D	N4.1 ▣ 40 G	N4.2 ▣ 35 G									

DCON MS tolerance h9.
Produkter fra denne serie fås også i sæt. Se G236.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1066.3	6.30	1.50	5.6	45.0	5.00	3
G1068.3	8.30	2.00	6.9	50.0	6.00	3
G10610.4	10.40	2.50	7.8	50.0	6.00	3
G10612.4	12.40	2.80	8.6	56.0	8.00	3
G10616.5	16.50	3.20	11.1	60.0	10.00	3
G10620.5	20.50	3.50	12.9	63.0	10.00	3
G10625.0	25.00	3.80	15.7	67.0	10.00	3
G10631.0	31.00	4.20	18.5	71.0	12.00	3
G10634.0	34.00	4.50	19.0	103.0	16.00	3
G10637.0	37.00	4.50	21.2	118.0	16.00	3
G10640.0	40.00	4.50	20.0	118.0	16.00	3
G10650.0	50.00	5.00	23.6	126.0	16.00	3

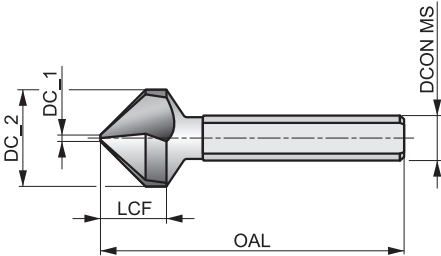
G506

 DORMER



HSS 3-Fladet lige skaft 90 ° Forsænker, TiAlN belagt

En 90 ° forsænker designet til reifning af huller og fjernelse af grater fra borede huller. Skaft med tre slebet flader giver forbedret hold i borepatron, især når det bruges i håndholdt elværktøj. TiAlN-belægning forlænger værktøjets levetid. Velegnet til reifning af huller i mange materialer.



HSS

 TiAlN

DIN 335C

 R



90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 40 E	■ 45 E	■ 46 E	■ 34 E	■ 30 D	■ 27 B	■ 28 D	■ 22 D	■ 19 B	■ 16 D	■ 14 B	▣ 11 B	▣ 11 C	▣ 9 C
M2.1	M2.2	M2.3	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2
▣ 10 C	▣ 9 C	▣ 8 B	■ 41 F	■ 30 D	▣ 23 D	■ 42 C	■ 34 C	▣ 27 C	■ 37 C	■ 28 C	▣ 23 C	▣ 34 C	▣ 26 C
K4.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1
▣ 19 C	■ 39 C	■ 29 C	▣ 23 C	▣ 60 G	▣ 45 G	■ 30 F	■ 30 F	■ 27 F	■ 19 F	■ 32 F	■ 18 F	▣ 19 D	▣ 62 G
N4.2													
▣ 55 G													

DCON MS tolerance h9.
Produkter fra denne serie fås også i sæt. Se G236.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G5066.3	6.30	1.50	5.6	45.0	5.00	3
G5068.3	8.30	2.00	6.9	50.0	6.00	3
G50610.4	10.40	2.50	7.8	50.0	6.00	3
G50612.4	12.40	2.80	8.6	56.0	8.00	3
G50616.5	16.50	3.20	11.1	60.0	10.00	3
G50620.5	20.50	3.50	12.9	63.0	10.00	3
G50625.0	25.00	3.80	15.7	67.0	10.00	3
G50631.0	31.00	4.20	18.5	71.0	12.00	3
G50637.0	37.00	4.50	21.2	118.0	16.00	3
G50640.0	40.00	4.50	20.0	118.0	16.00	3
G50650.0	50.00	5.00	23.6	126.0	16.00	3

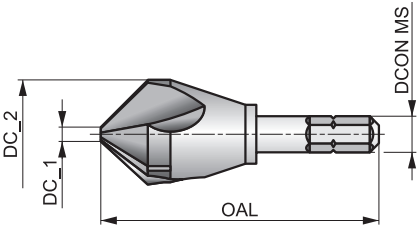
G107





HSS-E Hexagon 90 ° forsænker, blank finish

En alsidig forsænker med et sekskantet skaft, der gør det lettere at holde med elektriske skruetrækkeradaptre. 90 ° -reifer producerer affasninger til standard og rene grater fra borede huller. Velegnet til affasning af huller i mange materialer.



HSS-E

Bright









Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 23 E	P1.2 ■ 26 E	P1.3 ■ 27 E	P2.1 ■ 20 E	P2.2 ■ 18 D	P2.3 ▣ 16 B	P3.1 ■ 16 D	P3.2 ■ 13 D	P3.3 ▣ 11 B	P4.1 ■ 10 D	P4.2 ▣ 8 B	M1.1 ▣ 11 C	M1.2 ▣ 9 C	M2.1 ▣ 10 C
M2.2 ▣ 9 C	M2.3 ▣ 8 B	K1.1 ■ 20 F	K1.2 ▣ 15 D	K2.1 ■ 21 C	K2.2 ▣ 17 C	K3.1 ■ 18 C	K3.2 ▣ 14 C	K4.1 ▣ 15 C	K5.1 ■ 19 C	K5.2 ▣ 15 C	N1.1 ▣ 40 G	N1.2 ■ 30 G	N1.3 ▣ 20 F
N2.1 ▣ 20 F	N2.2 ▣ 18 F	N2.3 ▣ 20 F	N3.1 ■ 21 F	N3.2 ▣ 12 F	N3.3 ▣ 6 D	N4.1 ▣ 40 G	N4.2 ▣ 35 G						

6,35; 1/4" sekskantskaft; DIN 74.

Product	DC_2	DC_1	OAL	DCON MS	CZC MS	NOF
	(mm)	(mm)	(mm)	(inch)		
G1076.3	6.30	1.50	50.0	1/4"	M2-M3	3
G10710.4	10.40	2.50	50.0	1/4"	M5	3
G10712.4	12.40	2.80	50.0	1/4"	M6	3
G10716.5	16.50	3.20	50.0	1/4"	M8	3
G10720.5	20.50	3.50	50.0	1/4"	M10	3

G600



HSS forsænker lige skaft Lang rækkevidde 90 ° forsænket, blank finish

Det udvidede skaft giver mulighed for at affase huller i områder, der er svære at nå. 90 ° -forsækningen producerer affasninger til standardforsækning og rene grater fra borede huller. Velegnet til reifning af huller i mange materialer.

HSS

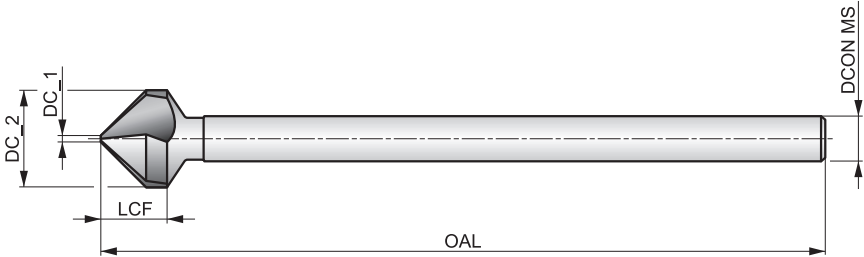
Bright











Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 20 E	P1.2 ■ 22 E	P1.3 ■ 23 E	P2.1 ■ 17 E	P2.2 ■ 15 D	P2.3 ▣ 13 B	P3.1 ■ 12 D	P3.2 ■ 9 D	P3.3 ▣ 8 B	P4.1 ■ 7 D	P4.2 ▣ 6 B	M1.1 ▣ 8 C	M1.2 ▣ 6 C	M2.1 ▣ 7 C
M2.2 ▣ 6 C	K1.1 ■ 17 E	K1.2 ▣ 12 C	K2.1 ▣ 18 B	K2.2 ▣ 14 B	K3.1 ▣ 15 B	K3.2 ▣ 11 B	K5.1 ▣ 16 B	K5.2 ▣ 12 B	N1.1 ▣ 35 G	N1.2 ▣ 25 G	N1.3 ▣ 15 F	N2.1 ▣ 15 F	N2.2 ▣ 13 F
N3.1 ■ 16 E	N3.2 ▣ 10 E	N3.3 ▣ 5 C											

DCON MS tolerance h9.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G6006.3	6.30	1.30	5.6	154.0	5.00	3
G6008.3	8.30	1.80	6.9	155.0	6.00	3
G60010.4	10.40	2.20	7.8	157.0	6.00	3
G60012.4	12.40	2.50	8.6	158.0	8.00	3
G60015.0	15.00	2.80	10.3	159.0	10.00	3
G60016.5	16.50	2.80	11.1	161.0	10.00	3
G60020.5	20.50	3.00	12.9	164.0	10.00	3
G60025.0	25.00	3.20	15.7	168.0	10.00	3

G236



Sæt af forsænkere i en cylindrisk plasttromle

Sæt, der indeholder forskellige størrelser af forskellige 90 ° forsænkere. Der er 5 forskellige sæt, enten med G106, G136 eller G560. Velegnet til mange materialer.



A = forskellige i sæt, B = nej. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
G2361	1	G136	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm
G2362	2	G136	4	6.30 mm, 10.40 mm, 16.50 mm, 20.50 mm
G2363	3	G560	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm
G2364	4	G106	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm
G2365	5	G506	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm

Materiale kode (BMC)	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS
Belægning													
Grundlæggende standard-gruppe (BSG)	DIN 206	ANSI	ANSI	ANSI	BS 328	DIN 2179	DIN 9	DIN 9	ANSI	ANSI	ANSI	ANSI	ANSI
Hånd (skæreretning)													
Skaft													
Rival form	B				A		A	B					
Opnåelig hultolerance (TCHA)	H7												
Konisk stigning - millimeter					1:48	1:50	1:50	1:50	1:48	1:48	1:48		
Produktfamiliekode	B100	B610	B620	B650	B301	B953	B903	B952	B630	B660	B670	B680	B122
PSF skærediametre rækkevidde	1.50 - 40.00	N60 - 1.1/2	1/16 - 1"	1/8 - 1"	3/32 - 1/2	2.00 - 12.00	1.50 - 20.00	1.20 - 40.00	7/0 - N10	N0 - N10	N0 - N10	1/8 - 1"	3/8 - 1"
P	P1	■	■	■	■	■	■	■	■	■	■	■	■
	P2	■	■	■	■	■	■	■	■	■	■	■	■
	P3	▣	■	■	■	■	▣	■	■	■	■	■	▣
	P4	▣	■	■	▣	▣	▣	▣	■	▣	▣	▣	■
M	M1	▣	▣	▣	▣	▣	▣	▣	▣	▣	▣	▣	▣
	M2	▣	▣	▣	▣	▣	▣	▣	▣	▣	▣	▣	▣
	M3												
	M4												
K	K1	■	■	■	■	■	▣	▣	■	■	■	■	
	K2	▣	■	■	■	■	■	■	■	■	■	■	
	K3	■	▣	▣	■	▣	▣	▣	■	■	■	■	
	K4												
	K5												
N	N1	■	▣	■	■	■	▣	■	■	■	■	■	▣
	N2	■	▣	■	■	■	■	■	■	■	■	■	▣
	N3	■	■	■	■	■	▣	■	■	■	■	■	■
	N4	▣	▣		▣	▣	▣	▣	▣	▣	▣	▣	▣
	N5												
S	S1												
	S2												
	S3												
	S4												
H	H1												
	H2												
	H3												
	H4												

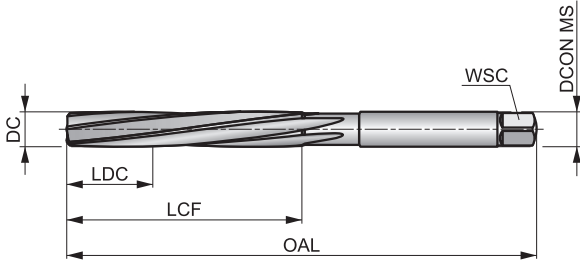
B100

 DORMER



HSS Lige Skaft Hånd Rival med H7-tolerance, blank og ST-finish

Primært designet til rivning i hånden. Den har en præcisionspunkt, venstre spiral med højre (med uret) skæring for jævn rivning, hvilket skaber en mere nøjagtig hulstørrelse og god overfladefinish. Velegnet til rivning af mange materialer, herunder stål.



HSS		DIN 206
		B
H7		

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
■	■	■	■	■	■								

DCON MS tolerance e9.

Product	DC	DC	OAL	LCF	LDC	NOF	WSC	DCON MS
	(inch)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B1001.5	—	1.50	41.0	20.0	5.00	3	1.12	1.50
B1002.0	—	2.00	50.0	25.0	6.00	4	1.60	2.00
B1003/32	3/32	2.38	54.0	27.0	7.00	4	1.80	2.38
B1002.5	—	2.50	58.0	29.0	7.00	4	2.10	2.50
B1003.0	—	3.00	62.0	31.0	8.00	6	2.40	3.00
B1001/8	1/8	3.18	66.0	33.0	8.00	6	2.40	3.18
B1003.2	—	3.20	66.0	33.0	8.00	6	2.40	3.20
B1003.5	—	3.50	71.0	35.0	9.00	6	2.70	3.50
B1005/32	5/32	3.97	76.0	38.0	10.00	6	3.00	3.97
B1004.0	—	4.00	76.0	38.0	10.00	6	3.00	4.00
B1004.5	—	4.50	81.0	41.0	10.00	6	3.40	4.50
B1003/16	3/16	4.76	87.0	44.0	11.00	6	3.80	4.76
B1005.0	—	5.00	87.0	44.0	11.00	6	3.80	5.00
B1005.5	—	5.50	93.0	47.0	12.00	6	4.30	5.50
B1007/32	7/32	5.56	93.0	47.0	12.00	6	4.30	5.56
B1006.0	—	6.00	93.0	47.0	12.00	6	4.90	6.00
B1001/4	1/4	6.35	100.0	50.0	13.00	6	4.90	6.35
B1006.5	—	6.50	100.0	50.0	13.00	6	4.90	6.50
B10017/64	17/64	6.75	107.0	54.0	14.00	6	5.50	6.75
B1007.0	—	7.00	107.0	54.0	14.00	6	5.50	7.00
B1009/32	9/32	7.14	107.0	54.0	14.00	6	6.20	7.14
B1007.5	—	7.50	107.0	54.0	14.00	6	6.20	7.50
B1005/16	5/16	7.94	115.0	58.0	15.00	6	6.20	7.94
B1008.0	—	8.00	115.0	58.0	15.00	6	6.20	8.00
B10021/64	21/64	8.33	115.0	58.0	15.00	6	7.00	8.33
B1008.5	—	8.50	115.0	58.0	15.00	6	7.00	8.50
B10011/32	11/32	8.73	124.0	62.0	16.00	6	7.00	8.73

Product	DC	DC	OAL	LCF	LDC	NOF	WSC	DCON MS
	(inch)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B1009.0	—	9.00	124.0	62.0	16.00	6	7.00	9.00
B1009.5	—	9.50	124.0	62.0	16.00	6	8.00	9.50
B1003/8	3/8	9.52	124.0	62.0	17.00	6	8.00	9.52
B10010.0	—	10.00	133.0	66.0	17.00	6	8.00	10.00
B10013/32	13/32	10.32	133.0	66.0	17.00	6	8.00	10.32
B10010.5	—	10.50	133.0	66.0	17.00	6	8.00	10.50
B10011.0	—	11.00	142.0	71.0	18.00	6	9.00	11.00
B1007/16	7/16	11.11	142.0	71.0	18.00	6	9.00	11.11
B10011.5	—	11.50	142.0	71.0	18.00	6	9.00	11.50
B10012.0	—	12.00	152.0	76.0	19.00	6	9.00	12.00
B10012.5	—	12.50	152.0	76.0	19.00	6	10.00	12.50
B1001/2	1/2	12.70	152.0	76.0	19.00	6	10.00	12.70
B10013.0	—	13.00	152.0	76.0	19.00	6	10.00	13.00
B10013.5	—	13.50	163.0	81.0	20.00	8	11.00	13.50
B10014.0	—	14.00	163.0	81.0	20.00	8	11.00	14.00
B1009/16	9/16	14.29	163.0	81.0	20.00	8	11.00	14.29
B10014.5	—	14.50	163.0	81.0	20.00	8	11.00	14.50
B10015.0	—	15.00	163.0	81.0	20.00	8	12.00	15.00
B1005/8	5/8	15.88	175.0	87.0	22.00	8	12.00	15.88
B10016.0	—	16.00	175.0	87.0	22.00	8	12.00	16.00
B10017.0	—	17.00	175.0	87.0	22.00	8	13.00	17.00
B10018.0	—	18.00	188.0	93.0	23.00	8	14.50	18.00
B10019.0	—	19.00	188.0	93.0	23.00	8	14.50	19.00
B1003/4	3/4	19.05	188.0	93.0	25.00	8	14.50	19.05
B10020.0	—	20.00	201.0	100.0	25.00	8	16.00	20.00
B10021.0	—	21.00	201.0	100.0	25.00	8	16.00	21.00
B10022.0	—	22.00	215.0	107.0	27.00	8	18.00	22.00
B1007/8	7/8	22.22	215.0	107.0	27.00	8	18.00	22.22
B10023.0	—	23.00	215.0	107.0	27.00	8	18.00	23.00
B10024.0	—	24.00	231.0	115.0	29.00	8	18.00	24.00
B10025.0	—	25.00	231.0	115.0	29.00	8	20.00	25.00
B1001	1"	25.40	231.0	115.0	29.00	8	20.00	25.40
B10026.0	—	26.00	231.0	115.0	29.00	8	20.00	26.00
B10028.0	—	28.00	247.0	124.0	31.00	10	22.00	28.00
B10030.0	—	30.00	247.0	124.0	31.00	10	24.00	30.00
B10032.0	—	32.00	265.0	133.0	33.00	10	24.00	32.00
B10035.0	—	35.00	284.0	142.0	36.00	10	29.00	35.00
B10040.0	—	40.00	305.0	152.0	38.00	10	32.00	40.00

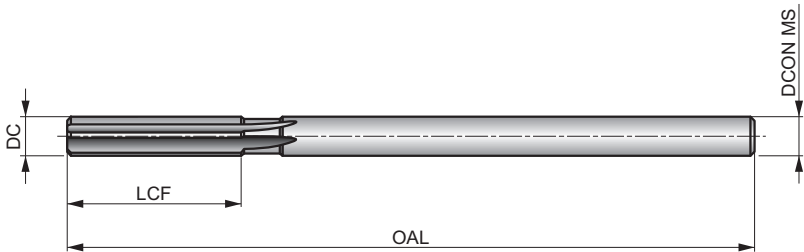
B610





HSS-fræser med lige skaft og lige fløjter, blank finish

De alsidige borehamre til generelle formål har kortere og dybere riller end håndbor og er designet til effektiv maskinfræsning af de fleste materialer. Et stort udvalg af størrelser er tilgængeligt, herunder brøkdeler, trådmål, bogstaver og inkrementelle decimalstørrelser produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 19 C	P1.2 22 C	P1.3 23 C	P2.1 16 C	P2.2 14 C	P2.3 12 B	P3.1 11 B	P3.2 9 B	P3.3 7 A	P4.1 5 B	P4.2 4 A	P4.3 3	M1.1 9 C	M1.2 8 B
M2.1 7 B	K1.1 14 E	K1.2 10 D	K1.3 7 D	K2.1 14 C	K2.2 11 C	K2.3 9 C	K3.1 12 C	K3.2 9 C	N1.1 22 F	N1.2 16 F	N1.3 9 F	N2.1 25 E	N2.2 22 E
N2.3 14 E	N3.1 45 D	N3.2 26 E	N3.3 12 D	N4.1 28 B									

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B610N60	—	N60	0.0400	0.039	1/2	2.1/2	4
B610N59	—	N59	0.0410	0.039	1/2	2.1/2	4
B610N58	—	N58	0.0420	0.039	1/2	2.1/2	4
B610N57	—	N57	0.0430	0.039	1/2	2.1/2	4
B610N56	—	N56	0.0465	0.045	1/2	2.1/2	4
B6103/64	3/64	—	0.0469	0.045	1/2	2.1/2	4
B610N55	—	N55	0.0520	0.051	1/2	2.1/2	4
B610N54	—	N54	0.0550	0.051	1/2	2.1/2	4
B610N53	—	N53	0.0595	0.059	1/2	2.1/2	4
B6101/16	1/16	—	0.0625	0.059	1/2	2.1/2	4
B610N52	—	N52	0.0635	0.059	1/2	2.1/2	4
B610N51	—	N51	0.0670	0.066	3/4	3"	4
B610N50	—	N50	0.0700	0.066	3/4	3"	4
B610N49	—	N49	0.0730	0.066	3/4	3"	4
B610N48	—	N48	0.0760	0.072	3/4	3"	4
B6105/64	5/64	—	0.0781	0.072	3/4	3"	4
B610N47	—	N47	0.0785	0.072	3/4	3"	4
B610N46	—	N46	0.0810	0.077	3/4	3"	4
B610N45	—	N45	0.0820	0.077	3/4	3"	4
B610N44	—	N44	0.0860	0.081	3/4	3"	4
B610N43	—	N43	0.0890	0.081	3/4	3"	4
B610N42	—	N42	0.0935	0.088	3/4	3"	4
B6103/32	3/32	—	0.0938	0.088	3/4	3"	4
B610N41	—	N41	0.0960	0.093	7/8	3.1/2	4
B610N40	—	N40	0.0980	0.093	7/8	3.1/2	4
B610N39	—	N39	0.0995	0.093	7/8	3.1/2	4
B610N38	—	N38	0.1015	0.095	7/8	3.1/2	4
B610N37	—	N37	0.1040	0.095	7/8	3.1/2	4

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B610N36	—	N36	0.1065	0.103	7/8	3.1/2	4
B6107/64	7/64	—	0.1094	0.103	7/8	3.1/2	4
B610N35	—	N35	0.1100	0.103	7/8	3.1/2	4
B610N34	—	N34	0.1110	0.105	7/8	3.1/2	4
B610N33	—	N33	0.1130	0.105	7/8	3.1/2	4
B610N32	—	N32	0.1160	0.112	7/8	3.1/2	4
B610N31	—	N31	0.1200	0.112	7/8	3.1/2	4
B610.1230	—	—	0.1230	0.112	7/8	3.1/2	4
B610.1240	—	—	0.1240	0.119	7/8	3.1/2	4
B610.1247	—	—	0.1247	0.119	7/8	3.1/2	4
B6101/8	1/8	—	0.1250	0.119	7/8	3.1/2	4
B610.1260	—	—	0.1260	0.119	7/8	3.1/2	4
B610N30	—	N30	0.1285	0.119	7/8	3.1/2	4
B610N29	—	N29	0.1360	0.128	1"	4"	4
B610N28	—	N28	0.1400	0.135	1"	4"	4
B6109/64	9/64	—	0.1410	0.135	1"	4"	4
B610N27	—	N27	0.1440	0.135	1"	4"	4
B610N26	—	N26	0.1470	0.143	1"	4"	4
B610N25	—	N25	0.1495	0.143	1"	4"	4
B610N24	—	N24	0.1520	0.146	1"	4"	4
B610N23	—	N23	0.1540	0.146	1"	4"	4
B6105/32	5/32	—	0.1562	0.151	1"	4"	6
B610N22	—	N22	0.1570	0.151	1"	4"	6
B610N21	—	N21	0.1590	0.153	1.1/8	4.1/2	6
B610N20	—	N20	0.1610	0.153	1.1/8	4.1/2	6
B610N19	—	N19	0.1660	0.160	1.1/8	4.1/2	6
B610N18	—	N18	0.1695	0.160	1.1/8	4.1/2	6
B61011/64	11/64	—	0.1719	0.165	1.1/8	4.1/2	6

Product	DC	DC	DC	DCON MS	LCF	OAL	NOF
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)	
B610N17	—	N17	0.1730	0.165	1.1/8	4.1/2	6
B610N16	—	N16	0.1770	0.170	1.1/8	4.1/2	6
B610N15	—	N15	0.1800	0.175	1.1/8	4.1/2	6
B610N14	—	N14	0.1820	0.175	1.1/8	4.1/2	6
B610N13	—	N13	0.1850	0.180	1.1/8	4.1/2	6
B610.1855	—	—	0.1855	0.180	1.1/8	4.1/2	6
B610.1865	—	—	0.1865	0.180	1.1/8	4.1/2	6
B610.1870	—	—	0.1870	0.180	1.1/8	4.1/2	6
B6103/16	3/16	—	0.1875	0.180	1.1/8	4.1/2	6
B610.1885	—	—	0.1885	0.180	1.1/8	4.1/2	6
B610N12	—	N12	0.1890	0.180	1.1/8	4.1/2	6
B610N11	—	N11	0.1910	0.186	1.1/4	5"	6
B610N10	—	N10	0.1935	0.186	1.1/4	5"	6
B610N9	—	N9	0.1960	0.190	1.1/4	5"	6
B610N8	—	N8	0.1990	0.190	1.1/4	5"	6
B610N7	—	N7	0.2010	0.195	1.1/4	5"	6
B61013/64	13/64	—	0.2031	0.195	1.1/4	5"	6
B610N6	—	N6	0.2040	0.195	1.1/4	5"	6
B610N5	—	N5	0.2055	0.202	1.1/4	5"	6
B610N4	—	N4	0.2090	0.202	1.1/4	5"	6
B610N3	—	N3	0.2130	0.207	1.1/4	5"	6
B6107/32	7/32	—	0.2188	0.207	1.1/4	5"	6
B610N2	—	N2	0.2210	0.217	1.1/2	6"	6
B610N1	—	N1	0.2280	0.217	1.1/2	6"	6
B610A	—	—	0.2340	0.227	1.1/2	6"	6
B61015/64	15/64	—	0.2344	0.227	1.1/2	6"	6
B610B	—	—	0.2380	0.233	1.1/2	6"	6
B610C	—	—	0.2420	0.233	1.1/2	6"	6
B610D	—	—	0.2460	0.233	1.1/2	6"	6
B610.2480	—	—	0.2480	0.233	1.1/2	6"	6
B610.2490	—	—	0.2490	0.240	1.1/2	6"	6
B610.2495	—	—	0.2495	0.240	1.1/2	6"	6
B6101/4	1/4	—	0.2500	0.240	1.1/2	6"	6
B610.2510	—	—	0.2510	0.240	1.1/2	6"	6
B610F	—	—	0.2570	0.248	1.1/2	6"	6
B610G	—	—	0.2610	0.248	1.1/2	6"	6
B61017/64	17/64	—	0.2656	0.248	1.1/2	6"	6
B610H	—	—	0.2660	0.248	1.1/2	6"	6
B610LETTERI	—	—	0.2720	0.248	1.1/2	6"	6
B610J	—	—	0.2770	0.248	1.1/2	6"	6
B610K	—	—	0.2810	0.248	1.1/2	6"	6
B6109/32	9/32	—	0.2812	0.248	1.1/2	6"	6
B610L	—	—	0.2900	0.279	1.1/2	6"	6
B610M	—	—	0.2950	0.279	1.1/2	6"	6
B61019/64	19/64	—	0.2969	0.279	1.1/2	6"	6
B610N	—	—	0.3020	0.279	1.1/2	6"	6
B610.3105	—	—	0.3105	0.279	1.1/2	6"	6
B610.3115	—	—	0.3115	0.279	1.1/2	6"	6
B610.3120	—	—	0.3120	0.279	1.1/2	6"	6
B6105/16	5/16	—	0.3125	0.279	1.1/2	6"	6
B610.3135	—	—	0.3135	0.279	1.1/2	6"	6
B6100	—	—	0.3160	0.279	1.1/2	6"	6
B610P	—	—	0.3230	0.279	1.1/2	6"	6
B61021/64	21/64	—	0.3281	0.279	1.1/2	6"	6
B610Q	—	—	0.3320	0.279	1.1/2	6"	6
B610R	—	—	0.3390	0.279	1.1/2	6"	6
B61011/32	11/32	—	0.3438	0.279	1.1/2	6"	6
B610S	—	—	0.3480	0.310	1.3/4	7"	6
B610T	—	—	0.3580	0.310	1.3/4	7"	6
B61023/64	23/64	—	0.3594	0.310	1.3/4	7"	6
B610U	—	—	0.3680	0.310	1.3/4	7"	6
B610.3730	—	—	0.3730	0.310	1.3/4	7"	6

Product	DC	DC	DC	DCON MS	LCF	OAL	NOF
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)	
B610.3740	—	—	0.3740	0.310	1.3/4	7"	6
B610.3745	—	—	0.3745	0.310	1.3/4	7"	6
B6103/8	3/8	—	0.3750	0.310	1.3/4	7"	6
B610.3760	—	—	0.3760	0.310	1.3/4	7"	6
B610V	—	—	0.3770	0.310	1.3/4	7"	6
B610W	—	—	0.3860	0.310	1.3/4	7"	6
B61025/64	25/64	—	0.3910	0.310	1.3/4	7"	6
B610X	—	—	0.3970	0.310	1.3/4	7"	6
B610Y	—	—	0.4040	0.310	1.3/4	7"	6
B61013/32	13/32	—	0.4062	0.310	1.3/4	7"	6
B610Z	—	—	0.4130	0.373	1.3/4	7"	6
B61027/64	27/64	—	0.4219	0.373	1.3/4	7"	6
B610.4355	—	—	0.4355	0.373	1.3/4	7"	6
B610.4365	—	—	0.4365	0.373	1.3/4	7"	6
B610.4370	—	—	0.4370	0.373	1.3/4	7"	6
B6107/16	7/16	—	0.4375	0.373	1.3/4	7"	6
B610.4385	—	—	0.4385	0.373	1.3/4	7"	6
B61029/64	29/64	—	0.4531	0.373	1.3/4	7"	6
B61015/32	15/32	—	0.4688	0.373	1.3/4	7"	6
B61031/64	31/64	—	0.4844	0.435	2"	8"	6
B610.4980	—	—	0.4980	0.435	2"	8"	6
B610.4990	—	—	0.4990	0.435	2"	8"	6
B610.4995	—	—	0.4995	0.435	2"	8"	6
B6101/2	1/2	—	0.5000	0.435	2"	8"	6
B610.5010	—	—	0.5010	0.435	2"	8"	6
B61033/64	33/64	—	0.5156	0.435	2"	8"	6
B61017/32	17/32	—	0.5312	0.435	2"	8"	6
B61035/64	35/64	—	0.5469	0.435	2"	8"	8
B6109/16	9/16	—	0.5625	0.435	2"	8"	8
B61037/64	37/64	—	0.5781	0.435	2"	8"	8
B61019/32	19/32	—	0.5938	0.435	2"	8"	8
B61039/64	39/64	—	0.6094	0.562	2.1/4	9"	8
B6105/8	5/8	—	0.6250	0.562	2.1/4	9"	8
B61041/64	41/64	—	0.6410	0.562	2.1/4	9"	8
B61021/32	21/32	—	0.6562	0.562	2.1/4	9"	8
B61043/64	43/64	—	0.6719	0.562	2.1/4	9"	8
B61011/16	11/16	—	0.6875	0.562	2.1/4	9"	8
B61045/64	45/64	—	0.7031	0.562	2.1/4	9"	8
B61023/32	23/32	—	0.7188	0.562	2.1/4	9"	8
B61047/64	47/64	—	0.7344	0.625	2.1/2	9.1/2	8
B6103/4	3/4	—	0.7500	0.625	2.1/2	9.1/2	8
B61049/64	49/64	—	0.7656	0.625	2.1/2	9.1/2	8
B61025/32	25/32	—	0.7812	0.625	2.1/2	9.1/2	8
B61051/64	51/64	—	0.7969	0.625	2.1/2	9.1/2	8
B61013/16	13/16	—	0.8125	0.625	2.1/2	9.1/2	8
B61053/64	53/64	—	0.8281	0.625	2.1/2	9.1/2	8
B61027/32	27/32	—	0.8438	0.625	2.1/2	9.1/2	8
B61055/64	55/64	—	0.8594	0.750	2.5/8	10"	8
B6107/8	7/8	—	0.8750	0.750	2.5/8	10"	8
B61057/64	57/64	—	0.8910	0.750	2.5/8	10"	8
B61029/32	29/32	—	0.9062	0.750	2.5/8	10"	8
B61059/64	59/64	—	0.9219	0.750	2.5/8	10"	8
B61015/16	15/16	—	0.9375	0.750	2.5/8	10"	8
B61061/64	61/64	—	0.9531	0.750	2.5/8	10"	8
B61031/32	31/32	—	0.9688	0.750	2.5/8	10"	8
B61063/64	63/64	—	0.9844	0.875	2.3/4	10.1/2	8
B6101	1"	—	1.0000	0.875	2.3/4	10.1/2	8
B6101.1/16	1.1/16	—	1.0625	0.875	2.3/4	10.1/2	8
B6101.1/8	1.1/8	—	1.1250	0.875	2.7/8	11"	8
B6101.3/16	1.3/16	—	1.1875	1.000	2.7/8	11"	8
B6101.1/4	1.1/4	—	1.2500	1.000	3"	11.1/2	8
B6101.3/8	1.3/8	—	1.3750	1.000	3.1/4	12"	8
B6101.1/2	1.1/2	—	1.5000	1.250	3.1/2	12.1/2	8

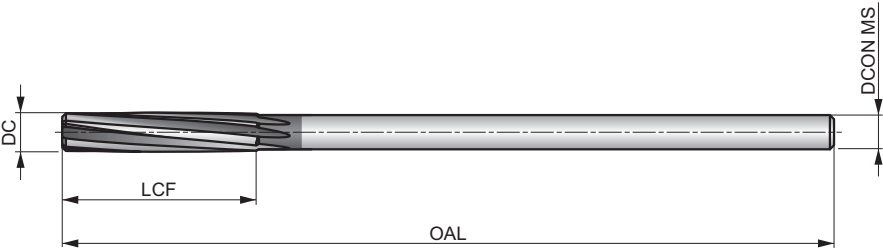
B620

 DORMER



HSS-fræser med lige skaft og langsom spiralfæser, blank finish

De alsidige universalfærsere har kortere og dybere lige riller end håndfrærsere og er designet til effektiv maskinfærsning af de fleste materialer. Der findes et stort udvalg af størrelser, herunder brøkdeler, trædmål, bogstaver og inkrementelle decimalstørrelser. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 21 C	■ 24 C	■ 25 C	■ 18 C	■ 16 C	■ 14 B	■ 13 B	■ 11 B	■ 9 B	■ 8 B	■ 7 B	■ 5 A	■ 11 C	■ 10 B
M2.1	M2.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1
■ 9 B	■ 8 B	■ 16 E	■ 12 D	■ 9 D	■ 16 C	■ 13 C	■ 10 C	■ 14 C	■ 11 C	■ 24 F	■ 18 F	■ 11 F	■ 27 E
N2.2	N2.3	N3.1	N3.2	N3.3									
■ 24 E	■ 16 E	■ 47 D	■ 28 E	■ 14 D									

Product	DC	DC	DC	DCON MS	LCF	OAL	NOF
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)	
B6201/16	1/16	—	0.0625	0.059	1/2	2.1/2	4
B6205/64	5/64	—	0.0781	0.072	3/4	3"	4
B6203/32	3/32	—	0.0938	0.088	3/4	3"	4
B6207/64	7/64	—	0.1094	0.103	7/8	3.1/2	4
B6201/8	1/8	—	0.1250	0.119	7/8	3.1/2	4
B6205/32	5/32	—	0.1562	0.151	1"	4"	6
B62011/64	11/64	—	0.1719	0.165	1.1/8	4.1/2	6
B6203/16	3/16	—	0.1875	0.180	1.1/8	4.1/2	6
B62013/64	13/64	—	0.2031	0.195	1.1/4	5"	6
B6207/32	7/32	—	0.2188	0.207	1.1/4	5"	6
B6201/4	1/4	—	0.2500	0.240	1.1/2	6"	6
B62017/64	17/64	—	0.2656	0.248	1.1/2	6"	6
B6209/32	9/32	—	0.2812	0.248	1.1/2	6"	6
B6205/16	5/16	—	0.3125	0.279	1.1/2	6"	6

Product	DC	DC	DC	DCON MS	LCF	OAL	NOF
	(inch)	(Wire gauge size)	(inch)	(inch)	(inch)	(inch)	
B62011/32	11/32	—	0.3438	0.279	1.1/2	6"	6
B6203/8	3/8	—	0.3750	0.310	1.3/4	7"	6
B62025/64	25/64	—	0.3910	0.310	1.3/4	7"	6
B62013/32	13/32	—	0.4062	0.310	1.3/4	7"	6
B6207/16	7/16	—	0.4375	0.373	1.3/4	7"	6
B62031/64	31/64	—	0.4844	0.435	2"	8"	6
B6201/2	1/2	—	0.5000	0.435	2"	8"	6
B62017/32	17/32	—	0.5312	0.435	2"	8"	6
B6209/16	9/16	—	0.5625	0.435	2"	8"	8
B6205/8	5/8	—	0.6250	0.562	2.1/4	9"	8
B62011/16	11/16	—	0.6875	0.562	2.1/4	9"	8
B6203/4	3/4	—	0.7500	0.625	2.1/2	9.1/2	8
B6207/8	7/8	—	0.8750	0.750	2.5/8	10"	8
B6201	1"	—	1.0000	0.875	2.3/4	10.1/2	8

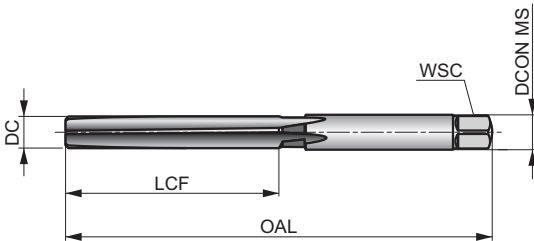
B650

 DORMER



HSS håndfræser med lige fløj, blank finish

Kraftig håndfræser med lige riller, der bruges til manuel efterbehandling af borede huller. Firkantet drev gør det muligt at rotere værktøjet ved hjælp af en skruenøgle eller montere værktøjet stationært til roterende dele. Velegnet til opfræsning af de fleste materialer, herunder stål. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI
R		

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	▣	■	▣	▣	▣	▣	▣	▣	▣
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
▣	■	■	▣	■	■	▣	■	▣	▣	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
▣	■	■	▣	▣	▣								

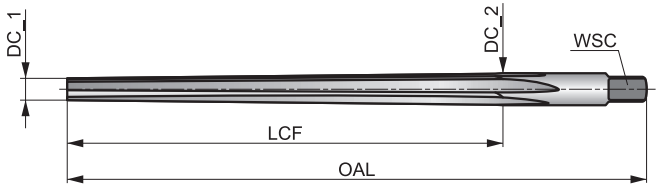
Product	DC	DC	LCF	OAL	NOF
	(inch)	(inch)	(inch)	(inch)	
B6501/8	1/8	0.1250	1.1/2	3"	6
B6503/16	3/16	0.1875	1.3/4	3.1/2	6
B6501/4	1/4	0.2500	2"	4"	6
B6505/16	5/16	0.3125	2.1/4	4.1/2	6
B6503/8	3/8	0.3750	2.1/2	5"	6
B6507/16	7/16	0.4375	2.3/4	5.1/2	6
B6501/2	1/2	0.5000	3"	6"	6
B6509/16	9/16	0.5625	3.1/4	6.1/2	8
B6505/8	5/8	0.6250	3.1/2	7"	8
B6503/4	3/4	0.7500	4.3/16	8.3/8	8
B6507/8	7/8	0.8750	4.7/8	9.3/4	8
B6501	1"	1.0000	5.7/16	10.7/8	8

B301



HSS ligeskær konisk håndriaval 1:48 , Blank og ST Finish

Designet til at afslutte tilspidsede huller til standard 1 til 48 til koniske stifter. Med en reduceret lille diameter lokaliserer og centrerer værktøjet let i det forborede hul for at forbedre nøjagtigheden og ydeevnen. Velegnet til rivning i mange materialer.



HSS	Bright ST	BS 328
R		A
1:48		

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	▣	■	▣	▣	▣	▣	▣	▣	▣
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
▣	■	■	▣	■	■	▣	■	▣	▣	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
▣	■	■	▣	▣	▣								

DC <= 1/4 tolerancegrænse +0,0030; DC >= 9/32 tolerance grænse +0,0050.

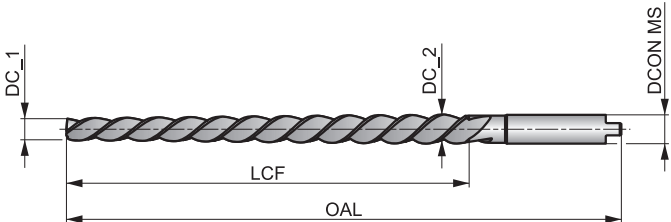
Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B3013/32	3/32	1.75	2.41	57.0	32.0	4	2.00	2.41
B3011/8	1/8	2.30	3.23	70.0	44.0	4	2.50	3.23
B3015/32	5/32	2.95	4.01	76.0	51.0	4	3.10	4.01
B3013/16	3/16	3.50	4.95	102.0	70.0	4	4.00	4.95
B3011/4	1/4	4.64	6.43	117.0	86.0	6	5.00	6.43
B3015/16	5/16	5.84	8.03	143.0	105.0	6	6.30	8.03
B3013/8	3/8	7.03	9.68	165.0	127.0	6	8.00	9.68
B3011/2	1/2	9.41	12.85	210.0	165.0	6	10.00	12.85

B953



HSS-E lige skaft maskinrival 1:50 Konisk, Blank Finish

Med en høj spiral, venstre spiral og højre skæring. Tilspidsningen på rivalen er designet til at afslutte tilspidsede huller for at tage standard metriske koniske stifter i forholdet 1 til 50, mens tilspidsen har en reduceret diameter for at forbedre ydeevnen. Velegnet til rivning i mange materialer.



HSS-E	Bright	DIN 2179
R		1:50 

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 10 B	P1.2 ■ 12 B	P1.3 ■ 13 B	P2.1 ■ 9 B	P2.2 ■ 8 B	P2.3 ▣ 6 A	P3.1 ■ 7 A	P3.2 ▣ 6 A	P3.3 ▣ 3 A	P4.1 ■ 4 A	P4.2 ▣ 3 A	P4.3 ▣ 2 A	M1.1 ▣ 11 C	M1.2 ▣ 10 B
M2.1 ▣ 9 B	M2.2 ▣ 8 B	K1.1 ■ 10 C	K1.2 ■ 6 B	K1.3 ▣ 4 B	K2.1 ■ 8 A	K2.2 ■ 6 A	K2.3 ▣ 4 A	K3.1 ■ 7 A	K3.2 ▣ 4 A	N1.1 ▣ 14 D	N1.2 ■ 12 D	N1.3 ■ 9 D	N2.1 ■ 16 C
N2.2 ■ 14 C	N2.3 ▣ 10 C	N3.1 ■ 22 B	N3.2 ■ 14 C	N3.3 ▣ 6 B	N4.1 ▣ 22 B								

DCON MS tolerance h9.

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)
B9532.0	2.0	1.90	2.86	86.0	48.0	3	3.15
B9532.5	2.5	2.40	3.36	86.0	48.0	3	3.15
B9533.0	3.0	2.90	4.06	100.0	58.0	3	4.00
B9534.0	4.0	3.90	5.26	112.0	68.0	3	5.00
B9535.0	5.0	4.90	6.36	122.0	73.0	3	6.30
B9536.0	6.0	5.90	8.00	160.0	105.0	3	8.00
B9536.5	6.5	6.40	8.78	188.0	119.0	3	8.50
B9538.0	8.0	7.90	10.80	207.0	145.0	3	10.00
B95310.0	10.0	9.90	13.40	245.0	175.0	3	12.50
B95312.0	12.0	11.80	16.00	290.0	210.0	3	16.00

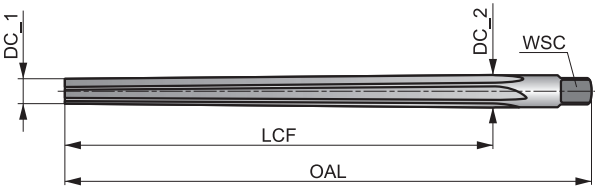
B903





HSS ligeskærs konisk håndriaval 1:50 , Blank og ST Finish

Designet til at afslutte koniske huller til standard metriske koniske stifter. Diameteren på den lille ende reduceres for at gøre det lettere at lokalisere og centrere rivalen i hullet. Velegnet til rivning i mange materialer.



HSS		DIN 9
		A
1:50		

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
■	■	■	■	■	■								

DCON MS tolerance h11; DC <= 5 mm tolerance grænse +0,0750; DC <5 mm tolerance grænse +0,1250.

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B9031.5	1.5	1.40	2.14	57.0	37.0	4	1.80	2.14
B9032.0	2.0	1.90	2.86	68.0	48.0	4	2.24	2.86
B9032.5	2.5	2.40	3.36	68.0	48.0	4	2.80	3.36
B9033.0	3.0	2.90	4.06	80.0	58.0	4	3.15	4.00
B9034.0	4.0	3.90	5.26	93.0	68.0	4	4.00	5.00
B9035.0	5.0	4.90	6.36	100.0	73.0	4	5.00	6.30
B9036.0	6.0	5.90	8.00	135.0	105.0	6	6.30	7.90
B9038.0	8.0	7.90	10.80	180.0	145.0	6	8.00	10.50
B90310.0	10.0	9.90	13.40	215.0	175.0	6	10.00	13.30
B90312.0	12.0	11.80	16.00	255.0	210.0	8	11.20	16.00
B90313.0	13.0	12.86	16.74	255.0	210.0	8	12.50	16.74
B90314.0	14.0	13.86	17.74	255.0	210.0	8	12.50	17.74
B90316.0	16.0	15.80	20.40	280.0	230.0	8	14.00	20.40
B90320.0	20.0	19.80	24.80	310.0	250.0	8	18.00	24.80

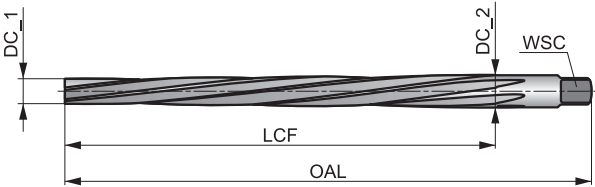
B952

 DORMER



HSS lige skaft maskinrival 1:50 Konisk, Blank Finish

Med venstre spiral og højre skæring giver glat rivning for en mere nøjagtig hulstørrelse og bedre finish. Den lille endediameter er reduceret, hvilket gør det lettere at centrere og centrere rivalen i hullet. Velegnet til rivning i mange materialer.



HSS	Bright	DIN 9
R		B
1:50		

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
■	■	■	■	■	■								

DCON MS tolerance h11; DC <= 2,5 mm lige skær, form A.

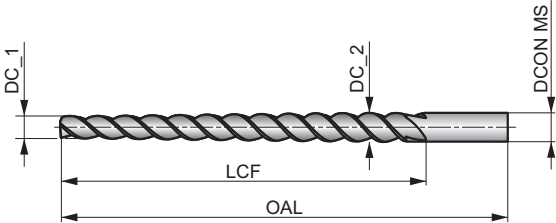
Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B9521.2	1.2	1.10	1.74	50.0	32.0	3	2.40	3.15
B9521.5	1.5	1.40	2.14	57.0	37.0	3	2.40	3.15
B9522.0	2.0	1.90	2.86	68.0	48.0	3	2.40	3.15
B9522.5	2.5	2.40	3.36	68.0	48.0	4	2.40	3.15
B9523.0	3.0	2.90	4.06	80.0	58.0	5	3.00	4.00
B9523.5	3.5	3.40	4.66	87.0	63.0	5	3.40	4.50
B9524.0	4.0	3.90	5.26	93.0	68.0	5	3.80	5.00
B9525.0	5.0	4.90	6.36	100.0	73.0	5	4.90	6.30
B9526.0	6.0	5.90	8.00	135.0	105.0	6	6.20	8.00
B9527.0	7.0	6.90	9.40	160.0	125.0	6	7.00	9.00
B9528.0	8.0	7.90	10.80	180.0	145.0	6	8.00	10.00
B9529.0	9.0	8.90	12.10	195.0	160.0	6	9.00	11.20
B95210.0	10.0	9.90	13.40	215.0	175.0	6	10.00	12.50
B95212.0	12.0	11.80	16.00	255.0	210.0	8	11.00	14.00
B95213.0	13.0	12.80	17.00	255.0	210.0	8	12.00	16.00
B95214.0	14.0	13.80	18.00	255.0	210.0	8	12.00	16.00
B95216.0	16.0	15.80	20.40	280.0	230.0	8	14.50	18.00
B95220.0	20.0	19.80	24.80	310.0	250.0	8	18.00	22.40
B95225.0	25.0	24.70	30.70	370.0	300.0	10	22.00	28.00
B95230.0	30.0	29.70	36.10	400.0	320.0	10	24.00	31.50
B95240.0	40.0	39.70	46.50	430.0	340.0	12	32.00	40.00

B630



Maskinfræser med lige skaft af HSS, konisk stifttype, blank finish

Den langsomme højre spiral gør det muligt for disse fræsere at arbejde glattere og uden spåner end fræsere med lige fløjter. Anbefales til sværere materialer, giver bedre overfladefinish, er gode til afbrydelser og kan hjælpe med spånevakuering fra blindhuller. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI
R		1:48

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
10 B	12 B	13 B	9 B	8 B	6 A	7 A	6 A	3 A	4 A	3 A	2 A	11 C	10 B
M2.1	M2.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1
9 B	8 B	10 C	6 B	4 B	8 A	6 A	4 A	7 A	4 A	14 D	12 D	9 D	16 C
N2.2	N2.3	N3.1	N3.2	N3.3	N4.1								
14 C	10 C	22 B	14 C	6 B	22 B								

Product	nom d	DC_1	DC_2	DCON MS	LCF	OAL	NOF
		(inch)	(inch)	(inch)	(inch)	(inch)	
B6307/0	7/0	0.0497	0.0666	5/64	13/16	1.13/16	2
B6306/0	6/0	0.0611	0.0810	3/32	15/16	1.15/16	2
B6305/0	5/0	0.0719	0.0966	7/64	1.3/16	2.3/16	2
B6304/0	4/0	0.0869	0.1142	1/8	1.5/16	2.5/16	2
B6303/0	3/0	0.1029	0.1300	9/64	1.5/16	5.5/16	2
B6302/0	2/0	0.1137	0.1462	5/32	1.9/16	2.9/16	3
B630N1	1	0.1447	0.1798	3/16	1.11/16	2.15/16	3
B630N2	2	0.1600	0.2010	13/64	1.15/16	3.3/16	3

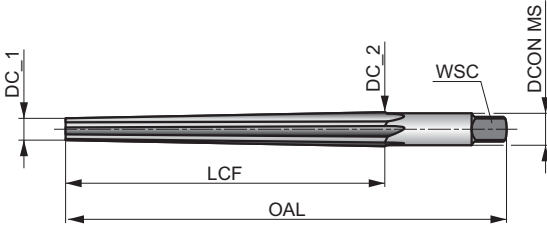
Product	nom d	DC_1	DC_2	DCON MS	LCF	OAL	NOF
		(inch)	(inch)	(inch)	(inch)	(inch)	
B630N3	3	0.1813	0.2294	15/64	2.5/16	3.11/16	3
B630N4	4	0.2071	0.2600	17/64	2.9/16	4.1/16	3
B630N5	5	0.2410	0.2994	5/16	2.13/16	4.5/16	3
B630N6	6	0.2773	0.3540	23/64	3.11/16	5.7/16	3
B630N7	7	0.3297	0.4220	13/32	4.7/16	6.5/16	3
B630N8	8	0.3971	0.5050	7/16	5.3/16	7.3/16	3
B630N9	9	0.4800	0.6066	9/16	6.1/16	8.5/16	4
B630N10	10	0.5799	0.7216	5/8	6.13/16	9.5/16	4

B660



HSS-håndfræser med lige fløj, konisk stifttype, blank finish

Designet til at konvertere et lige boret hul til et konisk hul (1/4" pr. fod) til standard koniske stifter (ASA B5.20-1958). Firkantet drev gør det muligt at rotere værktøjet ved hjælp af en skruenøgle eller montere værktøjet stationært til roterende dele. Velegnet til opboring i de fleste materialer, herunder stål. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI
R		1:48

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	▣	■	▣	▣	▣	▣	▣	▣	▣
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
▣	■	■	▣	■	■	▣	■	▣	▣	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
▣	■	■	▣	▣	▣								

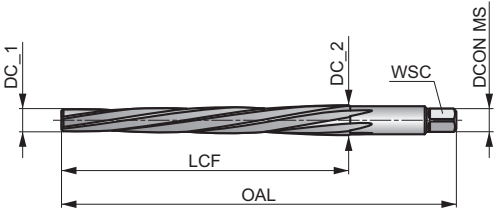
Product	nom d	DC_1	DC_2	DCON MS	LCF	OAL	WSC	NOF
		(inch)	(inch)	(inch)	(inch)	(inch)	(inch)	
B660N0	0	0.1287	0.1638	11/64	1.11/16	2.15/16	0.130	6
B660N1	1	0.1447	0.1798	3/16	1.11/16	2.15/16	0.140	6
B660N2	2	0.1600	0.2010	13/64	1.15/16	3.3/16	0.150	6
B660N3	3	0.1813	0.2294	15/64	2.5/16	3.11/16	0.175	6
B660N4	4	0.2071	0.2600	17/64	2.9/16	4.1/16	0.200	6
B660N5	5	0.2410	0.2994	5/16	2.13/16	4.5/16	0.235	6
B660N6	6	0.2773	0.3540	23/64	3.11/16	5.7/16	0.270	6
B660N7	7	0.3297	0.4220	13/32	4.7/16	6.5/16	0.305	6
B660N8	8	0.3971	0.5050	7/16	5.3/16	7.3/16	0.330	6
B660N9	9	0.4800	0.6066	9/16	6.1/16	8.5/16	0.420	8
B660N10	10	0.5799	0.7216	5/8	6.13/16	9.5/16	0.470	8

B670



HSS Spiral Flute håndfræser, konisk stifttype, blank finish

Højrehåndsskæring med venstrehånds langsom spiral til udfærsning af et konisk hul (1/4" pr. fod) til standard koniske stifter (ASA B5.20-1958). Firkantet drev gør det muligt at rotere værktøjet eller montere det statisk til roterende dele. Spiralrillen forbedrer overfladefinishen ved at hjælpe med spånevakuering. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI
R		1:48

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
■	■	■	■	■	■	■	■	■	■	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
■	■	■	■	■	■								

Nom d er Taper Pin-nummeret i henhold til American Standard Taper Pin Specification (ASA B5.20-1958)

Product	nom d	DC_1	DC_2	DCON MS	LCF	OAL	WSC	NOF
		(inch)	(inch)	(inch)	(inch)	(inch)	(inch)	
B670N0	0	0.1287	0.1638	11/64	1.11/16	2.15/16	0.130	6
B670N1	1	0.1447	0.1798	3/16	1.11/16	2.15/16	0.140	6
B670N2	2	0.1600	0.2010	13/64	1.15/16	3.3/16	0.150	6
B670N3	3	0.1813	0.2294	15/64	2.5/16	3.11/16	0.175	6
B670N4	4	0.2071	0.2600	17/64	2.9/16	4.1/16	0.200	6
B670N5	5	0.2410	0.2994	5/16	2.13/16	4.5/16	0.235	6
B670N6	6	0.2773	0.3540	23/64	3.11/16	5.7/16	0.270	6
B670N7	7	0.3297	0.4220	13/32	4.7/16	6.5/16	0.305	6
B670N8	8	0.3971	0.5050	7/16	5.3/16	7.3/16	0.330	6
B670N9	9	0.4800	0.6066	9/16	6.1/16	8.5/16	0.420	8
B670N10	10	0.5799	0.7216	5/8	6.13/16	9.5/16	0.470	8

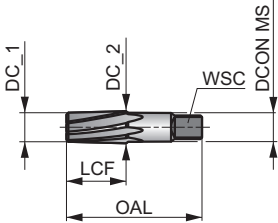
B680

DORMER



HSS Spiral Flute Hand Reamer, NPT Taper Pipe Type, blank finish

Højrehåndsskæring med venstrehåndsspiral til reamning af et konisk hul (3/4\” pr. fod) før NPT-gevindskæring. Firkantet drev gør det muligt at rotere værktøjet eller montere det statisk til roterende dele. Spiralrillen forbedrer overfladefinishen ved at hjælpe med spånevakuering. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS	Bright	ANSI

Arbejdsstykke materiale gruppe egnethed.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	▣	■	▣	▣	▣	▣	▣	▣	▣
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
▣	■	■	▣	■	■	▣	■	▣	▣	■	■	■	■
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2								
▣	■	■	▣	▣	▣								

Nom d er NPT-rørgvindstørrelsen.

Product	nom d	DC_1	DC_2	DCON MS	LCF	OAL	WSC	NOF
		(inch)	(inch)	(inch)	(inch)	(inch)	(inch)	
B6801/8	1/8	0.3160	0.3620	0.438	3/4	2.1/8	0.328	6
B6801/4	1/4	0.4060	0.4720	0.563	1.1/16	2.7/16	0.421	6
B6803/8	3/8	0.5400	0.6060	0.700	1.1/16	2.9/16	0.531	8
B6801/2	1/2	0.6650	0.7510	0.688	1.3/8	3.1/8	0.575	8
B6803/4	3/4	0.8760	0.9620	0.906	1.3/8	3.1/4	0.679	10
B6801	1"	1.1030	1.2120	1.125	1.3/4	3.3/4	0.843	10

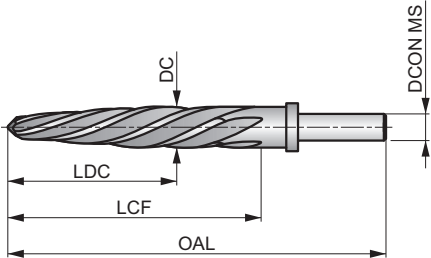
B122





HSS Reduceret skaft rival, damp og bronze hærdet finish

Designet til at justere huller i tyndvæggede stålplader, inden de boltes eller nites sammen. Det er designet til at blive brugt i hånden. Den lille styrdiameter gør det let at lokalisere og justere værktøjet i forborede huller. Velegnet i mange materialer.



HSS		ANSI
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 15 C	P1.2 ■ 16 C	P1.3 ■ 17 C	P2.1 ■ 13 C	P2.2 ■ 11 C	P3.1 ■ 7 B	M1.1 ■ 11 C	M1.2 ■ 10 B	M2.1 ■ 9 B	N1.1 ■ 23 F	N1.2 ■ 17 F	N2.1 ■ 23 E	N2.2 ■ 21 E	N3.1 ■ 34 D
N3.2 ■ 20 E	N4.1 ■ 22 B	N4.2 ■ 21 B											

Product	DC (inch)	DC (inch)	OAL (inch)	LCF (inch)	NOF	DCON MS (inch)
B1223/8	3/8	0.3750	4.5/8	2.1/2	4	3/8
B1221/2	1/2	0.5000	5.7/8	3.3/4	5	1/2
B1229/16	9/16	0.5625	5.7/8	3.3/4	5	1/2
B1225/8	5/8	0.6250	6.3/8	4.1/4	5	1/2
B12211/16	11/16	0.6875	6.3/8	4.1/4	5	1/2
B1223/4	3/4	0.7500	6.7/8	4.1/2	5	1/2
B12213/16	13/16	0.8125	6.7/8	4.1/2	5	1/2
B1227/8	7/8	0.8750	6.7/8	4.1/2	5	1/2
B12215/16	15/16	0.9375	6.7/8	4.1/2	5	1/2
B1221	1"	1.0000	6.7/8	4.1/2	5	1/2

Materiale kode (BMC)		HSS	HSS	HSS	HSS	HSS	HSS	HSS
Grundlæggende standard-gruppe (BSG)		DIN ANSI	DIN 338	DIN 338	DIN 338	DIN 338	DIN 338	DIN 338
Brugbar længde (ULDR)		2.5xD	4xD	4xD	4xD	4xD	4xD	4xD
Anvendelsesvinkel								
Belægning								
Skaft								
Spiral form								
Hånd (skæreretning)								
Produktfamiliekode PSF skærediametre række- vidde								
		A088	A089	A087	A094	A095	A099 Drillboy	A188
		Set	Set	Set	Set	Set	Set	Set
		92	92	93	93	94	94	95
P	P1							
	P2							
	P3							
	P4							
M	M1							
	M2							
	M3							
	M4							
K	K1							
	K2							
	K3							
	K4							
	K5							
N	N1							
	N2							
	N3							
	N4							
	N5							
S	S1							
	S2							
	S3							
	S4							
H	H1							
	H2							
	H3							
	H4							

	HSS-E DIN 338 4×D Bronze λ 20-35°	HSS DIN 338 4×D ST λ 20-35°	HSS DIN 338 4×D Bright λ 20-35°	HSS DIN 338 4×D ST λ 20-35°	Cr steel			
	A295	A190	A191	A191_2	M900	M901	M902	A080
	Set	Set	Set	Set	Size 1 - 9	Set	Set	Set
	95	96	97	97	98	99	99	99
P1					■			
P2					■			
P3					■			
P4					■			
M1					■			
M2					■			
M3					▣			
M4								
K1					■			
K2					■			
K3					■			
K4					■			
K5					■			
N1					■			
N2					■			
N3					■			
N4					■			
N5								
S1								
S2								
S3								
S4								
H1								
H2								
H3								
H4								

A088



HSS boresæt med A022 bor, TiN-tip belagt

Et sæt indeholdende 24 forskellige diametre af det populære A022 bor i en let kompakt kasse med størrelser tydeligt vist for let valg. Borene er velegnede til brug både i maskiner og håndboringer og i mange andre anvendelser. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.

HSS	DIN ANSI	2.5×D
 135°	 TiN-Tip	
 20-35°	 R	DC h8

A = forskellige i sæt, B = nej. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
A0882005	2005	A022	24	1.0 mm - 10.5 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm

A089



HSS boresæt med A002 bor, TiN-tip belagt

Et sæt indeholdende 5 forskellige diametre af den populære A002 bor i en praktisk beholder, der dækker mange diametre med et enkelt køb. Borene er velegnede til brug i både maskiner og håndboringer i mange applikationer. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.

HSS	DIN 338	4×D
 118°	 TiN-Tip	
 20-35°	 R	DC h8

A = forskellige i sæt, B = nej. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
A08910	10	A002	5	A0024.0, A0025.0, A0026.0, A0028.0, A00210.0

A087





HSS boresæt med A002 bor, TiN-tip belagt

Et sæt indeholdende 19 forskellige diametre af det populære A002 bor i en let kompakt kasse med størrelser tydeligt vist for let valg. Borene er velegnede til brug både i maskiner og håndboringer og i mange andre anvendelser. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.

HSS	DIN 338	4xD
		
		DC h8

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt. 1,0 mm = <DC> = 2,9 mm 118° 4 facetpunkt.

Product	Nr.	A	B	C
A087201	201	A002	19	1.0 mm - 10.0 mm x 0.5 mm

A094





HSS boresæt med A002 bor, TiN-tip belagt

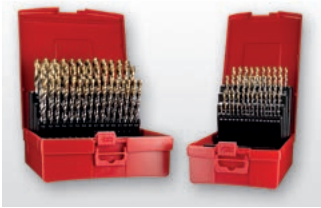
Et sæt indeholdende A002 bor med forskellige metriske diametre i en smart designet roterende dispenser, der gør valg af den ønskede størrelse meget enkel. Drej den klare plastikplade, indtil den ønskede størrelse fremhæves i hullet i kufferten, og vend sættet på hovedet for at fjerne boret.

HSS	DIN 338	4xD
		
		DC h8

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt. 1,0 mm = <DC> = 2,9 mm 118° 4 facetpunkt.

Product	Nr.	A	B	C
A094413	413	A002	13	1.5 mm - 6.5 mm x 0.5 mm + 3.3 mm, 4.2 mm
A094419	419	A002	19	1.0 mm - 10.0 mm x 0.5 mm

A095



HSS boresæt med A002 bor, TiN-tip belagt

Forskellige sæt i metriske eller tommestørrelser af vores A002 bor i et nyttigt plastopbevaringsetui. Sættet holder alle bor sammen, med størrelser tydeligt vist for let valg. Borene er velegnede til brug i både maskiner og håndholdte applikationer. TiN-Tip belægning forbedrer ydeevnen og forlænger værktøjets levetid.

HSS	DIN 338	4xD
 118°	 TiN-Tip	
 20-35°	 R	DC h8

1,0 mm = <DC> = 2,9 mm 118 ° 4 facet spids. A = forskellige i sæt, B = No. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
A09518	18	A002	29	1/16 inch - 1/2 inch x 1/64 inch
A095200	200	A002	24	1.0 mm - 10.5 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm
A095201	201	A002	19	1.0 mm - 10.0 mm x 0.5 mm
A095202	202	A002	51	1.0 mm - 6.0 mm x 0.1 mm
A095203	203	A002	41	6.0 mm - 10.0 mm x 0.1 mm
A095204	204	A002	25	1.0 mm - 13.0 mm x 0.5 mm
A095206	206	A002	29	1.0 mm - 13.0 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm
A095209	209	A002	91	1.0 mm - 10.0 mm x 0.1 mm

A099 Drillboy



Drillboy med HSS bor A002 bor, TiN-tip belagt

En fritstående borddispenser, der indeholder en bred vifte af størrelser af A002 bor. Designet til at stå på en bordplade eller en anden egnet flad overflade til et fremtrædende display, og hvor borene let kan fjernes efter behov. Let at genopfylde med yderligere A002 bor, det giver mange års god service.

HSS	DIN 338	4xD
 118°	 TiN-Tip	
 20-35°	 R	DC h8

1,0 mm = <DC> = 2,9 mm 118 ° 4 facet spids. A = forskellige i sæt, B = No. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
A099DRILLBOYXL	DRILLBOY	A002	55	3 x (1.0, 1.5, 2.0, 2.5, 3.0, 3.3, 3.5, 4.0) + 2 x (4.2, 4.5, 5.0, 5.5, 6.0, 6.5, 6.8, 7.0, 7.5, 8.0) + 8.5, 9.0, 9.5, 10.0, 10.2, 10.5, 11.0, 11.5, 12.0, 12.5, 13.0 mm

A188



HSS boresæt med A108 bor, damphærdet finish

Et sæt forskellige brøkstørrelser af vores A108 bor i en nyttig plastikopbevaringsetui. Kan bruges i mange forskellige maskin- og håndholdte applikationer.

HSS	DIN 338	4×D
 135°	 ST	
 λ>35°	 R	DC h8

A = forskellige i sæt, B = No. i sæt, C = diæmetre i sæt. DC> 1,5 mm; 1/16"Splitpunkt

Product	Nr.	A	B	C
A188201	201	A108	19	1.0 mm - 10.0 mm x 0.5 mm
A188204	204	A108	25	1.0 mm - 13.0 mm x 0.5 mm

A295



HSS-E (8% kobolt) boresæt med A777 bor, Bronze overfladefinish

Et sæt forskellige størrelser af vores A777 bor i en nyttig plastikopbevaringsetui. Sættet holder alle bor sammen i orden, med størrelser tydeligt vist for let valg. A777 bor er designet med et spids på 135 ° for at hjælpe med at centrere boret og reducere skærekrafterne.

HSS-E	DIN 338	4×D
 135°	 Bronze	
 λ20-35°	 R	DC h8

A = forskellige i sæt, B = No. i sæt, C = diæmetre i sæt. DC <= 1,4 mm 4 facet spids.

Product	Nr.	A	B	C
A295219	219	A777	19	1.0 mm - 10.0 mm x 0.5 mm
A295225	225	A777	25	1.0 mm - 13.0 mm x 0.5 mm

A190



HSS boresæt med A100 bor, damphærdet finish

Boresæt indeholdende A100 bor med konventionelt 118 ° spids. Leveres i metriske eller tommestørrelsessæt i en praktisk plastkuffert, der gør valg af den nødvendige borestørrelse meget enkel.

HSS	DIN 338	4xD
 118°	 ST	
 20-35°	 R	DC h8

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt. DC <= 1 mm; 3/64"; N60 Blank.

Product	Nr.	A	B	C
A1903	3	A100	21	1/16 inch - 3/8 inch x 1/64 inch
A19012	12	A100	60	No.1 - No.60
A19018	18	A100	29	1/16 inch - 1/2 inch x 1/64 inch
A19020	20	A100	15	1/16 inch - 1/2 inch x 1/32 inch
A190201	201	A100	19	1.0 mm - 10.0 mm x 0.5 mm
A190202	202	A100	51	1.0 mm - 6.0 mm x 0.1 mm
A190203	203	A100	41	6.0 mm - 10.0 mm x 0.1 mm
A190204	204	A100	25	1.0 mm - 13.0 mm x 0.5 mm
A190206	206	A100	29	1.0 mm - 13.0 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm
A190209 ¹⁾	209	A100	91	1.0 mm - 10.0 mm x 0.1 mm

¹⁾ Sælges i 2 kasser: kasse 1 indeholder størrelser (1,0-5,9 x 0,1 mm); kasse 2 indeholder størrelser (6,0-10,0 x 0,1 mm).

A191



HSS boresæt med A100 bor, damphærdet finish

Et sæt indeholdende A100 bor med forskellige metriske diametre i en kompakt kasse, der er let at bære med tydeligt viste størrelser og let valg af bor. A100 bor med konventionelt 118 ° spids. Leveres i metriske eller gevindstørrelsessæt i en praktisk plastkasse, der gør valg af den nødvendige borestørrelse meget enkel.

HSS	DIN 338	4xD
	Bright	
		DC h8

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt. DC <= 1 mm; 3/64 "; N60 Blank.

Product	Nr.	A	B	C
A19131M	31M	A100	20	0.3 mm - 1.0 mm x 0.05 mm + 0.38 mm, 0.52 mm, 0.58 mm, 0.78 mm, 0.82 mm

A191_2



HSS boresæt med A100 bor, damphærdet finish

Et sæt indeholdende A100 bor med forskellige metriske diametre i en smart designet roterende dispenser, der gør valg af den ønskede størrelse meget enkel. Drej den klare plastikplade, indtil den ønskede størrelse fremhæves i hullet i kufferten, og vend sættet på hovedet for at fjerne boret.

HSS	DIN 338	4xD
	ST	
		DC h8

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt. DC <= 1 mm; 3/64 "; N60 Blank.

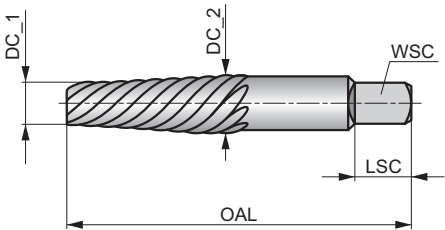
Product	Nr.	A	B	C
A191413	413	A100	13	1.5 mm - 6.5 mm x 0.5 mm + 3.3 mm, 4.2 mm
A191419	419	A100	19	1.0 mm - 10.0 mm x 0.5 mm

M900



Skrueudtrækker

Skrueudtrækker bruges mod uret til a tjerne knækkede højrehånds bolte fra gevindhuller uden at beskadige gevind. Det er nødvendigt at bore et styrehul af passende størrelse, før du bruger udtrækker.



Borstørrelse A: Anvendes på skruer med lav eller medium trækstyrke. B: Anvendes på skruer med høj trækstyrke

Product							DC_1	DC_2	WSC	LSC	OAL
		(mm)	(mm)	(inch)	(inch)	(inch)					
M9001	M5 - M6	2	2	3/16" - 1/4"	5/64	5/64	1.37	3.20	2.60	5.1	51.1
M9002	M6 - M8	2.8	3	1/4" - 5/16"	7/64	1/8	2.18	4.80	3.90	6.7	61.1
M9003	M8 - M12	4	4.2	5/16" - 7/16"	5/32	11/64	3.18	6.40	4.80	7.5	68.7
M9004	M12 - M14	5.5	6	7/16" - 9/16"	7/32	15/64	4.37	8.00	6.00	8	76.7
M9005	M14 - M20	7.2	8	9/16" - 3/4"	9/32	5/16	6.35	11.10	8.30	11.5	86.1
M9006	M20 - M30	10.5	11	3/4" - 1"	13/32	7/16	9.53	15.90	11.90	13.1	94.4
M9007	M30 - M42	13.5	14.5	1" - 1.3/8"	17/32	9/16	12.30	19.10	14.30	17.9	107.4
M9008	M42 - M45	20.5	21.5	1.3/8" - 1.3/4"	13/16	27/32	18.65	25.10	19.80	19.4	114.3
M9009	M45 - M50	27	28	1.3/4 - 2.1/8	1.1/16	1.3/32	24.61	32.30	24.60	22.6	121.3

M901



Skrueudtrækker sæt

Sæt med skrueudtrækker størrelser M9001-M9005 eller M9001-M9006.

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
M901A	A	M900	5	M9001-M9005
M901B	B	M900	6	M9001-M9006

M902



Sæt til fjernelse af bolt

Værktøjer til fjernelse af ødelagte bolte leveres i sæt på 4 stk. Brug først P100-fil til flad bolt. For det andet bruges P101-fil til at starte på spids hul. For det tredje skal du bruge HSS-E stub-boret A117 til at bore et hul til. Brug endelig skrueudtrækkeren i en bevægelse mod uret for at fjerne den knækkede bolt uden at beskadige gevindene.

A = forskellige i sæt, B = No. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
M902M6-M8	M6-M8	M900, P100, P101, A117	4	P1004.9, P1014.9, A1173.0, M9002
M902M8-M10	M8-M10	M900, P100, P101, A117	4	P1006.4, P1016.4, A1174.0, M9003
M902M10-M12	M10-M12	M900, P100, P101, A117	4	P1007.8, P1017.8, A1174.2, M9003
M902M12-M14	M12-M14	M900, P100, P101, A117	4	P1009.3, P1019.3, A1176.0, M9004
M902M14-M16	M14-M16	M900, P100, P101, A117	4	P10010.7, P10110.7, A1178.0, M9005

A080



Tom dispenser

Dispenseren leveres tom, så borene kan købes separat og vælger mængder, der passer til kontralg. Den kommer i rød plastik, markeret med et Dormer-logo og et billede af forskellige Dormer-bor. Metriske eller fraktionerede borediametre er markeret på de tre hylder.

Tom dispenser.

Product	Nr.	C
A080M1EMPTY	M1EMPTY	(1.00, 1.50, 2.00, 2.50, 3.00, 3.50, 4.00, 4.50, 5.00, 5.50, 6.00, 6.50, 7.00, 7.50, 8.00, 8.50, 9.00, 9.50, 10.00, 10.50, 11.00, 11.50, 12.00) mm
A080F1EMPTY	F1EMPTY	(1/16, 5/64, 3/32, 7/64, 1/8, 9/64, 5/32, 11/64, 3/16, 13/64, 7/32, 15/64, 1/4, 17/64, 9/32, 19/64, 5/16, 21/64, 11/32, 3/8, 13/32, 7/16, 1/2) inch



**VÆRKTØJER TIL BLANDET PRODUKTION. BRUGES TYPISK SAMMEN
MED KONVENTIONELLE MASKINER MED MASKINFREMFORING OG CNC.**

Materiale kode (BMC)	HSS-E	HSS	HSS-E	HSS-E	HSS-E	HM								
Grundlæggende standard-gruppe (BSG)	DIN 1899	DIN 1897	DIN 1897	DIN 1897	DIN ANSI	DIN 6539								
Brugbar længde (ULDR)	2.5×D	2.5×D	2.5×D	2.5×D	3×D	2.5×D								
Anvendelsesvinkel														
Belægning	Bright	TiN	Bronze	Bronze	Bright	TiN-Tip								
Skaft														
Spiral form														
Hånd (skæreretning)														
		ADX			PFX									
Produktfamiliekode	A720	A520	A620	A117	A920	R023								
PSF skærediametre række-vidde	0.15 - 1.40	3.00 - 13.00	2.50 - 13.00	1.00 - 13.00	1.00 - 20.00	1.00 - 12.00								
P	P1	■	■	▣	▣	■								
	P2	■	■	▣	▣	■								
	P3	■	■	▣	▣	■								
	P4	▣	■	▣	■	■								
M	M1	▣	■	■	■	■								
	M2	▣	■	■	■	■								
	M3	▣	■	■	■	■								
	M4	▣	■	■	■	■								
K	K1	■	■	▣	▣	▣								
	K2	▣	■	▣	▣	▣	■							
	K3	▣	■	▣	▣	▣	■							
	K4	▣	■	▣	■	▣	▣							
	K5	▣	■	▣	▣	▣	■							
N	N1	▣	▣	▣	▣	▣	■							
	N2	▣	■	▣	▣	▣	▣							
	N3	▣	■	▣	▣	▣	▣							
	N4	▣	■	▣	▣	▣	■							
	N5													
S	S1	▣	■	▣	■	■								
	S2	▣	▣	▣	■	■								
	S3	▣	▣	▣	■	■								
	S4	▣	▣	▣	■	■								
H	H1					▣								
	H2					▣								
	H3					▣								
	H4													

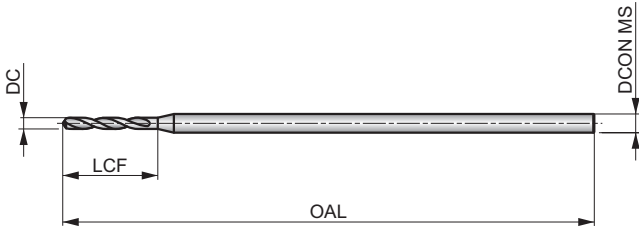
A720





HSS-E (5% kobolt) mikrobor, blank finish

Mikrobor i meget små diametre fra 0,15 mm til 1,40 mm. For at gøre værktøjsholdningen nemmere har alle bor enten en skaftdiameter på 1,00 mm eller 1,50 mm. Borene har alle et 118 °, 4-spidspunkt, hvilket er en stor hjælp til selvcentrering og reducerer skærekrafterne.



HSS-E	DIN 1899	2.5×D
	Bright	
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 36 A	P1.2 40 A	P1.3 41 A	P2.1 31 A	P2.2 27 A	P2.3 24 A	P3.1 25 A	P3.2 20 A	P3.3 17 A	P4.1 15 A	P4.2 13 A	P4.3 10 A	M1.1 30 A	M1.2 26 A
M2.1 27 A	M2.2 22 A	M3.1 12 A	M3.2 10 A	M3.3 9 A	M4.1 15 A	K1.1 30 A	K1.2 22 A	K1.3 17 A	K2.1 25 A	K2.2 20 A	K2.3 16 A	K3.1 22 A	K3.2 17 A
K3.3 13 A	K4.1 20 A	K4.2 15 A	K4.3 11 A	K4.4 10 A	K4.5 8 A	K5.1 23 A	K5.2 17 A	K5.3 13 A	N1.1 35 A	N1.2 26 A	N1.3 18 A	N2.1 42 A	N2.2 37 A
N2.3 27 A	N3.1 68 A	N3.2 40 A	N3.3 20 A	N4.1 48 A	N4.2 25 A	S1.1 23 A	S1.2 17 A	S1.3 8 A	S2.1 9 A	S2.2 6 A	S3.1 7 A	S3.2 4 A	S4.1 5 A
S4.2 3 A													

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A720.15	0.15	0.0059	1.0	25.0	1.00
A720.18	0.18	0.0070	1.4	25.0	1.00
A720.2	0.20	0.0079	1.8	25.0	1.00
A720.22	0.22	0.0087	1.8	25.0	1.00
A720.25	0.25	0.0098	2.2	25.0	1.00
A720.27	0.27	0.0106	2.2	25.0	1.00
A720.28	0.28	0.0110	2.2	25.0	1.00
A720.3	0.30	0.0118	2.2	25.0	1.00
A720.35	0.35	0.0138	2.8	25.0	1.00
A720.4	0.40	0.0157	3.6	25.0	1.00
A720.45	0.45	0.0177	3.6	25.0	1.00
A720.5	0.50	0.0197	4.0	25.0	1.00
A720.55	0.55	0.0217	4.5	25.0	1.00

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A720.6	0.60	0.0236	4.5	25.0	1.00
A720.62	0.62	0.0244	5.0	25.0	1.00
A720.65	0.65	0.0256	5.0	25.0	1.00
A720.7	0.70	0.0276	5.6	25.0	1.00
A720.75	0.75	0.0295	5.6	25.0	1.00
A720.8	0.80	0.0315	6.3	25.0	1.50
A720.85	0.85	0.0335	6.3	25.0	1.50
A720.9	0.90	0.0354	7.1	25.0	1.50
A720.95	0.95	0.0374	7.1	25.0	1.50
A7201.0	1.00	0.0394	8.0	25.0	1.50
A7201.05	1.05	0.0413	8.0	25.0	1.50
A7201.3	1.30	0.0512	10.0	25.0	1.50
A7201.4	1.40	0.0551	11.2	25.0	1.50

A520

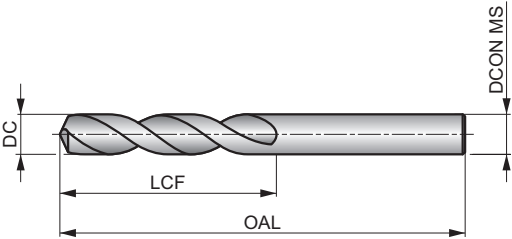




ADX HSS stubbor, TiN Belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9 hultolerance). En tynd spids på 130 °, som hjælper med selvcentrering og reducerer skærekrafter. Dette bor skal kun bruges i maskiner med konstant tilspændning. TiN-belægning forlænger værktøjets levetid.

ADX



HSS	DIN 1897	2.5xD
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 53 M	■ 59 M	■ 61 M	■ 45 M	■ 40 K	■ 35 G	■ 31 I	■ 25 I	■ 21 G	■ 19 I	■ 16 G	■ 13 E	■ 41 I	■ 35 I
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 37 I	■ 30 I	■ 19 I	■ 16 I	■ 14 I	■ 20 G	■ 48 M	■ 36 K	■ 27 K	■ 37 J	■ 30 J	■ 24 F	■ 33 J	■ 25 J
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 20 F	■ 30 J	■ 23 J	■ 17 F	■ 14 F	■ 12 F	■ 34 J	■ 26 J	■ 20 F	■ 55 I	■ 41 I	■ 28 M	■ 57 K	■ 51 K
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 37 K	■ 85 K	■ 50 I	■ 25 E	■ 65 G	■ 50 G	■ 35 F	■ 34 I	■ 20 G	■ 4 B	■ 15 G	■ 10 E	■ 11 G	■ 7 E
S4.1	S4.2												
■ 9 G	■ 6 E												

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5203.0	—	3.00	0.1181	16.0	46.0	3.00
A5203.1	—	3.10	0.1220	18.0	49.0	3.10
A5201/8	1/8	3.18	0.1250	18.0	49.0	3.18
A5203.2	—	3.20	0.1260	18.0	49.0	3.20
A5203.3	—	3.30	0.1299	18.0	49.0	3.30
A5203.4	—	3.40	0.1339	20.0	52.0	3.40
A5203.5	—	3.50	0.1378	20.0	52.0	3.50
A5203.6	—	3.60	0.1417	20.0	52.0	3.60
A5203.7	—	3.70	0.1457	20.0	52.0	3.70
A5203.8	—	3.80	0.1496	22.0	55.0	3.80
A5203.9	—	3.90	0.1535	22.0	55.0	3.90
A5204.0	—	4.00	0.1575	22.0	55.0	4.00
A5204.1	—	4.10	0.1614	22.0	55.0	4.10
A5204.2	—	4.20	0.1654	22.0	55.0	4.20
A5204.3	—	4.30	0.1693	24.0	58.0	4.30
A52011/64	11/64	4.37	0.1719	24.0	58.0	4.37
A5204.4	—	4.40	0.1732	24.0	58.0	4.40
A5204.5	—	4.50	0.1772	24.0	58.0	4.50
A5204.6	—	4.60	0.1811	24.0	58.0	4.60
A5204.7	—	4.70	0.1850	24.0	58.0	4.70
A5203/16	3/16	4.76	0.1875	26.0	62.0	4.76
A5204.8	—	4.80	0.1890	26.0	62.0	4.80
A5204.9	—	4.90	0.1929	26.0	62.0	4.90
A5205.0	—	5.00	0.1969	26.0	62.0	5.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5205.1	—	5.10	0.2008	26.0	62.0	5.10
A5205.2	—	5.20	0.2047	26.0	62.0	5.20
A5205.3	—	5.30	0.2087	26.0	62.0	5.30
A5205.4	—	5.40	0.2126	28.0	66.0	5.40
A5205.5	—	5.50	0.2165	28.0	66.0	5.50
A5207/32	7/32	5.56	0.2188	28.0	66.0	5.56
A5205.6	—	5.60	0.2205	28.0	66.0	5.60
A5205.7	—	5.70	0.2244	28.0	66.0	5.70
A5205.8	—	5.80	0.2283	28.0	66.0	5.80
A5205.9	—	5.90	0.2323	28.0	66.0	5.90
A5206.0	—	6.00	0.2362	28.0	66.0	6.00
A5206.1	—	6.10	0.2402	31.0	70.0	6.10
A5206.2	—	6.20	0.2441	31.0	70.0	6.20
A5206.3	—	6.30	0.2480	31.0	70.0	6.30
A5201/4	1/4	6.35	0.2500	31.0	70.0	6.35
A5206.4	—	6.40	0.2520	31.0	70.0	6.40
A5206.5	—	6.50	0.2559	31.0	70.0	6.50
A5206.6	—	6.60	0.2598	31.0	70.0	6.60
A5206.7	—	6.70	0.2638	31.0	70.0	6.70
A52017/64	17/64	6.75	0.2656	34.0	74.0	6.75
A5206.8	—	6.80	0.2677	34.0	74.0	6.80
A5206.9	—	6.90	0.2717	34.0	74.0	6.90
A5207.0	—	7.00	0.2756	34.0	74.0	7.00
A5207.1	—	7.10	0.2795	34.0	74.0	7.10

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5209/32	9/32	7.14	0.2813	34.0	74.0	7.14
A5207.2	—	7.20	0.2835	34.0	74.0	7.20
A5207.4	—	7.40	0.2913	34.0	74.0	7.40
A5207.5	—	7.50	0.2953	34.0	74.0	7.50
A5207.8	—	7.80	0.3071	37.0	79.0	7.80
A5207.9	—	7.90	0.3110	37.0	79.0	7.90
A5205/16	5/16	7.94	0.3125	37.0	79.0	7.94
A5208.0	—	8.00	0.3150	37.0	79.0	8.00
A5208.1	—	8.10	0.3189	37.0	79.0	8.10
A5208.2	—	8.20	0.3228	37.0	79.0	8.20
A5208.3	—	8.30	0.3268	37.0	79.0	8.30
A5208.4	—	8.40	0.3307	37.0	79.0	8.40
A5208.5	—	8.50	0.3346	37.0	79.0	8.50
A5208.6	—	8.60	0.3386	40.0	84.0	8.60
A5208.7	—	8.70	0.3425	40.0	84.0	8.70
A52011/32	11/32	8.73	0.3438	40.0	84.0	8.73
A5208.8	—	8.80	0.3465	40.0	84.0	8.80
A5209.0	—	9.00	0.3543	40.0	84.0	9.00
A5209.1	—	9.10	0.3583	40.0	84.0	9.10
A5209.5	—	9.50	0.3740	40.0	84.0	9.50
A5203/8	3/8	9.52	0.3750	43.0	89.0	9.52
A5209.6	—	9.60	0.3780	43.0	89.0	9.60
A5209.7	—	9.70	0.3819	43.0	89.0	9.70
A52025/64	25/64	9.92	0.3906	43.0	89.0	9.92

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A52010.0	—	10.00	0.3937	43.0	89.0	10.00
A52010.1	—	10.10	0.3976	43.0	89.0	10.10
A52010.2	—	10.20	0.4016	43.0	89.0	10.20
A52010.3	—	10.30	0.4055	43.0	89.0	10.30
A52013/32	13/32	10.32	0.4063	43.0	89.0	10.32
A52010.5	—	10.50	0.4134	43.0	89.0	10.50
A52027/64	27/64	10.72	0.4219	47.0	95.0	10.72
A52010.8	—	10.80	0.4252	47.0	95.0	10.80
A52011.0	—	11.00	0.4331	47.0	95.0	11.00
A52011.1	—	11.10	0.4370	47.0	95.0	11.10
A5207/16	7/16	11.11	0.4375	47.0	95.0	11.11
A52011.3	—	11.30	0.4449	47.0	95.0	11.30
A52011.5	—	11.50	0.4528	47.0	95.0	11.50
A52011.7	—	11.70	0.4606	47.0	95.0	11.70
A52011.8	—	11.80	0.4646	47.0	95.0	11.80
A52012.0	—	12.00	0.4724	51.0	102.0	12.00
A52012.1	—	12.10	0.4764	51.0	102.0	12.10
A52012.2	—	12.20	0.4803	51.0	102.0	12.20
A52031/64	31/64	12.30	0.4844	51.0	102.0	12.30
A52012.5	—	12.50	0.4921	51.0	102.0	12.50
A5201/2	1/2	12.70	0.5000	51.0	102.0	12.70
A52012.8	—	12.80	0.5039	51.0	102.0	12.80
A52013.0	—	13.00	0.5118	51.0	102.0	13.00

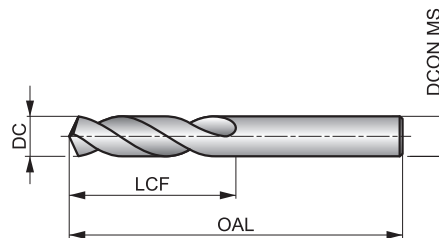
A620

 DORMER



HSS-E (5% kobolt) stubbor, bronze hærdet finish

Bor med 130 ° spids, som hjælper med selvcentrering og reducerer skærekrafterne. Bronze belægningen er et tyndt oxidlag, og det er en indikation for kobolt. Velegnet til boring i mange materialer. Bør ikke bruges i håndholdte enheder.



HSS-E	DIN 1897	2.5×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 40 H	P1.2 ■ 45 H	P1.3 ■ 46 H	P2.1 ■ 34 H	P2.2 ■ 30 G	P2.3 ■ 27 F	P3.1 ■ 27 G	P3.2 ■ 21 G	P3.3 ■ 18 F	P4.1 ■ 16 G	P4.2 ■ 13 F	P4.3 ■ 11 E	M1.1 ■ 30 F	M1.2 ■ 26 F
M2.1 ■ 27 F	M2.2 ■ 22 F	M3.1 ■ 13 H	M3.2 ■ 11 H	M3.3 ■ 10 H	M4.1 ■ 15 D	K1.1 ■ 34 K	K1.2 ■ 25 F	K1.3 ■ 19 F	K2.1 ■ 27 F	K2.2 ■ 22 F	K2.3 ■ 18 F	K3.1 ■ 24 F	K3.2 ■ 18 F
K3.3 ■ 15 F	K4.1 ■ 22 F	K4.2 ■ 17 F	K4.3 ■ 12 F	K4.4 ■ 11 F	K4.5 ■ 9 F	K5.1 ■ 25 F	K5.2 ■ 19 F	K5.3 ■ 15 F	N1.1 ■ 40 K	N1.2 ■ 30 K	N1.3 ■ 20 J	N2.1 ■ 49 I	N2.2 ■ 44 I
N2.3 ■ 32 I	N3.1 ■ 68 J	N3.2 ■ 40 K	N3.3 ■ 20 I	N4.1 ■ 40 L	N4.2 ■ 32 K	N4.3 ■ 18 I	S1.1 ■ 30 G	S1.2 ■ 18 F	S1.3 ■ 10 C	S2.1 ■ 12 F	S2.2 ■ 8 C	S3.1 ■ 9 F	S3.2 ■ 6 C
S4.1 ■ 7 F	S4.2 ■ 5 C												

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A6202.5	2.50	0.0984	14.0	43.0	2.50
A6202.6	2.60	0.1024	14.0	43.0	2.60
A6202.7	2.70	0.1063	16.0	46.0	2.70
A6202.8	2.80	0.1102	16.0	46.0	2.80
A6202.9	2.90	0.1142	16.0	46.0	2.90
A6203.0	3.00	0.1181	16.0	46.0	3.00
A6203.1	3.10	0.1220	18.0	49.0	3.10
A6203.2	3.20	0.1260	18.0	49.0	3.20
A6203.3	3.30	0.1299	18.0	49.0	3.30
A6203.4	3.40	0.1339	20.0	52.0	3.40
A6203.5	3.50	0.1378	20.0	52.0	3.50
A6204.0	4.00	0.1575	22.0	55.0	4.00
A6204.1	4.10	0.1614	22.0	55.0	4.10
A6204.2	4.20	0.1654	22.0	55.0	4.20
A6204.3	4.30	0.1693	24.0	58.0	4.30
A6204.5	4.50	0.1772	24.0	58.0	4.50
A6204.7	4.70	0.1850	24.0	58.0	4.70
A6204.9	4.90	0.1929	26.0	62.0	4.90
A6205.0	5.00	0.1969	26.0	62.0	5.00
A6205.1	5.10	0.2008	26.0	62.0	5.10
A6205.2	5.20	0.2047	26.0	62.0	5.20
A6205.3	5.30	0.2087	26.0	62.0	5.30
A6205.5	5.50	0.2165	28.0	66.0	5.50
A6205.6	5.60	0.2205	28.0	66.0	5.60
A6206.0	6.00	0.2362	28.0	66.0	6.00

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A6206.2	6.20	0.2441	31.0	70.0	6.20
A6206.3	6.30	0.2480	31.0	70.0	6.30
A6206.5	6.50	0.2559	31.0	70.0	6.50
A6206.8	6.80	0.2677	34.0	74.0	6.80
A6206.9	6.90	0.2717	34.0	74.0	6.90
A6207.0	7.00	0.2756	34.0	74.0	7.00
A6207.5	7.50	0.2953	34.0	74.0	7.50
A6207.8	7.80	0.3071	37.0	79.0	7.80
A6208.0	8.00	0.3150	37.0	79.0	8.00
A6208.2	8.20	0.3228	37.0	79.0	8.20
A6208.5	8.50	0.3346	37.0	79.0	8.50
A6208.7	8.70	0.3425	40.0	84.0	8.70
A6209.0	9.00	0.3543	40.0	84.0	9.00
A6209.5	9.50	0.3740	40.0	84.0	9.50
A62010.0	10.00	0.3937	43.0	89.0	10.00
A62010.2	10.20	0.4016	43.0	89.0	10.20
A62010.3	10.30	0.4055	43.0	89.0	10.30
A62010.5	10.50	0.4134	43.0	89.0	10.50
A62010.8	10.80	0.4252	47.0	95.0	10.80
A62011.0	11.00	0.4331	47.0	95.0	11.00
A62011.5	11.50	0.4528	47.0	95.0	11.50
A62012.0	12.00	0.4724	51.0	102.0	12.00
A62012.5	12.50	0.4921	51.0	102.0	12.50
A62013.0	13.00	0.5118	51.0	102.0	13.00

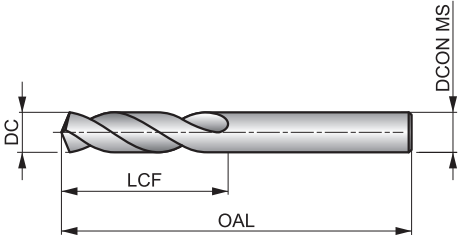
A117





HSS-E (8% kobolt) stubbor, bronze hærdet finish

Bor anbefales til brug i vanskelige materialer og applikationer. Et spids på 135 ° letter selvcentrering og reducerer også skærekrafterne. Kan stole på for at producere et præcist hul og kvalitetsfinish. Bronze belægning er et tyndt oxidlag, og det er en indikation for kobolt.



HSS-E	DIN 1897	2.5×D
		
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
40 H	45 H	46 H	34 H	30 G	27 F	27 G	21 G	18 F	16 G	13 F	11 E	30 F	26 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
27 F	22 F	13 H	11 H	10 H	15 D	34 K	25 F	19 F	27 F	22 F	18 F	24 F	18 F
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
15 F	22 F	17 F	12 F	11 F	9 F	25 F	19 F	15 F	35 K	26 K	18 J	48 I	43 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
31 I	68 J	40 K	20 I	35 M	28 K	17 I	30 G	18 F	10 C	12 F	8 C	9 F	6 C
S4.1	S4.2												
7 F	5 C												

DC <= 1.5mm 118° spids; DC < 3.00 mm 5% kobolt.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1171.0	—	1.00	0.0394	6.0	26.0	1.00
A1171.1	—	1.10	0.0433	7.0	28.0	1.10
A1171.2	—	1.20	0.0472	8.0	30.0	1.20
A1171.3	—	1.30	0.0512	8.0	30.0	1.30
A1171.4	—	1.40	0.0551	9.0	32.0	1.40
A1171.5	—	1.50	0.0591	9.0	32.0	1.50
A1171.6	—	1.60	0.0630	10.0	34.0	1.60
A1171.7	—	1.70	0.0669	10.0	34.0	1.70
A1171.8	—	1.80	0.0709	11.0	36.0	1.80
A1171.9	—	1.90	0.0748	11.0	36.0	1.90
A1172.0	—	2.00	0.0787	12.0	38.0	2.00
A1172.1	—	2.10	0.0827	12.0	38.0	2.10
A1172.2	—	2.20	0.0866	13.0	40.0	2.20
A1172.3	—	2.30	0.0906	13.0	40.0	2.30
A1172.4	—	2.40	0.0945	14.0	43.0	2.40
A1172.5	—	2.50	0.0984	14.0	43.0	2.50
A1172.6	—	2.60	0.1024	14.0	43.0	2.60
A1172.7	—	2.70	0.1063	16.0	46.0	2.70
A1172.8	—	2.80	0.1102	16.0	46.0	2.80
A1172.9	—	2.90	0.1142	16.0	46.0	2.90
A1173.0	—	3.00	0.1181	16.0	46.0	3.00
A1173.1	—	3.10	0.1220	18.0	49.0	3.10
A1171/8	1/8	3.18	0.1250	18.0	49.0	3.18

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1173.2	—	3.20	0.1260	18.0	49.0	3.20
A1173.3	—	3.30	0.1299	18.0	49.0	3.30
A1173.4	—	3.40	0.1339	20.0	52.0	3.40
A1173.5	—	3.50	0.1378	20.0	52.0	3.50
A1173.6	—	3.60	0.1417	20.0	52.0	3.60
A1173.7	—	3.70	0.1457	20.0	52.0	3.70
A1173.8	—	3.80	0.1496	22.0	55.0	3.80
A1173.9	—	3.90	0.1535	22.0	55.0	3.90
A1175/32	5/32	3.97	0.1563	22.0	55.0	3.97
A1174.0	—	4.00	0.1575	22.0	55.0	4.00
A1174.1	—	4.10	0.1614	22.0	55.0	4.10
A1174.2	—	4.20	0.1654	22.0	55.0	4.20
A1174.3	—	4.30	0.1693	24.0	58.0	4.30
A1174.4	—	4.40	0.1732	24.0	58.0	4.40
A1174.5	—	4.50	0.1772	24.0	58.0	4.50
A1174.6	—	4.60	0.1811	24.0	58.0	4.60
A1174.7	—	4.70	0.1850	24.0	58.0	4.70
A1173/16	3/16	4.76	0.1875	26.0	62.0	4.76
A1174.8	—	4.80	0.1890	26.0	62.0	4.80
A1174.9	—	4.90	0.1929	26.0	62.0	4.90
A1175.0	—	5.00	0.1969	26.0	62.0	5.00
A1175.1	—	5.10	0.2008	26.0	62.0	5.10
A1175.2	—	5.20	0.2047	26.0	62.0	5.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1175.3	—	5.30	0.2087	26.0	62.0	5.30
A1175.4	—	5.40	0.2126	28.0	66.0	5.40
A1175.5	—	5.50	0.2165	28.0	66.0	5.50
A1175.6	—	5.60	0.2205	28.0	66.0	5.60
A1175.7	—	5.70	0.2244	28.0	66.0	5.70
A1175.8	—	5.80	0.2283	28.0	66.0	5.80
A1175.9	—	5.90	0.2323	28.0	66.0	5.90
A1176.0	—	6.00	0.2362	28.0	66.0	6.00
A1176.1	—	6.10	0.2402	31.0	70.0	6.10
A1176.2	—	6.20	0.2441	31.0	70.0	6.20
A1176.3	—	6.30	0.2480	31.0	70.0	6.30
A1171/4	1/4	6.35	0.2500	31.0	70.0	6.35
A1176.4	—	6.40	0.2520	31.0	70.0	6.40
A1176.5	—	6.50	0.2559	31.0	70.0	6.50
A1176.6	—	6.60	0.2598	31.0	70.0	6.60
A1176.7	—	6.70	0.2638	31.0	70.0	6.70
A1176.8	—	6.80	0.2677	34.0	74.0	6.80
A1176.9	—	6.90	0.2717	34.0	74.0	6.90
A1177.0	—	7.00	0.2756	34.0	74.0	7.00
A1177.1	—	7.10	0.2795	34.0	74.0	7.10
A1177.2	—	7.20	0.2835	34.0	74.0	7.20
A1177.3	—	7.30	0.2874	34.0	74.0	7.30
A1177.4	—	7.40	0.2913	34.0	74.0	7.40
A1177.5	—	7.50	0.2953	34.0	74.0	7.50
A1177.6	—	7.60	0.2992	37.0	79.0	7.60
A1177.7	—	7.70	0.3031	37.0	79.0	7.70
A1177.8	—	7.80	0.3071	37.0	79.0	7.80

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1177.9	—	7.90	0.3110	37.0	79.0	7.90
A1175/16	5/16	7.94	0.3125	37.0	79.0	7.94
A1178.0	—	8.00	0.3150	37.0	79.0	8.00
A1178.1	—	8.10	0.3189	37.0	79.0	8.10
A1178.2	—	8.20	0.3228	37.0	79.0	8.20
A1178.3	—	8.30	0.3268	37.0	79.0	8.30
A1178.4	—	8.40	0.3307	37.0	79.0	8.40
A1178.5	—	8.50	0.3346	37.0	79.0	8.50
A1178.6	—	8.60	0.3386	40.0	84.0	8.60
A1178.7	—	8.70	0.3425	40.0	84.0	8.70
A1178.8	—	8.80	0.3465	40.0	84.0	8.80
A1178.9	—	8.90	0.3504	40.0	84.0	8.90
A1179.0	—	9.00	0.3543	40.0	84.0	9.00
A1179.1	—	9.10	0.3583	40.0	84.0	9.10
A1179.2	—	9.20	0.3622	40.0	84.0	9.20
A1179.3	—	9.30	0.3661	40.0	84.0	9.30
A1179.5	—	9.50	0.3740	40.0	84.0	9.50
A1179.9	—	9.90	0.3898	43.0	89.0	9.90
A11710.0	—	10.00	0.3937	43.0	89.0	10.00
A11710.2	—	10.20	0.4016	43.0	89.0	10.20
A11710.5	—	10.50	0.4134	43.0	89.0	10.50
A11711.0	—	11.00	0.4331	47.0	95.0	11.00
A11711.5	—	11.50	0.4528	47.0	95.0	11.50
A11712.0	—	12.00	0.4724	51.0	102.0	12.00
A1171/2	1/2	12.70	0.5000	51.0	102.0	12.70
A11713.0	—	13.00	0.5118	51.0	102.0	13.00

A920

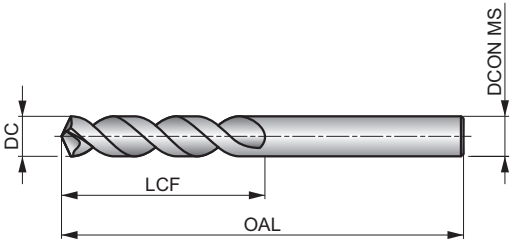




PFX HSS-E (5% kobolt) stubbor, blank finish

Højtydende boremaskine, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og fremførsler (H10 hultolerance). Selvcenterende 130 ° punktsvinkel og specielt parabolisk fløjtdesign hjælper med at bore dybe huller i en enkelt passage. Velegnet til mange materialer.

PFX



HSS-E	DIN ANSI	3×D
	Bright	
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 42 J	P1.2 ■ 47 J	P1.3 ■ 49 J	P2.1 ■ 36 J	P2.2 ■ 32 I	P2.3 ■ 28 E	P3.1 ■ 34 I	P3.2 ■ 27 I	P3.3 ■ 23 E	P4.1 ■ 20 I	P4.2 ■ 17 E	P4.3 ■ 14 E	M1.1 ■ 21 F	M1.2 ■ 17 F
M2.1 ■ 18 F	M2.2 ■ 15 F	M3.1 ■ 8 F	M3.2 ■ 7 F	M3.3 ■ 6 F	M4.1 ■ 9 D	K1.1 ▣ 34 L	K1.2 ▣ 25 L	K1.3 ▣ 19 L	K2.1 ▣ 32 L	K2.2 ▣ 26 L	K2.3 ▣ 21 J	K3.1 ▣ 28 L	K3.2 ▣ 22 L
K3.3 ▣ 17 J	K4.1 ▣ 26 L	K4.2 ▣ 20 L	K4.3 ▣ 14 J	K4.4 ▣ 12 J	K4.5 ▣ 10 J	K5.1 ▣ 30 L	K5.2 ▣ 22 L	K5.3 ▣ 17 J	N1.1 ▣ 75 L	N1.2 ▣ 56 L	N1.3 ■ 38 N	N2.1 ▣ 62 N	N2.2 ▣ 55 N
N2.3 ▣ 40 N	N3.1 ▣ 112 J	N3.2 ▣ 66 J	N3.3 ▣ 33 H	N4.1 ▣ 55 J	N4.2 ▣ 40 H	S1.1 ■ 30 G	S1.2 ■ 18 G	S1.3 ■ 10 C	S2.1 ■ 12 G	S2.2 ■ 8 E	S3.1 ■ 9 G	S3.2 ■ 6 E	S4.1 ■ 7 G
S4.2 ■ 5 E													

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9201.0	—	1.00	0.0394	6.0	26.0	1.00
A9203/64	3/64	1.19	0.0469	13.0	35.0	1.19
A9201.2	—	1.20	0.0472	8.0	30.0	1.20
A9201.25	—	1.25	0.0492	8.0	30.0	1.25
A9201.3	—	1.30	0.0512	8.0	30.0	1.30
A9201.35	—	1.35	0.0531	9.0	32.0	1.35
A9201.4	—	1.40	0.0551	9.0	32.0	1.40
A9201.5	—	1.50	0.0591	9.0	32.0	1.50
A9201.55	—	1.55	0.0610	10.0	34.0	1.55
A9201/16	1/16	1.59	0.0625	16.0	41.0	1.59
A9201.6	—	1.60	0.0630	10.0	34.0	1.60
A9201.7	—	1.70	0.0669	10.0	34.0	1.70
A9201.8	—	1.80	0.0709	11.0	36.0	1.80
A9201.9	—	1.90	0.0748	11.0	36.0	1.90
A9205/64	5/64	1.98	0.0781	17.0	43.0	1.98
A9202.0	—	2.00	0.0787	12.0	38.0	2.00
A9202.1	—	2.10	0.0827	12.0	38.0	2.10
A9202.15	—	2.15	0.0846	13.0	40.0	2.15
A9202.2	—	2.20	0.0866	13.0	40.0	2.20
A9202.3	—	2.30	0.0906	13.0	40.0	2.30
A9202.35	—	2.35	0.0925	14.0	43.0	2.35
A9203/32	3/32	2.38	0.0938	19.0	41.0	2.38
A9202.4	—	2.40	0.0945	14.0	43.0	2.40
A9202.5	—	2.50	0.0984	14.0	43.0	2.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9202.6	—	2.60	0.1024	14.0	43.0	2.60
A9202.7	—	2.70	0.1063	16.0	46.0	2.70
A9207/64	7/64	2.78	0.1094	21.0	46.0	2.78
A9202.8	—	2.80	0.1102	16.0	46.0	2.80
A9202.9	—	2.90	0.1142	16.0	46.0	2.90
A9203.0	—	3.00	0.1181	16.0	46.0	3.00
A9203.1	—	3.10	0.1220	18.0	49.0	3.10
A9201/8	1/8	3.18	0.1250	22.0	48.0	3.18
A9203.2	—	3.20	0.1260	18.0	49.0	3.20
A9203.3	—	3.30	0.1299	18.0	49.0	3.30
A9203.4	—	3.40	0.1339	20.0	52.0	3.40
A9203.5	—	3.50	0.1378	20.0	52.0	3.50
A9209/64	9/64	3.57	0.1406	24.0	49.0	3.57
A9203.6	—	3.60	0.1417	20.0	52.0	3.60
A9203.7	—	3.70	0.1457	20.0	52.0	3.70
A9203.8	—	3.80	0.1496	22.0	55.0	3.80
A9205/32	5/32	3.97	0.1563	25.0	52.0	3.97
A9204.0	—	4.00	0.1575	22.0	55.0	4.00
A9204.1	—	4.10	0.1614	22.0	55.0	4.10
A9204.2	—	4.20	0.1654	22.0	55.0	4.20
A9204.3	—	4.30	0.1693	24.0	58.0	4.30
A92011/64	11/64	4.37	0.1719	27.0	54.0	4.37
A9204.4	—	4.40	0.1732	24.0	58.0	4.40
A9204.5	—	4.50	0.1772	24.0	58.0	4.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9204.6	—	4.60	0.1811	24.0	58.0	4.60
A9203/16	3/16	4.76	0.1875	29.0	56.0	4.76
A9204.8	—	4.80	0.1890	26.0	62.0	4.80
A9204.9	—	4.90	0.1929	26.0	62.0	4.90
A9205.0	—	5.00	0.1969	26.0	62.0	5.00
A9205.1	—	5.10	0.2008	26.0	62.0	5.10
A92013/64	13/64	5.16	0.2031	30.0	57.0	5.16
A9205.2	—	5.20	0.2047	26.0	62.0	5.20
A9205.3	—	5.30	0.2087	26.0	62.0	5.30
A9205.4	—	5.40	0.2126	28.0	66.0	5.40
A9205.5	—	5.50	0.2165	28.0	66.0	5.50
A9207/32	7/32	5.56	0.2188	32.0	60.0	5.56
A9205.6	—	5.60	0.2205	28.0	66.0	5.60
A9205.7	—	5.70	0.2244	28.0	66.0	5.70
A9205.9	—	5.90	0.2323	28.0	66.0	5.90
A9206.0	—	6.00	0.2362	28.0	66.0	6.00
A9206.2	—	6.20	0.2441	31.0	70.0	6.20
A9201/4	1/4	6.35	0.2500	35.0	64.0	6.35
A9206.4	—	6.40	0.2520	31.0	70.0	6.40
A9206.5	—	6.50	0.2559	31.0	70.0	6.50
A9206.6	—	6.60	0.2598	31.0	70.0	6.60
A9206.7	—	6.70	0.2638	31.0	70.0	6.70
A92017/64	17/64	6.75	0.2656	37.0	67.0	6.75
A9206.8	—	6.80	0.2677	34.0	74.0	6.80
A9206.9	—	6.90	0.2717	34.0	74.0	6.90
A9207.0	—	7.00	0.2756	34.0	74.0	7.00
A9207.1	—	7.10	0.2795	34.0	74.0	7.10
A9209/32	9/32	7.14	0.2813	38.0	68.0	7.14
A9207.5	—	7.50	0.2953	34.0	74.0	7.50
A92019/64	19/64	7.54	0.2969	40.0	70.0	7.54
A9207.8	—	7.80	0.3071	37.0	79.0	7.80
A9205/16	5/16	7.94	0.3125	41.0	71.0	7.94
A9208.0	—	8.00	0.3150	37.0	79.0	8.00
A9208.3	—	8.30	0.3268	37.0	79.0	8.30

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9208.4	—	8.40	0.3307	37.0	79.0	8.40
A9208.5	—	8.50	0.3346	37.0	79.0	8.50
A9208.6	—	8.60	0.3386	40.0	84.0	8.60
A9208.7	—	8.70	0.3425	40.0	84.0	8.70
A9209.0	—	9.00	0.3543	40.0	84.0	9.00
A9209.5	—	9.50	0.3740	40.0	84.0	9.50
A9203/8	3/8	9.52	0.3750	46.0	79.0	9.52
A92025/64	25/64	9.92	0.3906	48.0	83.0	9.92
A92010.0	—	10.00	0.3937	43.0	89.0	10.00
A92010.2	—	10.20	0.4016	43.0	89.0	10.20
A92010.3	—	10.30	0.4055	43.0	89.0	10.30
A92010.5	—	10.50	0.4134	43.0	89.0	10.50
A92027/64	27/64	10.72	0.4219	51.0	86.0	10.72
A92010.8	—	10.80	0.4252	47.0	95.0	10.80
A92011.0	—	11.00	0.4331	47.0	95.0	11.00
A9207/16	7/16	11.11	0.4375	52.0	87.0	11.11
A92011.5	—	11.50	0.4528	47.0	95.0	11.50
A92011.8	—	11.80	0.4646	47.0	95.0	11.80
A92012.0	—	12.00	0.4724	51.0	102.0	12.00
A92012.5	—	12.50	0.4921	51.0	102.0	12.50
A9201/2	1/2	12.70	0.5000	57.0	95.0	12.70
A92013.0	—	13.00	0.5118	51.0	102.0	13.00
A92014.0	—	14.00	0.5512	54.0	107.0	14.00
A92014.5	—	14.50	0.5709	56.0	111.0	14.50
A92016.0	—	16.00	0.6299	58.0	115.0	16.00
A92016.5	—	16.50	0.6496	60.0	119.0	16.50
A92021/32	21/32	16.67	0.6563	73.0	114.0	16.67
A92017.0	—	17.00	0.6693	60.0	119.0	17.00
A92017.5	—	17.50	0.6890	62.0	123.0	17.50
A92018.0	—	18.00	0.7087	62.0	123.0	18.00
A92023/32	23/32	18.26	0.7188	76.0	121.0	18.26
A92019.0	—	19.00	0.7480	64.0	127.0	19.00
A92025/32	25/32	19.84	0.7813	83.0	130.0	19.84
A92020.0	—	20.00	0.7874	66.0	131.0	20.00

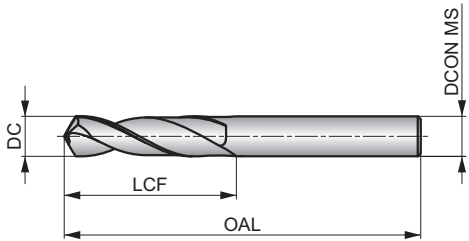
R023





Stubbør i massivt hårdmetal, TiN-spids belagt

Alsidigt begynderbør med 120° spidsvinkel med firefacetteret splitspidsgemetri for reduceret trykkraft og CTW-sporkonstruktion for forbedret indtrængningshastighed. TiN-belægning på spidsen forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til både CNC-maskiner og konventionelle maskiner på tværs af en bred vifte af emnematerialer.



HM	DIN 6539	2.5×D
		
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 99 T	■ 111 T	■ 115 T	■ 85 T	■ 75 T	■ 66 T	■ 66 T	■ 53 T	■ 45 T	■ 40 S	■ 34 S	■ 27 S	■ 75 U	■ 56 U
K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2
■ 42 U	■ 68 U	■ 55 U	■ 44 U	■ 60 U	■ 46 U	■ 37 U	■ 55 T	■ 42 T	■ 31 T	■ 26 T	■ 22 T	■ 63 U	■ 47 U
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.1	N4.2	H1.1	H2.1	H3.1
■ 37 U	■ 150 W	■ 113 W	■ 75 W	■ 129 W	■ 116 W	■ 84 W	■ 317 W	■ 190 W	■ 60 V	■ 100 V	■ 34 S	■ 20 S	■ 22 S

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R0231.0	1.00	0.0394	6.0	26.0	1.00
R0231.1	1.10	0.0433	7.0	28.0	1.10
R0231.2	1.20	0.0472	8.0	30.0	1.20
R0231.3	1.30	0.0512	8.0	30.0	1.30
R0231.4	1.40	0.0551	9.0	32.0	1.40
R0231.5	1.50	0.0591	9.0	32.0	1.50
R0231.6	1.60	0.0630	10.0	34.0	1.60
R0231.7	1.70	0.0669	10.0	34.0	1.70
R0231.8	1.80	0.0709	11.0	36.0	1.80
R0231.9	1.90	0.0748	11.0	36.0	1.90
R0232.0	2.00	0.0787	12.0	38.0	2.00
R0232.1	2.10	0.0827	12.0	38.0	2.10
R0232.2	2.20	0.0866	13.0	40.0	2.20
R0232.3	2.30	0.0906	13.0	40.0	2.30
R0232.4	2.40	0.0945	14.0	43.0	2.40
R0232.5	2.50	0.0984	14.0	43.0	2.50
R0232.6	2.60	0.1024	14.0	43.0	2.60
R0232.7	2.70	0.1063	16.0	46.0	2.70
R0232.8	2.80	0.1102	16.0	46.0	2.80
R0232.9	2.90	0.1142	16.0	46.0	2.90
R0233.0	3.00	0.1181	16.0	46.0	3.00
R0233.1	3.10	0.1220	18.0	49.0	3.10
R0233.2	3.20	0.1260	18.0	49.0	3.20
R0233.3	3.30	0.1299	18.0	49.0	3.30
R0233.4	3.40	0.1339	20.0	52.0	3.40
R0233.5	3.50	0.1378	20.0	52.0	3.50
R0233.6	3.60	0.1417	20.0	52.0	3.60
R0233.7	3.70	0.1457	20.0	52.0	3.70

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R0233.8	3.80	0.1496	22.0	55.0	3.80
R0233.9	3.90	0.1535	22.0	55.0	3.90
R0234.0	4.00	0.1575	22.0	55.0	4.00
R0234.1	4.10	0.1614	22.0	55.0	4.10
R0234.2	4.20	0.1654	22.0	55.0	4.20
R0234.3	4.30	0.1693	24.0	58.0	4.30
R0234.4	4.40	0.1732	24.0	58.0	4.40
R0234.5	4.50	0.1772	24.0	58.0	4.50
R0234.6	4.60	0.1811	24.0	58.0	4.60
R0234.7	4.70	0.1850	24.0	58.0	4.70
R0234.8	4.80	0.1890	26.0	62.0	4.80
R0234.9	4.90	0.1929	26.0	62.0	4.90
R0235.0	5.00	0.1969	26.0	62.0	5.00
R0235.1	5.10	0.2008	26.0	62.0	5.10
R0235.2	5.20	0.2047	26.0	62.0	5.20
R0235.3	5.30	0.2087	26.0	62.0	5.30
R0235.4	5.40	0.2126	28.0	66.0	5.40
R0235.5	5.50	0.2165	28.0	66.0	5.50
R0235.6	5.60	0.2205	28.0	66.0	5.60
R0235.7	5.70	0.2244	28.0	66.0	5.70
R0235.8	5.80	0.2283	28.0	66.0	5.80
R0235.9	5.90	0.2323	28.0	66.0	5.90
R0236.0	6.00	0.2362	28.0	66.0	6.00
R0236.1	6.10	0.2402	31.0	70.0	6.10
R0236.2	6.20	0.2441	31.0	70.0	6.20
R0236.3	6.30	0.2480	31.0	70.0	6.30
R0236.4	6.40	0.2520	31.0	70.0	6.40
R0236.5	6.50	0.2559	31.0	70.0	6.50

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R0236.6	6.60	0.2598	31.0	70.0	6.60
R0236.7	6.70	0.2638	31.0	70.0	6.70
R0236.8	6.80	0.2677	34.0	74.0	6.80
R0236.9	6.90	0.2717	34.0	74.0	6.90
R0237.0	7.00	0.2756	34.0	74.0	7.00
R0237.1	7.10	0.2795	34.0	74.0	7.10
R0237.2	7.20	0.2835	34.0	74.0	7.20
R0237.3	7.30	0.2874	34.0	74.0	7.30
R0237.4	7.40	0.2913	34.0	74.0	7.40
R0237.5	7.50	0.2953	34.0	74.0	7.50
R0237.6	7.60	0.2992	37.0	79.0	7.60
R0237.7	7.70	0.3031	37.0	79.0	7.70
R0237.8	7.80	0.3071	37.0	79.0	7.80
R0237.9	7.90	0.3110	37.0	79.0	7.90
R0238.0	8.00	0.3150	37.0	79.0	8.00
R0238.1	8.10	0.3189	37.0	79.0	8.10
R0238.2	8.20	0.3228	37.0	79.0	8.20
R0238.3	8.30	0.3268	37.0	79.0	8.30
R0238.4	8.40	0.3307	37.0	79.0	8.40
R0238.5	8.50	0.3346	37.0	79.0	8.50

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R0238.6	8.60	0.3386	40.0	84.0	8.60
R0238.7	8.70	0.3425	40.0	84.0	8.70
R0238.8	8.80	0.3465	40.0	84.0	8.80
R0238.9	8.90	0.3504	40.0	84.0	8.90
R0239.0	9.00	0.3543	40.0	84.0	9.00
R0239.1	9.10	0.3583	40.0	84.0	9.10
R0239.2	9.20	0.3622	40.0	84.0	9.20
R0239.3	9.30	0.3661	40.0	84.0	9.30
R0239.4	9.40	0.3701	40.0	84.0	9.40
R0239.5	9.50	0.3740	40.0	84.0	9.50
R0239.6	9.60	0.3780	43.0	89.0	9.60
R0239.7	9.70	0.3819	43.0	89.0	9.70
R0239.8	9.80	0.3858	43.0	89.0	9.80
R0239.9	9.90	0.3898	43.0	89.0	9.90
R02310.0	10.00	0.3937	43.0	89.0	10.00
R02310.2	10.20	0.4016	43.0	89.0	10.20
R02310.5	10.50	0.4134	43.0	89.0	10.50
R02311.0	11.00	0.4331	47.0	95.0	11.00
R02311.5	11.50	0.4528	47.0	95.0	11.50
R02312.0	12.00	0.4724	51.0	102.0	12.00

Materiale kode (BMC)	HSS-E	HSS-E	HSS	HSS-E	HM									
Grundlæggende standard-gruppe (BSG)	DIN 338	DIN 338	DIN 338	DORMER	DIN 338									
Brugbar længde (ULDR)	4xD	4xD	4xD	5xD	4xD									
Anvendelsesvinkel														
Belægning														
Skaft														
Spiral form		VA												
Hånd (skæreretning)														
Køling (CSP)														
			ADX	ADX										
Produktfamiliekode	A777	A147	A510	A553	R003									
PSF skærediametre rækkevidde	0.30 - 16.00	0.30 - 15.0	3.00 - 14.00	5.00 - 18.00	1.00 - 14.00									
P	P1													
	P2													
	P3													
	P4													
M	M1													
	M2													
	M3													
	M4													
K	K1													
	K2													
	K3													
	K4													
	K5													
N	N1													
	N2													
	N3													
	N4													
	N5													
S	S1													
	S2													
	S3													
	S4													
H	H1													
	H2													
	H3													
	H4													

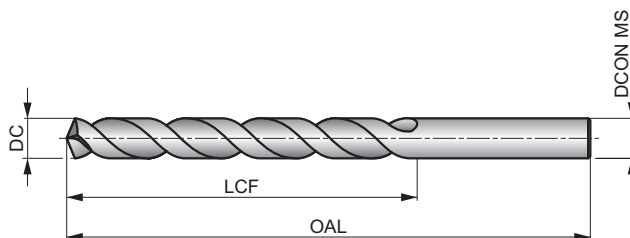
A777





HSS-E (8% kobolt) bor med A777 bor, Bronze overfladefinish

En top performer, der producerer nøjagtige størrelse huller med en kvalitetsfinish i materialer med høj styrke. Spids på 135 ° hjælper med at centrere sig selv. Bronzefinishen er et tyndt oxidlag dannet på værktøjsoverfladen og er en indikation for 8% kobolt HSS-E bor.



HSS-E	DIN 338	4xD
		
		

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
36 H	40 H	41 H	31 H	27 G	24 E	25 F	20 F	17 E	15 F	13 E	10 D	30 E	26 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
27 E	22 E	13 G	11 G	10 G	15 C	35 H	26 D	19 D	27 E	22 E	18 E	24 E	18 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
15 E	22 E	17 E	12 E	11 E	9 E	25 E	19 E	15 E	33 J	25 J	17 I	46 H	42 H
N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	
30 H	68 H	40 F	20 H	28 F	20 D	11 C	9 E	8 B	7 E	6 B	5 E	5 B	

NAS907J. DC <= 1.4mm 4 Facet spids.
Produkter fra denne serie fås også i sæt. Se venligst A295.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A777.3	—	0.30	0.0118	3.0	19.0	0.30
A777.35	—	0.35	0.0138	4.0	19.0	0.35
A777.4	—	0.40	0.0157	5.0	20.0	0.40
A777.45	—	0.45	0.0177	5.0	20.0	0.45
A777.5	—	0.50	0.0197	6.0	22.0	0.50
A777.55	—	0.55	0.0217	7.0	24.0	0.55
A777.6	—	0.60	0.0236	7.0	24.0	0.60
A777.65	—	0.65	0.0256	8.0	26.0	0.65
A777.7	—	0.70	0.0276	9.0	28.0	0.70
A777.8	—	0.80	0.0315	10.0	30.0	0.80
A777.9	—	0.90	0.0354	11.0	32.0	0.90
A777.95	—	0.95	0.0374	11.0	32.0	0.95
A7771.0	—	1.00	0.0394	12.0	34.0	1.00
A7771.1	—	1.10	0.0433	14.0	36.0	1.10
A7771.2	—	1.20	0.0472	16.0	38.0	1.20
A7771.3	—	1.30	0.0512	16.0	38.0	1.30
A7771.4	—	1.40	0.0551	18.0	40.0	1.40
A7771.5	—	1.50	0.0591	18.0	40.0	1.50
A7771/16	1/16	1.59	0.0625	20.0	43.0	1.59
A7771.6	—	1.60	0.0630	20.0	43.0	1.60
A7771.7	—	1.70	0.0669	20.0	43.0	1.70
A7771.8	—	1.80	0.0709	22.0	46.0	1.80
A7771.9	—	1.90	0.0748	22.0	46.0	1.90
A7775/64	5/64	1.98	0.0781	24.0	49.0	1.98

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7772.0	—	2.00	0.0787	24.0	49.0	2.00
A7772.1	—	2.10	0.0827	24.0	49.0	2.10
A7772.2	—	2.20	0.0866	27.0	53.0	2.20
A7772.3	—	2.30	0.0906	27.0	53.0	2.30
A7773/32	3/32	2.38	0.0938	30.0	57.0	2.38
A7772.4	—	2.40	0.0945	30.0	57.0	2.40
A7772.5	—	2.50	0.0984	30.0	57.0	2.50
A7772.6	—	2.60	0.1024	30.0	57.0	2.60
A7772.7	—	2.70	0.1063	33.0	61.0	2.70
A7777/64	7/64	2.78	0.1094	33.0	61.0	2.78
A7772.8	—	2.80	0.1102	33.0	61.0	2.80
A7772.9	—	2.90	0.1142	33.0	61.0	2.90
A7773.0	—	3.00	0.1181	33.0	61.0	3.00
A7773.1	—	3.10	0.1220	36.0	65.0	3.10
A7771/8	1/8	3.18	0.1250	36.0	65.0	3.18
A7773.2	—	3.20	0.1260	36.0	65.0	3.20
A7773.3	—	3.30	0.1299	36.0	65.0	3.30
A7773.4	—	3.40	0.1339	39.0	70.0	3.40
A7773.5	—	3.50	0.1378	39.0	70.0	3.50
A7779/64	9/64	3.57	0.1406	39.0	70.0	3.57
A7773.6	—	3.60	0.1417	39.0	70.0	3.60
A7773.7	—	3.70	0.1457	39.0	70.0	3.70
A7773.8	—	3.80	0.1496	43.0	75.0	3.80
A7773.9	—	3.90	0.1535	43.0	75.0	3.90

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7775/32	5/32	3.97	0.1563	43.0	75.0	3.97
A7774.0	—	4.00	0.1575	43.0	75.0	4.00
A7774.1	—	4.10	0.1614	43.0	75.0	4.10
A7774.2	—	4.20	0.1654	43.0	75.0	4.20
A7774.3	—	4.30	0.1693	47.0	80.0	4.30
A77711/64	11/64	4.37	0.1719	47.0	80.0	4.37
A7774.4	—	4.40	0.1732	47.0	80.0	4.40
A7774.5	—	4.50	0.1772	47.0	80.0	4.50
A7774.6	—	4.60	0.1811	47.0	80.0	4.60
A7774.7	—	4.70	0.1850	47.0	80.0	4.70
A7773/16	3/16	4.76	0.1875	52.0	86.0	4.76
A7774.8	—	4.80	0.1890	52.0	86.0	4.80
A7774.9	—	4.90	0.1929	52.0	86.0	4.90
A7775.0	—	5.00	0.1969	52.0	86.0	5.00
A7775.1	—	5.10	0.2008	52.0	86.0	5.10
A77713/64	13/64	5.16	0.2031	52.0	86.0	5.16
A7775.2	—	5.20	0.2047	52.0	86.0	5.20
A7775.3	—	5.30	0.2087	52.0	86.0	5.30
A7775.4	—	5.40	0.2126	57.0	93.0	5.40
A7775.5	—	5.50	0.2165	57.0	93.0	5.50
A7777/32	7/32	5.56	0.2188	57.0	93.0	5.56
A7775.6	—	5.60	0.2205	57.0	93.0	5.60
A7775.7	—	5.70	0.2244	57.0	93.0	5.70
A7775.8	—	5.80	0.2283	57.0	93.0	5.80
A7775.9	—	5.90	0.2323	57.0	93.0	5.90
A77715/64	15/64	5.95	0.2344	57.0	93.0	5.95
A7776.0	—	6.00	0.2362	57.0	93.0	6.00
A7776.1	—	6.10	0.2402	63.0	101.0	6.10
A7776.2	—	6.20	0.2441	63.0	101.0	6.20
A7776.3	—	6.30	0.2480	63.0	101.0	6.30
A7771/4	1/4	6.35	0.2500	63.0	101.0	6.35
A7776.4	—	6.40	0.2520	63.0	101.0	6.40
A7776.5	—	6.50	0.2559	63.0	101.0	6.50
A7776.6	—	6.60	0.2598	63.0	101.0	6.60
A7776.7	—	6.70	0.2638	63.0	101.0	6.70
A77717/64	17/64	6.75	0.2656	69.0	109.0	6.75
A7776.8	—	6.80	0.2677	69.0	109.0	6.80
A7776.9	—	6.90	0.2717	69.0	109.0	6.90
A7777.0	—	7.00	0.2756	69.0	109.0	7.00
A7777.1	—	7.10	0.2795	69.0	109.0	7.10
A7779/32	9/32	7.14	0.2813	69.0	109.0	7.14
A7777.2	—	7.20	0.2835	69.0	109.0	7.20
A7777.3	—	7.30	0.2874	69.0	109.0	7.30
A7777.4	—	7.40	0.2913	69.0	109.0	7.40
A7777.5	—	7.50	0.2953	69.0	109.0	7.50
A77719/64	19/64	7.54	0.2969	75.0	117.0	7.54
A7777.6	—	7.60	0.2992	75.0	117.0	7.60
A7777.7	—	7.70	0.3031	75.0	117.0	7.70
A7777.8	—	7.80	0.3071	75.0	117.0	7.80
A7777.9	—	7.90	0.3110	75.0	117.0	7.90
A7775/16	5/16	7.94	0.3125	75.0	117.0	7.94
A7778.0	—	8.00	0.3150	75.0	117.0	8.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7778.1	—	8.10	0.3189	75.0	117.0	8.10
A7778.2	—	8.20	0.3228	75.0	117.0	8.20
A7778.3	—	8.30	0.3268	75.0	117.0	8.30
A77721/64	21/64	8.33	0.3281	75.0	117.0	8.33
A7778.4	—	8.40	0.3307	75.0	117.0	8.40
A7778.5	—	8.50	0.3346	75.0	117.0	8.50
A7778.6	—	8.60	0.3386	81.0	125.0	8.60
A7778.7	—	8.70	0.3425	81.0	125.0	8.70
A77711/32	11/32	8.73	0.3438	81.0	125.0	8.73
A7778.8	—	8.80	0.3465	81.0	125.0	8.80
A7778.9	—	8.90	0.3504	81.0	125.0	8.90
A7779.0	—	9.00	0.3543	81.0	125.0	9.00
A7779.1	—	9.10	0.3583	81.0	125.0	9.10
A77723/64	23/64	9.13	0.3594	81.0	125.0	9.13
A7779.2	—	9.20	0.3622	81.0	125.0	9.20
A7779.3	—	9.30	0.3661	81.0	125.0	9.30
A7779.4	—	9.40	0.3701	81.0	125.0	9.40
A7779.5	—	9.50	0.3740	81.0	125.0	9.50
A7773/8	3/8	9.52	0.3750	87.0	133.0	9.52
A7779.6	—	9.60	0.3780	87.0	133.0	9.60
A7779.7	—	9.70	0.3819	87.0	133.0	9.70
A7779.8	—	9.80	0.3858	87.0	133.0	9.80
A7779.9	—	9.90	0.3898	87.0	133.0	9.90
A77725/64	25/64	9.92	0.3906	87.0	133.0	9.92
A77710.0	—	10.00	0.3937	87.0	133.0	10.00
A77710.1	—	10.10	0.3976	87.0	133.0	10.10
A77710.2	—	10.20	0.4016	87.0	133.0	10.20
A77713/32	13/32	10.32	0.4063	87.0	133.0	10.32
A77710.5	—	10.50	0.4134	87.0	133.0	10.50
A77727/64	27/64	10.72	0.4219	94.0	142.0	10.72
A77710.8	—	10.80	0.4252	94.0	142.0	10.80
A77711.0	—	11.00	0.4331	94.0	142.0	11.00
A7777/16	7/16	11.11	0.4375	94.0	142.0	11.11
A77711.2	—	11.20	0.4409	94.0	142.0	11.20
A77711.5	—	11.50	0.4528	94.0	142.0	11.50
A77729/64	29/64	11.51	0.4531	94.0	142.0	11.51
A77711.8	—	11.80	0.4646	94.0	142.0	11.80
A77715/32	15/32	11.91	0.4688	101.0	151.0	11.91
A77712.0	—	12.00	0.4724	101.0	151.0	12.00
A77712.2	—	12.20	0.4803	101.0	151.0	12.20
A77731/64	31/64	12.30	0.4844	101.0	151.0	12.30
A77712.5	—	12.50	0.4921	101.0	151.0	12.50
A7771/2	1/2	12.70	0.5000	101.0	151.0	12.70
A77712.8	—	12.80	0.5039	101.0	151.0	12.80
A77713.0	—	13.00	0.5118	101.0	151.0	13.00
A77713.5	—	13.50	0.5315	108.0	160.0	13.50
A77714.0	—	14.00	0.5512	108.0	160.0	14.00
A77714.5	—	14.50	0.5709	114.0	169.0	14.50
A77715.0	—	15.00	0.5906	114.0	169.0	15.00
A77715.5	—	15.50	0.6102	120.0	178.0	15.50
A77716.0	—	16.00	0.6299	120.0	178.0	16.00

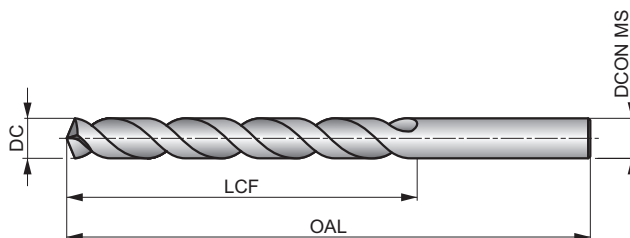
A147





HSS-E (5% kobolt) bor, blank finish (designet til rustfrit stål)

Alsidig og hårdtarbejdende bor, der opfylder alle krav til maskinboring i rustfrit stål, men kan også bruges til håndholdte operationer. Et spidst på 130 ° hjælper med at centrere boret selv og reducerer skærekrafterne. Blank finish.



HSS-E	DIN 338	4xD
	Bright	
VA		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
33 I	37 I	38 I	28 I	25 G	22 E	19 F	15 F	13 E	11 F	10 E	8 D	21 E	17 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
18 E	15 E	13 B	10 G	9 G	8 G	10 D	9 B	30 H	22 F	17 F	25 E	20 E	16 E
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
22 E	17 E	13 E	20 E	15 E	11 E	10 E	8 E	23 E	17 E	13 E	33 J	25 J	17 I
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2
42 H	37 H	27 H	59 H	35 I	18 G	30 J	28 H	14 F	25 G	16 E	7 B	9 G	8 E
S3.1	S3.2	S4.1	S4.2										
7 G	6 E	5 G	5 E										

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A147.3	–	0.30	0.0118	3.0	19.0	0.30
A147.4	–	0.40	0.0157	5.0	20.0	0.40
A147.5	–	0.50	0.0197	6.0	22.0	0.50
A147.6	–	0.60	0.0236	7.0	24.0	0.60
A147.7	–	0.70	0.0276	9.0	28.0	0.70
A147.8	–	0.80	0.0315	10.0	30.0	0.80
A147.9	–	0.90	0.0354	11.0	32.0	0.90
A1471.0	–	1.00	0.0394	12.0	34.0	1.00
A1471.1	–	1.10	0.0433	14.0	36.0	1.10
A1471.2	–	1.20	0.0472	16.0	38.0	1.20
A1471.3	–	1.30	0.0512	16.0	38.0	1.30
A1471.4	–	1.40	0.0551	18.0	40.0	1.40
A1471.5	–	1.50	0.0591	18.0	40.0	1.50
A1471/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1471.6	–	1.60	0.0630	20.0	43.0	1.60
A1471.7	–	1.70	0.0669	20.0	43.0	1.70
A1471.8	–	1.80	0.0709	22.0	46.0	1.80
A1471.9	–	1.90	0.0748	22.0	46.0	1.90
A1472.0	–	2.00	0.0787	24.0	49.0	2.00
A1472.1	–	2.10	0.0827	24.0	49.0	2.10
A1472.2	–	2.20	0.0866	27.0	53.0	2.20
A1472.3	–	2.30	0.0906	27.0	53.0	2.30
A1473/32	3/32	2.38	0.0938	30.0	57.0	2.38
A1472.4	–	2.40	0.0945	30.0	57.0	2.40

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1472.5	–	2.50	0.0984	30.0	57.0	2.50
A1472.6	–	2.60	0.1024	30.0	57.0	2.60
A1472.7	–	2.70	0.1063	33.0	61.0	2.70
A1472.8	–	2.80	0.1102	33.0	61.0	2.80
A1472.9	–	2.90	0.1142	33.0	61.0	2.90
A1473.0	–	3.00	0.1181	33.0	61.0	3.00
A1473.1	–	3.10	0.1220	36.0	65.0	3.10
A1471/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1473.2	–	3.20	0.1260	36.0	65.0	3.20
A1473.3	–	3.30	0.1299	36.0	65.0	3.30
A1473.4	–	3.40	0.1339	39.0	70.0	3.40
A1473.5	–	3.50	0.1378	39.0	70.0	3.50
A1473.6	–	3.60	0.1417	39.0	70.0	3.60
A1473.7	–	3.70	0.1457	39.0	70.0	3.70
A1473.8	–	3.80	0.1496	43.0	75.0	3.80
A1473.9	–	3.90	0.1535	43.0	75.0	3.90
A1475/32	5/32	3.97	0.1563	43.0	75.0	3.97
A1474.0	–	4.00	0.1575	43.0	75.0	4.00
A1474.1	–	4.10	0.1614	43.0	75.0	4.10
A1474.2	–	4.20	0.1654	43.0	75.0	4.20
A1474.3	–	4.30	0.1693	47.0	80.0	4.30
A1474.4	–	4.40	0.1732	47.0	80.0	4.40
A1474.5	–	4.50	0.1772	47.0	80.0	4.50
A1474.6	–	4.60	0.1811	47.0	80.0	4.60

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1474.7	—	4.70	0.1850	47.0	80.0	4.70
A1473/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1474.8	—	4.80	0.1890	52.0	86.0	4.80
A1474.9	—	4.90	0.1929	52.0	86.0	4.90
A1475.0	—	5.00	0.1969	52.0	86.0	5.00
A1475.1	—	5.10	0.2008	52.0	86.0	5.10
A1475.2	—	5.20	0.2047	52.0	86.0	5.20
A1475.3	—	5.30	0.2087	52.0	86.0	5.30
A1475.4	—	5.40	0.2126	57.0	93.0	5.40
A1475.5	—	5.50	0.2165	57.0	93.0	5.50
A1475.6	—	5.60	0.2205	57.0	93.0	5.60
A1475.7	—	5.70	0.2244	57.0	93.0	5.70
A1475.8	—	5.80	0.2283	57.0	93.0	5.80
A1475.9	—	5.90	0.2323	57.0	93.0	5.90
A1476.0	—	6.00	0.2362	57.0	93.0	6.00
A1476.1	—	6.10	0.2402	63.0	101.0	6.10
A1476.2	—	6.20	0.2441	63.0	101.0	6.20
A1476.3	—	6.30	0.2480	63.0	101.0	6.30
A1471/4	1/4	6.35	0.2500	63.0	101.0	6.35
A1476.4	—	6.40	0.2520	63.0	101.0	6.40
A1476.5	—	6.50	0.2559	63.0	101.0	6.50
A1476.6	—	6.60	0.2598	63.0	101.0	6.60
A1476.7	—	6.70	0.2638	63.0	101.0	6.70
A1476.8	—	6.80	0.2677	69.0	109.0	6.80
A1476.9	—	6.90	0.2717	69.0	109.0	6.90
A1477.0	—	7.00	0.2756	69.0	109.0	7.00
A1477.1	—	7.10	0.2795	69.0	109.0	7.10
A1477.2	—	7.20	0.2835	69.0	109.0	7.20
A1477.3	—	7.30	0.2874	69.0	109.0	7.30
A1477.4	—	7.40	0.2913	69.0	109.0	7.40
A1477.5	—	7.50	0.2953	69.0	109.0	7.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1477.7	—	7.70	0.3031	75.0	117.0	7.70
A1477.8	—	7.80	0.3071	75.0	117.0	7.80
A1477.9	—	7.90	0.3110	75.0	117.0	7.90
A1478.0	—	8.00	0.3150	75.0	117.0	8.00
A1478.1	—	8.10	0.3189	75.0	117.0	8.10
A1478.2	—	8.20	0.3228	75.0	117.0	8.20
A1478.3	—	8.30	0.3268	75.0	117.0	8.30
A1478.4	—	8.40	0.3307	75.0	117.0	8.40
A1478.5	—	8.50	0.3346	75.0	117.0	8.50
A1478.6	—	8.60	0.3386	81.0	125.0	8.60
A1478.7	—	8.70	0.3425	81.0	125.0	8.70
A1478.8	—	8.80	0.3465	81.0	125.0	8.80
A1478.9	—	8.90	0.3504	81.0	125.0	8.90
A1479.0	—	9.00	0.3543	81.0	125.0	9.00
A1479.1	—	9.10	0.3583	81.0	125.0	9.10
A1479.2	—	9.20	0.3622	81.0	125.0	9.20
A1479.5	—	9.50	0.3740	81.0	125.0	9.50
A1479.7	—	9.70	0.3819	87.0	133.0	9.70
A1479.8	—	9.80	0.3858	87.0	133.0	9.80
A14710.0	—	10.00	0.3937	87.0	133.0	10.00
A14710.2	—	10.20	0.4016	87.0	133.0	10.20
A14710.5	—	10.50	0.4134	87.0	133.0	10.50
A14711.0	—	11.00	0.4331	94.0	142.0	11.00
A14711.5	—	11.50	0.4528	94.0	142.0	11.50
A14712.0	—	12.00	0.4724	101.0	151.0	12.00
A14712.5	—	12.50	0.4921	101.0	151.0	12.50
A14713.0	—	13.00	0.5118	101.0	151.0	13.00
A14713.5	—	13.50	0.5315	108.0	160.0	13.50
A14714.0	—	14.00	0.5512	108.0	160.0	14.00
A14715.0	—	15.00	0.5906	114.0	169.0	15.00

A510

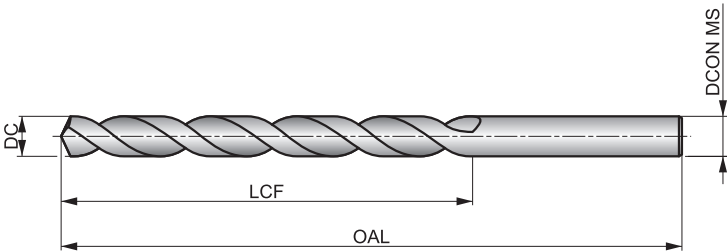




ADX HSS bor, TiN Belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9 hultolerance). En tynd spids på 130° hjælper med selvcentrering. Dette bor skal kun bruges i maskiner med konstant tilspændning. TiN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til boring af mange materialer.

ADX



HSS	DIN 338	4xD
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 53 M	■ 59 M	■ 61 M	■ 45 M	■ 40 K	■ 35 F	■ 31 H	■ 25 H	■ 21 F	■ 19 H	■ 16 F	■ 13 D	■ 38 G	■ 32 G
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 34 G	■ 28 G	■ 16 I	■ 14 I	■ 13 I	■ 19 G	■ 42 K	■ 31 J	■ 23 J	■ 34 J	■ 28 J	■ 22 F	■ 30 J	■ 23 J
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 19 F	■ 28 J	■ 21 J	■ 16 F	■ 13 F	■ 11 F	■ 32 J	■ 24 J	■ 19 F	■ 50 G	■ 38 G	■ 25 M	■ 48 I	■ 43 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 31 I	■ 85 I	■ 50 I	■ 25 D	■ 65 G	■ 50 G	■ 35 F	■ 32 G	■ 20 H	■ 4 B	■ 12 E	■ 8 E	■ 9 E	■ 6 E
S4.1	S4.2												
■ 7 E	■ 5 E												

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5103.0	—	3.00	0.1181	33.0	61.0	3.00
A5103.1	—	3.10	0.1220	36.0	65.0	3.10
A5101/8	1/8	3.18	0.1250	36.0	65.0	3.18
A5103.2	—	3.20	0.1260	36.0	65.0	3.20
A5103.3	—	3.30	0.1299	36.0	65.0	3.30
A5103.4	—	3.40	0.1339	39.0	70.0	3.40
A5103.5	—	3.50	0.1378	39.0	70.0	3.50
A5109/64	9/64	3.57	0.1406	39.0	70.0	3.57
A5103.6	—	3.60	0.1417	39.0	70.0	3.60
A5103.7	—	3.70	0.1457	39.0	70.0	3.70
A5103.8	—	3.80	0.1496	43.0	75.0	3.80
A5103.9	—	3.90	0.1535	43.0	75.0	3.90
A5105/32	5/32	3.97	0.1563	43.0	75.0	3.97
A5104.0	—	4.00	0.1575	43.0	75.0	4.00
A5104.1	—	4.10	0.1614	43.0	75.0	4.10
A5104.2	—	4.20	0.1654	43.0	75.0	4.20
A5104.3	—	4.30	0.1693	47.0	80.0	4.30
A5104.4	—	4.40	0.1732	47.0	80.0	4.40
A5104.5	—	4.50	0.1772	47.0	80.0	4.50
A5104.6	—	4.60	0.1811	47.0	80.0	4.60
A5104.7	—	4.70	0.1850	47.0	80.0	4.70
A5103/16	3/16	4.76	0.1875	52.0	86.0	4.76
A5104.8	—	4.80	0.1890	52.0	86.0	4.80
A5104.9	—	4.90	0.1929	52.0	86.0	4.90

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5105.0	—	5.00	0.1969	52.0	86.0	5.00
A5105.1	—	5.10	0.2008	52.0	86.0	5.10
A51013/64	13/64	5.16	0.2031	52.0	86.0	5.16
A5105.2	—	5.20	0.2047	52.0	86.0	5.20
A5105.3	—	5.30	0.2087	52.0	86.0	5.30
A5105.4	—	5.40	0.2126	57.0	93.0	5.40
A5105.5	—	5.50	0.2165	57.0	93.0	5.50
A5107/32	7/32	5.56	0.2188	57.0	93.0	5.56
A5105.6	—	5.60	0.2205	57.0	93.0	5.60
A5105.7	—	5.70	0.2244	57.0	93.0	5.70
A5105.8	—	5.80	0.2283	57.0	93.0	5.80
A5105.9	—	5.90	0.2323	57.0	93.0	5.90
A51015/64	15/64	5.95	0.2344	57.0	93.0	5.95
A5106.0	—	6.00	0.2362	57.0	93.0	6.00
A5106.1	—	6.10	0.2402	63.0	101.0	6.10
A5106.2	—	6.20	0.2441	63.0	101.0	6.20
A5106.3	—	6.30	0.2480	63.0	101.0	6.30
A5101/4	1/4	6.35	0.2500	63.0	101.0	6.35
A5106.4	—	6.40	0.2520	63.0	101.0	6.40
A5106.5	—	6.50	0.2559	63.0	101.0	6.50
A5106.6	—	6.60	0.2598	63.0	101.0	6.60
A5106.7	—	6.70	0.2638	63.0	101.0	6.70
A51017/64	17/64	6.75	0.2656	69.0	109.0	6.75
A5106.8	—	6.80	0.2677	69.0	109.0	6.80

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5106.9	—	6.90	0.2717	69.0	109.0	6.90
A5107.0	—	7.00	0.2756	69.0	109.0	7.00
A5107.1	—	7.10	0.2795	69.0	109.0	7.10
A5109/32	9/32	7.14	0.2813	69.0	109.0	7.14
A5107.2	—	7.20	0.2835	69.0	109.0	7.20
A5107.3	—	7.30	0.2874	69.0	109.0	7.30
A5107.4	—	7.40	0.2913	69.0	109.0	7.40
A5107.5	—	7.50	0.2953	69.0	109.0	7.50
A51019/64	19/64	7.54	0.2969	75.0	117.0	7.54
A5107.6	—	7.60	0.2992	75.0	117.0	7.60
A5107.8	—	7.80	0.3071	75.0	117.0	7.80
A5105/16	5/16	7.94	0.3125	75.0	117.0	7.94
A5108.0	—	8.00	0.3150	75.0	117.0	8.00
A5108.1	—	8.10	0.3189	75.0	117.0	8.10
A5108.2	—	8.20	0.3228	75.0	117.0	8.20
A5108.3	—	8.30	0.3268	75.0	117.0	8.30
A5108.5	—	8.50	0.3346	75.0	117.0	8.50
A5108.6	—	8.60	0.3386	81.0	125.0	8.60
A5108.7	—	8.70	0.3425	81.0	125.0	8.70
A51011/32	11/32	8.73	0.3438	81.0	125.0	8.73
A5108.8	—	8.80	0.3465	81.0	125.0	8.80
A5108.9	—	8.90	0.3504	81.0	125.0	8.90
A5109.0	—	9.00	0.3543	81.0	125.0	9.00
A5109.1	—	9.10	0.3583	81.0	125.0	9.10
A5109.2	—	9.20	0.3622	81.0	125.0	9.20
A5109.3	—	9.30	0.3661	81.0	125.0	9.30
A5109.4	—	9.40	0.3701	81.0	125.0	9.40
A5109.5	—	9.50	0.3740	81.0	125.0	9.50
A5103/8	3/8	9.52	0.3750	87.0	133.0	9.52

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5109.6	—	9.60	0.3780	87.0	133.0	9.60
A5109.7	—	9.70	0.3819	87.0	133.0	9.70
A5109.8	—	9.80	0.3858	87.0	133.0	9.80
A5109.9	—	9.90	0.3898	87.0	133.0	9.90
A51025/64	25/64	9.92	0.3906	87.0	133.0	9.92
A51010.0	—	10.00	0.3937	87.0	133.0	10.00
A51010.1	—	10.10	0.3976	87.0	133.0	10.10
A51010.2	—	10.20	0.4016	87.0	133.0	10.20
A51010.3	—	10.30	0.4055	87.0	133.0	10.30
A51013/32	13/32	10.32	0.4063	87.0	133.0	10.32
A51010.4	—	10.40	0.4094	87.0	133.0	10.40
A51010.5	—	10.50	0.4134	87.0	133.0	10.50
A51027/64	27/64	10.72	0.4219	94.0	142.0	10.72
A51010.8	—	10.80	0.4252	94.0	142.0	10.80
A51011.0	—	11.00	0.4331	94.0	142.0	11.00
A51011.1	—	11.10	0.4370	94.0	142.0	11.10
A5107/16	7/16	11.11	0.4375	94.0	142.0	11.11
A51011.5	—	11.50	0.4528	94.0	142.0	11.50
A51011.7	—	11.70	0.4606	94.0	142.0	11.70
A51011.8	—	11.80	0.4646	94.0	142.0	11.80
A51015/32	15/32	11.91	0.4688	101.0	151.0	11.91
A51012.0	—	12.00	0.4724	101.0	151.0	12.00
A51012.3	—	12.30	0.4843	101.0	151.0	12.30
A51031/64	31/64	12.30	0.4844	101.0	151.0	12.30
A51012.5	—	12.50	0.4921	101.0	151.0	12.50
A5101/2	1/2	12.70	0.5000	101.0	151.0	12.70
A51013.0	—	13.00	0.5118	101.0	151.0	13.00
A51014.0	—	14.00	0.5512	108.0	160.0	14.00

A553

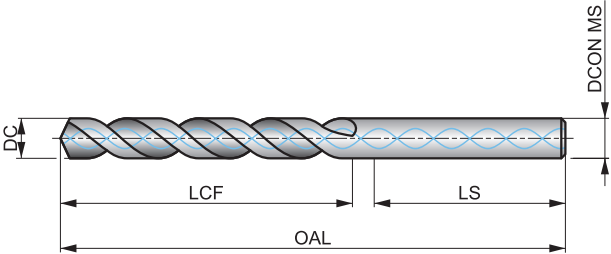


ADX HSS-E (5% kobolt) bor, TiAlN top belagt med indvendig kølemiddeltilførsel

Højtydende bor, der er i stand til at producere nøjagtige huller i høj kvalitet ved høje hastigheder og tilspændinger (H9 hultolerance). En tynd spids på 130 ° og TiAlN Topcoating forbedrer ydeevnen og forlænger værktøjets levetid. Dette bor bør kun bruges i CNC-maskiner. Velegnet til boring af mange materialer.

ADX

HSS-E		5xD
	TiAlN Top	DIN 6535HA
		
DC h8		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 80 L	P1.2 ■ 89 L	P1.3 ■ 92 L	P2.1 ■ 68 L	P2.2 ■ 60 L	P2.3 ■ 53 F	P3.1 ■ 41 H	P3.2 ■ 33 H	P3.3 ■ 28 F	P4.1 ■ 25 H	P4.2 ■ 21 F	P4.3 ■ 17 D	M1.1 ■ 55 G	M1.2 ■ 46 G
M2.1 ■ 49 G	M2.2 ■ 40 G	M3.1 ■ 22 I	M3.2 ■ 19 I	M3.3 ▣ 17 I	M4.1 ▣ 27 G	K1.1 ■ 70 K	K1.2 ■ 52 J	K1.3 ■ 39 J	K2.1 ■ 55 J	K2.2 ■ 45 J	K2.3 ■ 36 F	K3.1 ■ 49 J	K3.2 ■ 37 J
K3.3 ■ 30 F	K4.1 ■ 45 J	K4.2 ■ 34 J	K4.3 ■ 25 F	K4.4 ■ 22 F	K4.5 ■ 18 F	K5.1 ■ 51 J	K5.2 ■ 39 J	K5.3 ■ 30 F	N1.1 ▣ 70 H	N1.2 ▣ 53 H	N1.3 ■ 35 M	N2.1 ■ 85 I	N2.2 ■ 76 I
N2.3 ■ 55 I	N3.1 ■ 144 I	N3.2 ■ 85 I	N3.3 ▣ 43 G	N4.1 ■ 90 G	S1.1 ■ 45 G	S1.2 ▣ 30 E	S1.3 ▣ 8 C	S2.1 ▣ 20 E	S2.2 ▣ 14 G	S3.1 ▣ 15 E	S3.2 ▣ 10 G	S4.1 ▣ 12 E	S4.2 ▣ 8 G

DCON MS tolerance h6.

Product	DC	DC	LCF	OAL	LS	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
A5535.0	5.00	0.1969	36.0	79.0	36.0	6.00
A5535.5	5.50	0.2165	40.0	79.0	36.0	6.00
A5536.0	6.00	0.2362	43.0	79.0	36.0	6.00
A5538.0	8.00	0.3150	58.0	94.0	36.0	8.00
A5538.5	8.50	0.3346	75.0	130.0	40.0	10.00
A5539.0	9.00	0.3543	75.0	130.0	40.0	10.00
A5539.5	9.50	0.3740	75.0	130.0	40.0	10.00
A55310.3	10.30	0.4055	87.0	150.0	45.0	12.00
A55311.0	11.00	0.4331	94.0	150.0	45.0	12.00

Product	DC	DC	LCF	OAL	LS	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
A55311.3	11.30	0.4449	94.0	150.0	45.0	12.00
A55311.5	11.50	0.4528	94.0	150.0	45.0	12.00
A55312.0	12.00	0.4724	94.0	150.0	45.0	12.00
A55312.5	12.50	0.4921	101.0	160.0	45.0	14.00
A55313.0	13.00	0.5118	101.0	160.0	45.0	14.00
A55313.5	13.50	0.5315	101.0	160.0	45.0	14.00
A55314.0	14.00	0.5512	101.0	160.0	45.0	14.00
A55315.0	15.00	0.5906	108.0	170.0	48.0	16.00
A55318.0	18.00	0.7087	130.0	190.0	48.0	18.00

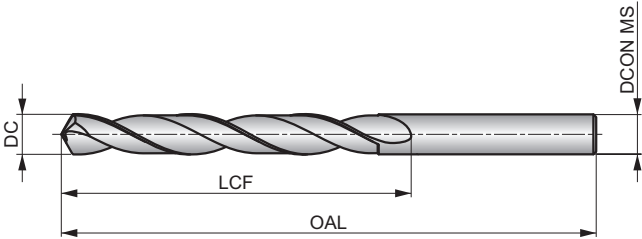
R003





Arbejdsbor i massivt hårdmetal, TiN-spids belagt

Alsiddigt begynderbor med 120° spidsvinkel med firefacetteret splitspidsgemetri for reduceret trykkraft og CTW-sporkonstruktion for forbedret indtrængningshastighed. TiN-belægning på spidsen forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til både CNC-maskiner og konventionelle maskiner på tværs af en bred vifte af emnematerialer.



HM	DIN 338	4×D
		
		DC h7

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 99 S	■ 111 S	■ 115 S	■ 85 S	■ 75 S	■ 66 S	■ 66 S	■ 53 S	■ 45 S	■ 40 S	■ 34 S	■ 27 S	■ 75 T	■ 56 T
K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2
■ 42 T	■ 68 T	■ 55 T	■ 44 T	■ 60 T	■ 46 T	■ 37 T	■ 55 T	■ 42 T	■ 31 T	■ 26 T	■ 22 T	■ 63 T	■ 47 T
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.1	N4.2	H1.1	H2.1	H3.1
■ 37 T	■ 150 V	■ 113 V	■ 75 V	■ 129 V	■ 116 V	■ 84 V	■ 317 V	■ 190 V	■ 60 U	■ 100 U	■ 34 S	■ 20 S	■ 22 S

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R0031.0	—	1.00	0.0394	12.0	34.0	1.00
R003N60	N60	1.02	0.0400	12.0	34.0	1.02
R0031.1	—	1.10	0.0433	14.0	36.0	1.10
R003N56	N56	1.18	0.0465	16.0	38.0	1.18
R0033/64	3/64	1.19	0.0469	16.0	38.0	1.19
R0031.2	—	1.20	0.0472	16.0	38.0	1.20
R0031.3	—	1.30	0.0512	16.0	38.0	1.30
R003N54	N54	1.40	0.0550	18.0	40.0	1.40
R0031.4	—	1.40	0.0551	18.0	40.0	1.40
R0031.5	—	1.50	0.0591	18.0	40.0	1.50
R003N53	N53	1.51	0.0595	20.0	43.0	1.51
R0031/16	1/16	1.59	0.0625	20.0	43.0	1.59
R0031.6	—	1.60	0.0630	20.0	43.0	1.60
R003N52	N52	1.61	0.0635	20.0	43.0	1.61
R0031.7	—	1.70	0.0669	20.0	43.0	1.70
R003N51	N51	1.70	0.0670	22.0	46.0	1.70
R003N50	N50	1.78	0.0700	22.0	46.0	1.78
R0031.8	—	1.80	0.0709	22.0	46.0	1.80
R0031.9	—	1.90	0.0748	22.0	46.0	1.90
R003N48	N48	1.93	0.0760	24.0	49.0	1.93
R0035/64	5/64	1.98	0.0781	24.0	49.0	1.98
R003N47	N47	1.99	0.0785	24.0	49.0	1.99
R0032.0	—	2.00	0.0787	24.0	49.0	2.00
R003N46	N46	2.06	0.0810	24.0	49.0	2.06
R0032.1	—	2.10	0.0827	24.0	49.0	2.10
R003N44	N44	2.18	0.0860	27.0	53.0	2.18
R0032.2	—	2.20	0.0866	27.0	53.0	2.20
R003N43	N43	2.26	0.0890	27.0	53.0	2.26

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R0032.3	—	2.30	0.0906	27.0	53.0	2.30
R0033/32	3/32	2.38	0.0937	30.0	57.0	2.38
R0032.4	—	2.40	0.0945	30.0	57.0	2.40
R003N41	N41	2.44	0.0960	30.0	57.0	2.44
R0032.5	—	2.50	0.0984	30.0	57.0	2.50
R003N39	N39	2.53	0.0995	30.0	57.0	2.53
R003N38	N38	2.58	0.1015	30.0	57.0	2.58
R0032.6	—	2.60	0.1024	30.0	57.0	2.60
R003N37	N37	2.64	0.1040	30.0	57.0	2.64
R0032.7	—	2.70	0.1063	33.0	61.0	2.70
R003N36	N36	2.71	0.1065	33.0	61.0	2.71
R0037/64	7/64	2.78	0.1094	33.0	61.0	2.78
R0032.8	—	2.80	0.1102	33.0	61.0	2.80
R003N33	N33	2.87	0.1130	33.0	61.0	2.87
R0032.9	—	2.90	0.1142	33.0	61.0	2.90
R003N32	N32	2.95	0.1160	33.0	61.0	2.95
R0033.0	—	3.00	0.1181	33.0	61.0	3.00
R003N31	N31	3.05	0.1200	36.0	65.0	3.05
R0033.1	—	3.10	0.1220	36.0	65.0	3.10
R0031/8	1/8	3.17	0.1250	36.0	65.0	3.17
R0033.2	—	3.20	0.1260	36.0	65.0	3.20
R0033.3	—	3.30	0.1299	36.0	65.0	3.30
R0033.4	—	3.40	0.1339	39.0	70.0	3.40
R003N29	N29	3.45	0.1360	39.0	70.0	3.45
R0033.5	—	3.50	0.1378	39.0	70.0	3.50
R003N28	N28	3.57	0.1405	39.0	70.0	3.57
R0039/64	9/64	3.57	0.1406	39.0	70.0	3.57
R0033.6	—	3.60	0.1417	39.0	70.0	3.60

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R0033.7	—	3.70	0.1457	39.0	70.0	3.70
R003N26	N26	3.73	0.1470	39.0	70.0	3.73
R003N25	N25	3.80	0.1495	43.0	75.0	3.80
R0033.8	—	3.80	0.1496	43.0	75.0	3.80
R0033.9	—	3.90	0.1535	43.0	75.0	3.90
R0035/32	5/32	3.97	0.1563	43.0	75.0	3.97
R0034.0	—	4.00	0.1575	43.0	75.0	4.00
R003N21	N21	4.04	0.1590	43.0	75.0	4.04
R003N20	N20	4.09	0.1610	43.0	75.0	4.09
R0034.1	—	4.10	0.1614	43.0	75.0	4.10
R0034.2	—	4.20	0.1654	43.0	75.0	4.20
R003N19	N19	4.22	0.1660	43.0	75.0	4.22
R0034.3	—	4.30	0.1693	47.0	80.0	4.30
R00311/64	11/64	4.37	0.1719	47.0	80.0	4.37
R003N17	N17	4.39	0.1730	47.0	80.0	4.39
R0034.4	—	4.40	0.1732	47.0	80.0	4.40
R0034.5	—	4.50	0.1772	47.0	80.0	4.50
R003N15	N15	4.57	0.1800	47.0	80.0	4.57
R0034.6	—	4.60	0.1811	47.0	80.0	4.60
R0034.7	—	4.70	0.1850	47.0	80.0	4.70
R0033/16	3/16	4.76	0.1875	52.0	86.0	4.76
R003N12	N12	4.80	0.1890	52.0	86.0	4.80
R0034.8	—	4.80	0.1890	52.0	86.0	4.80
R003N11	N11	4.85	0.1910	52.0	86.0	4.85
R0034.9	—	4.90	0.1929	52.0	86.0	4.90
R003N10	N10	4.92	0.1935	52.0	86.0	4.92
R0035.0	—	5.00	0.1969	52.0	86.0	5.00
R0035.1	—	5.10	0.2008	52.0	86.0	5.10
R003N7	N7	5.11	0.2010	52.0	86.0	5.11
R00313/64	13/64	5.16	0.2031	52.0	86.0	5.16
R0035.2	—	5.20	0.2047	52.0	86.0	5.20
R0035.3	—	5.30	0.2087	52.0	86.0	5.30
R0035.4	—	5.40	0.2126	57.0	93.0	5.40
R003N3	N3	5.41	0.2130	57.0	93.0	5.41
R0035.5	—	5.50	0.2165	57.0	93.0	5.50
R0037/32	7/32	5.56	0.2187	57.0	93.0	5.56
R0035.6	—	5.60	0.2205	57.0	93.0	5.60
R003N2	N2	5.61	0.2210	57.0	93.0	5.61
R0035.7	—	5.70	0.2244	57.0	93.0	5.70
R0035.8	—	5.80	0.2283	57.0	93.0	5.80
R0035.9	—	5.90	0.2323	57.0	93.0	5.90
R00315/64	15/64	5.95	0.2344	57.0	93.0	5.95
R0036.0	—	6.00	0.2362	57.0	93.0	6.00
R0036.1	—	6.10	0.2402	63.0	101.0	6.10
R003C	C	6.15	0.2420	63.0	101.0	6.15
R0036.2	—	6.20	0.2441	63.0	101.0	6.20
R0036.3	—	6.30	0.2480	63.0	101.0	6.30
R0031/4	1/4	6.35	0.2500	63.0	101.0	6.35
R0036.4	—	6.40	0.2520	63.0	101.0	6.40
R0036.5	—	6.50	0.2559	63.0	101.0	6.50
R003F	F	6.53	0.2570	63.0	101.0	6.53
R0036.6	—	6.60	0.2598	63.0	101.0	6.60
R0036.7	—	6.70	0.2638	63.0	101.0	6.70
R00317/64	17/64	6.75	0.2656	69.0	109.0	6.75
R0036.8	—	6.80	0.2677	69.0	109.0	6.80
R0036.9	—	6.90	0.2717	69.0	109.0	6.90

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R003I	I	6.91	0.2720	69.0	109.0	6.91
R0037.0	—	7.00	0.2756	69.0	109.0	7.00
R0037.1	—	7.10	0.2795	69.0	109.0	7.10
R0039/32	9/32	7.14	0.2813	69.0	109.0	7.14
R0037.2	—	7.20	0.2835	69.0	109.0	7.20
R0037.3	—	7.30	0.2874	69.0	109.0	7.30
R0037.4	—	7.40	0.2913	69.0	109.0	7.40
R0037.5	—	7.50	0.2953	69.0	109.0	7.50
R00319/64	19/64	7.54	0.2969	75.0	117.0	7.54
R0037.6	—	7.60	0.2992	75.0	117.0	7.60
R0037.7	—	7.70	0.3031	75.0	117.0	7.70
R0037.8	—	7.80	0.3071	75.0	117.0	7.80
R0037.9	—	7.90	0.3110	75.0	117.0	7.90
R0035/16	5/16	7.94	0.3125	75.0	117.0	7.94
R0038.0	—	8.00	0.3150	75.0	117.0	8.00
R0038.1	—	8.10	0.3189	75.0	117.0	8.10
R0038.2	—	8.20	0.3228	75.0	117.0	8.20
R0038.3	—	8.30	0.3268	75.0	117.0	8.30
R00321/64	21/64	8.33	0.3281	75.0	117.0	8.33
R0038.4	—	8.40	0.3307	75.0	117.0	8.40
R003Q	Q	8.43	0.3320	75.0	117.0	8.43
R0038.5	—	8.50	0.3346	75.0	117.0	8.50
R0038.6	—	8.60	0.3386	81.0	125.0	8.60
R003R	R	8.61	0.3390	81.0	125.0	8.61
R0038.7	—	8.70	0.3425	81.0	125.0	8.70
R00311/32	11/32	8.73	0.3437	81.0	125.0	8.73
R0038.8	—	8.80	0.3465	81.0	125.0	8.80
R0038.9	—	8.90	0.3504	81.0	125.0	8.90
R0039.0	—	9.00	0.3543	81.0	125.0	9.00
R0039.1	—	9.10	0.3583	81.0	125.0	9.10
R00323/64	23/64	9.13	0.3594	81.0	125.0	9.13
R0039.2	—	9.20	0.3622	81.0	125.0	9.20
R0039.3	—	9.30	0.3661	81.0	125.0	9.30
R003U	U	9.35	0.3680	81.0	125.0	9.35
R0039.4	—	9.40	0.3701	81.0	125.0	9.40
R0039.5	—	9.50	0.3740	81.0	125.0	9.50
R0033/8	3/8	9.53	0.3750	87.0	133.0	9.53
R0039.6	—	9.60	0.3780	87.0	133.0	9.60
R0039.7	—	9.70	0.3819	87.0	133.0	9.70
R0039.8	—	9.80	0.3858	87.0	133.0	9.80
R003W	W	9.80	0.3860	87.0	133.0	9.80
R0039.9	—	9.90	0.3898	87.0	133.0	9.90
R00310.0	—	10.00	0.3937	87.0	133.0	10.00
R00310.2	—	10.20	0.4016	87.0	133.0	10.20
R00313/32	13/32	10.32	0.4063	87.0	133.0	10.32
R00310.5	—	10.50	0.4134	87.0	133.0	10.50
R00327/64	27/64	10.72	0.4219	94.0	142.0	10.72
R00311.0	—	11.00	0.4331	94.0	142.0	11.00
R0037/16	7/16	11.11	0.4375	94.0	142.0	11.11
R00311.5	—	11.50	0.4528	94.0	142.0	11.50
R00329/64	29/64	11.51	0.4531	94.0	142.0	11.51
R00315/32	15/32	11.91	0.4687	101.0	151.0	11.91
R00312.0	—	12.00	0.4724	101.0	151.0	12.00
R0031/2	1/2	12.70	0.5000	101.0	151.0	12.70
R00313.0	—	13.00	0.5118	101.0	151.0	13.00
R00314.0	—	14.00	0.5512	108.0	160.0	14.00

Materiale kode (BMC)	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS								
Grundlæggende standard-gruppe (BSG)	DIN ANSI	DIN ANSI	DIN 1869-1	DIN 1869-2	DIN 1869-3	DIN 1870(2)								
Brugbar længde (ULDR)	6×D	10×D	15×D	20×D	25×D	20×D								
Anvendelsesvinkel														
Belægning	Bright	Bright	Bright	Bright	Bright	Bright ST								
Skaft														
Spiral form														
Hånd (skæreretning)														
	PFX	PFX	PFX	PFX	PFX									
Produktfamiliekode	A900	A940	A976	A977	A978	A952								
PSF skærediametre række-vidde	1.00 - 20.00	1.00 - 19.00	1.50 - 14.00	1.50 - 14.00	3.00 - 10.00	8.00 - 30.00								
	126	128	130	131	132	133								
P	P1	■	■	■	■	■								
	P2	■	■	■	■	■								
	P3	■	■	■	■	■								
	P4	■	■	■	■	■								
M	M1	■	■	■	■	■								
	M2	■	■	■	■	■								
	M3	■	■	■	■	■								
	M4	■	■	■	■	■								
K	K1	■		■		■								
	K2	■	■	■	■	■								
	K3	■	■	■	■	■								
	K4	■	■	■	■	■								
	K5	■	■	■	■	■								
N	N1	■	■			■								
	N2	■	■			■								
	N3	■	■	■	■	■								
	N4	■	■			■								
	N5													
S	S1	■	■	■	■	■								
	S2	■				■								
	S3	■				■								
	S4	■				■								
H	H1													
	H2													
	H3													
	H4													

A900

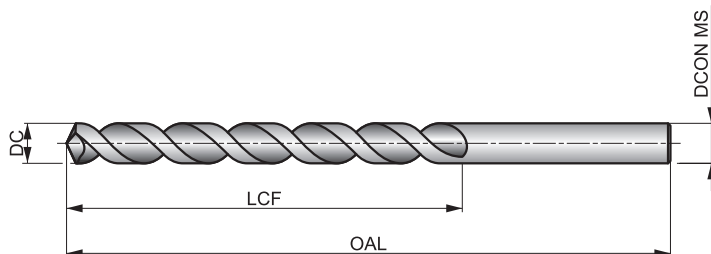
 DORMER



PFX HSS-E (5% kobolt) bor, blank finish

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og skærehastigheder (H10 hultolerance). Selvcenterende 130 ° spidsvinkel og specielt parabolisk skærdesign hjælper med at bore dybe huller i en enkelt passage. Velegnet til mange materialer.

PFX



HSS-E	DIN ANSI	6×D
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 34 H	P1.2 ■ 39 H	P1.3 ■ 40 H	P2.1 ■ 30 H	P2.2 ■ 26 H	P2.3 ■ 23 E	P3.1 ■ 31 H	P3.2 ■ 25 H	P3.3 ■ 21 E	P4.1 ■ 19 H	P4.2 ■ 16 E	P4.3 ■ 13 E	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 8 E	M3.2 ■ 7 E	M3.3 ■ 6 E	M4.1 ■ 9 C	K1.1 ■ 24 J	K1.2 ■ 18 J	K1.3 ■ 13 J	K2.1 ■ 23 J	K2.2 ■ 19 J	K2.3 ■ 15 I	K3.1 ■ 21 J	K3.2 ■ 16 J
K3.3 ■ 13 I	K4.1 ■ 19 J	K4.2 ■ 14 J	K4.3 ■ 11 I	K4.4 ■ 9 I	K4.5 ■ 8 I	K5.1 ■ 22 J	K5.2 ■ 16 J	K5.3 ■ 13 I	N1.1 ■ 60 J	N1.2 ■ 45 J	N1.3 ■ 30 N	N2.1 ■ 62 N	N2.2 ■ 55 N
N2.3 ■ 40 N	N3.1 ■ 90 H	N3.2 ■ 53 I	N3.3 ■ 27 G	N4.1 ■ 55 I	N4.2 ■ 40 G	S1.1 ■ 22 E	S1.2 ■ 15 E	S1.3 ■ 6 C	S2.1 ■ 9 G	S2.2 ■ 8 C	S3.1 ■ 7 G	S3.2 ■ 6 C	S4.1 ■ 5 G
S4.2 ■ 5 C													

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9001.0	—	1.00	0.0394	12.0	34.0	1.00
A9001.1	—	1.10	0.0433	14.0	36.0	1.10
A9001.2	—	1.20	0.0472	16.0	38.0	1.20
A9001.25	—	1.25	0.0492	16.0	36.0	1.25
A9001.3	—	1.30	0.0512	16.0	38.0	1.30
A9001.4	—	1.40	0.0551	18.0	40.0	1.40
A9001.5	—	1.50	0.0591	18.0	40.0	1.50
A9001.55	—	1.55	0.0610	20.0	43.0	1.55
A9001/16	1/16	1.59	0.0625	22.0	48.0	1.59
A9001.6	—	1.60	0.0630	20.0	43.0	1.60
A9001.7	—	1.70	0.0669	20.0	43.0	1.70
A9001.75	—	1.75	0.0689	22.0	46.0	1.75
A9001.8	—	1.80	0.0709	22.0	46.0	1.80
A9001.9	—	1.90	0.0748	22.0	46.0	1.90
A9005/64	5/64	1.98	0.0781	25.0	51.0	1.98
A9002.0	—	2.00	0.0787	24.0	49.0	2.00
A9002.1	—	2.10	0.0827	24.0	49.0	2.10
A9002.2	—	2.20	0.0866	27.0	53.0	2.20
A9002.3	—	2.30	0.0906	27.0	53.0	2.30
A9003/32	3/32	2.38	0.0937	32.0	57.0	2.38
A9002.4	—	2.40	0.0945	30.0	57.0	2.40
A9002.5	—	2.50	0.0984	30.0	57.0	2.50
A9002.6	—	2.60	0.1024	30.0	57.0	2.60
A9002.7	—	2.70	0.1063	33.0	61.0	2.70

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9007/64	7/64	2.78	0.1094	38.0	67.0	2.78
A9002.8	—	2.80	0.1102	33.0	61.0	2.80
A9002.9	—	2.90	0.1142	33.0	61.0	2.90
A9003.0	—	3.00	0.1181	33.0	61.0	3.00
A9003.1	—	3.10	0.1220	36.0	65.0	3.10
A9001/8	1/8	3.18	0.1250	41.0	70.0	3.18
A9003.2	—	3.20	0.1260	36.0	65.0	3.20
A9003.3	—	3.30	0.1299	36.0	65.0	3.30
A9003.4	—	3.40	0.1339	39.0	70.0	3.40
A9003.5	—	3.50	0.1378	39.0	70.0	3.50
A9009/64	9/64	3.57	0.1406	44.0	73.0	3.57
A9003.6	—	3.60	0.1417	39.0	70.0	3.60
A9003.7	—	3.70	0.1457	39.0	70.0	3.70
A9003.8	—	3.80	0.1496	43.0	75.0	3.80
A9003.9	—	3.90	0.1535	43.0	75.0	3.90
A9005/32	5/32	3.97	0.1563	51.0	79.0	3.97
A9004.0	—	4.00	0.1575	43.0	75.0	4.00
A9004.1	—	4.10	0.1614	43.0	75.0	4.10
A9004.2	—	4.20	0.1654	43.0	75.0	4.20
A9004.3	—	4.30	0.1693	47.0	80.0	4.30
A90011/64	11/64	4.37	0.1719	54.0	83.0	4.37
A9004.5	—	4.50	0.1772	47.0	80.0	4.50
A9004.6	—	4.60	0.1811	47.0	80.0	4.60
A9004.7	—	4.70	0.1850	47.0	80.0	4.70

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9003/16	3/16	4.76	0.1875	59.0	89.0	4.76
A9004.9	—	4.90	0.1929	52.0	86.0	4.90
A9005.0	—	5.00	0.1969	52.0	86.0	5.00
A9005.1	—	5.10	0.2008	52.0	86.0	5.10
A90013/64	13/64	5.16	0.2031	62.0	92.0	5.16
A9005.2	—	5.20	0.2047	52.0	86.0	5.20
A9005.3	—	5.30	0.2087	52.0	86.0	5.30
A9005.4	—	5.40	0.2126	57.0	93.0	5.40
A9005.5	—	5.50	0.2165	57.0	93.0	5.50
A9007/32	7/32	5.56	0.2188	64.0	95.0	5.56
A9005.6	—	5.60	0.2205	57.0	93.0	5.60
A9005.7	—	5.70	0.2244	57.0	93.0	5.70
A9005.8	—	5.80	0.2283	57.0	93.0	5.80
A9005.9	—	5.90	0.2323	57.0	93.0	5.90
A9006.0	—	6.00	0.2362	57.0	93.0	6.00
A9006.1	—	6.10	0.2402	63.0	101.0	6.10
A9006.2	—	6.20	0.2441	63.0	101.0	6.20
A9006.3	—	6.30	0.2480	63.0	101.0	6.30
A9001/4	1/4	6.35	0.2500	70.0	102.0	6.35
A9006.4	—	6.40	0.2520	63.0	101.0	6.40
A9006.5	—	6.50	0.2559	63.0	101.0	6.50
A9006.6	—	6.60	0.2598	63.0	101.0	6.60
A9006.7	—	6.70	0.2638	63.0	101.0	6.70
A90017/64	17/64	6.75	0.2656	73.0	105.0	6.75
A9006.8	—	6.80	0.2677	69.0	109.0	6.80
A9006.9	—	6.90	0.2717	69.0	109.0	6.90
A9007.0	—	7.00	0.2756	69.0	109.0	7.00
A9007.1	—	7.10	0.2795	69.0	109.0	7.10
A9007.2	—	7.20	0.2835	69.0	109.0	7.20
A9007.4	—	7.40	0.2913	69.0	109.0	7.40
A9007.5	—	7.50	0.2953	69.0	109.0	7.50
A9005/16	5/16	7.94	0.3125	81.0	114.0	7.94
A9008.0	—	8.00	0.3150	75.0	117.0	8.00
A9008.1	—	8.10	0.3189	75.0	117.0	8.10
A9008.5	—	8.50	0.3346	75.0	117.0	8.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9008.7	—	8.70	0.3425	81.0	125.0	8.70
A90011/32	11/32	8.73	0.3438	87.0	121.0	8.73
A9008.8	—	8.80	0.3465	81.0	125.0	8.80
A9009.0	—	9.00	0.3543	81.0	125.0	9.00
A9009.5	—	9.50	0.3740	81.0	125.0	9.50
A9003/8	3/8	9.52	0.3750	92.0	127.0	9.52
A90010.0	—	10.00	0.3937	87.0	133.0	10.00
A90010.2	—	10.20	0.4016	87.0	133.0	10.20
A90010.3	—	10.30	0.4055	87.0	133.0	10.30
A90010.5	—	10.50	0.4134	87.0	133.0	10.50
A90011.0	—	11.00	0.4331	94.0	142.0	11.00
A90011.5	—	11.50	0.4528	94.0	142.0	11.50
A90011.8	—	11.80	0.4646	94.0	142.0	11.80
A90015/32	15/32	11.91	0.4688	110.0	146.0	11.91
A90012.0	—	12.00	0.4724	101.0	151.0	12.00
A90031/64	31/64	12.30	0.4844	111.0	149.0	12.30
A90012.5	—	12.50	0.4921	101.0	151.0	12.50
A9001/2	1/2	12.70	0.5000	101.0	151.0	12.70
A90013.0	—	13.00	0.5118	101.0	151.0	13.00
A90013.5	—	13.50	0.5315	108.0	160.0	13.50
A90014.0	—	14.00	0.5512	108.0	160.0	14.00
A9009/16	9/16	14.29	0.5625	122.0	168.0	14.29
A90015.0	—	15.00	0.5906	114.0	169.0	15.00
A90016.0	—	16.00	0.6299	120.0	178.0	16.00
A90017.0	—	17.00	0.6693	125.0	184.0	17.00
A90011/16	11/16	17.46	0.6875	143.0	194.0	17.46
A90018.0	—	18.00	0.7087	130.0	191.0	18.00
A90023/32	23/32	18.26	0.7188	130.0	191.0	18.26
A90018.5	—	18.50	0.7283	135.0	198.0	18.50
A90047/64	47/64	18.65	0.7344	135.0	198.0	18.65
A9003/4	3/4	19.05	0.7500	135.0	198.0	19.05
A90049/64	49/64	19.45	0.7656	135.0	198.0	19.45
A90019.5	—	19.50	0.7677	140.0	205.0	19.50
A90025/32	25/32	19.84	0.7813	140.0	205.0	19.84
A90020.0	—	20.00	0.7874	140.0	205.0	20.00

A940

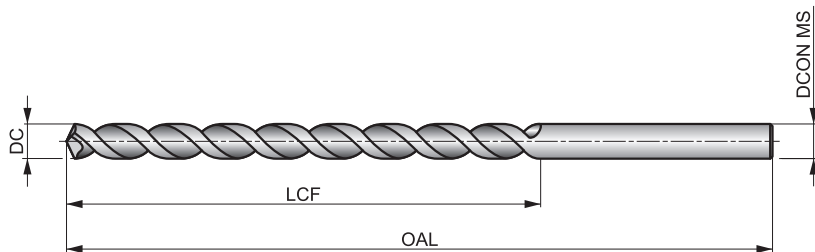
 DORMER



PFX HSS-E (5% kobolt) langt bor, blank finish

Højtydende boremaskine, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og fremførslser (H10 hultolerance). Selvcenterende 130 ° punktsvinkel og specielt parabolisk fløjtdesign hjælper med at bore dybe huller i en enkelt passage. Velegnet til mange materialer.

PFX



HSS-E	DIN ANSI	10×D
	Bright	
		DC h8

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 29 F	P1.2 ■ 33 F	P1.3 ■ 34 F	P2.1 ■ 25 F	P2.2 ■ 22 G	P2.3 ■ 19 C	P3.1 ■ 25 G	P3.2 ■ 20 G	P3.3 ■ 17 C	P4.1 ■ 15 G	P4.2 ■ 13 C	P4.3 ■ 10 C	M1.1 ■ 21 C	M1.2 ■ 17 C
M2.1 ■ 18 C	M2.2 ■ 15 C	M3.1 ■ 8 E	M3.2 ■ 7 E	M3.3 ■ 6 E	M4.1 ■ 9 B	K2.1 ■ 20 I	K2.2 ■ 16 I	K2.3 ■ 13 H	K3.1 ■ 17 I	K3.2 ■ 13 I	K3.3 ■ 11 H	K4.1 ■ 16 I	K4.2 ■ 12 I
K4.3 ■ 9 H	K4.4 ■ 8 H	K4.5 ■ 6 H	K5.1 ■ 18 I	K5.2 ■ 14 I	K5.3 ■ 11 H	N1.1 ■ 53 H	N1.2 ■ 40 H	N1.3 ■ 27 N	N2.1 ■ 62 N	N2.2 ■ 55 N	N2.3 ■ 40 N	N3.1 ■ 119 G	N3.2 ■ 70 F
N3.3 ■ 35 F	N4.1 ■ 55 H	N4.2 ■ 40 F	S1.1 ■ 18 E	S1.2 ■ 13 C	S1.3 ■ 6 C								

DC> = 9,6 mm mindre end 10xD.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9401.0	—	1.00	0.0394	33.0	56.0	1.00
A9401.1	—	1.10	0.0433	37.0	60.0	1.10
A9403/64	3/64	1.19	0.0469	29.0	57.0	1.19
A9401.2	—	1.20	0.0472	41.0	65.0	1.20
A9401.3	—	1.30	0.0512	41.0	65.0	1.30
A9401.4	—	1.40	0.0551	45.0	70.0	1.40
A9401.5	—	1.50	0.0591	45.0	70.0	1.50
A9401/16	1/16	1.59	0.0625	44.0	76.0	1.59
A9401.6	—	1.60	0.0630	50.0	76.0	1.60
A9401.7	—	1.70	0.0669	50.0	76.0	1.70
A9401.8	—	1.80	0.0709	53.0	80.0	1.80
A9401.9	—	1.90	0.0748	53.0	80.0	1.90
A9405/64	5/64	1.98	0.0781	51.0	95.0	1.98
A9402.0	—	2.00	0.0787	56.0	85.0	2.00
A9402.1	—	2.10	0.0827	56.0	85.0	2.10
A9402.2	—	2.20	0.0866	59.0	90.0	2.20
A9402.3	—	2.30	0.0906	59.0	90.0	2.30
A9403/32	3/32	2.38	0.0938	57.0	108.0	2.38
A9402.4	—	2.40	0.0945	62.0	95.0	2.40
A9402.5	—	2.50	0.0984	62.0	95.0	2.50
A9402.6	—	2.60	0.1024	62.0	95.0	2.60
A9402.7	—	2.70	0.1063	66.0	100.0	2.70
A9407/64	7/64	2.78	0.1094	64.0	117.0	2.78
A9402.8	—	2.80	0.1102	66.0	100.0	2.80
A9402.9	—	2.90	0.1142	66.0	100.0	2.90

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9403.0	—	3.00	0.1181	66.0	100.0	3.00
A9403.1	—	3.10	0.1220	69.0	106.0	3.10
A9401/8	1/8	3.18	0.1250	70.0	130.0	3.18
A9403.2	—	3.20	0.1260	69.0	106.0	3.20
A9403.3	—	3.30	0.1299	69.0	106.0	3.30
A9403.4	—	3.40	0.1339	73.0	112.0	3.40
A9403.5	—	3.50	0.1378	73.0	112.0	3.50
A9409/64	9/64	3.57	0.1406	76.0	137.0	3.57
A9403.6	—	3.60	0.1417	73.0	112.0	3.60
A9403.7	—	3.70	0.1457	73.0	112.0	3.70
A9403.8	—	3.80	0.1496	78.0	119.0	3.80
A9403.9	—	3.90	0.1535	78.0	119.0	3.90
A9405/32	5/32	3.97	0.1563	76.0	137.0	3.97
A9404.0	—	4.00	0.1575	78.0	119.0	4.00
A9404.1	—	4.10	0.1614	78.0	119.0	4.10
A9404.2	—	4.20	0.1654	78.0	119.0	4.20
A9404.3	—	4.30	0.1693	82.0	126.0	4.30
A9404.4	—	4.40	0.1732	82.0	126.0	4.40
A9404.5	—	4.50	0.1772	82.0	126.0	4.50
A9404.6	—	4.60	0.1811	82.0	126.0	4.60
A9403/16	3/16	4.76	0.1875	86.0	146.0	4.76
A9404.8	—	4.80	0.1890	87.0	132.0	4.80
A9404.9	—	4.90	0.1929	87.0	132.0	4.90
A9405.0	—	5.00	0.1969	87.0	132.0	5.00
A9405.1	—	5.10	0.2008	87.0	132.0	5.10

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9405.2	—	5.20	0.2047	87.0	132.0	5.20
A9405.3	—	5.30	0.2087	87.0	132.0	5.30
A9405.4	—	5.40	0.2126	91.0	139.0	5.40
A9405.5	—	5.50	0.2165	91.0	139.0	5.50
A9405.8	—	5.80	0.2283	91.0	139.0	5.80
A9405.9	—	5.90	0.2323	91.0	139.0	5.90
A9406.0	—	6.00	0.2362	91.0	139.0	6.00
A9406.1	—	6.10	0.2402	97.0	148.0	6.10
A9406.2	—	6.20	0.2441	97.0	148.0	6.20
A9401/4	1/4	6.35	0.2500	95.0	156.0	6.35
A9406.4	—	6.40	0.2520	97.0	148.0	6.40
A9406.5	—	6.50	0.2559	97.0	148.0	6.50
A9406.6	—	6.60	0.2598	97.0	148.0	6.60
A9406.7	—	6.70	0.2638	97.0	148.0	6.70
A94017/64	17/64	6.75	0.2656	98.0	159.0	6.75
A9406.8	—	6.80	0.2677	102.0	156.0	6.80
A9406.9	—	6.90	0.2717	102.0	156.0	6.90
A9407.0	—	7.00	0.2756	102.0	156.0	7.00
A9407.2	—	7.20	0.2835	102.0	156.0	7.20
A9407.3	—	7.30	0.2874	102.0	156.0	7.30
A9407.5	—	7.50	0.2953	102.0	156.0	7.50
A9407.8	—	7.80	0.3071	109.0	165.0	7.80
A9405/16	5/16	7.94	0.3125	102.0	162.0	7.94
A9408.0	—	8.00	0.3150	109.0	165.0	8.00
A9408.2	—	8.20	0.3228	109.0	165.0	8.20
A9408.3	—	8.30	0.3268	109.0	165.0	8.30
A9408.5	—	8.50	0.3346	109.0	165.0	8.50
A9408.6	—	8.60	0.3386	115.0	175.0	8.60
A9408.7	—	8.70	0.3425	115.0	175.0	8.70
A94011/32	11/32	8.73	0.3438	105.0	165.0	8.73

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9409.0	—	9.00	0.3543	115.0	175.0	9.00
A9409.5	—	9.50	0.3740	115.0	175.0	9.50
A9409.8	—	9.80	0.3858	121.0	184.0	9.80
A94010.0	—	10.00	0.3937	121.0	184.0	10.00
A94010.2	—	10.20	0.4016	121.0	184.0	10.20
A94010.3	—	10.30	0.4055	121.0	184.0	10.30
A94013/32	13/32	10.32	0.4063	111.0	178.0	10.32
A94010.5	—	10.50	0.4134	121.0	184.0	10.50
A94027/64	27/64	10.72	0.4219	117.0	184.0	10.72
A94011.0	—	11.00	0.4331	128.0	195.0	11.00
A9407/16	7/16	11.11	0.4375	117.0	184.0	11.11
A94011.5	—	11.50	0.4528	128.0	195.0	11.50
A94029/64	29/64	11.51	0.4531	121.0	190.0	11.51
A94011.8	—	11.80	0.4646	128.0	195.0	11.80
A94012.0	—	12.00	0.4724	134.0	205.0	12.00
A94012.2	—	12.20	0.4803	134.0	205.0	12.20
A94031/64	31/64	12.30	0.4844	121.0	197.0	12.30
A94012.5	—	12.50	0.4921	134.0	205.0	12.50
A94013.0	—	13.00	0.5118	134.0	205.0	13.00
A94017/32	17/32	13.49	0.5313	121.0	203.0	13.49
A94014.0	—	14.00	0.5512	140.0	214.0	14.00
A9409/16	9/16	14.29	0.5625	124.0	210.0	14.29
A94014.5	—	14.50	0.5709	144.0	220.0	14.50
A94015.0	—	15.00	0.5906	144.0	220.0	15.00
A94015.5	—	15.50	0.6102	149.0	227.0	15.50
A94016.0	—	16.00	0.6299	149.0	227.0	16.00
A94021/32	21/32	16.67	0.6563	130.0	229.0	16.67
A94017.0	—	17.00	0.6693	154.0	235.0	17.00
A94011/16	11/16	17.46	0.6875	137.0	235.0	17.46
A94019.0	—	19.00	0.7480	162.0	247.0	19.00

A976

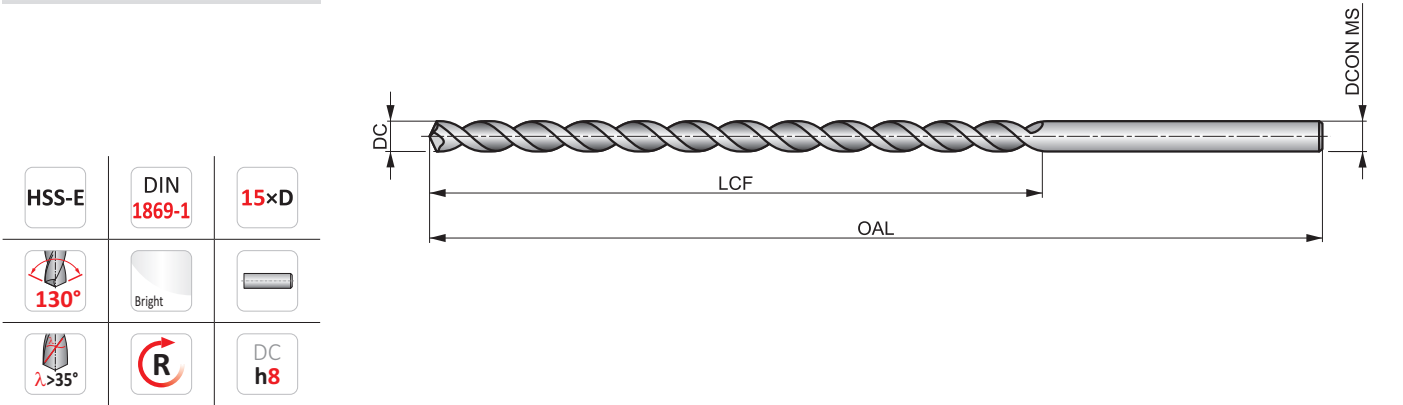
 DORMER



PFX HSS-E (5% kobolt) ekstra langt bor (DIN 1869 serie 1), blank finish

Anbefales til boring af meget dybe huller og i applikationer, hvor der er behov for ekstra rækkevidde. Specielt designet parabolske skær fjerner behovet for at bore dybe huller i korte trin (hakke). Et 130 ° spids. Det anbefales at centrere med en kort 3xD PFX-bor (for at holde samme DC-tolerance). Velegnet til boring af mange materialer.

PFX



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■29 C	■33 C	■34 C	■25 C	■22 C	■19 A	■18 C	■14 C	■12 A	■11 C	■9 A	■7 A	■16 B	■14 B
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2
■15 B	■12 B	■8 C	■7 C	■6 C	■8 A	■20 C	■16 C	■13 A	■17 C	■13 C	■11 A	■16 C	■12 C
K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N3.1	S1.1	S1.2	S1.3				
■19 A	■8 A	■6 A	■18 C	■14 C	■11 A	■30 D	■15 C	■11 A	■5 A				

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9761.5	—	1.50	0.0591	75.0	115.0	1.50
A9762.0X125	—	2.00	0.0787	85.0	125.0	2.00
A9762.1X125	—	2.10	0.0827	85.0	125.0	2.10
A9762.2X135	—	2.20	0.0866	90.0	135.0	2.20
A9762.3X135	—	2.30	0.0906	90.0	135.0	2.30
A9762.4X140	—	2.40	0.0945	95.0	140.0	2.40
A9762.5X140	—	2.50	0.0984	95.0	140.0	2.50
A9762.6X140	—	2.60	0.1024	95.0	140.0	2.60
A9762.7X150	—	2.70	0.1063	100.0	150.0	2.70
A9762.8X150	—	2.80	0.1102	100.0	150.0	2.80
A9762.9X150	—	2.90	0.1142	100.0	150.0	2.90
A9763.0X150	—	3.00	0.1181	100.0	150.0	3.00
A9763.1X155	—	3.10	0.1220	105.0	155.0	3.10
A9761/8	1/8	3.18	0.1250	105.0	155.0	3.18
A9763.2X155	—	3.20	0.1260	105.0	155.0	3.20
A9763.3X155	—	3.30	0.1299	105.0	155.0	3.30
A9763.4X165	—	3.40	0.1339	115.0	165.0	3.40
A9763.5X165	—	3.50	0.1378	115.0	165.0	3.50
A9763.6X165	—	3.60	0.1417	115.0	165.0	3.60
A9763.7X165	—	3.70	0.1457	115.0	165.0	3.70
A9763.8X175	—	3.80	0.1496	120.0	175.0	3.80
A9763.9X175	—	3.90	0.1535	120.0	175.0	3.90
A9765/32	5/32	3.97	0.1563	120.0	175.0	3.97
A9764.0X175	—	4.00	0.1575	120.0	175.0	4.00
A9764.1X175	—	4.10	0.1614	120.0	175.0	4.10
A9764.2X175	—	4.20	0.1654	120.0	175.0	4.20
A9764.3X185	—	4.30	0.1693	125.0	185.0	4.30
A9764.5X185	—	4.50	0.1772	125.0	185.0	4.50
A9764.6X185	—	4.60	0.1811	125.0	185.0	4.60
A9764.7X185	—	4.70	0.1850	125.0	185.0	4.70
A9763/16	3/16	4.76	0.1875	135.0	195.0	4.76
A9764.8X195	—	4.80	0.1890	135.0	195.0	4.80
A9765.0X195	—	5.00	0.1969	135.0	195.0	5.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9765.1X195	—	5.10	0.2008	135.0	195.0	5.10
A9765.2X195	—	5.20	0.2047	135.0	195.0	5.20
A9765.3X195	—	5.30	0.2087	135.0	195.0	5.30
A9765.5X205	—	5.50	0.2165	140.0	205.0	5.50
A9765.7X205	—	5.70	0.2244	140.0	205.0	5.70
A9765.8X205	—	5.80	0.2283	140.0	205.0	5.80
A9765.9X205	—	5.90	0.2323	140.0	205.0	5.90
A9766.0X205	—	6.00	0.2362	140.0	205.0	6.00
A9766.1X215	—	6.10	0.2402	150.0	215.0	6.10
A9766.2X215	—	6.20	0.2441	150.0	215.0	6.20
A9761/4	1/4	6.35	0.2500	150.0	215.0	6.35
A9766.4X215	—	6.40	0.2520	150.0	215.0	6.40
A9766.5X215	—	6.50	0.2559	150.0	215.0	6.50
A9766.7X215	—	6.70	0.2638	150.0	215.0	6.70
A9766.8X225	—	6.80	0.2677	155.0	225.0	6.80
A9767.0X225	—	7.00	0.2756	155.0	225.0	7.00
A9767.5X225	—	7.50	0.2953	155.0	225.0	7.50
A9765/16	5/16	7.94	0.3125	165.0	240.0	7.94
A9768.0X240	—	8.00	0.3150	165.0	240.0	8.00
A9768.5X240	—	8.50	0.3346	165.0	240.0	8.50
A97611/32	11/32	8.73	0.3438	175.0	250.0	8.73
A9769.0X250	—	9.00	0.3543	175.0	250.0	9.00
A9769.5X250	—	9.50	0.3740	175.0	250.0	9.50
A9763/8	3/8	9.52	0.3750	185.0	265.0	9.52
A97610.0X265	—	10.00	0.3937	185.0	265.0	10.00
A97610.5	—	10.50	0.4134	185.0	265.0	10.50
A97611.0	—	11.00	0.4331	195.0	280.0	11.00
A9767/16	7/16	11.11	0.4375	195.0	280.0	11.11
A97611.5	—	11.50	0.4528	195.0	280.0	11.50
A97612.0	—	12.00	0.4724	205.0	295.0	12.00
A97612.5	—	12.50	0.4921	205.0	295.0	12.50
A97613.0	—	13.00	0.5118	205.0	295.0	13.00
A97614.0 ¹⁾	—	14.00	0.5512	215.0	310.0	14.00

A977

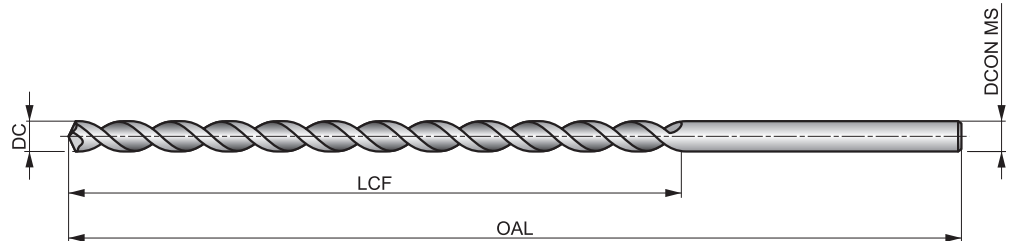
 **DORMER**



PFX HSS-E (5% kobolt) ekstra langt bor (DIN 1869 serie 2), blank finish

Anbefales til boring af meget dybe huller og i applikationer, hvor der er behov for ekstra rækkevidde. Specielt designet parabolske skær fjerner behovet for at bore dybe huller i korte trin (hakke). Et 130 ° spids. Det anbefales at centrere med en kort 3xD PFX-bor (for at holde samme DC-tolerance). Velegnet til boring af mange materialer.

PFX



HSS-E	DIN 1869-2	20xD
	Bright	
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ▣29 B	P1.2 ▣33 B	P1.3 ▣34 B	P2.1 ▣25 B	P2.2 ▣22 B	P2.3 ▣19 A	P3.1 ▣18 B	P3.2 ▣14 B	P3.3 ▣12 A	P4.1 ▣11 B	P4.2 ▣9 A	P4.3 ▣7 A	M1.1 ▣16 B	M1.2 ▣14 B
M2.1 ▣15 B	M2.2 ▣12 B	M3.1 ▣8 B	M3.2 ▣7 B	M3.3 ▣6 B	M4.1 ▣8 A	K2.1 ▣20 B	K2.2 ▣16 B	K2.3 ▣13 A	K3.1 ▣17 B	K3.2 ▣13 B	K3.3 ▣11 A	K4.1 ▣16 B	K4.2 ▣12 B
K4.3 ▣9 A	K4.4 ▣8 A	K4.5 ▣6 A	K5.1 ▣18 B	K5.2 ▣14 B	K5.3 ▣11 A	N3.1 ▣30 C	S1.1 ▣15 B	S1.2 ▣11 A	S1.3 ▣5 A				

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9771.5 ¹⁾	—	1.50	0.0591	100.0	150.0	1.50
A9771/16 ¹⁾	1/16	1.59	0.0625	100.0	150.0	1.59
A9772.0 ¹⁾	—	2.00	0.0787	110.0	160.0	2.00
A9773/32 ¹⁾	3/32	2.38	0.0938	115.0	170.0	2.38
A9773.0X190	—	3.00	0.1181	130.0	190.0	3.00
A9771/8	1/8	3.18	0.1250	135.0	200.0	3.18
A9773.5X210	—	3.50	0.1378	145.0	210.0	3.50
A9774.0X220	—	4.00	0.1575	150.0	220.0	4.00
A9774.5X235	—	4.50	0.1772	160.0	235.0	4.50
A9773/16	3/16	4.76	0.1875	170.0	245.0	4.76
A9775.0X245	—	5.00	0.1969	170.0	245.0	5.00
A9775.5X260	—	5.50	0.2165	180.0	260.0	5.50
A9776.0X260	—	6.00	0.2362	180.0	260.0	6.00
A9771/4	1/4	6.35	0.2500	190.0	275.0	6.35

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9776.5X275	—	6.50	0.2559	190.0	275.0	6.50
A9777.0X290	—	7.00	0.2756	200.0	290.0	7.00
A9778.0X305	—	8.00	0.3150	210.0	305.0	8.00
A9778.5X305	—	8.50	0.3346	210.0	305.0	8.50
A9779.0X320	—	9.00	0.3543	220.0	320.0	9.00
A9779.5X320	—	9.50	0.3740	220.0	320.0	9.50
A97710.0X340	—	10.00	0.3937	235.0	340.0	10.00
A97710.5	—	10.50	0.4134	235.0	340.0	10.50
A97711.0	—	11.00	0.4331	250.0	365.0	11.00
A97711.5	—	11.50	0.4528	250.0	365.0	11.50
A97712.0	—	12.00	0.4724	260.0	375.0	12.00
A97712.5	—	12.50	0.4921	260.0	375.0	12.50
A97713.0	—	13.00	0.5118	260.0	375.0	13.00
A97714.0 ¹⁾	—	14.00	0.5512	270.0	390.0	14.00

¹⁾ Dormer Standard.

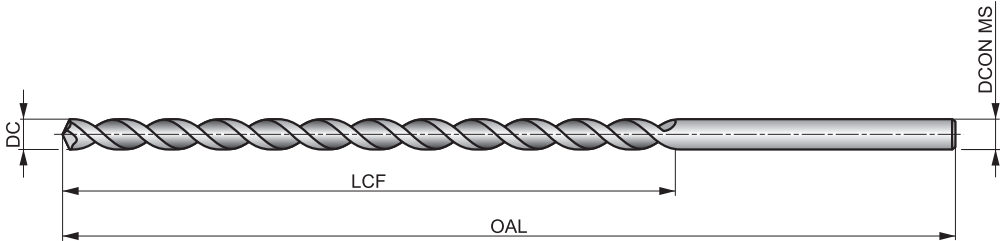
A978



PFX HSS-E (5% kobolt) ekstra langt bor (DIN 1869 serie 3), blank finish

Anbefales til boring af meget dybe huller og i applikationer, hvor der er behov for ekstra rækkevidde. Specielt designet parabolske skær fjerner behovet for at bore dybe huller i korte trin (hakke). Et 130 ° spids. Det anbefales at centrere med en kort 3xD PFX-bor (for at holde samme DC-tolerance). Velegnet til boring af mange materialer.

PFX



HSS-E	DIN 1869-3	25xD
	Bright	
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ▣29 A	P1.2 ▣33 A	P1.3 ▣34 A	P2.1 ▣25 A	P2.2 ▣22 A	P2.3 ▣19 A	P3.1 ▣18 A	P3.2 ▣14 A	P3.3 ▣12 A	P4.1 ▣11 A	P4.2 ▣9 A	P4.3 ▣7 A	M1.1 ▣16 A	M1.2 ▣14 A
M2.1 ▣15 A	M2.2 ▣12 A	M3.1 ▣8 A	M3.2 ▣7 A	M3.3 ▣6 A	M4.1 ▣8 A	K2.1 ▣20 A	K2.2 ▣16 A	K2.3 ▣13 A	K3.1 ▣17 A	K3.2 ▣13 A	K3.3 ▣11 A	K4.1 ▣16 A	K4.2 ▣12 A
K4.3 ▣9 A	K4.4 ▣8 A	K4.5 ▣6 A	K5.1 ▣18 A	K5.2 ▣14 A	K5.3 ▣11 A	N3.1 ▣30 B	S1.1 ▣15 A	S1.2 ▣11 A	S1.3 ▣5 A				

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9783.0 ¹⁾	—	3.00	0.1181	160.0	240.0	3.00
A9783.5X265	—	3.50	0.1378	180.0	265.0	3.50
A9784.0X280	—	4.00	0.1575	190.0	280.0	4.00
A9784.5X295	—	4.50	0.1772	200.0	295.0	4.50
A9785.0X315	—	5.00	0.1969	210.0	315.0	5.00
A9786.0X330	—	6.00	0.2362	225.0	330.0	6.00
A9781/4	1/4	6.35	0.2500	235.0	350.0	6.35
A9786.5X350	—	6.50	0.2559	235.0	350.0	6.50
A9787.0X370	—	7.00	0.2756	250.0	370.0	7.00
A9788.0X390	—	8.00	0.3150	265.0	390.0	8.00
A9788.5X390	—	8.50	0.3346	265.0	390.0	8.50
A9789.0X410	—	9.00	0.3543	280.0	410.0	9.00
A9789.5X410	—	9.50	0.3740	280.0	410.0	9.50
A97810.0X430	—	10.00	0.3937	295.0	430.0	10.00

¹⁾ Dormer Standard.

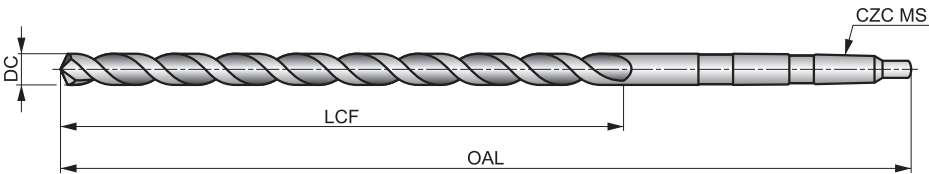
A952





HSS PFX ekstra lang serie MK skaftbor (DIN 1870 serie 2), blank finish

Et alsidig bor med et specielt parabolisk skærdesign til boring af dybe huller i en enkelt passage. Boret har et selvcentrerende 130 ° spids (det anbefales at centrere med en kort PFX-bor), så den krævede kraft til at bore hullet reduceres. Velegnet til boring af mange materialer.



HSS	DIN 1870(2)	20xD
		
		DC h8

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 25 G	P1.2 ■ 28 G	P1.3 ■ 29 G	P2.1 ■ 22 G	P2.2 ■ 19 E	P2.3 ■ 17 C	P3.1 ■ 12 D	P3.2 ■ 9 D	P3.3 ■ 8 C	P4.1 ■ 7 D	P4.2 ■ 6 C	P4.3 ■ 5 B	M1.1 ■ 16 C	M1.2 ■ 14 C
M2.1 ■ 15 C	M2.2 ■ 12 C	M3.1 ■ 7 E	M3.2 ■ 6 E	M3.3 ■ 5 E	M4.1 ■ 12 A	K1.1 ■ 22 G	K1.2 ■ 16 D	K1.3 ■ 12 D	K2.1 ■ 16 C	K2.2 ■ 13 C	K2.3 ■ 10 C	K3.1 ■ 14 C	K3.2 ■ 11 C
K3.3 ■ 9 C	K4.1 ■ 13 C	K4.2 ■ 10 C	K4.3 ■ 7 C	K4.4 ■ 6 C	K4.5 ■ 5 C	K5.1 ■ 15 C	K5.2 ■ 11 C	K5.3 ■ 9 C	N1.1 ■ 30 H	N1.2 ■ 23 H	N1.3 ■ 15 G	N2.1 ■ 37 F	N2.2 ■ 33 F
N2.3 ■ 24 F	N3.1 ■ 56 F	N3.2 ■ 33 G	N3.3 ■ 17 D	N4.1 ■ 30 J	N4.2 ■ 30 H	N4.3 ■ 10 F	S1.1 ■ 18 D	S1.2 ■ 10 B	S1.3 ■ 6 A	S2.1 ■ 7 C	S2.2 ■ 4 A	S3.1 ■ 5 C	S3.2 ■ 3 A
S4.1 ■ 4 C	S4.2 ■ 2 A												

DC> = 14,5 mm mindre end 20xD; DC >23 mm blank.

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A9528.0	8.00	0.3150	210.0	330.0	MK 1
A9529.0	9.00	0.3543	220.0	345.0	MK 1
A95210.0	10.00	0.3937	235.0	360.0	MK 1
A95211.0	11.00	0.4331	250.0	375.0	MK 1
A95213.0	13.00	0.5118	260.0	395.0	MK 1
A95214.0	14.00	0.5512	275.0	410.0	MK 1
A95215.0	15.00	0.5906	275.0	425.0	MK 2
A95216.0	16.00	0.6299	295.0	445.0	MK 2
A95217.0	17.00	0.6693	295.0	445.0	MK 2
A95219.0	19.00	0.7480	310.0	465.0	MK 2

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A95220.0	20.00	0.7874	325.0	490.0	MK 2
A95221.0	21.00	0.8268	325.0	490.0	MK 2
A95223.0	23.00	0.9055	345.0	515.0	MK 2
A95224.0	24.00	0.9449	365.0	555.0	MK 3
A95225.0	25.00	0.9843	365.0	555.0	MK 3
A95226.0	26.00	1.0236	365.0	555.0	MK 3
A95227.0	27.00	1.0630	385.0	580.0	MK 3
A95228.0	28.00	1.1024	385.0	580.0	MK 3
A95229.0	29.00	1.1417	385.0	580.0	MK 3
A95230.0	30.00	1.1811	385.0	580.0	MK 3

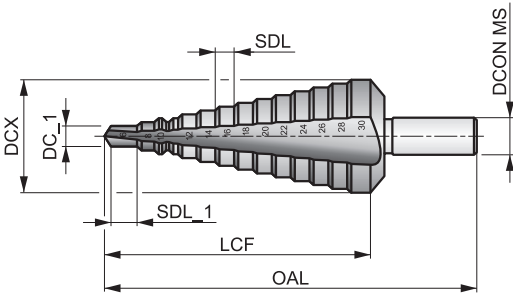
Materiale kode (BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
Grundlæggende standard-gruppe (BSG)		DIN 373	ANSI	ANSI	ANSI	ANSI	ANSI	DIN 8374	DIN 8376			
Brugbar længde (ULDR)								4×D	4×D	2.5×D	2.5×D	
Anvendelsesvinkel												
Belægning												
Skaft												
Spiral form												
Hånd (skæreretning)												
Produktfamiliekode	G314	G125	G702	G703	G704	G705	G706	A400	A402	A413	A412	
PSF skærediametre række-vidde	4.00 - 9.00	6.50 - 20.00	1/4 - 2"	1/2 - 2.1/8	1/8 - 1.1/2	1/4 - 15/16	1/4 - 1"	M3 - M8	M3 - M10	M3 - M10	M3 - M10	
P	P1											
	P2											
	P3											
	P4											
M	M1											
	M2											
	M3											
	M4											
K	K1											
	K2											
	K3											
	K4											
	K5											
N	N1											
	N2											
	N3											
	N4											
	N5											
S	S1											
	S2											
	S3											
	S4											
H	H1											
	H2											
	H3											
	H4											

G314



HSS konisk pladebor til tynde materialer, blank finish

Konisk pladebor har et flertrinsdesign, der muliggør en gradvis forstørrelse af huller til den krævede diameter. Det reducerede glatte skaft betyder, at alle diametre kan holdes i en standard borepatron og holder. Velegnet til at forstørre huller i mange materialer.



HSS

Bright

20°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	M1.1	M1.2	M2.1	K1.1	N1.1	N1.2
■ 20	■ 22	■ 23	■ 17	▣ 15	▣ 13	■ 12	▣ 9	▣ 8	▣ 6	▣ 7	▣ 17	■ 30	■ 23
N1.3	N2.1	N2.2	N3.1	N3.2	N3.3	N4.1	N4.2						
▣ 15	▣ 31	▣ 28	■ 34	■ 20	▣ 10	■ 30	■ 20						

SDI = trin i trindiameter.

Product	Nr.	DC_1	DCX	SDL	SDI	SDL_1	LCF	OAL	DCON MS
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)
G314412	412	4.00	12.00	5.00	4 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12	5.00	61.0	80.0	6.00
G3141220	1220	12.00	20.00	4.00	12 - 13 - 14 - 15 - 16 - 17 - 18 - 19 - 20	4.00	55.0	76.0	9.00
G3142030	2030	20.00	30.00	4.00	20 - 21 - 22 - 23 - 24 - 25 - 26 - 27 - 28 - 29 - 30	4.00	67.0	88.0	12.00
G3143040	3040	30.00	40.00	4.00	30 - 31 - 32 - 33 - 34 - 35 - 36 - 37 - 38 - 39 - 40	4.00	74.0	98.0	13.00
G314420	420	4.00	20.00	4.00	4 - 6 - 8 - 10 - 12 - 14 - 16 - 18 - 20	4.00	48.0	76.0	8.00
G314630	630	6.00	30.00	4.00	6 - 8 - 10 - 12 - 14 - 16 - 18 - 20 - 22 - 24 - 26 - 28 - 30	4.00	73.0	98.0	10.00
G314M	M	9.00	36.00	3.00	9 - 12 - 15 - 18 - 21 - 24 - 27 - 30 - 33 - 36	3.00	57.0	86.0	12.00

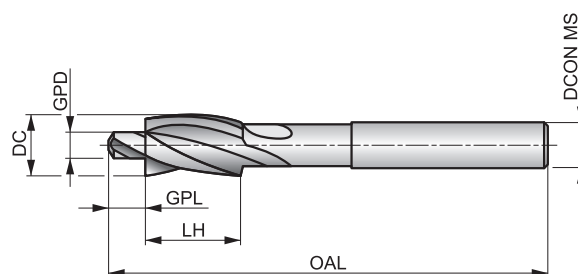
G125

 **DORMER**



HSS lige skaft 180° Tapforsænker, blank finish

Tapforsænker med en 180° vinkel, designet til at skabe huller til standard sokkelhoved- og dækselskruer. Den har et solidt styr (fås til forskellige præ-bearbejdede hulstørrelsestolerancer), som hjælper med nøjagtigt at styre boringen i standardhuller i metrisk størrelse. Velegnet til at bore huller i mange materialer.



HSS	Bright	DIN 373
R		180°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 20 E	P1.2 ■ 22 E	P1.3 ■ 23 E	P2.1 ■ 17 E	P2.2 ■ 15 D	P2.3 ■ 13 C	P3.1 ■ 12 D	P3.2 ■ 9 D	P3.3 ■ 8 C	P4.1 ■ 7 D	P4.2 ■ 6 C	M1.1 ■ 8 D	M1.2 ■ 6 D	M2.1 ■ 7 D
M2.2 ■ 6 D	M2.3 ■ 5 C	K1.1 ■ 17 E	K1.2 ■ 12 E	K1.3 ■ 11 E	K2.1 ■ 15 D	K2.2 ■ 12 D	K2.3 ■ 10 C	K3.1 ■ 13 D	K3.2 ■ 10 D	K4.1 ■ 12 D	K4.2 ■ 9 D	K5.1 ■ 14 D	K5.2 ■ 10 D
N1.1 ■ 30 G	N1.2 ■ 23 G	N1.3 ■ 15 G	N2.1 ■ 31 G	N2.2 ■ 28 G	N2.3 ■ 20 G	N3.1 ■ 34 C	N3.2 ■ 20 C	N3.3 ■ 10 C	N4.1 ■ 30 C	N4.2 ■ 20 C			

DCON MS tolerance h9.

Product	DC	GPD	CZC MS	GPL	OAL	LH	DCON MS	NOF
	(mm)	(mm)		(mm)	(mm)	(mm)	(mm)	
G1256.5X3.2 ¹⁾	6.50	3.20	M 3 f	4.50	71.0	14.0	5.00	3
G1256.5X3.4 ²⁾	6.50	3.40	M 3 m	4.50	71.0	14.0	5.00	3
G1258.0X3.3 ³⁾	8.00	3.30	M 4 t	5.00	71.0	14.0	5.00	3
G1258.0X4.3 ¹⁾	8.00	4.30	M 4 f	5.00	71.0	14.0	5.00	3
G1258.0X4.5 ²⁾	8.00	4.50	M 4 m	5.00	71.0	14.0	5.00	3
G12510.0X4.2 ³⁾	10.00	4.20	M 5 t	5.50	80.0	18.0	8.00	3
G12510.0X5.3 ¹⁾	10.00	5.30	M 5 f	5.50	80.0	18.0	8.00	3
G12510.0X5.5 ²⁾	10.00	5.50	M 5 m	5.50	80.0	18.0	8.00	3
G12511.0X5.0 ³⁾	11.00	5.00	M 6 t	6.00	80.0	18.0	8.00	3
G12511.0X6.4 ¹⁾	11.00	6.40	M 6 f	6.00	80.0	18.0	8.00	3
G12511.0X6.6 ²⁾	11.00	6.60	M 6 m	6.00	80.0	18.0	8.00	3
G12515.0X6.8 ³⁾	15.00	6.80	M 8 t	8.00	100.0	22.0	12.50	3
G12515.0X8.4 ¹⁾	15.00	8.40	M 8 f	8.00	100.0	22.0	12.50	3
G12515.0X9.0 ²⁾	15.00	9.00	M 8 m	8.00	100.0	22.0	12.50	3
G12518.0X8.5 ³⁾	18.00	8.50	M 10 t	10.00	100.0	22.0	12.50	3
G12518.0X10.5 ¹⁾	18.00	10.50	M 10 f	10.00	100.0	22.0	12.50	3
G12518.0X11.0 ²⁾	18.00	11.00	M 10 m	10.00	100.0	22.0	12.50	3
G12520.0X10.2 ³⁾	20.00	10.20	M 12 t	10.00	100.0	22.0	12.50	3
G12520.0X13.0 ¹⁾	20.00	13.00	M 12 f	10.00	100.0	22.0	12.50	3
G12520.0X13.5 ²⁾	20.00	13.50	M 12 m	10.00	100.0	22.0	12.50	3

¹⁾ f = for gennemgående hul fin.

²⁾ m = til gennemgående hul medium.

³⁾ t = til taphul.

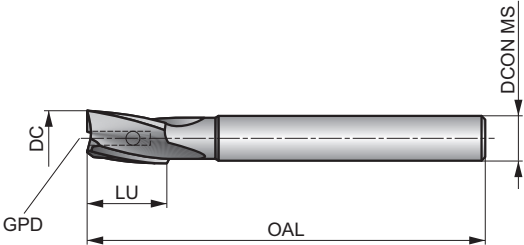
G702

 DORMER



HSS-forsænkingslegeme med reduceret skaft, udskiftelig pilottype

Cylindrisk skaft til forsækning, der bruges sammen med aftagelige piloter til at forstørre toppen af et præformet hul ved at skære en forsækning med flad bund. En aftagelig pilot G704, der ikke skærer, er monteret i kroppen og følger det eksisterende hul for at guide og centrere udboringsoperationen.



HSS	Bright	ANSI
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
20 E	22 E	23 E	17 E	15 D	13 C	12 D	9 D	8 C	7 D	6 C		8 D	6 D
M2.1	M2.2	M2.3	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K4.1	K4.2	K5.1
7 D	6 D	5 C	17 E	12 E	11 E	15 D	12 D	10 C	13 D	10 D	12 D	9 D	14 D
K5.2	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2		
10 D	30 G	23 G	15 G	31 G	28 G	20 G	34 C	20 C	10 C	30 C	20 C		

Product	DC	DC	LU	OAL	DCON MS	NOF	GPD	GPDN	GPDx
	(inch)	(inch)	(inch)	(inch)	(inch)		(inch)	(inch)	(inch)
G7021/4	1/4	0.2500	3/4	3.13/16	15/64	3	3/32	1/8	3/16
G7029/32	9/32	0.2813	3/4	3.13/16	17/64	3	3/32	1/8	7/32
G7025/16	5/16	0.3125	3/4	3.13/16	19/64	3	3/32	1/8	1/4
G70211/32	11/32	0.3438	3/4	3.13/16	5/16	3	3/32	1/8	9/32
G7023/8	3/8	0.3750	1"	4.1/16	5/16	3	5/32	3/16	5/16
G70213/32	13/32	0.4063	1"	4.1/16	3/8	3	5/32	3/16	11/32
G7027/16	7/16	0.4375	1"	4.1/16	3/8	3	5/32	3/16	3/8
G70215/32	15/32	0.4688	1.1/4	4.5/16	7/16	3	3/16	3/16	13/32
G7021/2	1/2	0.5000	1.1/4	4.5/16	7/16	3	3/16	3/16	7/16
G7029/16	9/16	0.5625	1.1/4	4.5/16	1/2	3	3/16	3/16	1/2
G70219/32	19/32	0.5938	1.1/4	5.1/8	1/2	3	3/16	3/16	17/32
G7025/8	5/8	0.6250	1.1/4	5.1/8	1/2	3	3/16	3/16	9/16
G70211/16	11/16	0.6875	1.1/4	5.1/8	1/2	3	3/16	3/16	5/8
G7023/4	3/4	0.7500	1.1/2	5.3/8	1/2	3	1/4	5/16	11/16
G70225/32	25/32	0.7813	1.1/2	5.3/8	5/8	3	1/4	5/16	23/32
G70213/16	13/16	0.8125	1.1/2	5.3/8	5/8	3	1/4	5/16	3/4
G70227/32	27/32	0.8438	1.1/2	5.3/8	3/4	3	1/4	5/16	25/32
G7027/8	7/8	0.8750	1.1/2	5.3/8	3/4	3	1/4	5/16	13/16
G7021	1"	1.0000	1.3/4	6.3/8	3/4	3	5/16	3/8	15/16
G7022	2"	2.0000	2.1/2	8.3/8	1.1/2	5	1/2	9/16	1.15/16

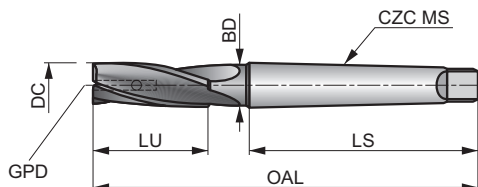
G703

 DORMER



HSS-forsænkingslegeme med konisk skaft, udskiftelig pilottype

Forboringsskrop med morsekonusskaft, der bruges sammen med aftagelige piloter til at forstørre toppen af et forformet hul ved at skære en forboring med flad bund. En aftagelig pilot G704, der ikke skærer, er monteret i kroppen og følger det eksisterende hul for at guide og centrere udboringen.



HSS	Bright	ANSI
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 20 E	P1.2 ■ 22 E	P1.3 ■ 23 E	P2.1 ■ 17 E	P2.2 ■ 15 D	P2.3 ■ 13 C	P3.1 ■ 12 D	P3.2 ■ 9 D	P3.3 ■ 8 C	P4.1 ■ 7 D	P4.2 ■ 6 C	P4.3 ■	M1.1 ■ 8 D	M1.2 ■ 6 D
M2.1 ■ 7 D	M2.2 ■ 6 D	M2.3 ■ 5 C	K1.1 ■ 17 E	K1.2 ■ 12 E	K1.3 ■ 11 E	K2.1 ■ 15 D	K2.2 ■ 12 D	K2.3 ■ 10 C	K3.1 ■ 13 D	K3.2 ■ 10 D	K4.1 ■ 12 D	K4.2 ■ 9 D	K5.1 ■ 14 D
K5.2 ■ 10 D	N1.1 ■ 30 G	N1.2 ■ 23 G	N1.3 ■ 15 G	N2.1 ■ 31 G	N2.2 ■ 28 G	N2.3 ■ 20 G	N3.1 ■ 34 C	N3.2 ■ 20 C	N3.3 ■ 10 C	N4.1 ■ 30 C	N4.2 ■ 20 C		

Product	DC	DC	LU	OAL	CZC MS	BD	LS	NOF	GPD	GPDN	GPDx
	(inch)	(inch)	(inch)	(inch)		(inch)	(inch)		(inch)	(inch)	(inch)
G7031/2	1/2	0.5000	1.1/4	4.5/16	1	29/64	2.9/16	3	3/16	1/4	7/16
G70311/16	11/16	0.6875	1.1/4	5.1/8	2	5/8	3.1/8	3	3/16	1/4	5/8
G7033/4	3/4	0.7500	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	11/16
G70313/16	13/16	0.8125	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	3/4
G7037/8	7/8	0.8750	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	13/16
G70315/16	15/16	0.9375	1.1/2	6.1/8	3	7/8	3.7/8	3	1/4	5/16	7/8
G7031	1"	1.0000	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	15/16
G7031.1/16	1.1/16	1.0625	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1"
G7031.1/8	1.1/8	1.1250	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1.1/16
G7031.3/16	1.3/16	1.1875	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1.1/8
G7031.1/4	1.1/4	1.2500	2"	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.3/16
G7031.3/8	1.3/8	1.3750	2"	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.5/16
G7031.1/2	1.1/2	1.5000	2"	7.7/8	4	1.3/16	4.7/8	5	3/8	7/16	1.7/16
G7031.5/8	1.5/8	1.6250	2.1/4	8.1/8	4	1.3/8	4.7/8	5	7/16	1/2	1.9/16
G7032	2"	2.0000	2.1/2	8.3/8	4	1.1/2	4.7/8	5	1/2	9/16	1.5/16
G7032.1/8	2.1/8	2.1250	2.1/2	9.7/8	5	1.3/4	6.1/8	5	1/2	9/16	2.1/16

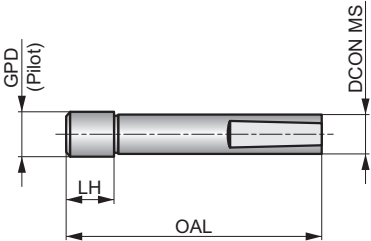
G704



HSS-forsænkingspilot, aftagelig

Ikke-skærende, aftagelige piloter til brug sammen med forsækningslegemer til at følge eksisterende huller i emnet. Flere piloter med samme monteringsdiameter (skaft) vil passe til monteringsdiameteren i udboringskroppen. Sørg for, at piloternes monteringsdiameter passer korrekt til kroppens monteringsdiameter

HSS	Bright	ANSI
		



Product	GPD	DCON MS	LH	OAL
	(inch)	(inch)	(inch)	(inch)
G7041/8X3/32	1/8	3/32	0.125	1.1/4
G7045/32X3/32	5/32	3/32	0.188	1.5/16
G7043/16X3/32	3/16	3/32	0.188	1.5/16
G7047/32X3/32	7/32	3/32	0.250	1.3/8
G7041/4X3/32	1/4	3/32	0.250	1.3/8
G7041/8X1/8	1/8	1/8	0.125	1.7/16
G7045/32X1/8	5/32	1/8	0.188	1.1/2
G7043/16X1/8	3/16	1/8	0.188	1.1/2
G7047/32X1/8	7/32	1/8	0.250	1.9/16
G7041/4X1/8	1/4	1/8	0.250	1.9/16
G7049/32X1/8	9/32	1/8	0.313	1.5/8
G7045/16X1/8	5/16	1/8	0.313	1.5/8
G7043/8X1/8	3/8	1/8	0.375	1.11/16
G7047/16X1/8	7/16	1/8	0.438	1.3/4
G7041/2X1/8	1/2	1/8	0.500	1.13/16
G7043/16X5/32	3/16	5/32	0.188	1.9/16
G7047/32X5/32	7/32	5/32	0.250	1.5/8
G7041/4X5/32	1/4	5/32	0.250	1.5/8
G7049/32X5/32	9/32	5/32	0.313	1.11/16
G7045/16X5/32	5/16	5/32	0.313	1.11/16
G7043/8X5/32	3/8	5/32	0.375	1.3/4
G7043/16X3/16	3/16	3/16	0.250	1.7/8
G7047/32X3/16	7/32	3/16	0.250	1.7/8
G7041/4X3/16	1/4	3/16	0.250	1.7/8
G7049/32X3/16	9/32	3/16	0.313	1.15/16
G7045/16X3/16	5/16	3/16	0.313	1.15/16
G70411/32X3/16	11/32	3/16	0.375	2"
G7043/8X3/16	3/8	3/16	0.375	2"
G70413/32X3/16	13/32	3/16	0.438	2.1/16
G7047/16X3/16	7/16	3/16	0.438	2.1/16
G70415/32X3/16	15/32	3/16	0.500	2.1/8
G7041/2X3/16	1/2	3/16	0.500	2.1/8
G7049/16X3/16	9/16	3/16	0.563	2.3/16
G7045/8X3/16	5/8	3/16	0.563	2.3/16
G70413/16X3/16	13/16	3/16	0.813	2.7/16
G7047/8X3/16	7/8	3/16	0.875	2.1/2
G7041/4X1/4	1/4	1/4	0.250	1.11/16
G7049/32X1/4	9/32	1/4	0.313	1.3/4
G7045/16X1/4	5/16	1/4	0.313	1.3/4

Product	GPD	DCON MS	LH	OAL
	(inch)	(inch)	(inch)	(inch)
G7043/8X1/4	3/8	1/4	0.375	1.13/16
G7047/16X1/4	7/16	1/4	0.438	1.7/8
G7041/2X1/4	1/2	1/4	0.500	1.15/16
G70417/32X1/4	17/32	1/4	0.563	2"
G7049/16X1/4	9/16	1/4	0.563	2"
G7045/8X1/4	5/8	1/4	0.625	2.1/16
G70411/16X1/4	11/16	1/4	0.688	2.1/8
G7043/4X1/4	3/4	1/4	0.750	2.3/16
G70413/16X1/4	13/16	1/4	0.875	2.5/16
G7041X1/4	1"	1/4	1.000	2.7/16
G7043/8X5/16	3/8	5/16	0.375	2"
G7047/16X5/16	7/16	5/16	0.438	2.1/16
G7041/2X5/16	1/2	5/16	0.500	2.1/8
G7049/16X5/16	9/16	5/16	0.563	2.3/16
G7045/8X5/16	5/8	5/16	0.625	2.1/4
G70411/16X5/16	11/16	5/16	0.688	2.5/16
G7043/4X5/16	3/4	5/16	0.750	2.3/8
G70413/16X5/16	13/16	5/16	0.875	2.1/2
G70415/16X5/16	15/16	5/16	1.000	2.5/8
G7041X5/16	1"	5/16	1.000	2.5/8
G7047/16X3/8	7/16	3/8	0.438	2.5/16
G7041/2X3/8	1/2	3/8	0.500	2.3/8
G7049/16X3/8	9/16	3/8	0.563	2.7/16
G7045/8X3/8	5/8	3/8	0.625	2.1/2
G70411/16X3/8	11/16	3/8	0.688	2.9/16
G7043/4X3/8	3/4	3/8	0.750	2.5/8
G70413/16X3/8	13/16	3/8	0.875	2.3/4
G7047/8X3/8	7/8	3/8	0.875	2.3/4
G70415/16X3/8	15/16	3/8	1.000	2.5/8
G7049/16X7/16	9/16	7/16	0.625	2.7/8
G70411/16X7/16	11/16	7/16	0.750	3"
G7043/4X7/16	3/4	7/16	0.750	3"
G70413/16X7/16	13/16	7/16	0.875	3.1/8
G7047/8X7/16	7/8	7/16	0.875	3.1/8
G70415/16X7/16	15/16	7/16	1.000	3.1/4
G7041X7/16	1"	7/16	1.000	3.1/4
G7049/16X1/2	9/16	1/2	0.625	3.1/8
G7041X1/2	1"	1/2	1.000	3.1/2
G7041.1/2X1/2	1.1/2	1/2	1.500	4"

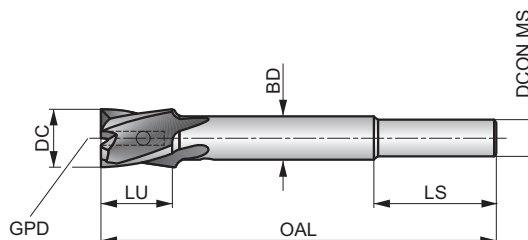
G705

 **DORMER**



HSS-forsænkingslegeme, lang flyserie, udskiftelig pilotype

Cylindrisk skaft til lang serie af flyforsænkere, der bruges sammen med aftagelige piloter til at forstørre toppen af et præfabrikeret hul ved at skære en flad bundforsækning. En aftagelig pilot G704, der ikke skærer, er monteret i kroppen og følger det eksisterende hul for at guide og centrere skæringen.



HSS	 Bright	ANSI
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 20 E	P1.2 ■ 22 E	P1.3 ■ 23 E	P2.1 ■ 17 E	P2.2 ■ 15 D	P2.3 ■ 13 C	P3.1 ■ 12 D	P3.2 ■ 9 D	P3.3 ■ 8 C	P4.1 ■ 7 D	P4.2 ■ 6 C	M1.1 ■ 8 D	M1.2 ■ 6 D	M2.1 ■ 7 D
M2.2 ■ 6 D	M2.3 ■ 5 C	K1.1 ■ 17 E	K1.2 ■ 12 E	K1.3 ■ 11 E	K2.1 ■ 15 D	K2.2 ■ 12 D	K2.3 ■ 10 C	K3.1 ■ 13 D	K3.2 ■ 10 D	K4.1 ■ 12 D	K4.2 ■ 9 D	K5.1 ■ 14 D	K5.2 ■ 10 D
N1.1 ■ 30 G	N1.2 ■ 23 G	N1.3 ■ 15 G	N2.1 ■ 31 G	N2.2 ■ 28 G	N2.3 ■ 20 G	N3.1 ■ 34 C	N3.2 ■ 20 C	N3.3 ■ 10 C	N4.1 ■ 30 C	N4.2 ■ 20 C			

Product	DC	DC	LU	OAL	DCON MS	LS	BD	NOF	GPD	GPDN	GPDx
	(inch)	(inch)	(inch)	(inch)	(inch)	(inch)	(inch)		(inch)	(inch)	(inch)
G7051/4	1/4	0.2500	1/2	4	15/64	15/64	15/64	4	3/32	1/8	3/16
G7055/16	5/16	0.3125	1/2	4	19/64	19/64	19/64	4	3/32	1/8	1/4
G7053/8	3/8	0.3750	5/8	4	5/16	5/16	5/16	4	3/32	1/8	5/16
G7057/16	7/16	0.4375	5/8	4	3/8	3/8	3/8	4	1/8	3/16	3/8
G7051/2	1/2	0.5000	5/8	4.1/4	7/16	7/16	7/16	4	1/8	1/8	7/16
G70517/32	17/32	0.5313	5/8	4.1/4	1/2	1/2	1/2	4	1/8	1/8	1/2
G7059/16	9/16	0.5625	5/8	4.1/4	1/2	1/2	1/2	4	1/8	1/8	1/2
G70519/32	19/32	0.5938	5/8	4.1/4	1/2	9/16	9/16	4	1/8	1/8	1/2
G7055/8	5/8	0.6250	5/8	4.1/4	1/2	9/16	9/16	4	1/8	1/8	1/2
G70521/32	21/32	0.6563	5/8	5.3/8	1/2	9/16	9/16	4	3/16	3/16	5/8
G70511/16	11/16	0.6875	5/8	5.3/8	1/2	5/8	5/8	4	3/16	3/16	5/8
G7053/4	3/4	0.7500	3/4	5.3/8	1/2	11/16	11/16	4	3/16	3/16	5/8
G70525/32	25/32	0.7813	3/4	5.3/8	1/2	11/16	11/16	4	3/16	3/16	5/8
G70513/16	13/16	0.8125	3/4	5.3/8	1/2	3/4	3/4	4	3/16	3/16	5/8
G7057/8	7/8	0.8750	15/16	5.3/8	1/2	3/4	3/4	4	3/16	3/16	13/16
G70515/16	15/16	0.9375	15/16	5.3/8	1/2	3/4	3/4	4	3/16	3/16	7/8

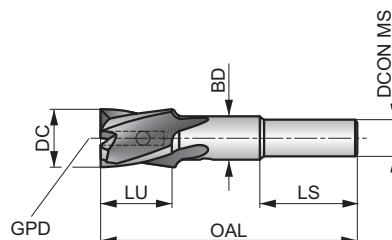
G706

 DORMER



HSS-forsænkingslegeme, kort serie til fly, udskiftelig pilottype

Cylindrisk skaft til kort serie af flyforsænkere, der bruges sammen med aftagelige piloter til at forstørre toppen af et forformet hul ved at skære en forsækning med flad bund. En aftagelig pilot G704, der ikke skærer, er monteret i kroppen og følger det eksisterende hul for at guide og centrere skæringen.



HSS	Bright	ANSI
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 20 E	P1.2 ■ 22 E	P1.3 ■ 23 E	P2.1 ■ 17 E	P2.2 ■ 15 D	P2.3 ▣ 13 C	P3.1 ■ 12 D	P3.2 ▣ 9 D	P3.3 ▣ 8 C	P4.1 ▣ 7 D	P4.2 ▣ 6 C	M1.1 ▣ 8 D	M1.2 ▣ 6 D	M2.1 ▣ 7 D
M2.2 ▣ 6 D	M2.3 ▣ 5 C	K1.1 ■ 17 E	K1.2 ▣ 12 E	K1.3 ▣ 11 E	K2.1 ■ 15 D	K2.2 ▣ 12 D	K2.3 ▣ 10 C	K3.1 ▣ 13 D	K3.2 ▣ 10 D	K4.1 ▣ 12 D	K4.2 ▣ 9 D	K5.1 ■ 14 D	K5.2 ▣ 10 D
N1.1 ▣ 30 G	N1.2 ■ 23 G	N1.3 ■ 15 G	N2.1 ▣ 31 G	N2.2 ▣ 28 G	N2.3 ▣ 20 G	N3.1 ■ 34 C	N3.2 ■ 20 C	N3.3 ▣ 10 C	N4.1 ■ 30 C	N4.2 ▣ 20 C			

Product	DC	DC	LU	OAL	DCON MS	LS	BD	NOF	GPD	GPDN	GPDx
	(inch)	(inch)	(inch)	(inch)	(inch)	(inch)	(inch)		(inch)	(inch)	(inch)
G7061/4	1/4	0.2500	1/2	2.3/8	1/4	1.1/8	15/64	4	3/32	1/8	3/16
G7065/16	5/16	0.3125	1/2	2.3/8	1/4	7/8	17/64	4	3/32	1/8	1/4
G70611/32	11/32	0.3438	1/2	2.3/8	1/4	7/8	19/64	4	3/32	1/8	9/32
G7063/8	3/8	0.3750	1/2	2.3/8	1/4	7/8	5/16	4	3/32	3/16	5/16
G70613/32	13/32	0.4063	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	11/32
G7067/16	7/16	0.4375	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	3/8
G70615/32	15/32	0.4688	1/2	2.13/16	1/4	7/8	5/16	4	1/8	1/4	13/32
G7061/2	1/2	0.5000	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	7/16
G70617/32	17/32	0.5313	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	15/32
G7069/16	9/16	0.5625	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	1/2
G70611/16	11/16	0.6875	1/2	2.13/16	1/4	7/8	1/2	4	1/8	1/4	5/8
G7063/4	3/4	0.7500	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	11/16
G70613/16	13/16	0.8125	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	3/4
G7067/8	7/8	0.8750	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	13/16
G7061	1"	1.0000	1/2	2.13/16	1/4	7/8	1/2	4	3/16	3/8	15/16

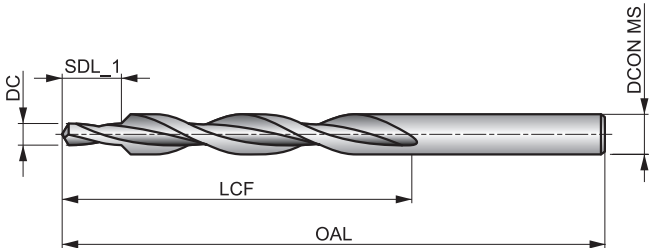
A400



HSS Trinbor, damphærdet finish

Et alsidigt værktøj designet til at bore undersænkede frigangshuller til standard metriske skruer. En vinkel på 118 ° på boret spids og en 90 ° undersænkning. Velegnet til både CNC og konventionelle maskiner. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Velegnet til boring af mange materialer.

HSS	DIN 8374	4×D
90°	ST	
λ 20-35°	R	118°



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 29 G	■ 33 G	■ 34 G	■ 25 G	■ 22 E	▣ 19 C	■ 15 E	■ 12 E	▣ 10 C	■ 9 E	▣ 7 C	▣ 6 C	▣ 22 E	▣ 19 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
▣ 20 E	▣ 16 E	▣ 10 G	▣ 9 G	▣ 8 G	▣ 12 C	■ 30 G	■ 22 E	■ 17 E	▣ 23 E	▣ 19 E	▣ 15 C	▣ 21 E	▣ 16 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
▣ 13 C	▣ 19 E	▣ 14 E	▣ 11 C	▣ 9 C	▣ 8 C	▣ 22 E	▣ 16 E	▣ 13 C	▣ 45 E	▣ 34 E	▣ 23 E	▣ 49 E	▣ 44 E
N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
▣ 32 E	▣ 68 E	▣ 40 E	▣ 20 E	▣ 30 I	▣ 23 E	▣ 14 C	▣ 8 A	▣ 8 C	▣ 6 A	▣ 6 C	▣ 4 A	▣ 5 C	▣ 3 A

Product	TDZ	DC	DC	LCF	OAL	SDL_1	DCON MS
		(mm)	(inch)				
A400M3	M3	3.20	0.1260	57.0	93.0	9.00	6.00
A400M4	M4	4.30	0.1693	75.0	117.0	11.00	8.00
A400M5	M5	5.30	0.2087	87.0	133.0	13.00	10.00
A400M6	M6	6.40	0.2520	94.0	142.0	15.00	11.50
A400M8	M8	8.40	0.3307	114.0	169.0	19.00	15.00

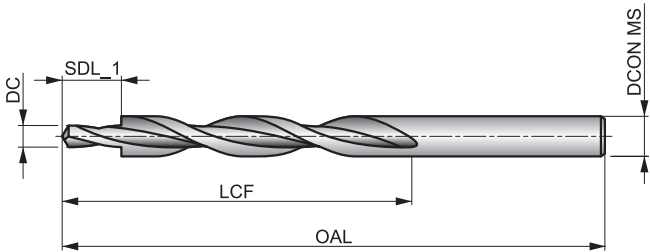
A402



HSS trinbor, damphærdet finish

Inkluderer en 118 ° spids- og 180 ° udboring med specifik spidsdiameter og -længde, der anbefales til at skabe modborede frigangshuller til standard metriske skruer. Damphærdet finish bevarer skærevæske og forhindrer svejsning fra spån til værktøj. Velegnet til boring af mange materialer.

HSS	DIN 8376	4×D
180°	ST	
λ 20-35°	R	118°

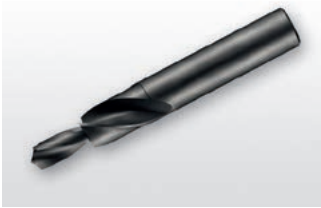


Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 29 G	P1.2 ■ 33 G	P1.3 ■ 34 G	P2.1 ■ 25 G	P2.2 ■ 22 E	P2.3 ▣ 19 C	P3.1 ■ 15 E	P3.2 ■ 12 E	P3.3 ▣ 10 C	P4.1 ■ 9 E	P4.2 ▣ 7 C	P4.3 ▣ 6 C	M1.1 ▣ 22 E	M1.2 ▣ 19 E
M2.1 ▣ 20 E	M2.2 ▣ 16 E	M3.1 ▣ 10 G	M3.2 ▣ 9 G	M3.3 ▣ 8 G	M4.1 ▣ 12 C	K1.1 ■ 30 G	K1.2 ■ 22 E	K1.3 ■ 17 E	K2.1 ▣ 23 E	K2.2 ▣ 19 E	K2.3 ▣ 15 C	K3.1 ▣ 21 E	K3.2 ▣ 16 E
K3.3 ▣ 13 C	K4.1 ▣ 19 E	K4.2 ▣ 14 E	K4.3 ▣ 11 C	K4.4 ▣ 9 C	K4.5 ▣ 8 C	K5.1 ▣ 22 E	K5.2 ▣ 16 E	K5.3 ▣ 13 C	N1.1 ▣ 45 E	N1.2 ▣ 34 E	N1.3 ▣ 23 E	N2.1 ▣ 49 E	N2.2 ▣ 44 E
N2.3 ▣ 32 E	N3.1 ▣ 68 E	N3.2 ▣ 40 E	N3.3 ▣ 20 E	N4.1 ▣ 30 I	S1.1 ▣ 23 E	S1.2 ▣ 14 C	S1.3 ▣ 8 A	S2.1 ▣ 8 C	S2.2 ▣ 6 A	S3.1 ▣ 6 C	S3.2 ▣ 4 A	S4.1 ▣ 5 C	S4.2 ▣ 3 A

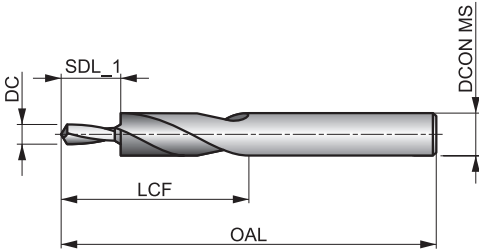
Product	TDZ	DC	DC	LCF	OAL	SDL_1	DCON MS
		(mm)	(inch)				
A402M3	M3	3.40	0.1339	57.0	93.0	9.00	6.00
A402M4	M4	4.50	0.1772	75.0	117.0	11.00	8.00
A402M5	M5	5.50	0.2165	87.0	133.0	13.00	10.00
A402M6	M6	6.60	0.2598	94.0	142.0	15.00	11.00
A402M8	M8	9.00	0.3543	114.0	169.0	19.00	15.00
A402M10	M10	11.00	0.4331	130.0	191.0	23.00	18.00

A413



HSS trinbor, damphærdet finish

Et alsidigt værktøj, der anbefales til at skabe borede frigangshuller til standard metriske skruer. En 118 ° spids og 180 ° udboring. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Velegnet til både CNC og konventionelle maskiner. Velegnet til boring af mange materialer.



HSS		2.5×D
180°		
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 29 I	■ 33 I	■ 34 I	■ 25 I	■ 22 G	▣ 19 E	■ 15 G	■ 12 G	▣ 10 E	■ 9 G	▣ 7 E	▣ 6 C	■ 22 G	■ 19 G
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 20 G	■ 16 G	▣ 10 I	▣ 9 I	▣ 8 I	▣ 12 E	■ 30 G	■ 22 E	■ 17 E	▣ 23 E	▣ 19 E	▣ 15 E	▣ 21 E	▣ 16 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
▣ 13 E	▣ 19 E	▣ 14 E	▣ 11 E	▣ 9 E	▣ 8 E	▣ 22 E	▣ 16 E	▣ 13 E	▣ 45 G	▣ 34 G	▣ 23 G	▣ 42 G	▣ 37 G
N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
▣ 27 G	▣ 68 G	▣ 40 G	▣ 20 G	▣ 30 I	▣ 27 G	▣ 16 E	▣ 8 C	▣ 11 G	▣ 6 C	▣ 8 G	▣ 4 C	▣ 6 G	▣ 3 C

Product	TDZ	DC	DC	LCF	OAL	SDL_1	DCON MS
		(mm)	(inch)				
A413M3	M3	3.40	0.1339	28.0	66.0	9.00	6.00
A413M4	M4	4.50	0.1772	37.0	79.0	11.00	8.00
A413M5	M5	5.50	0.2165	43.0	89.0	13.00	10.00
A413M6	M6	6.60	0.2598	47.0	95.0	15.00	11.00
A413M8	M8	9.00	0.3543	56.0	111.0	19.00	15.00
A413M10	M10	11.00	0.4331	62.0	123.0	23.00	18.00

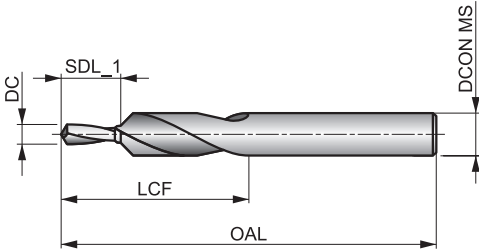
A412

DORMER



HSS tapbor, damphærdet finish

Tapbor designet til at bore affasede frigangshuller til standard metriske skruer. En vinkel på 118° på boret, trin med en 90° affasning. Damphærdet finish bevarer skærevæske og forhindrer svejsning af spån til værktøj. Velegnet til boring af mange materialer. Den er velegnet til både CNC og konventionelle maskiner.



HSS		2.5×D
90°		
R		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

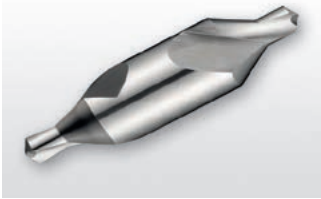
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 29 I	■ 33 I	■ 34 I	■ 25 I	■ 22 G	▣ 19 E	■ 15 G	■ 12 G	▣ 10 E	■ 9 G	▣ 7 E	▣ 6 C	■ 22 G	■ 19 G
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 20 G	■ 16 G	▣ 10 I	▣ 9 I	▣ 8 I	▣ 12 E	■ 30 G	■ 22 E	■ 17 E	▣ 23 E	▣ 19 E	▣ 15 E	▣ 21 E	▣ 16 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
▣ 13 E	▣ 19 E	▣ 14 E	▣ 11 E	▣ 9 E	▣ 8 E	▣ 22 E	▣ 16 E	▣ 13 E	▣ 45 G	▣ 34 G	▣ 23 G	▣ 42 G	▣ 37 G
N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
▣ 27 G	▣ 68 G	▣ 40 G	▣ 20 G	▣ 30 I	▣ 27 G	▣ 16 E	▣ 8 C	▣ 11 G	▣ 6 C	▣ 8 G	▣ 4 C	▣ 6 G	▣ 3 C

Product	TDZ	DC	DC	LCF	OAL	SDL_1	DCON MS
		(mm)	(inch)				
A412M3	M3	3.40	0.1339	31.0	70.0	9.00	6.60
A412M4	M4	4.50	0.1772	40.0	84.0	11.00	9.00
A412M5	M5	5.50	0.2165	47.0	95.0	13.00	11.00
A412M6	M6	6.60	0.2598	51.0	102.0	15.00	13.00
A412M8	M8	9.00	0.3543	62.0	123.0	19.00	17.20
A412M10	M10	11.00	0.4331	70.0	141.0	23.00	21.50

Materiale kode (BMC)	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	HSS-E	HM	HSS		
Grundlæggende standard-gruppe (BSG)	DIN 333A	DIN 333A	DIN 333A	DIN 333A	DIN 333R	DORMER	BS 328	DORMER	DIN 333A			
Brugbar længde (ULDR)	1xD	1xD	1xD	1xD	1xD	1xD	1xD	1xD	1xD	1xD		
Anvendelsesvinkel	60°	60°	60°	60°	R	60°	60°	60°	60°	60°		
Belægning	Bright	TiN	Bright	TAiN	Bright	Bright	Bright	Bright	Bright	Bright		
Skaft												
Hånd (skæreretning)	R	R	R	R	R	R	R	R	R	R		
Produktfamiliekode	A200	A205	A206	A266	A210	A201	A225	A242	R200	A296		
PSF skærediametre række-vidde	0.50 - 12.50	1.00 - 5.00	1.00 - 5.00	1.00 - 5.00	0.50 - 8.00	0.63 - 6.00	3/64 - 5/16	1.00 - 5.00	1.00 - 5.00	Set		
	148	149	150	151	152	153	154	155	156	156		
P	P1											
	P2											
	P3											
	P4											
M	M1											
	M2											
	M3											
	M4											
K	K1											
	K2											
	K3											
	K4											
	K5											
N	N1											
	N2											
	N3											
	N4											
	N5											
S	S1											
	S2											
	S3											
	S4											
H	H1											
	H2											
	H3											
	H4											

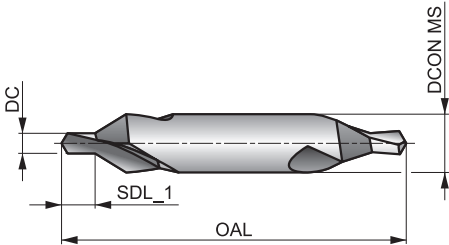
A200

 DORMER



HSS Pinolbor med 118 ° punktsvinkel og 60 ° undersænkning, blank finish

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. Velegnet til mange materialer.



HSS	DIN 333A	1xD
60°	Bright	
R	118°	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

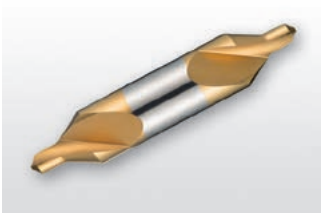
P1.1 ■ 33 I	P1.2 ■ 37 I	P1.3 ■ 38 I	P2.1 ■ 28 I	P2.2 ■ 25 G	P2.3 ■ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ■ 13 E	P4.1 ■ 11 F	P4.2 ■ 10 E	P4.3 ■ 8 D	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 9 G	M3.2 ■ 8 G	M3.3 ■ 7 G	M4.1 ■ 10 C	K1.1 ■ 30 I	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E
K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E	K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N1.1 ■ 33 J	N1.2 ■ 25 J	N1.3 ■ 17 I	N2.1 ■ 42 H	N2.2 ■ 37 H
N2.3 ■ 27 H	N3.1 ■ 56 H	N3.2 ■ 33 I	N3.3 ■ 17 G	N4.1 ■ 30 J	N4.2 ■ 28 H	N4.3 ■ 14 F	S1.1 ■ 24 F	S1.2 ■ 13 D	S1.3 ■ 7 B	S2.1 ■ 7 E	S2.2 ■ 6 A	S3.1 ■ 5 E	S3.2 ■ 4 A
S4.1 ■ 4 E	S4.2 ■ 3 A												

Produkter fra denne serie fås også i sæt. Se A296.

Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)			
A200.5X3.15 ¹⁾	0.50	0.0197	0.9 - 0.6	25.0	3.15
A200.8X3.15 ¹⁾	0.80	0.0315	1.3 - 1.0	25.0	3.15
A2001.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2001.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2001.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2002.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2002.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2003.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2004.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2005.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50
A2006.3X16.0	6.30	0.2480	8.9 - 8.0	71.0	16.00
A2008.0X20.0	8.00	0.3150	11.1 - 10.1	80.0	20.00
A20010.0X25.0	10.00	0.3937	13.8 - 12.8	100.0	25.00
A20012.5X31.5	12.50	0.4921	17.5 - 16.5	125.0	31.50

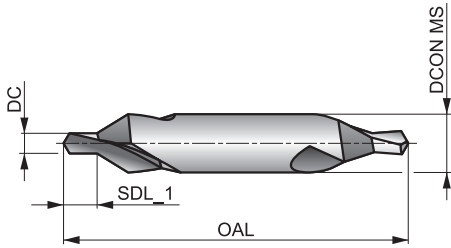
¹⁾ Single ende

A205



HSS-E Pinolbor med 118 ° punktsvinkel og 60 ° undersækning, TiN belagt

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. TiN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til boring af mange materialer.



HSS	DIN 333A	1xD
60°	TiN	
R	118°	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 40 I	P1.2 ■ 45 I	P1.3 ■ 46 I	P2.1 ■ 34 I	P2.2 ■ 30 G	P2.3 ■ 27 E	P3.1 ■ 24 F	P3.2 ■ 19 F	P3.3 ■ 16 E	P4.1 ■ 14 F	P4.2 ■ 12 E	P4.3 ■ 10 D	M1.1 ■ 25 E	M1.2 ■ 21 E
M2.1 ■ 22 E	M2.2 ■ 18 E	M3.1 ■ 12 G	M3.2 ■ 10 G	M3.3 ■ 9 G	M4.1 ■ 12 C	K1.1 ■ 36 I	K1.2 ■ 27 F	K1.3 ■ 20 F	K2.1 ■ 30 E	K2.2 ■ 24 E	K2.3 ■ 19 E	K3.1 ■ 26 E	K3.2 ■ 20 E
K3.3 ■ 16 E	K4.1 ■ 24 E	K4.2 ■ 18 E	K4.3 ■ 13 E	K4.4 ■ 11 E	K4.5 ■ 10 E	K5.1 ■ 27 E	K5.2 ■ 21 E	K5.3 ■ 16 E	N1.1 ■ 40 J	N1.2 ■ 30 J	N1.3 ■ 20 I	N2.1 ■ 49 H	N2.2 ■ 44 H
N2.3 ■ 32 H	N3.1 ■ 68 H	N3.2 ■ 40 I	N3.3 ■ 20 G	N4.1 ■ 36 J	N4.2 ■ 34 H	N4.3 ■ 17 F	S1.1 ■ 29 F	S1.2 ■ 16 D	S1.3 ■ 8 B	S2.1 ■ 8 E	S2.2 ■ 7 A	S3.1 ■ 6 E	S3.2 ■ 5 A
S4.1 ■ 5 E	S4.2 ■ 4 A												

Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)			
A2051.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2051.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2051.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2052.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2052.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2053.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2054.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2055.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

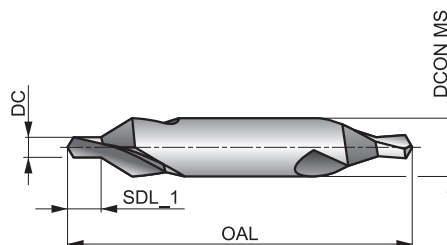
A206

 DORMER



HSS-E Pinolbor med 118° punktsvinkel og 60° undersænkning, blank finish

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. Velegnet til boring af mange materialer.



HSS-E	DIN 333A	1xD
60°	Bright	
R	118°	

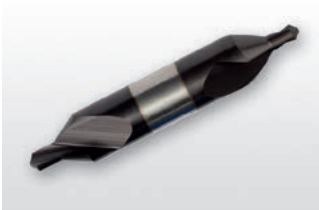
Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 40 I	P1.2 ■ 45 I	P1.3 ■ 46 I	P2.1 ■ 34 I	P2.2 ■ 30 G	P2.3 ▣ 27 E	P3.1 ■ 24 F	P3.2 ■ 19 F	P3.3 ▣ 16 E	P4.1 ■ 14 F	P4.2 ▣ 12 E	P4.3 ▣ 10 D	M1.1 ▣ 25 E	M1.2 ▣ 21 E
M2.1 ▣ 22 E	M2.2 ▣ 18 E	M3.1 ▣ 12 G	M3.2 ▣ 10 G	M3.3 ▣ 9 G	M4.1 ▣ 12 C	K1.1 ■ 36 I	K1.2 ■ 27 F	K1.3 ■ 20 F	K2.1 ▣ 30 E	K2.2 ▣ 24 E	K2.3 ▣ 19 E	K3.1 ▣ 26 E	K3.2 ▣ 20 E
K3.3 ▣ 16 E	K4.1 ▣ 24 E	K4.2 ▣ 18 E	K4.3 ▣ 13 E	K4.4 ▣ 11 E	K4.5 ▣ 10 E	K5.1 ▣ 27 E	K5.2 ▣ 21 E	K5.3 ▣ 16 E	N1.1 ▣ 40 J	N1.2 ▣ 30 J	N1.3 ▣ 20 I	N2.1 ▣ 49 H	N2.2 ▣ 44 H
N2.3 ▣ 32 H	N3.1 ▣ 68 H	N3.2 ▣ 40 I	N3.3 ▣ 20 G	N4.1 ▣ 36 J	N4.2 ▣ 34 H	N4.3 ▣ 17 F	S1.1 ▣ 29 F	S1.2 ▣ 16 D	S1.3 ▣ 8 B	S2.1 ▣ 8 E	S2.2 ▣ 7 A	S3.1 ▣ 6 E	S3.2 ▣ 5 A
S4.1 ▣ 5 E	S4.2 ▣ 4 A												

Product	DC	DC	SDL_1	OAL	DC ON MS
	(mm)	(inch)			
A2061.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2061.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2061.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2062.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2062.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2063.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2064.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2065.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

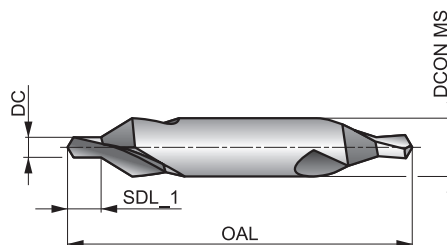
A266

 DORMER



HSS-E Pinolbor med 118 ° punktsvinkel og 60 ° undersænkning, TiALN belagt

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. TiALN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til boring af mange materialer.



HSS-E	DIN 333A	1xD
60°	TiALN	
R	118°	

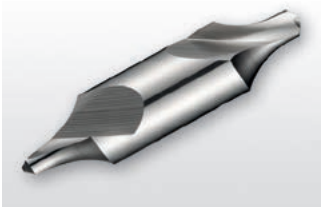
Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
40 I	45 I	46 I	34 I	30 G	27 E	24 F	19 F	16 E	14 F	12 E	10 D	25 E	21 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
22 E	18 E	12 G	10 G	9 G	12 C	36 I	27 F	20 F	30 E	24 E	19 E	26 E	20 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
16 E	24 E	18 E	13 E	11 E	10 E	27 E	21 E	16 E	40 J	30 J	20 I	49 H	44 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
32 H	68 H	40 I	20 G	36 J	34 H	17 F	29 F	16 D	8 B	8 E	7 A	6 E	5 A
S4.1	S4.2												
5 E	4 A												

Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)			
A2661.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2661.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2661.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2662.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2662.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2663.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2664.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2665.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

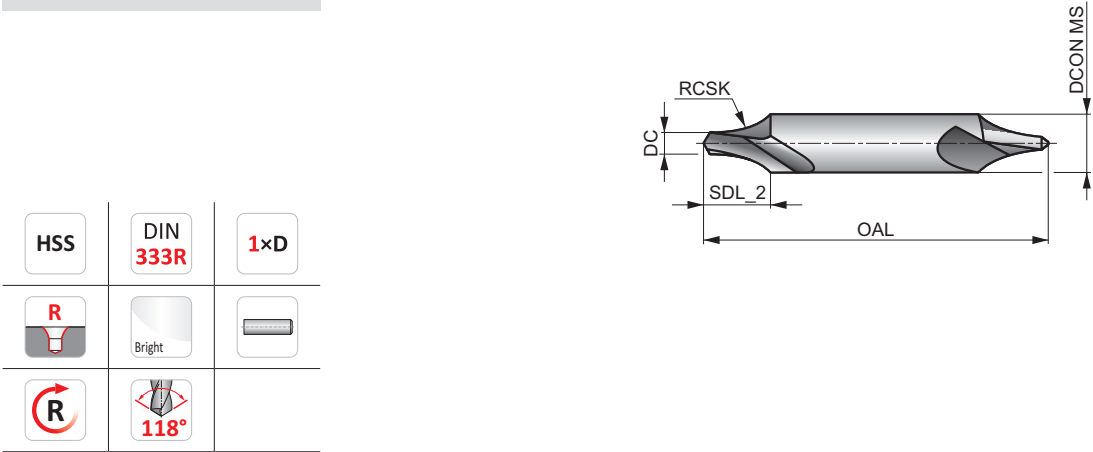
A210





HSS Pinolbor med 118 ° punktsvinkel og konkav undersænkning, blank finish

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. Kan bruges til at bearbejde et antal materialer.



HSS	DIN 333R	1xD
	Bright	
	118°	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 33 I	■ 37 I	■ 38 I	■ 28 I	■ 25 G	▣ 22 E	■ 19 F	■ 15 F	▣ 13 E	■ 11 F	▣ 10 E	▣ 8 D	▣ 21 E	▣ 17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
▣ 18 E	▣ 15 E	▣ 9 G	▣ 8 G	▣ 7 G	▣ 10 C	■ 30 I	■ 22 F	■ 17 F	▣ 25 E	▣ 20 E	▣ 16 E	▣ 22 E	▣ 17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
▣ 13 E	▣ 20 E	▣ 15 E	▣ 11 E	▣ 10 E	▣ 8 E	▣ 23 E	▣ 17 E	▣ 13 E	▣ 33 J	▣ 25 J	▣ 17 I	▣ 42 H	▣ 37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
▣ 27 H	▣ 56 H	▣ 33 I	▣ 17 G	▣ 30 J	▣ 28 H	▣ 14 F	▣ 24 F	▣ 13 D	▣ 7 B	▣ 7 E	▣ 6 A	▣ 5 E	▣ 4 A
S4.1	S4.2												
▣ 4 E	▣ 3 A												

Product	DC	DC	SDL_2	OAL	RCSK	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
A210.5X3.15 ¹⁾	0.50	0.0197	2.6 - 2.3	25.0	2.50 - 2.00	3.15
A210.8X3.15 ¹⁾	0.80	0.0315	2.9 - 2.6	25.0	3.15 - 2.50	3.15
A2101.0X3.15	1.00	0.0394	3.3 - 3.0	31.0	3.65 - 2.90	3.15
A2101.25X3.15	1.25	0.0492	3.6 - 3.3	31.0	3.95 - 3.15	3.15
A2101.6X4.0	1.60	0.0630	4.7 - 4.2	35.0	5.00 - 4.00	4.00
A2102.0X5.0	2.00	0.0787	5.4 - 5.0	40.0	6.25 - 5.00	5.00
A2102.5X6.3	2.50	0.0984	6.8 - 6.3	45.0	7.88 - 6.30	6.30
A2103.15X8.0	3.15	0.1240	8.5 - 8.0	50.0	10.00 - 8.00	8.00
A2104.0X10.0	4.00	0.1575	10.6 - 10.0	55.0	12.50 - 10.00	10.00
A2105.0X12.5	5.00	0.1969	13.1 - 12.5	63.0	15.63 - 12.50	12.50
A2106.3X16.0	6.30	0.2480	16.6 - 16.0	71.0	20.00 - 16.00	16.00
A2108.0X20.0	8.00	0.3150	20.7 - 20.0	80.0	25.00 - 20.00	20.00

¹⁾ Single ende

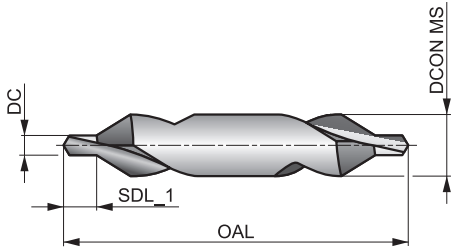
A201

 DORMER



HSS Pinolbor med 122 ° punktsvinkel og 60 ° undersænkning, blank finish

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. Velegnet til boring af mange materialer.



HSS	 DORMER	1xD
60°	Bright	
R	122°	

Arbejdsemnets materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 33 I	■ 37 I	■ 38 I	■ 28 I	■ 25 G	■ 22 E	■ 19 F	■ 15 F	■ 13 E	■ 11 F	■ 10 E	■ 8 D	■ 21 E	■ 17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 18 E	■ 15 E	■ 9 G	■ 8 G	■ 7 G	■ 10 C	■ 30 I	■ 22 F	■ 17 F	■ 25 E	■ 20 E	■ 16 E	■ 22 E	■ 17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 13 E	■ 20 E	■ 15 E	■ 11 E	■ 10 E	■ 8 E	■ 23 E	■ 17 E	■ 13 E	■ 33 J	■ 25 J	■ 17 I	■ 42 H	■ 37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 27 H	■ 56 H	■ 33 I	■ 17 G	■ 30 J	■ 28 H	■ 14 F	■ 24 F	■ 13 D	■ 7 B	■ 7 E	■ 6 A	■ 5 E	■ 4 A
S4.1	S4.2												
■ 4 E	■ 3 A												

Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)			
A201.63X3.15 ¹⁾	0.63	0.0248	1.2 - 0.9	20.0	3.15
A201.75X3.5	0.75	0.0295	1.3 - 1.0	35.0	3.50
A2011.0X4.0	1.00	0.0394	2.1 - 1.5	35.0	4.00
A2011.5X5.0	1.50	0.0591	2.8 - 2.0	40.0	5.00
A2011.6X5.0	1.60	0.0630	2.4 - 2.0	40.0	5.00
A2012.0X6.0	2.00	0.0787	4.0 - 3.0	45.0	6.00
A2012.0X6.3	2.00	0.0787	2.9 - 2.5	45.0	6.30
A2012.5X8.0	2.50	0.0984	4.5 - 3.5	50.0	8.00
A2013.0X8.0	3.00	0.1181	4.4 - 3.9	50.0	8.00
A2013.0X10.0	3.00	0.1181	5.0 - 4.0	56.0	10.00
A2013.15X10.0	3.15	0.1240	4.4 - 3.9	56.0	10.00
A2014.0X12.0	4.00	0.1575	6.2 - 5.0	66.0	12.00
A2015.0X14.0	5.00	0.1969	7.7 - 6.5	78.0	14.00
A2016.0X18.0	6.00	0.2362	9.2 - 8.0	90.0	18.00

¹⁾ Single ende

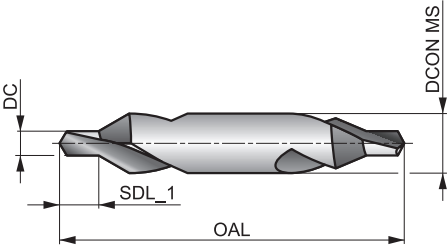
A225

 **DORMER**



HSS Pinolbor med 120 ° punktsvinkel og 60 ° undersænkning, blank finish

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. Britisk standard 328. De to borender giver øget produktivitet pr. Værktøj. Velegnet til boring af mange materialer.



HSS	BS 328	1xD
60°	Bright	
R	120°	

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 I	P1.2 ■ 37 I	P1.3 ■ 38 I	P2.1 ■ 28 I	P2.2 ■ 25 G	P2.3 ■ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ■ 13 E	P4.1 ■ 11 F	P4.2 ■ 10 E	P4.3 ■ 8 D	M1.1 ■ 21 E	M1.2 ■ 17 E
M2.1 ■ 18 E	M2.2 ■ 15 E	M3.1 ■ 9 G	M3.2 ■ 8 G	M3.3 ■ 7 G	M4.1 ■ 10 C	K1.1 ■ 30 I	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ■ 25 E	K2.2 ■ 20 E	K2.3 ■ 16 E	K3.1 ■ 22 E	K3.2 ■ 17 E
K3.3 ■ 13 E	K4.1 ■ 20 E	K4.2 ■ 15 E	K4.3 ■ 11 E	K4.4 ■ 10 E	K4.5 ■ 8 E	K5.1 ■ 23 E	K5.2 ■ 17 E	K5.3 ■ 13 E	N1.1 ■ 33 J	N1.2 ■ 25 J	N1.3 ■ 17 I	N2.1 ■ 42 H	N2.2 ■ 37 H
N2.3 ■ 27 H	N3.1 ■ 56 H	N3.2 ■ 33 I	N3.3 ■ 17 G	N4.1 ■ 30 J	N4.2 ■ 28 H	N4.3 ■ 14 F	S1.1 ■ 24 F	S1.2 ■ 13 D	S1.3 ■ 7 B	S2.1 ■ 7 E	S2.2 ■ 6 A	S3.1 ■ 5 E	S3.2 ■ 4 A
S4.1 ■ 4 E	S4.2 ■ 3 A												

Produkter fra denne serie fås også i sæt. Se A296.

Product	Nr.	DC	DC	SDL_1	OAL	DCON MS
		(inch)	(inch)	(inch)	(inch)	(inch)
A225BS1	BS1	3/64	0.0469	5/64 - 1/16	1.1/2	1/8
A225BS2	BS2	1/16	0.0625	3/32 - 5/64	1.3/4	3/16
A225BS3	BS3	3/32	0.0938	5/32 - 1/8	2"	1/4
A225BS4	BS4	1/8	0.1250	3/16 - 5/32	2.1/4	5/16
A225BS5	BS5	3/16	0.1875	9/32 - 1/4	2.1/2	7/16
A225BS5A	BS5A	7/32	0.2188	5/16 - 9/32	2.3/4	1/2
A225BS6	BS6	1/4	0.2500	3/8 - 5/16	3"	5/8
A225BS7	BS7	5/16	0.3125	15/32 - 13/32	3.1/2	3/4

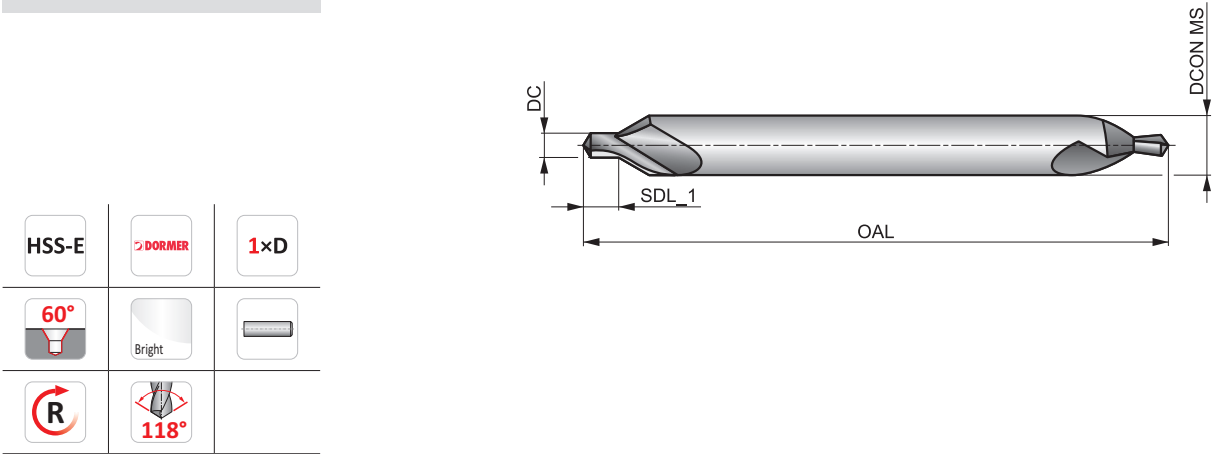
A242

 **DORMER**



HSS-E (5% kobolt) langt pinolbor, 118 ° spids, 60 ° undersænket, blank finish

Designet til at starte et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj. Velegnet til boring af mange materialer.



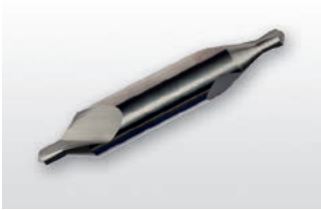
Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 33 I	P1.2 ■ 37 I	P1.3 ■ 38 I	P2.1 ■ 28 I	P2.2 ■ 25 G	P2.3 ▣ 22 E	P3.1 ■ 19 F	P3.2 ■ 15 F	P3.3 ▣ 13 E	P4.1 ■ 11 F	P4.2 ▣ 10 E	P4.3 ▣ 8 D	M1.1 ▣ 21 E	M1.2 ▣ 17 E
M2.1 ▣ 18 E	M2.2 ▣ 15 E	M3.1 ▣ 9 G	M3.2 ▣ 8 G	M3.3 ▣ 7 G	M4.1 ▣ 10 C	K1.1 ■ 30 I	K1.2 ■ 22 F	K1.3 ■ 17 F	K2.1 ▣ 25 E	K2.2 ▣ 20 E	K2.3 ▣ 16 E	K3.1 ▣ 22 E	K3.2 ▣ 17 E
K3.3 ▣ 13 E	K4.1 ▣ 20 E	K4.2 ▣ 15 E	K4.3 ▣ 11 E	K4.4 ▣ 10 E	K4.5 ▣ 8 E	K5.1 ▣ 23 E	K5.2 ▣ 17 E	K5.3 ▣ 13 E	N1.1 ▣ 33 J	N1.2 ▣ 25 J	N1.3 ▣ 17 I	N2.1 ▣ 42 H	N2.2 ▣ 37 H
N2.3 ▣ 27 H	N3.1 ▣ 56 H	N3.2 ▣ 33 I	N3.3 ▣ 17 G	N4.1 ▣ 30 J	N4.2 ▣ 28 H	N4.3 ▣ 14 F	S1.1 ▣ 24 F	S1.2 ▣ 13 D	S1.3 ▣ 7 B	S2.1 ▣ 7 E	S2.2 ▣ 6 A	S3.1 ▣ 5 E	S3.2 ▣ 4 A
S4.1 ▣ 4 E	S4.2 ▣ 3 A												

Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)			
A2421.0X4.0	1.00	0.0394	1.7 - 1.3	100.0	4.00
A2421.5X5.0	1.50	0.0591	2.6 - 2.0	100.0	5.00
A2422.0X6.0	2.00	0.0787	3.1 - 2.5	100.0	6.00
A2422.5X8.0	2.50	0.0984	3.8 - 3.1	100.0	8.00
A2423.0X8.0	3.00	0.1181	4.6 - 3.9	100.0	8.00
A2423.0X10.0	3.00	0.1181	4.6 - 3.9	100.0	10.00
A2424.0X10.0	4.00	0.1575	5.9 - 5.0	100.0	10.00
A2424.0X12.0	4.00	0.1575	5.9 - 5.0	100.0	12.00
A2425.0X12.0	5.00	0.1969	7.2 - 6.3	100.0	12.00

R200

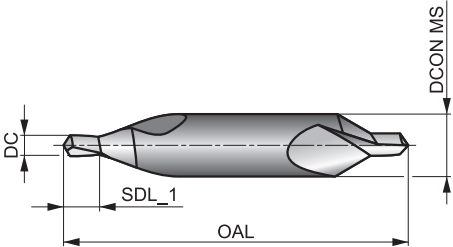




HM Pinolbor med 118 ° punktsvinkel og 60 ° undersækning, blank finish

Anbefales til start af et præcist hul i enden af en aksel, så det kan holdes sikkert inden bearbejdning. Velegnet til bearbejdning af et antal materialer og har to borender, der giver øget produktivitet pr. Værktøj. Inkluderer en 118 ° spidsvinkel og 60 ° forsækning. Velegnet til alle CNC-maskiner.

HM	DIN 333A	1xD
60°	Bright	
R		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 60 H	■ 67 H	■ 69 H	■ 51 H	■ 45 F	■ 40 D	■ 44 E	■ 36 E	■ 30 D	■ 26 E	■ 22 D	■ 18 C	■ 40 H	■ 30 E
K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2
■ 22 E	■ 37 D	■ 30 D	■ 24 D	■ 33 D	■ 25 D	■ 20 D	■ 30 D	■ 23 D	■ 17 D	■ 14 D	■ 12 D	■ 34 D	■ 26 D
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3				
■ 20 D	■ 120 I	■ 90 I	■ 60 H	■ 154 G	■ 138 G	■ 100 G	■ 169 G	■ 100 H	■ 50 F				

Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R2001.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
R2001.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
R2001.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
R2002.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
R2002.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
R2003.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
R2004.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
R2005.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

A296





HSS pinolboresæt

Et sæt af fem pinolbor, der kommer i en praktisk plastiketui, der holder alle dine pinolbor sammen. Anbefales til start af et præcist hul i enden af en aksel, det kan holdes sikkert inden bearbejdning. De to borender giver øget produktivitet pr. Værktøj.

A296200 - 118 ° spids DIN333A, A296225 - 120 ° spids BS328. A = forskellige i sæt, B = nej. i sæt, C = diametre i sæt.

Product	Nr.	A	B	C
A296200	200	A200	5	1.00 mm, 2.00 mm, 2.50 mm, 3.15 mm, 4.00 mm
A296225	225	A225	5	BS1, BS2, BS3, BS4, BS5

Materiale kode (BMC)	HSS	HSS-E	HSS	HSS-E	HM	HSS	HSS	HSS	HSS			
Belægning												
Grundlæggende standard-gruppe (BSG)	DIN 334C		DIN 335C	DIN 335C	DIN 335C	DIN 335C	DIN 334D	DIN 335D	DIN 335D			
Hånd (skæreretning)												
Skaft												
Anvendelsesvinkel	60°	90°	90°	90°	90°	100°	60°	90°	90°			
Produktfamiliekode	G335	G149	G560	G570	G400	G171	G137	G138	G338			
PSF skærediametre rækkevidde	6.30 - 25.00	5.00 - 25.00	6.30 - 31.00	6.30 - 31.00	6.30 - 31.00	6.30 - 25.00	31.50 - 50.00	25.00 - 63.00	25.00 - 50.00			
	158	159	160	161	162	163	164	165	166			
P	P1	■	■	■	■	■	■	■	■			
	P2	■	■	■	■	■	■	■	■			
	P3	■	■	■	■	■	■	■	■			
	P4	■		■	■	■	■	■	■			
M	M1	■	■	■	■	■	■	■	■			
	M2	■	■	■	■	■	■	■	■			
	M3	■			■	■						
	M4				■	■						
K	K1	■	■	■	■	■	■	■	■			
	K2	■	■	■	■	■	■	■	■			
	K3	■	■	■	■	■	■	■	■			
	K4	■	■	■	■	■	■	■	■			
	K5	■	■	■	■	■	■	■	■			
N	N1	■	■	■	■	■	■	■	■			
	N2	■	■	■	■	■	■	■	■			
	N3	■	■	■	■	■	■	■	■			
	N4	■	■	■		■	■	■	■			
	N5											
S	S1				■							
	S2				■							
	S3				■							
	S4				■							
H	H1				■							
	H2				■							
	H3				■							
	H4				■							

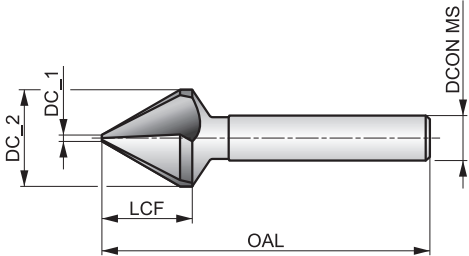
G335





HSS lige skaft 60 ° forsænker, TiN belagt

Til 60 ° forsænkede huller til og fjernelse af grater fra borede huller. TiN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Alsidigt værktøj, der kan bruges i både håndholdte og maskinapplikationer. Velegnet til reifning af huller i mange materialer.



HSS

TiN

DIN 334C





60°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 33 E	■ 37 E	■ 38 E	■ 28 E	■ 25 D	■ 22 B	■ 23 D	■ 18 D	■ 15 B	■ 13 D	■ 11 B	▧ 9 B	▧ 10 C	▧ 8 C
M2.1	M3.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
▧ 9 C	▧ 8 B	■ 34 F	■ 25 D	▧ 19 D	■ 35 C	■ 28 C	▧ 23 C	■ 31 C	■ 24 C	▧ 19 C	▧ 29 C	▧ 22 C	▧ 16 C
K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
■ 32 C	■ 24 C	▧ 19 C	■ 53 G	■ 40 G	■ 27 F	■ 27 F	■ 24 F	■ 17 F	■ 28 F	■ 16 F	▧ 8 D	▧ 58 G	▧ 50 G

DCON MS tolerance h9.

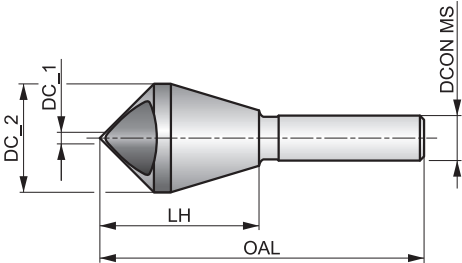
Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G3356.3	6.30	1.60	6.8	45.0	5.00	3
G3358.0	8.00	2.00	8.5	50.0	6.00	3
G33510.0	10.00	2.50	7.6	50.0	6.00	3
G33512.5	12.50	3.20	11.7	56.0	8.00	3
G33516.0	16.00	4.00	14.5	63.0	10.00	3
G33520.0	20.00	5.00	17.5	67.0	10.00	3
G33525.0	25.00	6.30	20.5	71.0	10.00	3

G149



HSS-E Lige skaft med tværhul 90 ° forsækning, blank finish

En 90 ° forsænke designet til at reife huller og til at fjerne grater fra borede huller. Det specielle tværhullede design styrer spåner væk fra forkant for at give en jævn affasningsoperation. Velegnet til reifning af huller i mange materialer.



HSS-E

Bright

90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ▣21 D	P1.2 ▣24 D	P1.3 ▣25 D	P2.1 ▣18 D	P2.2 ▣16 C	P2.3 ▣14 A	P3.1 ▣16 B	P3.2 ▣13 B	M1.1 ▣8 B	M1.2 ▣6 B	M2.1 ▣7 B	K1.1 ▣18 D	K2.1 ▣19 A	K3.1 ▣16 A
K5.1 ▣14 A	N1.1 ▣34 D	N1.2 ▣25 D	N1.3 ▣16 C	N2.1 ▣16 C	N2.2 ▣14 C	N3.1 ▣17 C	N3.2 ▣9 C	N3.3 ▣5 B	N4.1 ▣17 D	N4.2 ▣5 D			

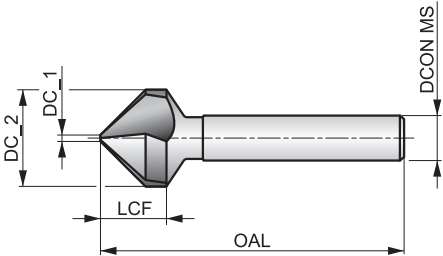
Product	DC_2 (mm)	DC_1 (mm)	LH (mm)	OAL (mm)	DCON MS (mm)	DC (mm)	NOF
G1495	5.00	2.00	19.0	45.0	6.00	10.00	1
G14910	10.00	5.00	23.0	48.0	8.00	14.00	1
G14915	15.00	10.00	34.0	65.0	10.00	21.00	1
G14920	20.00	15.00	43.0	84.0	12.00	28.00	1
G14925	25.00	20.00	48.0	102.0	15.00	35.00	1

G560



HSS lige skaft 90 ° forsænker, TiAlN belagt

En 90 ° forsænker designet til reifning og fjernelse af grater fra borede huller. Reduceret skaft muliggør reifning med større diameter i standardholdere og borepatroner. Alsidigt værktøj, som kan bruges i håndholdte applikationer og maskiner. TiAlN-belægning forbedrer ydeevnen og forlænger værktøjets levetid.



HSS

DIN
335C

90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 40 E	■ 45 E	■ 46 E	■ 34 E	■ 30 D	■ 27 B	■ 28 D	■ 22 D	■ 19 B	■ 16 D	■ 14 B	▣ 11 B	▣ 11 C	▣ 9 C
M2.1	M2.2	M2.3	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2
▣ 10 C	▣ 9 C	▣ 8 B	■ 41 F	■ 30 D	▣ 23 D	■ 42 C	■ 34 C	▣ 27 C	■ 37 C	■ 28 C	▣ 23 C	▣ 34 C	▣ 26 C
K4.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1
▣ 19 C	■ 39 C	■ 29 C	▣ 23 C	▣ 60 G	▣ 45 G	■ 30 F	■ 30 F	■ 27 F	■ 19 F	■ 32 F	■ 18 F	▣ 19 D	▣ 62 G
N4.2													
▣ 55 G													

DCON MS tolerance h9.
Produkter fra denne serie fås også i sæt. Se G236.

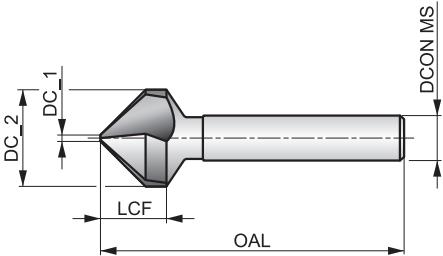
Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G5606.3	6.30	1.50	5.5	45.0	5.00	3
G5608.0	8.00	2.00	6.1	50.0	6.00	3
G5608.3	8.30	2.00	6.5	50.0	6.00	3
G56010.0	10.00	2.50	7.6	50.0	6.00	3
G56010.4	10.40	2.50	7.6	50.0	6.00	3
G56012.4	12.40	2.80	8.5	56.0	8.00	3
G56016.5	16.50	3.20	10.5	60.0	10.00	3
G56020.5	20.50	3.50	13.0	63.0	10.00	3
G56025.0	25.00	3.80	15.5	67.0	10.00	3
G56031.0	31.00	4.20	18.5	71.0	12.00	3

G570



HSS-E lige skaft 90 ° forsænker, AlTiCN belagt

En 90 ° forsænker designet til reifning af huller og rens grater fra borede huller. Kan bruges i maskin- og håndholdte applikationer. Særligt velegnet til reifning af huller i hårde og slibende materialer. AlTiCN-belægning forbedrer ydeevnen og forlænger værktøjets levetid.



HSS-E

AlTiCN

DIN 335C





90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
▣40 E	▣45 E	▣46 E	▣34 E	▣30 D	▣27 B	▣28 D	▣22 D	▣19 B	▣16 D	▣14 B	▣11 B	▣23 C	▣20 C
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
▣21 C	▣17 C	▣14 A	▣14 B	▣12 B	▣11 B	▣15 A	▣13 A	▣41 C	▣30 C	▣23 C	▣42 C	▣34 C	▣27 C
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
▣37 C	▣28 C	▣23 C	▣34 C	▣26 C	▣19 C	▣39 C	▣29 C	▣23 C	▣60 G	▣45 G	▣30 F	▣30 F	▣27 F
N2.3	N3.1	N3.2	N3.3										
▣19 F	▣32 F	▣18 F	▣9 D										

DCON MS tolerance h9.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G5706.3	6.30	1.50	6.5	45.0	5.00	3
G5708.3	8.30	2.00	8.2	50.0	6.00	3
G57010.4	10.40	2.50	9.7	50.0	6.00	3
G57012.4	12.40	2.80	10.6	56.0	8.00	3
G57016.5	16.50	3.20	13.9	60.0	10.00	3
G57020.5	20.50	3.50	17.1	63.0	10.00	3
G57025.0	25.00	3.80	21.4	67.0	10.00	3
G57031.0	31.00	4.20	24.4	71.0	12.00	3

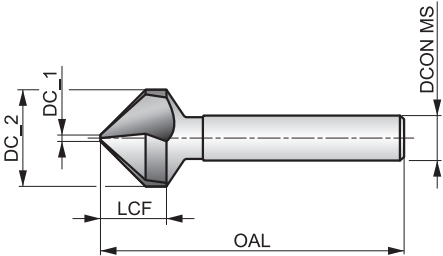
G400

DORMER



Hårdmetal lige skaft 90 ° forsænker, blank finish

Højtydende 90 ° forsænker med blank finish designet til brug med CNC-maskiner, hvor der kræves høj produktivitet og kvalitet. Kan bruges til affasning af huller i hårde og slibende materialer. En 90 ° vinkel er designet til at affase huller til standard med 90 ° hoved.



HM

DIN 335C

90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 64 E	■ 72 E	■ 74 E	■ 55 E	■ 48 D	■ 43 B	■ 45 D	■ 36 D	■ 30 B	■ 26 D	■ 23 B	■ 18 A	■ 24 C	■ 21 C
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■ 22 C	▣ 18 C	▣ 15 B	■ 20 B	▣ 17 B	▣ 15 B	▣ 15 A	▣ 13 A	■ 45 F	■ 33 D	■ 25 D	■ 46 C	■ 37 C	▣ 30 C
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■ 41 C	■ 31 C	▣ 25 C	■ 38 C	■ 28 C	■ 21 C	▣ 18 C	▣ 15 C	■ 43 C	■ 32 C	■ 25 C	▣ 75 G	■ 55 G	■ 40 F
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 40 F	■ 36 F	■ 26 F	■ 42 F	■ 25 F	▣ 13 D	■ 17 E	■ 12 C	■ 10 A	▣ 9 A	■ 8 B	▣ 7 A	■ 6 B	▣ 5 A
S4.1	S4.2	H1.1	H2.1	H2.2	H3.1	H3.2	H4.1	H4.2					
■ 5 B	▣ 4 A	■ 12 A	■ 7 A	▣ 6 B	■ 8 A	▣ 7 B	■ 5 A	▣ 4 B					

DCON MS tolerance h6.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G4006.3	6.30	1.50	5.0	45.0	5.00	3
G4008.3	8.30	2.00	6.0	50.0	6.00	3
G40010.4	10.40	2.50	7.1	50.0	6.00	3
G40012.4	12.40	2.80	8.0	56.0	8.00	3
G40016.5	16.50	3.20	10.0	60.0	10.00	3
G40020.5	20.50	3.50	12.5	63.0	10.00	3
G40025.0	25.00	3.80	15.0	67.0	10.00	3
G40031.0	31.00	4.20	18.0	71.0	12.00	3

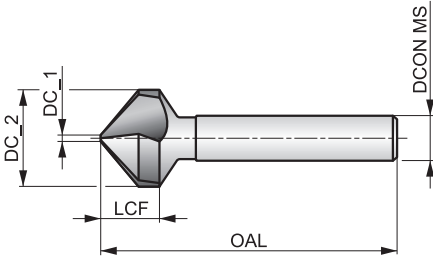
G171





HSS lige skaft 100 ° forsænker, TiAlN belagt

En 100 ° forsænker designet til reifning af standard huller og fjernelse af grater. Et alsidigt værktøj med en TiAlN-belægning, der forbedrer ydeevnen og forlænger værktøjets levetid. Alsidigt værktøj, der kan bruges i både håndholdte og maskinapplikationer. Velegnet til reifning af huller i mange materialer.



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 40 E	P1.2 ■ 45 E	P1.3 ■ 46 E	P2.1 ■ 34 E	P2.2 ■ 30 D	P2.3 ■ 27 B	P3.1 ■ 28 D	P3.2 ■ 22 D	P3.3 ■ 19 B	P4.1 ■ 16 D	P4.2 ■ 14 B	P4.3 ▣ 11 B	M1.1 ▣ 11 C	M1.2 ▣ 9 C
M2.1 ▣ 10 C	K1.1 ■ 41 F	K1.2 ■ 30 D	K1.3 ▣ 23 D	K2.1 ■ 42 C	K2.2 ■ 34 C	K2.3 ▣ 27 C	K3.1 ■ 37 C	K3.2 ■ 28 C	K3.3 ▣ 23 C	K4.1 ▣ 34 C	K4.2 ▣ 26 C	K4.3 ▣ 19 C	K5.1 ■ 39 C
K5.2 ■ 29 C	K5.3 ▣ 23 C	N1.1 ▣ 60 G	N1.2 ▣ 45 G	N1.3 ■ 30 F	N2.1 ■ 30 F	N2.2 ■ 27 F	N2.3 ■ 19 F	N3.1 ■ 32 F	N3.2 ■ 18 F	N3.3 ▣ 9 D	N4.1 ▣ 62 G	N4.2 ▣ 55 G	

DCON MS tolerance h9.

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1716.3	6.30	1.50	4.5	44.0	5.00	3
G1718.3	8.30	2.00	5.5	49.0	6.00	3
G17110.4	10.40	2.50	6.6	49.0	6.00	3
G17112.4	12.40	2.80	7.0	53.0	8.00	3
G17116.5	16.50	3.20	9.0	56.0	10.00	3
G17120.5	20.50	3.50	11.0	61.0	10.00	3
G17125.0	25.00	3.80	13.5	65.0	10.00	3

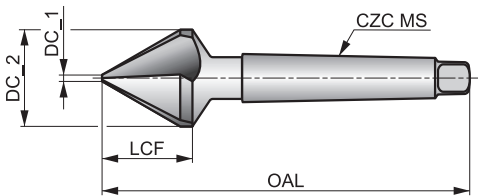
G137

 **DORMER**



HSS MK skaft 60 ° forsænker, blank finish

Forsænker med blank finish og en vinkel på 60 ° til reifning af huller og fjernelse af grater fra borede huller. Konisk MK skaftdesign gør det muligt at bruge værktøjet til maskinapplikationer, hvor det holdes direkte i spindlen. Velegnet til affasning af huller i mange materialer.



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 23 E	P1.2 ■ 26 E	P1.3 ■ 27 E	P2.1 ■ 20 E	P2.2 ■ 18 D	P2.3 ▣ 16 B	P3.1 ■ 16 D	P3.2 ▣ 13 D	P3.3 ▣ 11 B	P4.1 ■ 10 D	P4.2 ▣ 8 B	M1.1 ▣ 8 C	M1.2 ▣ 6 C	M2.1 ▣ 7 C
M2.2 ▣ 6 C	K1.1 ▣ 20 F	K1.2 ▣ 15 D	K2.1 ▣ 21 C	K2.2 ▣ 17 C	K3.1 ▣ 18 C	K3.2 ▣ 14 C	K5.1 ▣ 19 C	K5.2 ▣ 15 C	N1.1 ▣ 40 G	N1.2 ■ 30 G	N1.3 ▣ 20 F	N2.1 ■ 20 F	N2.2 ▣ 18 F
N3.1 ■ 21 F	N3.2 ■ 12 F	N3.3 ▣ 6 D	N4.1 ▣ 40 G	N4.2 ▣ 35 G									

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	CZC MS	NOF
G13731.5	31.50	10.00	23.0	118.0	MK 2	3
G13740.0	40.00	12.50	28.5	150.0	MK 3	3
G13750.0	50.00	16.00	36.0	160.0	MK 3	3

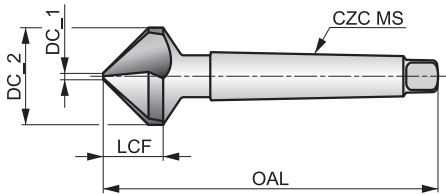
G138





HSS konisk skaft 90 ° forsænker, Blank finish

En 90 ° forsænker designet til reifning af huller og fjernelse af grater fra borede huller. Konisk skaftdesign gør det muligt at bruge værktøjet til maskinapplikationer, hvor det holdes direkte i spindlen. Velegnet til affasning af huller i mange materialer.



HSS	Bright	DIN 335D
R		90°

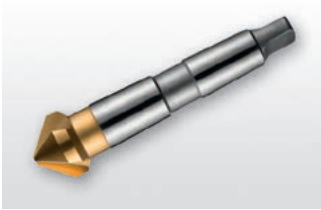
Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	▣ 16 B	■ 16 D	▣ 13 D	▣ 11 B	■ 10 D	▣ 8 B	▣ 8	▣ 6	▣ 7
M2.2	K1.1	K1.2	K2.1	K2.2	K3.1	K3.2	K5.1	K5.2	N1.1	N1.2	N1.3	N2.1	N2.2
▣ 6	▣ 20 F	▣ 15 D	▣ 21 C	▣ 17 C	▣ 18 C	▣ 14 C	▣ 19 C	▣ 15 C	▣ 40 G	■ 30 G	▣ 20 F	■ 20 F	▣ 18 F
N3.1	N3.2	N3.3	N4.1	N4.2									
■ 21 F	■ 12 F	▣ 6 D	▣ 40 G	▣ 35 G									

Product	DC_2	DC_1	LCF	OAL	CZC MS	NOF
	(mm)	(mm)	(mm)	(mm)		
G13825.0	25.00	3.80	15.5	106.0	MK 2	3
G13830.0	30.00	4.20	18.5	112.0	MK 2	3
G13831.0	31.00	4.20	20.0	112.0	MK 2	3
G13834.0	34.00	4.50	19.5	118.0	MK 2	3
G13837.0	37.00	4.80	21.7	118.0	MK 2	3
G13840.0	40.00	10.00	20.5	140.0	MK 3	3
G13850.0	50.00	14.00	24.1	150.0	MK 3	3
G13863.0	63.00	16.00	28.5	180.0	MK 4	3

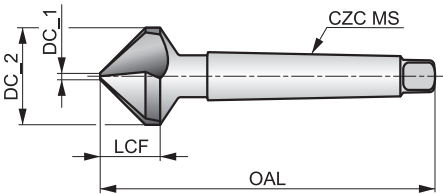
G338





HSS konisk skaft 90 ° forsænker, TiN belagt

En 90 ° forsænker designet til reifning af huller og fjernelse af grater. Forbedret ydelse ved bearbejdning i lange perioder med høj hastighed. Konisk skaftdesign gør det muligt at holde det direkte i spindlen. TiN Coating forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til mange materialer.





HSS



TiN



DIN
335D



R





90°

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 280.

P1.1 ■ 33 E	P1.2 ■ 37 E	P1.3 ■ 38 E	P2.1 ■ 28 E	P2.2 ■ 25 D	P2.3 ■ 22 B	P3.1 ■ 23 D	P3.2 ■ 18 D	P3.3 ■ 15 B	P4.1 ■ 13 D	P4.2 ■ 11 B	P4.3 ▣ 9 B	M1.1 ▣ 11 C	M1.2 ▣ 9 C
M2.1 ▣ 10 C	M2.2 ▣ 9 C	M2.3 ▣ 8 B	K1.1 ■ 34 F	K1.2 ■ 25 D	K1.3 ▣ 19 D	K2.1 ■ 35 C	K2.2 ■ 28 C	K2.3 ▣ 23 C	K3.1 ■ 31 C	K3.2 ■ 24 C	K3.3 ▣ 19 C	K4.1 ▣ 29 C	K4.2 ▣ 22 C
K4.3 ▣ 16 C	K5.1 ■ 32 C	K5.2 ■ 24 C	K5.3 ▣ 19 C	N1.1 ■ 53 G	N1.2 ■ 40 G	N1.3 ■ 27 F	N2.1 ■ 27 F	N2.2 ■ 24 F	N2.3 ■ 17 F	N3.1 ■ 28 F	N3.2 ■ 16 F	N3.3 ▣ 18 D	N4.1 ▣ 58 G
N4.2 ▣ 50 G													

Product	DC_2	DC_1	LCF	OAL	CZC MS	NOF
	(mm)	(mm)	(mm)	(mm)		
G33825.0	25.00	3.80	15.5	106.0	MK 2	3
G33831.0	31.00	4.20	20.0	112.0	MK 2	3
G33837.0	37.00	4.80	21.7	118.0	MK 2	3
G33840.0	40.00	10.00	20.5	140.0	MK 3	3
G33850.0	50.00	14.00	24.1	150.0	MK 3	3

Materiale kode (BMC)	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS	HSS				
Belægning												
Grundlæggende standard-gruppe (BSG)	BS 328	DIN 212	DIN 212	DIN 208	BS 328	DIN 2180	DIN 311	ANSI				
Hånd (skæreretning)												
Skaft												
Rival form	B	B	B	B	B							
Opnåelig hultolerance (TCHA)	H7	H7	ø 95-5.5 +0.004 ø 5.51-12 +0.005	H7	H7		k11					
Konisk stigning - millimeter						1:50 						
Produktfamiliekode	B901	B180	B170	B161	B101	B954	B121	B640				
PSF skærediametre række-vidde	1.50 - 1/2	1.50 - 20.00	1.00 - 12.00	3.00 - 50.00	3.00 - 50.00	8.00 - 30.00	12.00 - 25.00	7/16 - 1.1/16				
	168	169	171	173	174	175	176	177				
P	P1	■	■	■	■	■	■	■				
	P2	■	■	■	■	■	■	■				
	P3	■	■	■	■	■	■	■				
	P4	▣	▣	▣	▣	▣	▣	▣				
M	M1	▣	▣	▣	▣	▣						
	M2	▣	▣	▣	▣	▣						
	M3											
	M4											
K	K1	■	■	■	■	■	■	■				
	K2	■	■	■	■	■	■	■				
	K3	▣	▣	▣	▣	▣	▣	▣				
	K4											
	K5											
N	N1	■	■	■	■	■	■	■				
	N2	■	■	■	■	■	■	■				
	N3	■	■	■	■	■	■	■				
	N4	▣	▣	▣	▣	▣	▣	▣				
	N5											
S	S1											
	S2											
	S3											
	S4											
H	H1											
	H2											
	H3											
	H4											

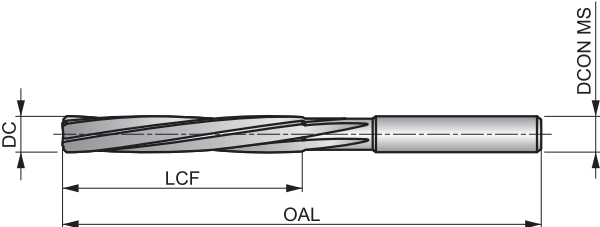
B901





HSS-E Lige skaft Maskin Rival, H7-tolerance, blank og ST-finish

Præcisions rival geometrien med venstre spiral og højre skæring forbedrer hulstørrelse og overfladefinish. Rivalen har et lige skaft til højtydende maskinindrivning. Velegnet til rivning i mange materialer.



HSS-E		BS 328
		B
H7		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 15 C	P1.2 ■ 16 C	P1.3 ■ 17 C	P2.1 ■ 13 C	P2.2 ■ 11 C	P2.3 ▣ 10 B	P3.1 ■ 7 B	P3.2 ■ 6 B	P3.3 ▣ 5 B	P4.1 ■ 4 B	P4.2 ▣ 4 B	P4.3 ▣ 3 A	M1.1 ▣ 10 C	M1.2 ▣ 8 C
M2.1 ▣ 9 C	K1.1 ■ 14 E	K1.2 ■ 10 D	K1.3 ▣ 8 D	K2.1 ■ 12 C	K2.2 ■ 10 C	K2.3 ▣ 8 C	K3.1 ▣ 11 C	K3.2 ▣ 8 C	N1.1 ▣ 23 F	N1.2 ■ 17 F	N1.3 ■ 12 F	N2.1 ■ 25 E	N2.2 ■ 22 E
N2.3 ▣ 14 E	N3.1 ■ 34 D	N3.2 ■ 20 E	N3.3 ■ 10 D	N4.1 ▣ 22 B	N4.2 ▣ 21 B								

Product	DC	DC	OAL	LCF	NOF	DCON MS
	(inch)	(mm)	(mm)	(mm)		(mm)
B9011.5	—	1.50	44.0	21.0	4	1.50
B9012.0	—	2.00	50.0	25.0	4	2.00
B9013/32	3/32	2.38	58.0	29.0	4	2.38
B9012.5	—	2.50	58.0	29.0	4	2.50
B9013.0	—	3.00	62.0	31.0	4	3.00
B9011/8	1/8	3.18	66.0	33.0	4	3.18
B9015/32	5/32	3.97	76.0	38.0	6	3.97
B9014.0	—	4.00	76.0	38.0	6	4.00
B9013/16	3/16	4.76	87.0	44.0	6	4.76
B9015.0	—	5.00	87.0	44.0	6	5.00
B90115/64	15/64	5.95	93.0	47.0	6	5.95
B9016.0	—	6.00	93.0	47.0	6	6.00

Product	DC	DC	OAL	LCF	NOF	DCON MS
	(inch)	(mm)	(mm)	(mm)		(mm)
B9011/4	1/4	6.35	100.0	50.0	6	6.35
B9017.0	—	7.00	107.0	54.0	6	7.00
B9019/32	9/32	7.14	107.0	54.0	6	7.14
B9015/16	5/16	7.94	115.0	58.0	6	7.94
B9018.0	—	8.00	115.0	58.0	6	8.00
B9019.0	—	9.00	124.0	62.0	6	9.00
B9013/8	3/8	9.52	133.0	66.0	6	9.52
B90110.0	—	10.00	133.0	66.0	6	10.00
B90111.0	—	11.00	142.0	71.0	6	11.00
B9017/16	7/16	11.11	142.0	71.0	6	11.11
B90112.0	—	12.00	152.0	76.0	6	12.00
B9011/2	1/2	12.70	152.0	76.0	6	12.70

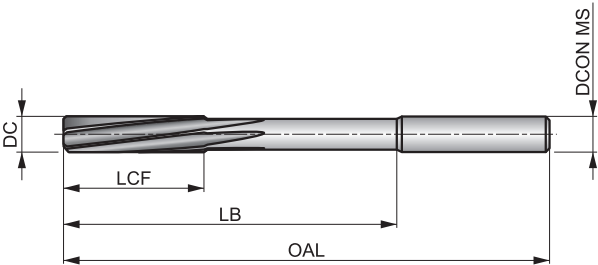
B180





HSS-E lige skaft maskin rival med H7 tolerance, blank finish

Højtydende rival til CNC-maskiner, holdes i værktøjsholdere eller patroner med høj nøjagtighed. Den nøjagtige venstre spiral og højre skærevirkning sikrer jævn rivning og forbedret overfladefinish og hulstørrelse. Velegnet til rivning i mange materialer.



HSS-E	Bright	DIN 212
R	DIN 6535HA	B
H7		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 21 C	P1.2 ■ 24 C	P1.3 ■ 25 C	P2.1 ■ 18 C	P2.2 ■ 16 C	P2.3 ▣ 14 B	P3.1 ■ 13 B	P3.2 ■ 11 B	P3.3 ▣ 9 B	P4.1 ■ 8 B	P4.2 ▣ 7 B	P4.3 ▣ 5 A	M1.1 ▣ 11 C	M1.2 ▣ 10 B
M2.1 ▣ 9 B	K1.1 ■ 16 E	K1.2 ■ 12 D	K1.3 ▣ 9 D	K2.1 ■ 16 C	K2.2 ■ 13 C	K2.3 ▣ 10 C	K3.1 ■ 14 C	K3.2 ▣ 11 C	N1.1 ▣ 24 F	N1.2 ■ 18 F	N1.3 ■ 11 F	N2.1 ▣ 27 E	N2.2 ■ 24 E
N2.3 ■ 16 E	N3.1 ■ 47 D	N3.2 ■ 28 E	N3.3 ▣ 14 D	N4.1 ▣ 30 B									

DCON MS tolerance h6.

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1801.5	1.50	40.0	8.0	18.00	3	2.00
B1801.6	1.60	43.0	9.0	20.00	3	2.00
B1801.7	1.70	43.0	9.0	20.00	3	2.00
B1801.8	1.80	46.0	10.0	22.00	4	2.00
B1801.9	1.90	46.0	10.0	22.00	4	2.00
B1802.0	2.00	49.0	11.0	24.00	4	2.00
B1802.1	2.10	49.0	11.0	24.00	4	2.00
B1802.2	2.20	53.0	12.0	26.00	4	3.00
B1802.3	2.30	53.0	12.0	26.00	4	3.00
B1802.4	2.40	57.0	14.0	28.00	4	3.00
B1802.5	2.50	57.0	14.0	28.00	4	3.00
B1802.6	2.60	57.0	14.0	28.00	4	3.00
B1802.7	2.70	61.0	15.0	32.00	6	3.00
B1802.8	2.80	61.0	15.0	32.00	6	3.00
B1802.9	2.90	61.0	15.0	32.00	6	3.00
B1803.0	3.00	61.0	15.0	32.00	6	3.00
B1803.1	3.10	65.0	16.0	35.00	6	4.00
B1803.2	3.20	65.0	16.0	35.00	6	4.00
B1803.3	3.30	65.0	16.0	35.00	6	4.00
B1803.4	3.40	70.0	18.0	40.00	6	4.00
B1803.5	3.50	70.0	18.0	40.00	6	4.00
B1803.6	3.60	70.0	18.0	40.00	6	4.00
B1803.9	3.90	75.0	19.0	43.00	6	4.00
B1804.0	4.00	75.0	19.0	43.00	6	4.00
B1804.1	4.10	75.0	19.0	43.00	6	4.00
B1804.2	4.20	75.0	19.0	43.00	6	4.00
B1804.3	4.30	80.0	21.0	47.00	6	5.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1804.5	4.50	80.0	21.0	47.00	6	5.00
B1804.6	4.60	80.0	21.0	47.00	6	5.00
B1804.7	4.70	80.0	21.0	47.00	6	5.00
B1804.8	4.80	86.0	23.0	52.00	6	5.00
B1804.9	4.90	86.0	23.0	52.00	6	5.00
B1805.0	5.00	86.0	23.0	52.00	6	5.00
B1805.1	5.10	86.0	23.0	52.00	6	5.00
B1805.2	5.20	86.0	23.0	52.00	6	5.00
B1805.3	5.30	86.0	23.0	52.00	6	5.00
B1805.4	5.40	93.0	26.0	57.00	6	6.00
B1805.5	5.50	93.0	26.0	57.00	6	6.00
B1805.6	5.60	93.0	26.0	57.00	6	6.00
B1805.7	5.70	93.0	26.0	57.00	6	6.00
B1805.9	5.90	93.0	26.0	57.00	6	6.00
B1806.0	6.00	93.0	26.0	57.00	6	6.00
B1806.1	6.10	101.0	28.0	63.00	6	6.00
B1806.2	6.20	101.0	28.0	63.00	6	6.00
B1806.3	6.30	101.0	28.0	63.00	6	6.00
B1806.4	6.40	101.0	28.0	63.00	6	6.00
B1806.5	6.50	101.0	28.0	63.00	6	6.00
B1806.6	6.60	101.0	28.0	63.00	6	6.00
B1806.7	6.70	101.0	28.0	63.00	6	6.00
B1806.8	6.80	109.0	31.0	69.00	6	8.00
B1807.0	7.00	109.0	31.0	69.00	6	8.00
B1807.1	7.10	109.0	31.0	69.00	6	8.00
B1807.2	7.20	109.0	31.0	69.00	6	8.00
B1807.5	7.50	109.0	31.0	69.00	6	8.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1807.8	7.80	117.0	33.0	75.00	6	8.00
B1807.9	7.90	117.0	33.0	75.00	6	8.00
B1808.0	8.00	117.0	33.0	75.00	6	8.00
B1808.1	8.10	117.0	33.0	75.00	6	8.00
B1808.2	8.20	117.0	33.0	75.00	6	8.00
B1808.3	8.30	117.0	33.0	75.00	6	8.00
B1808.4	8.40	117.0	33.0	75.00	6	8.00
B1808.5	8.50	117.0	33.0	75.00	6	8.00
B1808.7	8.70	125.0	36.0	81.00	6	10.00
B1808.8	8.80	125.0	36.0	81.00	6	10.00
B1809.0	9.00	125.0	36.0	81.00	6	10.00
B1809.5	9.50	125.0	36.0	81.00	6	10.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1809.6	9.60	133.0	38.0	87.00	6	10.00
B18010.0	10.00	133.0	38.0	87.00	6	10.00
B18011.0	11.00	142.0	41.0	96.00	6	10.00
B18012.0	12.00	151.0	44.0	105.00	6	10.00
B18013.0	13.00	151.0	44.0	105.00	6	10.00
B18014.0	14.00	160.0	47.0	110.00	8	14.00
B18015.0	15.00	162.0	50.0	112.00	8	14.00
B18016.0	16.00	170.0	52.0	120.00	8	14.00
B18017.0	17.00	175.0	54.0	123.00	8	14.00
B18018.0	18.00	182.0	56.0	130.00	8	14.00
B18019.0	19.00	189.0	58.0	131.00	8	16.00
B18020.0	20.00	195.0	60.0	137.00	8	16.00

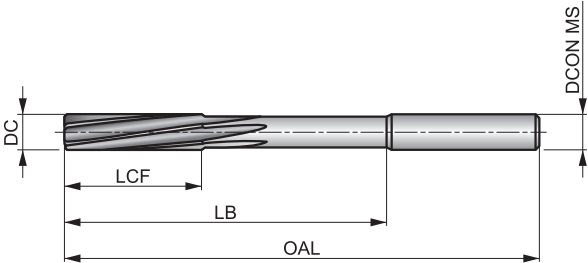
B170





HSS-E ligeskaft maskinrival - 0,01 mm intervaller, blank finish

Forskellige trin i størrelsen giver dig mulighed for at producere nøjagtige hulstørrelser og yderligere hultolerancer. Med en venstre spiral og en højre skærevirkning giver den præcise grundgeometri glat rivning og forbedrer hulstørrelse og overfladefinish. Velegnet til rivning i mange materialer.



HSS-E	Bright	DIN 212
		B
ø 95-5.5 +0.004 ø 5.51-12 +0.005		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 21 C	P1.2 ■ 24 C	P1.3 ■ 25 C	P2.1 ■ 18 C	P2.2 ■ 16 C	P2.3 ■ 14 B	P3.1 ■ 13 B	P3.2 ■ 11 B	P3.3 ■ 9 B	P4.1 ■ 8 B	P4.2 ■ 7 B	P4.3 ■ 5 A	M1.1 ■ 11 C	M1.2 ■ 10 B
M2.1 ■ 9 B	K1.1 ■ 16 E	K1.2 ■ 12 D	K1.3 ■ 9 D	K2.1 ■ 16 C	K2.2 ■ 13 C	K2.3 ■ 10 C	K3.1 ■ 14 C	K3.2 ■ 11 C	N1.1 ■ 24 D	N1.2 ■ 18 F	N1.3 ■ 11 F	N2.1 ■ 27 E	N2.2 ■ 24 E
N2.3 ■ 16 E	N3.1 ■ 47 D	N3.2 ■ 28 E	N3.3 ■ 14 D	N4.1 ■ 30 B									

DCON MS tolerance h9.

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1701.0	1.00	34.0	5.5	15.00	3	1.00
B1701.05	1.05	34.0	5.5	15.00	3	1.00
B1701.49	1.49	40.0	8.0	18.00	3	1.50
B1701.5	1.50	40.0	8.0	18.00	3	1.50
B1701.52	1.52	43.0	9.0	20.00	3	1.60
B1701.98	1.98	49.0	11.0	24.00	4	2.00
B1701.99	1.99	49.0	11.0	24.00	4	2.00
B1702.0	2.00	49.0	11.0	24.00	4	2.00
B1702.01	2.01	49.0	11.0	24.00	4	2.00
B1702.02	2.02	49.0	11.0	24.00	4	2.00
B1702.03	2.03	49.0	11.0	24.00	4	2.00
B1702.05	2.05	49.0	11.0	24.00	4	2.00
B1702.5	2.50	57.0	14.0	28.00	4	2.50
B1702.51	2.51	57.0	14.0	28.00	4	2.50
B1702.98	2.98	61.0	15.0	32.00	6	3.00
B1702.99	2.99	61.0	15.0	32.00	6	3.00
B1703.0	3.00	61.0	15.0	32.00	6	3.00
B1703.01	3.01	65.0	16.0	35.00	6	3.20
B1703.02	3.02	65.0	16.0	35.00	6	3.20
B1703.03	3.03	65.0	16.0	35.00	6	3.20
B1703.05	3.05	65.0	16.0	35.00	6	3.20
B1703.98	3.98	75.0	19.0	43.00	6	4.00
B1703.99	3.99	75.0	19.0	43.00	6	4.00
B1704.0	4.00	75.0	19.0	43.00	6	4.00
B1704.01	4.01	75.0	19.0	43.00	6	4.00
B1704.02	4.02	75.0	19.0	43.00	6	4.00
B1704.03	4.03	75.0	19.0	43.00	6	4.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1704.04	4.04	75.0	19.0	43.00	6	4.00
B1704.05	4.05	75.0	19.0	43.00	6	4.00
B1704.98	4.98	86.0	23.0	52.00	6	5.00
B1704.99	4.99	86.0	23.0	52.00	6	5.00
B1705.0	5.00	86.0	23.0	52.00	6	5.00
B1705.01	5.01	86.0	23.0	52.00	6	5.00
B1705.02	5.02	86.0	23.0	52.00	6	5.00
B1705.03	5.03	86.0	23.0	52.00	6	5.00
B1705.04	5.04	86.0	23.0	52.00	6	5.00
B1705.05	5.05	86.0	23.0	52.00	6	5.00
B1705.5	5.50	93.0	26.0	57.00	6	5.60
B1705.98	5.98	93.0	26.0	57.00	6	5.60
B1705.99	5.99	93.0	26.0	57.00	6	5.60
B1706.0	6.00	93.0	26.0	57.00	6	5.60
B1706.01	6.01	101.0	28.0	63.00	6	6.30
B1706.02	6.02	101.0	28.0	63.00	6	6.30
B1706.03	6.03	101.0	28.0	63.00	6	6.30
B1706.04	6.04	101.0	28.0	63.00	6	6.30
B1706.05	6.05	101.0	28.0	63.00	6	6.30
B1706.51	6.51	101.0	28.0	63.00	6	6.30
B1706.98	6.98	109.0	31.0	69.00	6	7.10
B1706.99	6.99	109.0	31.0	69.00	6	7.10
B1707.0	7.00	109.0	31.0	69.00	6	7.10
B1707.01	7.01	109.0	31.0	69.00	6	7.10
B1707.02	7.02	109.0	31.0	69.00	6	7.10
B1707.05	7.05	109.0	31.0	69.00	6	7.10
B1707.98	7.98	117.0	33.0	75.00	6	8.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1707.99	7.99	117.0	33.0	75.00	6	8.00
B1708.0	8.00	117.0	33.0	75.00	6	8.00
B1708.01	8.01	117.0	33.0	75.00	6	8.00
B1708.02	8.02	117.0	33.0	75.00	6	8.00
B1708.03	8.03	117.0	33.0	75.00	6	8.00
B1708.04	8.04	117.0	33.0	75.00	6	8.00
B1708.05	8.05	117.0	33.0	75.00	6	8.00
B1708.98	8.98	125.0	36.0	81.00	6	9.00
B1709.0	9.00	125.0	36.0	81.00	6	9.00
B1709.01	9.01	125.0	36.0	81.00	6	9.00
B1709.02	9.02	125.0	36.0	81.00	6	9.00
B1709.05	9.05	125.0	36.0	81.00	6	9.00
B1709.5	9.50	125.0	36.0	81.00	6	9.00
B1709.51	9.51	133.0	38.0	87.00	6	10.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1709.52	9.52	133.0	38.0	87.00	6	10.00
B1709.98	9.98	133.0	38.0	87.00	6	10.00
B1709.99	9.99	133.0	38.0	87.00	6	10.00
B17010.0	10.00	133.0	38.0	87.00	6	10.00
B17010.01	10.01	133.0	38.0	87.00	6	10.00
B17010.02	10.02	133.0	38.0	87.00	6	10.00
B17010.03	10.03	133.0	38.0	87.00	6	10.00
B17010.04	10.04	133.0	38.0	87.00	6	10.00
B17010.05	10.05	133.0	38.0	87.00	6	10.00
B17010.98	10.98	142.0	41.0	96.00	6	10.00
B17011.98	11.98	151.0	44.0	105.00	6	10.00
B17011.99	11.99	151.0	44.0	105.00	6	10.00
B17012.0	12.00	151.0	44.0	105.00	6	10.00

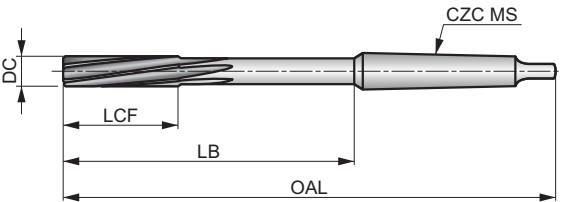
B161





HSS-E Taper lige Maskin Rival med H7-tolerance, blank finish

Den nøjagtige rival i venstre spiral og højre skærevirkning sikrer jævn rivning og forbedret overfladefinish og hulstørrelse Velegnet til rivning i mange materialer.



HSS-E	Bright	DIN 208
R		B
H7		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 21 C	■ 24 C	■ 25 C	■ 18 C	■ 16 C	▣ 14 B	■ 13 B	■ 11 B	▣ 9 B	■ 8 B	▣ 7 B	▣ 5 A	▣ 11 C	▣ 10 B
M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
▣ 9 B	■ 16 E	■ 12 D	▣ 9 D	■ 16 C	■ 13 C	▣ 10 C	■ 14 C	▣ 11 C	▣ 24 F	■ 18 F	■ 11 F	▣ 27 E	■ 24 E
N2.3	N3.1	N3.2	N3.3	N4.1									
■ 16 E	■ 47 D	■ 28 E	▣ 14 D	▣ 30 B									

Product	DC	OAL	LCF	LB	NOF	CZC MS
	(mm)	(mm)	(mm)	(mm)		
B1613.0	3.00	113.0	15.0	47.50	6	MK 1
B1614.0	4.00	124.0	19.0	58.50	6	MK 1
B1615.0	5.00	133.0	23.0	67.50	6	MK 1
B1616.0	6.00	138.0	26.0	72.50	6	MK 1
B1617.0	7.00	150.0	31.0	84.50	6	MK 1
B1618.0	8.00	156.0	33.0	90.50	6	MK 1
B1619.0	9.00	162.0	36.0	96.50	6	MK 1
B16110.0	10.00	168.0	38.0	102.50	6	MK 1
B16111.0	11.00	175.0	41.0	109.50	6	MK 1
B16112.0	12.00	182.0	44.0	116.50	6	MK 1
B16113.0	13.00	182.0	44.0	116.50	6	MK 1
B16114.0	14.00	189.0	47.0	123.50	8	MK 1
B16115.0	15.00	204.0	50.0	124.00	8	MK 2
B16116.0	16.00	210.0	52.0	130.00	8	MK 2
B16117.0	17.00	214.0	54.0	134.00	8	MK 2
B16118.0	18.00	219.0	56.0	139.00	8	MK 2
B16119.0	19.00	223.0	58.0	143.00	8	MK 2
B16120.0	20.00	228.0	60.0	148.00	8	MK 2

Product	DC	OAL	LCF	LB	NOF	CZC MS
	(mm)	(mm)	(mm)	(mm)		
B16121.0	21.00	232.0	62.0	152.00	8	MK 2
B16122.0	22.00	237.0	64.0	157.00	8	MK 2
B16123.0	23.00	241.0	66.0	161.00	8	MK 2
B16124.0	24.00	268.0	68.0	169.00	8	MK 3
B16125.0	25.00	268.0	68.0	169.00	8	MK 3
B16126.0	26.00	273.0	70.0	174.00	8	MK 3
B16127.0	27.00	277.0	71.0	178.00	10	MK 3
B16128.0	28.00	277.0	71.0	178.00	10	MK 3
B16130.0	30.00	281.0	73.0	182.00	10	MK 3
B16132.0	32.00	317.0	77.0	193.00	10	MK 4
B16134.0	34.00	321.0	78.0	197.00	10	MK 4
B16135.0	35.00	321.0	78.0	197.00	10	MK 4
B16138.0	38.00	329.0	81.0	205.00	10	MK 4
B16140.0	40.00	329.0	81.0	205.00	10	MK 4
B16142.0	42.00	333.0	82.0	209.00	12	MK 4
B16145.0	45.00	336.0	83.0	212.00	12	MK 4
B16150.0	50.00	344.0	86.0	220.00	12	MK 4

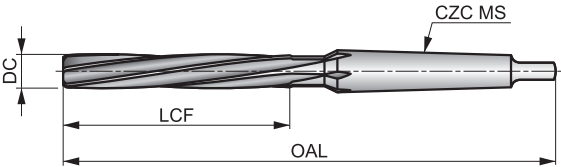
B101





HSS-E konisk skaftdril med H7-tolerance

MK maskindril i henhold til BS 328. Den nøjagtige venstre spiral og højre skærevirkning sikrer jævn rivning og forbedret overfladefinish og hultørrelse. Velegnet til rivning i mange materialer.



HSS-E	 Bright ST	BS 328
 R	 B	
H7		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 15 C	■ 16 C	■ 17 C	■ 13 C	■ 11 C	▣ 10 B	■ 7 B	■ 6 B	▣ 5 B	■ 4 B	▣ 4 B	▣ 3 A	▣ 7 B	▣ 6 A
K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
■ 14 E	■ 10 D	▣ 8 D	■ 12 C	■ 10 C	▣ 8 C	■ 11 C	▣ 8 C	▣ 23 F	■ 17 F	■ 9 F	▣ 25 E	■ 18 E	■ 14 E
N3.1	N3.2	N3.3	N4.1										
■ 34 D	■ 20 E	▣ 10 D	▣ 22 B										

Product	DC	DC	OAL	LCF	NOF	CZC MS
	(inch)	(mm)	(mm)	(mm)		
B1013.0	—	3.00	112.0	33.0	4	MK 1
B1014.0	—	4.00	117.0	38.0	6	MK 1
B1013/16	3/16	4.76	124.0	44.0	6	MK 1
B1015.0	—	5.00	124.0	44.0	6	MK 1
B1016.0	—	6.00	127.0	47.0	6	MK 1
B1011/4	1/4	6.35	130.0	50.0	6	MK 1
B1015/16	5/16	7.94	138.0	58.0	6	MK 1
B1018.0	—	8.00	138.0	58.0	6	MK 1
B1013/8	3/8	9.52	146.0	66.0	6	MK 1
B10110.0	—	10.00	146.0	66.0	6	MK 1
B10111.0	—	11.00	151.0	71.0	6	MK 1
B1017/16	7/16	11.11	151.0	71.0	6	MK 1
B10112.0	—	12.00	156.0	76.0	6	MK 1
B1011/2	1/2	12.70	156.0	76.0	6	MK 1
B10113.0	—	13.00	156.0	76.0	6	MK 1
B10114.0	—	14.00	161.0	81.0	8	MK 1
B1019/16	9/16	14.29	181.0	81.0	8	MK 2
B10115.0	—	15.00	181.0	81.0	8	MK 2
B1015/8	5/8	15.88	187.0	87.0	8	MK 2
B10116.0	—	16.00	187.0	87.0	8	MK 2
B10116.5	—	16.50	187.0	87.0	8	MK 2
B10117.0	—	17.00	187.0	87.0	8	MK 2

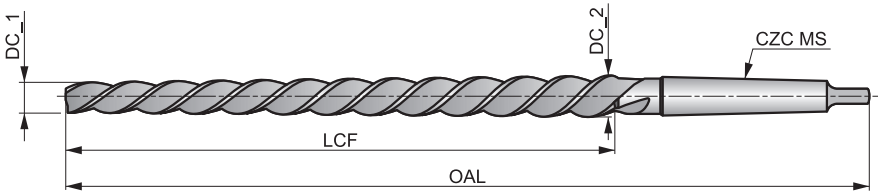
Product	DC	DC	OAL	LCF	NOF	CZC MS
	(inch)	(mm)	(mm)	(mm)		
B10118.0	—	18.00	193.0	93.0	8	MK 2
B10119.0	—	19.00	193.0	93.0	8	MK 2
B1013/4	3/4	19.05	200.0	100.0	8	MK 2
B10120.0	—	20.00	200.0	100.0	8	MK 2
B10121.0	—	21.00	200.0	100.0	8	MK 2
B10122.0	—	22.00	207.0	107.0	8	MK 2
B1017/8	7/8	22.22	207.0	107.0	8	MK 2
B10123.0	—	23.00	207.0	107.0	8	MK 2
B10124.0	—	24.00	242.0	115.0	8	MK 3
B10125.0	—	25.00	242.0	115.0	10	MK 3
B1011	1"	25.40	242.0	115.0	10	MK 3
B10126.0	—	26.00	242.0	115.0	10	MK 3
B10128.0	—	28.00	251.0	124.0	10	MK 3
B10129.0	—	29.00	251.0	124.0	10	MK 3
B10130.0	—	30.00	251.0	124.0	10	MK 3
B1011.1/4	1.1/4	31.75	260.0	133.0	10	MK 3
B10135.0	—	35.00	302.0	142.0	10	MK 4
B10140.0	—	40.00	312.0	152.0	10	MK 4
B10141.0	—	41.00	312.0	152.0	10	MK 4
B10144.0	—	44.00	323.0	163.0	10	MK 4
B10150.0	—	50.00	334.0	174.0	12	MK 4

B954



HSS-E Maskinrival konisk 1:50

Jævn rivning med forbedret nøjagtighed og ydeevne opnås gennem den specialdesignede høj spiral venstre spiral og højre skæring. Designet til at færdiggøre koniske huller og accepterer standard metriske koniske stifter 1 til 50-forhold. Velegnet til rivning i mange materialer.



HSS-E	Bright	DIN 2180
R		1:50

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 10 B	P1.2 ■ 12 B	P1.3 ■ 13 B	P2.1 ■ 9 B	P2.2 ■ 8 B	P2.3 ▣ 6 A	P3.1 ■ 7 A	P3.2 ■ 6 A	P3.3 ▣ 3 A	P4.1 ■ 4 A	P4.2 ▣ 3 A	P4.3 ▣ 2 A	M1.1 ▣ 11 C	M1.2 ▣ 10 B
M2.1 ▣ 9 B	M2.2 ▣ 8 B	K1.1 ■ 10 C	K1.2 ■ 6 B	K1.3 ▣ 4 B	K2.1 ■ 8 A	K2.2 ■ 6 A	K2.3 ▣ 4 A	K3.1 ■ 11 A	K3.2 ▣ 8 A	N1.1 ▣ 14 F	N1.2 ■ 12 F	N1.3 ■ 9 F	N2.1 ■ 16 E
N2.2 ■ 14 E	N2.3 ▣ 10 E	N3.1 ■ 22 D	N3.2 ■ 14 E	N3.3 ▣ 6 D	N4.1 ▣ 22 B								

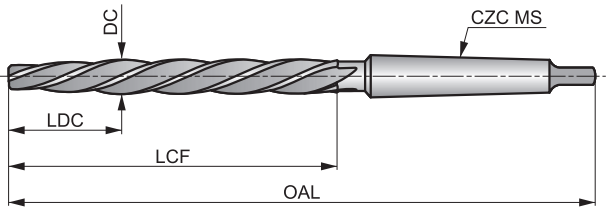
Product	nom d	DC_1	DC_2	OAL	LCF	NOF	CZC MS
		(mm)	(mm)	(mm)	(mm)		
B9548.0	8.0	7.90	10.80	227.0	145.0	3	MK 1
B95410.0	10.0	9.90	13.40	257.0	175.0	3	MK 1
B95412.0	12.0	11.80	16.00	315.0	210.0	3	MK 2
B95413.0	13.0	12.86	16.74	295.0	194.0	3	MK 2
B95414.0	14.0	13.86	17.74	295.0	194.0	3	MK 2
B95416.0	16.0	15.80	20.40	335.0	230.0	3	MK 2
B95420.0	20.0	19.80	24.80	377.0	250.0	3	MK 3
B95425.0	25.0	24.70	30.70	427.0	300.0	3	MK 3
B95430.0	30.0	29.70	36.10	475.0	320.0	4	MK 4

B121



HSS MK konisk maskin rival

Designet til at justere huller i store fabrikationer, hvor to eller flere emner er forbundet, før de boltes eller nites. Den lille dtyrdiameter fra 1 til 10 konisk rivning forenkler behovet for at placere og justere værktøjet i forborede huller. Velegnet til rivning i mange materialer.



HSS	 Bright ST	DIN 311
		k11

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 15 C	P1.2 ■ 16 C	P1.3 ■ 17 C	P2.1 ■ 13 C	P2.2 ■ 11 C	P2.3 ▣ 10 B	P3.1 ■ 7 B	P3.2 ■ 6 B	P3.3 ▣ 5 B	P4.1 ■ 4 B	P4.2 ▣ 4 B	P4.3 ▣ 3 A	K1.1 ■ 14 E	K1.2 ■ 10 D
K1.3 ▣ 8 D	K2.1 ■ 12 C	K2.2 ■ 10 C	K2.3 ▣ 8 C	K3.1 ▣ 11 C	K3.2 ▣ 8 C	N1.1 ▣ 23 F	N1.2 ■ 17 F	N1.3 ■ 9 F	N2.1 ▣ 21 E	N2.2 ■ 18 E	N2.3 ▣ 14 E	N3.1 ■ 34 D	N3.2 ■ 20 E
N3.3 ▣ 10 D	N4.1 ▣ 21 B												

Med 1:10 starter (LDC).

Product	DC (mm)	OAL (mm)	LCF (mm)	LDC (mm)	NOF	CZC MS
B12112.0	12.00	199.0	105.0	39.00	4	MK 2
B12114.0	14.00	209.0	115.0	42.00	4	MK 2
B12116.0	16.00	229.0	135.0	48.00	4	MK 2
B12117.0	17.00	251.0	135.0	51.00	4	MK 3
B12118.0	18.00	261.0	145.0	58.00	4	MK 3
B12120.0	20.00	271.0	155.0	62.00	4	MK 3
B12121.0	21.00	271.0	155.0	62.00	4	MK 3
B12122.0	22.00	281.0	165.0	66.00	4	MK 3
B12124.0	24.00	296.0	180.0	72.00	4	MK 3
B12125.0	25.00	296.0	180.0	72.00	4	MK 3

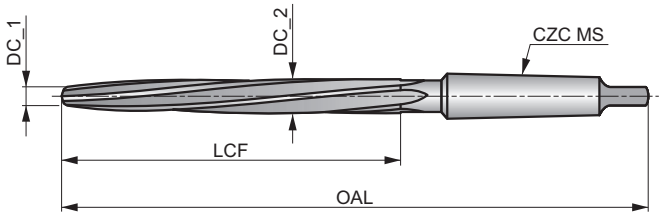
B640

 DORMER



HSS brofræser med konisk skaft, damphærdet

Bruges til at justere huller i store konstruktioner som I-bjælker, hvor to eller flere emner skal samles med bolte eller nitter. Den mindre startende med den lange koniske spids gør det muligt for operatøren at justere de uoverensstemmende forborede huller ved at fræse uoverensstemmelsen væk. Produceret i henhold til ANSI B94.2-1983 (R1988).



HSS		ANSI
		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 15 C	P1.2 ■ 16 C	P1.3 ■ 17 C	P2.1 ■ 13 C	P2.2 ■ 11 C	P2.3 ▣ 10 B	P3.1 ■ 7 B	P3.2 ■ 6 B	P3.3 ▣ 5 B	P4.1 ■ 4 B	P4.2 ▣ 4 B	P4.3 ▣ 3 A	K1.1 ■ 14 E	K1.2 ■ 10 D
K1.3 ▣ 8 D	K2.1 ■ 12 C	K2.2 ■ 10 C	K2.3 ▣ 8 C	K3.1 ▣ 11 C	K3.2 ▣ 8 C	N1.1 ▣ 23 F	N1.2 ■ 17 F	N1.3 ■ 9 F	N2.1 ▣ 21 E	N2.2 ■ 18 E	N2.3 ▣ 14 E	N3.1 ■ 34 D	N3.2 ■ 20 E
N3.3 ▣ 10 D	N4.1 ▣ 21 B												

Product	nom d	DC_1	DC_2	CZC MS	LCF	OAL	NOF
		(inch)	(inch)		(inch)	(inch)	
B6407/16	7/16	0.2500	0.4375	2	4.3/8	8.1/4	5
B6401/2	1/2	0.2813	0.5000	2	5.1/8	9"	5
B6409/16	9/16	0.3438	0.5625	2	5.1/8	9"	5
B6405/8	5/8	0.3750	0.6250	2	6.1/8	10"	5
B64011/16	11/16	0.3906	0.6875	3	7.1/8	11.3/4	5
B6403/4	3/4	0.4375	0.7500	3	7.3/8	12"	5
B64013/16	13/16	0.5000	0.8125	3	7.3/8	12"	5
B6407/8	7/8	0.5625	0.8750	3	7.3/8	12"	5
B64015/16	15/16	0.6250	0.9375	3	7.3/8	12"	5
B6401	1"	0.6875	1.0000	3	7.3/8	12"	5
B6401.1/16	1.1/16	0.7500	1.0625	3	7.3/8	12"	5



**VÆRKTØJER TIL PROCESSIONSikkerhed OG PRODUKTIVITET.
BRUGES TYPISK TIL CNC OG AUTOMATISERET PRODUKTION.**

Materiale kode (BMC)	HM	HM	HM	HM										
Grundlæggende standard-gruppe (BSG)														
Brugbar længde (ULDR)	1×D	1×D	1×D	1×D										
Anvendelsesvinkel														
Belægning														
Skaft														
Spiral form														
Hånd (skæreretning)														
Produktfamiliekode	R123	R6011	R122	R125										
PSF skærediametre række-vidde	5.00 - 20.00	6.00 - 16.00	5.00 - 20.00	5.00 - 16.00										
	182	183	184	185										
P	P1	■	■	■	■									
	P2	■	■	■	■									
	P3	■	■	■	■									
	P4	■	■	■	■									
M	M1	■	■	■	■									
	M2	■	■	■	■									
	M3	■	■	■	■									
	M4													
K	K1	■	■	■	■									
	K2	■	■	■	■									
	K3	■	■	■	■									
	K4	■	■	■	■									
	K5	■	■	■	■									
N	N1	■	■	■	■									
	N2	■	■	■	■									
	N3	■	■	■	■									
	N4	■	■	■	■									
	N5													
S	S1	■	■	■	■									
	S2	■	■	■	■									
	S3	■	■	■	■									
	S4	■	■	■	■									
H	H1	■	■	■	■									
	H2	▣	▣	▣	▣									
	H3	▣	▣	▣	▣									
	H4													

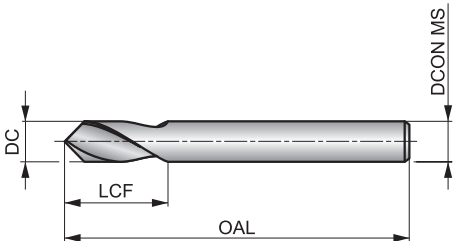
R123





HM NC forbor hårdmetal, 90 ° spids

Den nøjagtigt konstruerede spidsvinkel giver et nøjagtigt punkt, der hjælper med centrering af opfølgningsboringen af hullet. Et 90 ° spids hjælper med selvcentrering og reducerer skærekrafterne, når der bores i forskellige materialer.



HM		1xD
90°	Bright	
		DC h6

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 99 S	■ 111 S	■ 115 S	■ 85 S	■ 75 S	■ 66 S	■ 66 S	■ 53 S	■ 45 S	■ 40 S	■ 34 S	■ 27 S	■ 73 S	■ 61 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 65 S	■ 53 S	■ 52 S	■ 45 S	■ 75 T	■ 56 T	■ 42 T	■ 68 T	■ 55 T	■ 44 T	■ 60 T	■ 46 T	■ 37 T	■ 55 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 42 T	■ 31 T	■ 26 T	■ 22 T	■ 63 T	■ 47 T	■ 37 T	■ 200 V	■ 150 V	■ 100 V	■ 172 V	■ 155 V	■ 112 V	■ 423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■ 250 V	■ 125 V	■ 60 X	■ 100 V	■ 45 T	■ 35 T	■ 25 S	■ 40 S	■ 28 S	■ 30 S	■ 20 S	■ 23 S	■ 16 S	■ 56 S
H2.1	H2.2	H3.1	H3.2										
■ 33 S	■ 36 S	■ 37 S	■ 30 S										

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R1235.0	5.00	0.1969	16.0	62.0	5.00
R1236.0	6.00	0.2362	17.0	66.0	6.00
R1238.0	8.00	0.3150	22.0	79.0	8.00
R12310.0	10.00	0.3937	26.0	89.0	10.00
R12312.0	12.00	0.4724	30.0	102.0	12.00
R12316.0	16.00	0.6299	34.0	115.0	16.00
R12320.0	20.00	0.7874	40.0	131.0	20.00

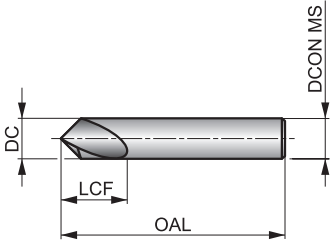
R6011

 **DORMER**



HM NC forbor hårdmetal, 90 ° spids. TiALN belægning

Den nøjagtigt konstruerede spidstvinkel giver et nøjagtig punkt, der hjælper med centrering af opfølgningsboringen af hullet. Et 90 ° spids hjælper med selvcentrering og reducerer skærekrafter, når der bores i materialet. TiALN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til boring af mange materialer.



HM	 DORMER	1xD
90°	 TiALN	 DIN 6535HA
 λ 20-35°	 R	DC h6

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 119 S	P1.2 ■ 134 S	P1.3 ■ 138 S	P2.1 ■ 102 S	P2.2 ■ 90 S	P2.3 ■ 80 S	P3.1 ■ 81 S	P3.2 ■ 65 S	P3.3 ■ 55 S	P4.1 ■ 48 S	P4.2 ■ 41 S	P4.3 ■ 34 S	M1.1 ■ 82 S	M1.2 ■ 70 S
M2.1 ■ 73 S	M2.2 ■ 60 S	M3.1 ■ 58 S	M3.2 ■ 50 S	K1.1 ■ 80 T	K1.2 ■ 59 T	K1.3 ■ 44 T	K2.1 ■ 86 T	K2.2 ■ 70 T	K2.3 ■ 56 T	K3.1 ■ 76 T	K3.2 ■ 58 T	K3.3 ■ 47 T	K4.1 ■ 71 T
K4.2 ■ 53 T	K4.3 ■ 39 T	K4.4 ■ 33 T	K4.5 ■ 28 T	K5.1 ■ 80 T	K5.2 ■ 60 T	K5.3 ■ 46 T	N1.1 ■ 200 V	N1.2 ■ 150 V	N1.3 ■ 100 V	N2.1 ■ 172 V	N2.2 ■ 155 V	N2.3 ■ 112 V	N3.1 ■ 423 V
N3.2 ■ 250 V	N3.3 ■ 125 V	N4.1 ■ 60 X	N4.2 ■ 100 V	S1.1 ■ 55 T	S1.2 ■ 45 T	S1.3 ■ 35 S	S2.1 ■ 53 S	S2.2 ■ 42 S	S3.1 ■ 40 S	S3.2 ■ 30 S	S4.1 ■ 31 S	S4.2 ■ 24 S	H1.1 ■ 56 S
H2.1 ■ 33 S	H2.2 ■ 36 S	H3.1 ■ 37 S	H3.2 ■ 30 S										

DCON MS tolerance h6.

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R60116.0	6.00	0.2362	16.0	50.0	6.00
R601110.0	10.00	0.3937	25.0	70.0	10.00
R601116.0	16.00	0.6299	26.0	90.0	16.00

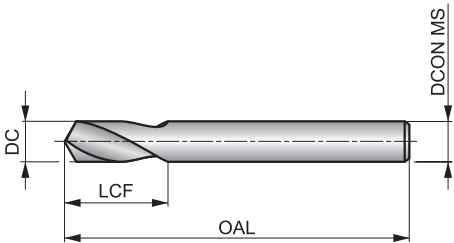
R122

 DORMER



HM NC forbor hårdmetal, 120° spids

Den nøjagtigt konstruerede spidsvinkel giver en nøjagtig punkt, der hjælper med centrering af opfølgningsboringen af hullet. En vinkel på 120° hjælper med selvcentrering og reducerer skærekrafter ved boring af forskellige materialer.



HM	 DORMER	1xD
120°	Bright	
		DC h6

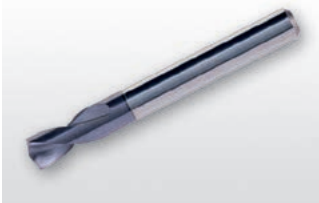
Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 99 S	■ 111 S	■ 115 S	■ 85 S	■ 75 S	■ 66 S	■ 66 S	■ 53 S	■ 45 S	■ 40 S	■ 34 S	■ 27 S	■ 73 S	■ 61 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 65 S	■ 53 S	■ 52 S	■ 45 S	■ 75 T	■ 56 T	■ 42 T	■ 68 T	■ 55 T	■ 44 T	■ 60 T	■ 46 T	■ 37 T	■ 55 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 42 T	■ 31 T	■ 26 T	■ 22 T	■ 63 T	■ 47 T	■ 37 T	■ 200 V	■ 150 V	■ 100 V	■ 172 V	■ 155 V	■ 112 V	■ 423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■ 250 V	■ 125 V	■ 60 X	■ 100 V	■ 45 T	■ 35 T	■ 25 S	■ 40 S	■ 28 S	■ 30 S	■ 20 S	■ 23 S	■ 16 S	■ 56 S
H2.1	H2.2	H3.1	H3.2										
■ 33 S	■ 36 S	■ 37 S	■ 30 S										

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R1225.0	5.00	0.1969	16.0	62.0	5.00
R1226.0	6.00	0.2362	17.0	66.0	6.00
R1228.0	8.00	0.3150	22.0	79.0	8.00
R12210.0	10.00	0.3937	26.0	89.0	10.00
R12212.0	12.00	0.4724	30.0	102.0	12.00
R12216.0	16.00	0.6299	34.0	115.0	16.00
R12220.0	20.00	0.7874	40.0	131.0	20.00

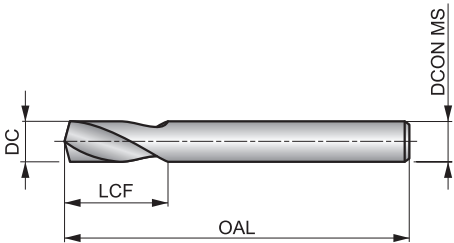
R125

 DORMER



HM NC forbor hårdmetal, 150 ° spids. TiAlN belægning

Den nøjagtigt konstruerede spidstvinkel giver et nøjagtig punkt, der hjælper med centrering af opfølgningsboringen af hullet. Et 150 ° spids hjælper med selvcentrering og reducerer skærekrafter, når der bores i materialet. TiAlN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til boring af mange materialer.



HM	 DORMER	1xD
150°	TiAlN	
 20-35°	 R	DC h6

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 119 S	■ 134 S	■ 138 S	■ 102 S	■ 90 S	■ 80 S	■ 81 S	■ 65 S	■ 55 S	■ 48 S	■ 41 S	■ 34 S	■ 82 S	■ 70 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■ 73 S	■ 60 S	■ 58 S	■ 50 S	■ 80 T	■ 59 T	■ 44 T	■ 86 T	■ 70 T	■ 56 T	■ 76 T	■ 58 T	■ 47 T	■ 71 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■ 53 T	■ 39 T	■ 33 T	■ 28 T	■ 80 T	■ 60 T	■ 46 T	■ 200 V	■ 150 V	■ 100 V	■ 172 V	■ 155 V	■ 112 V	■ 423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■ 250 V	■ 125 V	■ 60 X	■ 100 V	■ 55 T	■ 45 T	■ 35 S	■ 53 S	■ 42 S	■ 40 S	■ 30 S	■ 31 S	■ 24 S	■ 56 S
H2.1	H2.2	H3.1	H3.2										
■ 33 S	■ 36 S	■ 37 S	■ 30 S										

DCON MS tolerance h6.

Product	DC	LCF	OAL	DCON MS
	(mm)	(mm)	(mm)	(mm)
R1255.0	5.00	16.0	62.0	5.00
R1256.0	6.00	17.0	66.0	6.00
R1258.0	8.00	22.0	79.0	8.00
R12510.0	10.00	26.0	89.0	10.00
R12512.0	12.00	30.0	102.0	12.00
R12516.0	16.00	34.0	115.0	16.00

Materiale kode (BMC)	HM	HM	HM	HM	HM	HM	HM	HM	HM	HM			
Grundlæggende standard-gruppe (BSG)	DIN 6539	DIN 338	DIN 6537K	DIN 6537K	DIN 6537L	DIN 6537L	DORMER	DIN 6537K	DIN 6537L	DORMER			
Brugbar længde (ULDR)	2.5xD	4xD	3xD	3xD	5xD	5xD	8xD	3xD	5xD	3xD			
Anvendelsesvinkel													
Belægning													
Skaft													
Spiral form													
Hånd (skæreretning)													
Køling (CSP)													
	CDX	CDX	FORCE X	FORCE X	FORCE X	FORCE X	FORCE X	FORCE M	FORCE M	FORCE M			
Produktfamiliekode	R520	R510	R458	R457	R454	R453	R459	R467	R463	R7131			
PSF skærediametre rækkevidde	3.00 - 16.50	3.00 - 14.00	3.00 - 20.00	3.00 - 20.00	3.00 - 20.00	3.00 - 20.00	3.00 - 16.00	3.00 - 16.00	3.00 - 16.00	3.30 - 10.40			
P	P1												
	P2												
	P3												
	P4												
M	M1												
	M2												
	M3												
	M4												
K	K1												
	K2												
	K3												
	K4												
	K5												
N	N1												
	N2												
	N3												
	N4												
	N5												
S	S1												
	S2												
	S3												
	S4												
H	H1												
	H2												
	H3												
	H4												

R520

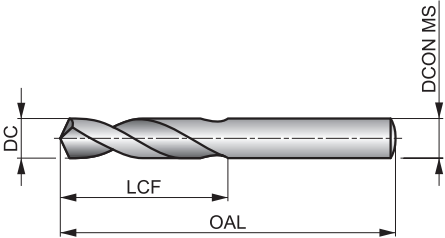
 **DORMER**



CDX massiv hårdmetal stubbor, TiN-belagt

Højtydende stubbor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H8 hultolerance). Vinklen på 130 ° hjælper med selvcentering og reducerer skærekrafterne. TiN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til alle CNC-maskiner og mange materialer.

CDX



HM	DIN 6539	2.5×D
		
		DC h7

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 119 X	P1.2 ■ 134 X	P1.3 ■ 138 X	P2.1 ■ 102 X	P2.2 ■ 90 X	P2.3 ■ 80 X	P3.1 ■ 81 X	P3.2 ■ 65 X	P3.3 ■ 55 X	P4.1 ■ 48 X	P4.2 ■ 41 X	P4.3 ■ 34 W	M1.1 ■ 69 W	M1.2 ■ 58 W
M2.1 ■ 61 W	M2.2 ■ 50 W	K1.1 ■ 90 Y	K1.2 ■ 67 Y	K1.3 ■ 50 Y	K2.1 ■ 80 X	K2.2 ■ 65 X	K2.3 ■ 52 X	K3.1 ■ 71 X	K3.2 ■ 54 X	K3.3 ■ 44 X	K4.1 ■ 66 X	K4.2 ■ 49 X	K4.3 ■ 36 X
K4.4 ■ 31 X	K4.5 ■ 26 X	K5.1 ■ 74 X	K5.2 ■ 56 X	K5.3 ■ 43 X	N1.1 ■ 225 Z	N1.2 ■ 169 Z	N1.3 ■ 113 Z	N2.1 ■ 231 Y	N2.2 ■ 208 Y	N2.3 ■ 150 Y	N4.1 ■ 75 Z	N4.2 ■ 115 V	S1.1 ■ 60 W
S1.2 ■ 45 V	S1.3 ■ 35 U	H1.1 ■ 65 U	H2.1 ■ 38 U	H2.2 ■ 36 T	H3.1 ■ 43 U	H3.2 ■ 35 U							

DCON MS tolerance h7.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R5203.0	—	3.00	0.1181	16.0	46.0	3.00
R5203.1	—	3.10	0.1220	18.0	49.0	3.10
R5201/8	1/8	3.18	0.1250	18.0	49.0	3.18
R5203.2	—	3.20	0.1260	18.0	49.0	3.20
R5203.3	—	3.30	0.1299	18.0	49.0	3.30
R5203.4	—	3.40	0.1339	20.0	52.0	3.40
R5203.5	—	3.50	0.1378	20.0	52.0	3.50
R5203.6	—	3.60	0.1417	20.0	52.0	3.60
R5203.7	—	3.70	0.1457	20.0	52.0	3.70
R5203.8	—	3.80	0.1496	22.0	55.0	3.80
R5203.9	—	3.90	0.1535	22.0	55.0	3.90
R5204.0	—	4.00	0.1575	22.0	55.0	4.00
R5204.1	—	4.10	0.1614	22.0	55.0	4.10
R5204.2	—	4.20	0.1654	22.0	55.0	4.20
R5204.3	—	4.30	0.1693	24.0	58.0	4.30
R5204.4	—	4.40	0.1732	24.0	58.0	4.40
R5204.5	—	4.50	0.1772	24.0	58.0	4.50
R5204.6	—	4.60	0.1811	24.0	58.0	4.60
R5204.7	—	4.70	0.1850	24.0	58.0	4.70
R5204.8	—	4.80	0.1890	26.0	62.0	4.80
R5204.9	—	4.90	0.1929	26.0	62.0	4.90
R5205.0	—	5.00	0.1969	26.0	62.0	5.00
R5205.1	—	5.10	0.2008	26.0	62.0	5.10
R5205.2	—	5.20	0.2047	26.0	62.0	5.20
R5205.3	—	5.30	0.2087	26.0	62.0	5.30

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R5205.4	—	5.40	0.2126	28.0	66.0	5.40
R5205.5	—	5.50	0.2165	28.0	66.0	5.50
R5205.6	—	5.60	0.2205	28.0	66.0	5.60
R5205.8	—	5.80	0.2283	28.0	66.0	5.80
R5205.9	—	5.90	0.2323	28.0	66.0	5.90
R5206.0	—	6.00	0.2362	28.0	66.0	6.00
R5206.1	—	6.10	0.2402	31.0	70.0	6.10
R5206.2	—	6.20	0.2441	31.0	70.0	6.20
R5206.3	—	6.30	0.2480	31.0	70.0	6.30
R5201/4	1/4	6.35	0.2500	31.0	70.0	6.35
R5206.4	—	6.40	0.2520	31.0	70.0	6.40
R5206.5	—	6.50	0.2559	31.0	70.0	6.50
R5206.6	—	6.60	0.2598	31.0	70.0	6.60
R5206.7	—	6.70	0.2638	31.0	70.0	6.70
R5206.8	—	6.80	0.2677	34.0	74.0	6.80
R5206.9	—	6.90	0.2717	34.0	74.0	6.90
R5207.0	—	7.00	0.2756	34.0	74.0	7.00
R5207.1	—	7.10	0.2795	34.0	74.0	7.10
R5207.2	—	7.20	0.2835	34.0	74.0	7.20
R5207.3	—	7.30	0.2874	34.0	74.0	7.30
R5207.4	—	7.40	0.2913	34.0	74.0	7.40
R5207.5	—	7.50	0.2953	34.0	74.0	7.50
R5207.6	—	7.60	0.2992	37.0	79.0	7.60
R5207.7	—	7.70	0.3031	37.0	79.0	7.70
R5207.8	—	7.80	0.3071	37.0	79.0	7.80

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R5205/16	5/16	7.94	0.3126	37.0	79.0	7.94
R5208.0	—	8.00	0.3150	37.0	79.0	8.00
R5208.1	—	8.10	0.3189	37.0	79.0	8.10
R5208.2	—	8.20	0.3228	37.0	79.0	8.20
R5208.3	—	8.30	0.3268	37.0	79.0	8.30
R5208.4	—	8.40	0.3307	37.0	79.0	8.40
R5208.5	—	8.50	0.3346	37.0	79.0	8.50
R5208.6	—	8.60	0.3386	40.0	84.0	8.60
R5208.7	—	8.70	0.3425	40.0	84.0	8.70
R5208.8	—	8.80	0.3465	40.0	84.0	8.80
R5209.0	—	9.00	0.3543	40.0	84.0	9.00
R5209.1	—	9.10	0.3583	40.0	84.0	9.10
R5209.3	—	9.30	0.3661	40.0	84.0	9.30
R5209.5	—	9.50	0.3740	40.0	84.0	9.50
R5203/8	3/8	9.52	0.3748	43.0	89.0	9.52
R5209.6	—	9.60	0.3780	43.0	89.0	9.60
R5209.7	—	9.70	0.3819	43.0	89.0	9.70
R5209.8	—	9.80	0.3858	43.0	89.0	9.80
R52010.0	—	10.00	0.3937	43.0	89.0	10.00
R52010.1	—	10.10	0.3976	43.0	89.0	10.10
R52010.2	—	10.20	0.4016	43.0	89.0	10.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R52010.3	—	10.30	0.4055	43.0	89.0	10.30
R52010.4	—	10.40	0.4094	43.0	89.0	10.40
R52010.5	—	10.50	0.4134	43.0	89.0	10.50
R52011.0	—	11.00	0.4331	47.0	95.0	11.00
R5207/16	7/16	11.11	0.4374	47.0	95.0	11.11
R52011.2	—	11.20	0.4409	47.0	95.0	11.20
R52011.5	—	11.50	0.4528	47.0	95.0	11.50
R52012.0	—	12.00	0.4724	51.0	102.0	12.00
R52012.5	—	12.50	0.4921	51.0	102.0	12.50
R5201/2	1/2	12.70	0.5000	51.0	102.0	12.70
R52013.0	—	13.00	0.5118	51.0	102.0	13.00
R52013.5	—	13.50	0.5315	54.0	107.0	13.50
R52014.0	—	14.00	0.5512	54.0	107.0	14.00
R52014.2	—	14.20	0.5591	56.0	111.0	14.20
R52014.25	—	14.25	0.5610	56.0	111.0	14.25
R52014.5	—	14.50	0.5709	56.0	111.0	14.50
R52015.0	—	15.00	0.5906	56.0	111.0	15.00
R52015.1	—	15.10	0.5945	58.0	115.0	15.10
R5205/8	5/8	15.88	0.6252	58.0	115.0	15.88
R52016.0	—	16.00	0.6299	58.0	115.0	16.00
R52016.5	—	16.50	0.6496	60.0	119.0	16.50

R510

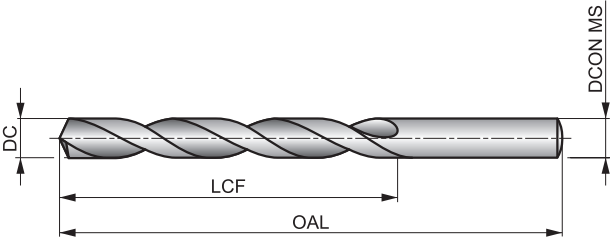
DORMER



CDX Solid HM-bor, TiN-belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændninger (H8 hultolerance). 130 ° spids hjælper med selvcentrering og reducerer skærekraften. TiN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til alle CNC-maskiner og mange materialer.

CDX



HM	DIN 338	4xD
	TiN	
	R	DC h7

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 119 W	■ 134 W	■ 138 W	■ 102 W	■ 90 W	■ 80 V	■ 81 W	■ 65 W	■ 55 V	■ 48 W	■ 41 V	■ 34 V	▣ 69 V	▣ 58 V
M2.1	M2.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
▣ 61 V	▣ 50 V	■ 90 X	■ 67 X	■ 50 X	■ 80 W	■ 65 W	■ 52 W	■ 71 W	■ 54 W	■ 44 W	■ 66 W	■ 49 W	■ 36 W
K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N4.1	N4.2	S1.1
■ 31 W	■ 26 W	■ 74 W	■ 56 W	■ 43 W	■ 225 Y	■ 169 Y	■ 113 Y	■ 231 X	■ 208 X	■ 150 X	■ 75 X	■ 115 V	▣ 45 V
H1.1	H2.1	H2.2	H3.1	H3.2									
▣ 65 T	▣ 38 T	▣ 36 S	▣ 43 T	▣ 35 T									

DCON MS tolerance h7.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R5103.0	—	3.00	0.1181	33.0	61.0	3.00
R5101/8	1/8	3.18	0.1250	36.0	65.0	3.18
R5103.2	—	3.20	0.1260	36.0	65.0	3.20
R5103.3	—	3.30	0.1299	36.0	65.0	3.30
R5103.4	—	3.40	0.1339	39.0	70.0	3.40
R5103.5	—	3.50	0.1378	39.0	70.0	3.50
R5103.7	—	3.70	0.1457	39.0	70.0	3.70
R5103.9	—	3.90	0.1535	43.0	75.0	3.90
R5104.0	—	4.00	0.1575	43.0	75.0	4.00
R5104.1	—	4.10	0.1614	43.0	75.0	4.10
R5104.2	—	4.20	0.1654	43.0	75.0	4.20
R5104.3	—	4.30	0.1693	47.0	80.0	4.30
R5104.5	—	4.50	0.1772	47.0	80.0	4.50
R5104.7	—	4.70	0.1850	47.0	80.0	4.70
R5103/16	3/16	4.76	0.1874	52.0	86.0	4.76
R5104.9	—	4.90	0.1929	52.0	86.0	4.90
R5105.0	—	5.00	0.1969	52.0	86.0	5.00
R5105.1	—	5.10	0.2008	52.0	86.0	5.10
R5105.5	—	5.50	0.2165	57.0	93.0	5.50
R5105.6	—	5.60	0.2205	57.0	93.0	5.60
R5105.7	—	5.70	0.2244	57.0	93.0	5.70
R5106.0	—	6.00	0.2362	57.0	93.0	6.00
R5101/4	1/4	6.35	0.2500	63.0	101.0	6.35
R5106.5	—	6.50	0.2559	63.0	101.0	6.50
R5106.6	—	6.60	0.2598	63.0	101.0	6.60
R5106.8	—	6.80	0.2677	69.0	109.0	6.80
R5107.0	—	7.00	0.2756	69.0	109.0	7.00
R5107.3	—	7.30	0.2874	69.0	109.0	7.30

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R5107.4	—	7.40	0.2913	69.0	109.0	7.40
R5107.5	—	7.50	0.2953	69.0	109.0	7.50
R5107.8	—	7.80	0.3071	75.0	117.0	7.80
R5105/16	5/16	7.94	0.3126	75.0	117.0	7.94
R5108.0	—	8.00	0.3150	75.0	117.0	8.00
R5108.5	—	8.50	0.3346	75.0	117.0	8.50
R5108.7	—	8.70	0.3425	81.0	125.0	8.70
R5108.8	—	8.80	0.3465	81.0	125.0	8.80
R5109.0	—	9.00	0.3543	81.0	125.0	9.00
R5109.2	—	9.20	0.3622	81.0	125.0	9.20
R5109.3	—	9.30	0.3661	81.0	125.0	9.30
R5109.5	—	9.50	0.3740	81.0	125.0	9.50
R5103/8	3/8	9.52	0.3748	87.0	133.0	9.52
R5109.9	—	9.90	0.3898	87.0	133.0	9.90
R51010.0	—	10.00	0.3937	87.0	133.0	10.00
R51010.2	—	10.20	0.4016	87.0	133.0	10.20
R51010.3	—	10.30	0.4055	87.0	133.0	10.30
R51010.4	—	10.40	0.4094	87.0	133.0	10.40
R51010.5	—	10.50	0.4134	87.0	133.0	10.50
R51010.8	—	10.80	0.4252	94.0	142.0	10.80
R51011.0	—	11.00	0.4331	94.0	142.0	11.00
R5107/16	7/16	11.11	0.4374	94.0	142.0	11.11
R51011.2	—	11.20	0.4409	94.0	142.0	11.20
R51011.5	—	11.50	0.4528	94.0	142.0	11.50
R51012.0	—	12.00	0.4724	101.0	151.0	12.00
R5101/2	1/2	12.70	0.5000	101.0	151.0	12.70
R51013.0	—	13.00	0.5118	101.0	151.0	13.00
R51014.0	—	14.00	0.5512	108.0	160.0	14.00

R458

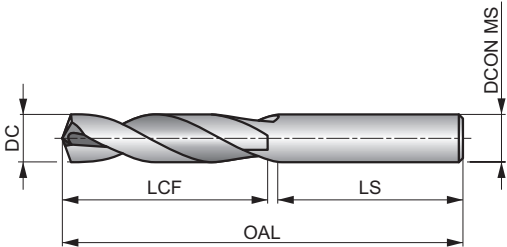




FORCE X solid hårdmetal 5XD bor, TiAlN belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændninger (H9 hultolerance). Selvcentrerende 140 °, 4-facets spidspunkt og CTW-skærkonstruktion for forbedret gennemtrængningshastighed. Kølemiddelhuller til forbedring af spånevakuerung. TiAlN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE X



HM	DIN 6537K	3xD
		
		DC m7

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 143 W	■ 160 W	■ 166 W	■ 122 W	■ 108 W	■ 95 V	■ 106 V	■ 86 V	■ 72 V	■ 63 V	■ 54 V	■ 44 U	▣ 60 U	▣ 51 U
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
▣ 54 U	▣ 44 U	▣ 37 T	▣ 33 T	▣ 28 T	▣ 26 T	▣ 24 T	▣ 21 T	■ 88 W	■ 65 W	■ 49 W	■ 78 V	■ 64 V	■ 51 V
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■ 70 V	■ 54 V	■ 43 V	■ 65 V	■ 49 V	■ 36 V	■ 30 V	■ 26 V	■ 73 V	■ 55 V	■ 42 V	■ 200 W	■ 150 W	■ 100 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	H1.1	H2.1	H2.2	H3.1	H3.2
■ 246 V	■ 222 V	■ 160 V	■ 298 V	■ 176 V	■ 88 V	▣ 44 U	▣ 36 U	▣ 32 T	■ 45 U	▣ 26 U	▣ 24 U	▣ 30 U	▣ 24 U

DCON MS tolerance h6.

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4583.0	—	3.00	0.1181	20.0	62.0	36.0	6.00
R4583.1	—	3.10	0.1220	20.0	62.0	36.0	6.00
R4581/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
R4583.2	—	3.20	0.1260	20.0	62.0	36.0	6.00
R458N30	N30	3.26	0.1283	20.0	62.0	36.0	6.00
R4583.3	—	3.30	0.1299	20.0	62.0	36.0	6.00
R4583.4	—	3.40	0.1339	20.0	62.0	36.0	6.00
R458N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
R4583.5	—	3.50	0.1378	20.0	62.0	36.0	6.00
R458N28	N28	3.57	0.1406	20.0	62.0	36.0	6.00
R4589/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
R4583.6	—	3.60	0.1417	20.0	62.0	36.0	6.00
R458N27	N27	3.66	0.1441	20.0	62.0	36.0	6.00
R4583.7	—	3.70	0.1457	20.0	62.0	36.0	6.00
R4583.73	—	3.73	0.1469	24.0	66.0	36.0	6.00
R458N26	N26	3.73	0.1469	24.0	66.0	36.0	6.00
R458N25	N25	3.80	0.1496	24.0	66.0	36.0	6.00
R4583.8	—	3.80	0.1496	24.0	66.0	36.0	6.00
R458N24	N24	3.86	0.1520	24.0	66.0	36.0	6.00
R4583.9	—	3.90	0.1535	24.0	66.0	36.0	6.00
R458N23	N23	3.91	0.1539	24.0	66.0	36.0	6.00
R4585/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
R458N22	N22	3.99	0.1571	24.0	66.0	36.0	6.00
R4584.0	—	4.00	0.1575	24.0	66.0	36.0	6.00
R458N21	N21	4.04	0.1591	24.0	66.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R458N20	N20	4.09	0.1610	24.0	66.0	36.0	6.00
R4584.1	—	4.10	0.1614	24.0	66.0	36.0	6.00
R4584.2	—	4.20	0.1654	24.0	66.0	36.0	6.00
R458N19	N19	4.22	0.1661	24.0	66.0	36.0	6.00
R4584.3	—	4.30	0.1693	24.0	66.0	36.0	6.00
R458N18	N18	4.31	0.1697	24.0	66.0	36.0	6.00
R45811/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
R458N17	N17	4.39	0.1728	24.0	66.0	36.0	6.00
R4584.4	—	4.40	0.1732	24.0	66.0	36.0	6.00
R4584.5	—	4.50	0.1772	24.0	66.0	36.0	6.00
R458N16	N16	4.50	0.1772	24.0	66.0	36.0	6.00
R458N15	N15	4.57	0.1799	24.0	66.0	36.0	6.00
R4584.6	—	4.60	0.1811	24.0	66.0	36.0	6.00
R458N14	N14	4.62	0.1819	24.0	66.0	36.0	6.00
R458N13	N13	4.70	0.1850	24.0	66.0	36.0	6.00
R4584.7	—	4.70	0.1850	24.0	66.0	36.0	6.00
R4583/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
R4584.8	—	4.80	0.1890	28.0	66.0	36.0	6.00
R458N12	N12	4.80	0.1890	28.0	66.0	36.0	6.00
R458N11	N11	4.85	0.1909	28.0	66.0	36.0	6.00
R4584.9	—	4.90	0.1929	28.0	66.0	36.0	6.00
R458N10	N10	4.92	0.1937	28.0	66.0	36.0	6.00
R458N9	N9	4.98	0.1961	28.0	66.0	36.0	6.00
R4585.0	—	5.00	0.1969	28.0	66.0	36.0	6.00
R458N8	N8	5.06	0.1992	28.0	66.0	36.0	6.00
R4585.1	—	5.10	0.2008	28.0	66.0	36.0	6.00
R458N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
R45813/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
R458N6	N6	5.18	0.2039	28.0	66.0	36.0	6.00
R4585.2	—	5.20	0.2047	28.0	66.0	36.0	6.00
R458N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
R4585.3	—	5.30	0.2087	28.0	66.0	36.0	6.00
R458N4	N4	5.31	0.2091	28.0	66.0	36.0	6.00
R4585.4	—	5.40	0.2126	28.0	66.0	36.0	6.00
R458N3	N3	5.41	0.2130	28.0	66.0	36.0	6.00
R4585.5	—	5.50	0.2165	28.0	66.0	36.0	6.00
R4587/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
R4585.6	—	5.60	0.2205	28.0	66.0	36.0	6.00
R458N2	N2	5.61	0.2209	28.0	66.0	36.0	6.00
R4585.7	—	5.70	0.2244	28.0	66.0	36.0	6.00
R458N1	N1	5.79	0.2280	28.0	66.0	36.0	6.00
R4585.8	—	5.80	0.2283	28.0	66.0	36.0	6.00
R4585.9	—	5.90	0.2323	28.0	66.0	36.0	6.00
R45815/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
R4586.0	—	6.00	0.2362	28.0	66.0	36.0	6.00
R458B	B	6.05	0.2380	34.0	79.0	36.0	8.00
R4586.1	—	6.10	0.2402	34.0	79.0	36.0	8.00
R458C	C	6.15	0.2421	34.0	79.0	36.0	8.00
R4586.2	—	6.20	0.2441	34.0	79.0	36.0	8.00
R458D	D	6.25	0.2461	34.0	79.0	36.0	8.00
R4586.3	—	6.30	0.2480	34.0	79.0	36.0	8.00
R4581/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
R4586.4	—	6.40	0.2520	34.0	79.0	36.0	8.00
R4586.5	—	6.50	0.2559	34.0	79.0	36.0	8.00
R458F	F	6.53	0.2571	34.0	79.0	36.0	8.00
R4586.6	—	6.60	0.2598	34.0	79.0	36.0	8.00
R458G	G	6.63	0.2610	34.0	79.0	36.0	8.00
R4586.7	—	6.70	0.2638	34.0	79.0	36.0	8.00
R45817/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
R458H	H	6.76	0.2661	34.0	79.0	36.0	8.00
R4586.8	—	6.80	0.2677	34.0	79.0	36.0	8.00
R4586.9	—	6.90	0.2717	34.0	79.0	36.0	8.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R458I	I	6.91	0.2720	34.0	79.0	36.0	8.00
R4587.0	—	7.00	0.2756	34.0	79.0	36.0	8.00
R458J	J	7.04	0.2772	34.0	79.0	36.0	8.00
R4587.1	—	7.10	0.2795	41.0	79.0	36.0	8.00
R4589/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
R4587.2	—	7.20	0.2835	41.0	79.0	36.0	8.00
R4587.3	—	7.30	0.2874	41.0	79.0	36.0	8.00
R458L	L	7.37	0.2902	41.0	79.0	36.0	8.00
R4587.4	—	7.40	0.2913	41.0	79.0	36.0	8.00
R4587.5	—	7.50	0.2953	41.0	79.0	36.0	8.00
R45819/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
R4587.6	—	7.60	0.2992	41.0	79.0	36.0	8.00
R458N	N	7.67	0.3020	41.0	79.0	36.0	8.00
R4587.7	—	7.70	0.3031	41.0	79.0	36.0	8.00
R4587.8	—	7.80	0.3071	41.0	79.0	36.0	8.00
R4587.9	—	7.90	0.3110	41.0	79.0	36.0	8.00
R4585/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
R4588.0	—	8.00	0.3150	41.0	79.0	36.0	8.00
R4580	O	8.03	0.3161	47.0	89.0	40.0	10.00
R4588.1	—	8.10	0.3189	47.0	89.0	40.0	10.00
R4588.2	—	8.20	0.3228	47.0	89.0	40.0	10.00
R4588.3	—	8.30	0.3268	47.0	89.0	40.0	10.00
R45821/64	21/64	8.33	0.3281	47.0	89.0	40.0	10.00
R4588.4	—	8.40	0.3307	47.0	89.0	40.0	10.00
R458Q	Q	8.43	0.3319	47.0	89.0	40.0	10.00
R4588.5	—	8.50	0.3346	47.0	89.0	40.0	10.00
R4588.6	—	8.60	0.3386	47.0	89.0	40.0	10.00
R458R	R	8.61	0.3390	47.0	89.0	40.0	10.00
R4588.7	—	8.70	0.3425	47.0	89.0	40.0	10.00
R45811/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
R4588.8	—	8.80	0.3465	47.0	89.0	40.0	10.00
R458S	S	8.84	0.3480	47.0	89.0	40.0	10.00
R4588.9	—	8.90	0.3504	47.0	89.0	40.0	10.00
R4589.0	—	9.00	0.3543	47.0	89.0	40.0	10.00
R458T	T	9.09	0.3579	47.0	89.0	40.0	10.00
R4589.1	—	9.10	0.3583	47.0	89.0	40.0	10.00
R45823/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
R4589.2	—	9.20	0.3622	47.0	89.0	40.0	10.00
R4589.3	—	9.30	0.3661	47.0	89.0	40.0	10.00
R458U	U	9.35	0.3681	47.0	89.0	40.0	10.00
R4589.4	—	9.40	0.3701	47.0	89.0	40.0	10.00
R4589.5	—	9.50	0.3740	47.0	89.0	40.0	10.00
R4583/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
R458V	V	9.58	0.3772	47.0	89.0	40.0	10.00
R4589.6	—	9.60	0.3780	47.0	89.0	40.0	10.00
R4589.7	—	9.70	0.3819	47.0	89.0	40.0	10.00
R4589.8	—	9.80	0.3858	47.0	89.0	40.0	10.00
R4589.9	—	9.90	0.3898	47.0	89.0	40.0	10.00
R45825/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
R45810.0	—	10.00	0.3937	47.0	89.0	40.0	10.00
R458X	X	10.08	0.3969	55.0	102.0	45.0	12.00
R45810.1	—	10.10	0.3976	55.0	102.0	45.0	12.00
R45810.2	—	10.20	0.4016	55.0	102.0	45.0	12.00
R458Y	Y	10.26	0.4039	55.0	102.0	45.0	12.00
R45810.3	—	10.30	0.4055	55.0	102.0	45.0	12.00
R45813/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
R45810.4	—	10.40	0.4094	55.0	102.0	45.0	12.00
R45810.5	—	10.50	0.4134	55.0	102.0	45.0	12.00
R45810.6	—	10.60	0.4173	55.0	102.0	45.0	12.00
R45810.7	—	10.70	0.4213	55.0	102.0	45.0	12.00
R45827/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
R45810.8	—	10.80	0.4252	55.0	102.0	45.0	12.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45810.9	–	10.90	0.4291	55.0	102.0	45.0	12.00
R45811.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
R45811.1	–	11.10	0.4370	55.0	102.0	45.0	12.00
R4587/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
R45811.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
R45811.3	–	11.30	0.4449	55.0	102.0	45.0	12.00
R45811.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
R45811.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
R45829/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
R45811.6	–	11.60	0.4567	55.0	102.0	45.0	12.00
R45811.7	–	11.70	0.4606	55.0	102.0	45.0	12.00
R45811.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
R45811.9	–	11.90	0.4685	55.0	102.0	45.0	12.00
R45815/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
R45812.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
R45812.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
R45812.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
R45831/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
R45812.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
R45812.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
R4581/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
R45812.8	–	12.80	0.5039	60.0	107.0	45.0	14.00
R45813.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
R45833/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
R45813.3	–	13.30	0.5236	60.0	107.0	45.0	14.00
R45817/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
R45813.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
R45813.8	–	13.80	0.5433	60.0	107.0	45.0	14.00
R45835/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
R45814.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
R45814.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
R4589/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
R45814.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
R45837/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
R45814.8	–	14.80	0.5827	65.0	115.0	48.0	16.00
R45815.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
R45819/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
R45815.1	–	15.10	0.5945	65.0	115.0	48.0	16.00
R45815.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
R45839/64	39/64	15.48	0.6094	65.0	115.0	48.0	16.00
R45815.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
R45815.8	–	15.80	0.6220	65.0	115.0	48.0	16.00
R4585/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
R45816.0	–	16.00	0.6299	65.0	115.0	48.0	16.00
R45841/64	41/64	16.27	0.6406	73.0	123.0	48.0	18.00
R45816.5	–	16.50	0.6496	73.0	123.0	48.0	18.00
R45821/32	21/32	16.67	0.6563	73.0	123.0	48.0	18.00
R45817.0	–	17.00	0.6693	73.0	123.0	48.0	18.00
R45843/64	43/64	17.07	0.6720	73.0	123.0	48.0	18.00
R45811/16	11/16	17.46	0.6874	73.0	123.0	48.0	18.00
R45817.5	–	17.50	0.6890	73.0	123.0	48.0	18.00
R45817.8	–	17.80	0.7008	73.0	123.0	48.0	18.00
R45845/64	45/64	17.86	0.7031	73.0	123.0	48.0	18.00
R45818.0	–	18.00	0.7087	73.0	123.0	48.0	18.00
R45823/32	23/32	18.26	0.7189	79.0	131.0	50.0	20.00
R45818.5	–	18.50	0.7283	79.0	131.0	50.0	20.00
R45847/64	47/64	18.65	0.7343	79.0	131.0	50.0	20.00
R45819.0	–	19.00	0.7480	79.0	131.0	50.0	20.00
R4583/4	–	19.05	0.7500	79.0	131.0	50.0	20.00
R45819.5	–	19.50	0.7677	79.0	131.0	50.0	20.00
R45819.8	–	19.80	0.7795	79.0	131.0	50.0	20.00
R45820.0	–	20.00	0.7874	79.0	131.0	50.0	20.00

R457



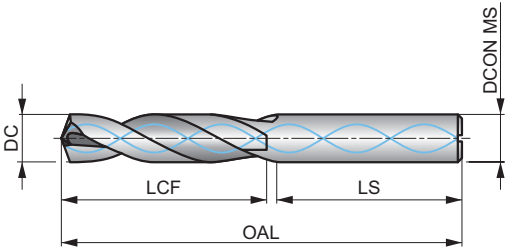


FORCE X solid hårdmetal SXD bor med indvendig kølemiddeltilførsel, TiAlN belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9 hulltolerance). Selvcentrerende 140 °, 4-facets spidspunkt og CTW-skærkonstruktion for forbedret gennemtrængningshastighed. Kølemiddelhuller til forbedring af spånevakuering. TiAlN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE X

HM	DIN 6537K	3xD
 140°	 TiAlN	 DIN 6535HA
		
DC m7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 179 W	■ 200 W	■ 207 W	■ 153 W	■ 135 W	■ 119 V	■ 133 V	■ 107 V	■ 90 V	■ 79 V	■ 67 V	■ 55 U	▣ 75 V	▣ 64 V
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
▣ 67 V	▣ 55 V	▣ 46 U	▣ 41 V	▣ 35 V	▣ 32 V	▣ 30 U	▣ 26 U	■ 110 W	■ 81 W	■ 61 W	■ 98 V	■ 80 V	■ 64 V
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■ 87 V	■ 67 V	■ 54 V	■ 81 V	■ 61 V	■ 45 V	■ 38 V	■ 32 V	■ 91 V	■ 69 V	■ 53 V	■ 250 W	■ 188 W	■ 125 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	H1.1	H2.1	H2.2	H3.1	H3.2
■ 308 V	■ 277 V	■ 200 V	■ 373 W	■ 220 W	■ 110 W	■ 55 V	■ 45 V	■ 40 U	■ 56 U	▣ 33 U	▣ 30 U	▣ 37 U	▣ 30 U

DCON MS tolerance h6.

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4573.0	—	3.00	0.1181	20.0	62.0	36.0	6.00
R4573.1	—	3.10	0.1220	20.0	62.0	36.0	6.00
R4571/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
R4573.2	—	3.20	0.1260	20.0	62.0	36.0	6.00
R457N30	N30	3.26	0.1283	20.0	62.0	36.0	6.00
R4573.3	—	3.30	0.1299	20.0	62.0	36.0	6.00
R4573.4	—	3.40	0.1339	20.0	62.0	36.0	6.00
R457N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
R4573.5	—	3.50	0.1378	20.0	62.0	36.0	6.00
R457N28	N28	3.57	0.1406	20.0	62.0	36.0	6.00
R4579/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
R4573.6	—	3.60	0.1417	20.0	62.0	36.0	6.00
R457N27	N27	3.66	0.1441	20.0	62.0	36.0	6.00
R4573.7	—	3.70	0.1457	20.0	62.0	36.0	6.00
R457N26	N26	3.73	0.1469	24.0	66.0	36.0	6.00
R457N25	N25	3.80	0.1496	24.0	66.0	36.0	6.00
R4573.8	—	3.80	0.1496	24.0	66.0	36.0	6.00
R457N24	N24	3.86	0.1520	24.0	66.0	36.0	6.00
R4573.9	—	3.90	0.1535	24.0	66.0	36.0	6.00
R457N23	N23	3.91	0.1539	24.0	66.0	36.0	6.00
R4575/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
R457N22	N22	3.99	0.1571	24.0	66.0	36.0	6.00
R4574.0	—	4.00	0.1575	24.0	66.0	36.0	6.00
R457N21	N21	4.04	0.1591	24.0	66.0	36.0	6.00
R4574.05	—	4.05	0.1594	24.0	66.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R457N20	N20	4.09	0.1610	24.0	66.0	36.0	6.00
R4574.1	—	4.10	0.1614	24.0	66.0	36.0	6.00
R4574.2	—	4.20	0.1654	24.0	66.0	36.0	6.00
R4574.3	—	4.30	0.1693	24.0	66.0	36.0	6.00
R457N18	N18	4.31	0.1697	24.0	66.0	36.0	6.00
R45711/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
R457N17	N17	4.39	0.1728	24.0	66.0	36.0	6.00
R4574.4	—	4.40	0.1732	24.0	66.0	36.0	6.00
R4574.5	—	4.50	0.1772	24.0	66.0	36.0	6.00
R457N16	N16	4.50	0.1772	24.0	66.0	36.0	6.00
R457N15	N15	4.57	0.1799	24.0	66.0	36.0	6.00
R4574.6	—	4.60	0.1811	24.0	66.0	36.0	6.00
R457N14	N14	4.62	0.1819	24.0	66.0	36.0	6.00
R4574.7	—	4.70	0.1850	24.0	66.0	36.0	6.00
R4573/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
R4574.8	—	4.80	0.1890	28.0	66.0	36.0	6.00
R457N11	N11	4.85	0.1909	28.0	66.0	36.0	6.00
R4574.9	—	4.90	0.1929	28.0	66.0	36.0	6.00
R457N9	N9	4.98	0.1961	28.0	66.0	36.0	6.00
R4575.0	—	5.00	0.1969	28.0	66.0	36.0	6.00
R4575.05	—	5.05	0.1988	28.0	66.0	36.0	6.00
R457N8	N8	5.06	0.1992	28.0	66.0	36.0	6.00
R4575.1	—	5.10	0.2008	28.0	66.0	36.0	6.00
R457N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
R45713/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
R457N6	N6	5.18	0.2039	28.0	66.0	36.0	6.00
R4575.2	—	5.20	0.2047	28.0	66.0	36.0	6.00
R457N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
R4575.3	—	5.30	0.2087	28.0	66.0	36.0	6.00
R457N4	N4	5.31	0.2091	28.0	66.0	36.0	6.00
R4575.4	—	5.40	0.2126	28.0	66.0	36.0	6.00
R457N3	N3	5.41	0.2130	28.0	66.0	36.0	6.00
R4575.5	—	5.50	0.2165	28.0	66.0	36.0	6.00
R4577/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
R4575.6	—	5.60	0.2205	28.0	66.0	36.0	6.00
R457N2	N2	5.61	0.2209	28.0	66.0	36.0	6.00
R4575.7	—	5.70	0.2244	28.0	66.0	36.0	6.00
R457N1	N1	5.79	0.2280	28.0	66.0	36.0	6.00
R4575.8	—	5.80	0.2283	28.0	66.0	36.0	6.00
R4575.9	—	5.90	0.2323	28.0	66.0	36.0	6.00
R457A	A	5.94	0.2339	28.0	66.0	36.0	6.00
R45715/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
R4576.0	—	6.00	0.2362	28.0	66.0	36.0	6.00
R457B	B	6.05	0.2380	34.0	79.0	36.0	8.00
R4576.05	—	6.05	0.2382	34.0	79.0	36.0	8.00
R4576.1	—	6.10	0.2402	34.0	79.0	36.0	8.00
R457C	C	6.15	0.2421	34.0	79.0	36.0	8.00
R4576.2	—	6.20	0.2441	34.0	79.0	36.0	8.00
R457D	D	6.25	0.2461	34.0	79.0	36.0	8.00
R4576.3	—	6.30	0.2480	34.0	79.0	36.0	8.00
R4571/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
R4576.4	—	6.40	0.2520	34.0	79.0	36.0	8.00
R4576.5	—	6.50	0.2559	34.0	79.0	36.0	8.00
R457F	F	6.53	0.2571	34.0	79.0	36.0	8.00
R4576.6	—	6.60	0.2598	34.0	79.0	36.0	8.00
R457G	G	6.63	0.2610	34.0	79.0	36.0	8.00
R4576.7	—	6.70	0.2638	34.0	79.0	36.0	8.00
R45717/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
R4576.8	—	6.80	0.2677	34.0	79.0	36.0	8.00
R4576.9	—	6.90	0.2717	34.0	79.0	36.0	8.00
R457I	I	6.91	0.2720	34.0	79.0	36.0	8.00
R4577.0	—	7.00	0.2756	34.0	79.0	36.0	8.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R457J	J	7.04	0.2772	41.0	79.0	36.0	8.00
R4577.1	—	7.10	0.2795	41.0	79.0	36.0	8.00
R4579/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
R4577.2	—	7.20	0.2835	41.0	79.0	36.0	8.00
R4577.3	—	7.30	0.2874	41.0	79.0	36.0	8.00
R4577.4	—	7.40	0.2913	41.0	79.0	36.0	8.00
R4577.5	—	7.50	0.2953	41.0	79.0	36.0	8.00
R45719/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
R4577.6	—	7.60	0.2992	41.0	79.0	36.0	8.00
R457N	N	7.67	0.3020	41.0	79.0	36.0	8.00
R4577.7	—	7.70	0.3031	41.0	79.0	36.0	8.00
R4577.8	—	7.80	0.3071	41.0	79.0	36.0	8.00
R4577.9	—	7.90	0.3110	41.0	79.0	36.0	8.00
R4575/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
R4578.0	—	8.00	0.3150	41.0	79.0	36.0	8.00
R4570	0	8.03	0.3161	47.0	89.0	40.0	10.00
R4578.05	—	8.05	0.3169	47.0	89.0	40.0	10.00
R4578.1	—	8.10	0.3189	47.0	89.0	40.0	10.00
R4578.2	—	8.20	0.3228	47.0	89.0	40.0	10.00
R457P	P	8.20	0.3228	47.0	89.0	40.0	10.00
R4578.3	—	8.30	0.3268	47.0	89.0	40.0	10.00
R45721/64	21/64	8.33	0.3281	47.0	89.0	40.0	10.00
R4578.4	—	8.40	0.3307	47.0	89.0	40.0	10.00
R457Q	Q	8.43	0.3319	47.0	89.0	40.0	10.00
R4578.5	—	8.50	0.3346	47.0	89.0	40.0	10.00
R4578.6	—	8.60	0.3386	47.0	89.0	40.0	10.00
R457R	R	8.61	0.3390	47.0	89.0	40.0	10.00
R4578.7	—	8.70	0.3425	47.0	89.0	40.0	10.00
R45711/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
R4578.8	—	8.80	0.3465	47.0	89.0	40.0	10.00
R457S	S	8.84	0.3480	47.0	89.0	40.0	10.00
R4578.9	—	8.90	0.3504	47.0	89.0	40.0	10.00
R4579.0	—	9.00	0.3543	47.0	89.0	40.0	10.00
R4579.1	—	9.10	0.3583	47.0	89.0	40.0	10.00
R45723/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
R4579.2	—	9.20	0.3622	47.0	89.0	40.0	10.00
R4579.3	—	9.30	0.3661	47.0	89.0	40.0	10.00
R457U	U	9.35	0.3681	47.0	89.0	40.0	10.00
R4579.4	—	9.40	0.3701	47.0	89.0	40.0	10.00
R4579.5	—	9.50	0.3740	47.0	89.0	40.0	10.00
R4573/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
R457V	V	9.58	0.3772	47.0	89.0	40.0	10.00
R4579.6	—	9.60	0.3780	47.0	89.0	40.0	10.00
R4579.7	—	9.70	0.3819	47.0	89.0	40.0	10.00
R4579.8	—	9.80	0.3858	47.0	89.0	40.0	10.00
R457W	W	9.80	0.3858	47.0	89.0	40.0	10.00
R4579.9	—	9.90	0.3898	47.0	89.0	40.0	10.00
R45725/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
R45710.0	—	10.00	0.3937	47.0	89.0	40.0	10.00
R45710.05	—	10.05	0.3957	55.0	102.0	45.0	12.00
R457X	X	10.08	0.3969	55.0	102.0	45.0	12.00
R45710.1	—	10.10	0.3976	55.0	102.0	45.0	12.00
R45710.2	—	10.20	0.4016	55.0	102.0	45.0	12.00
R457Y	Y	10.26	0.4039	55.0	102.0	45.0	12.00
R45710.3	—	10.30	0.4055	55.0	102.0	45.0	12.00
R45713/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
R45710.4	—	10.40	0.4094	55.0	102.0	45.0	12.00
R457Z	Z	10.49	0.4130	55.0	102.0	45.0	12.00
R45710.5	—	10.50	0.4134	55.0	102.0	45.0	12.00
R45710.6	—	10.60	0.4173	55.0	102.0	45.0	12.00
R45727/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
R45710.8	—	10.80	0.4252	55.0	102.0	45.0	12.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45711.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
R4577/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
R45711.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
R45711.3	–	11.30	0.4449	55.0	102.0	45.0	12.00
R45711.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
R45711.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
R45729/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
R45711.6	–	11.60	0.4567	55.0	102.0	45.0	12.00
R45711.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
R45715/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
R45712.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
R45712.05	–	12.05	0.4744	60.0	107.0	45.0	14.00
R45712.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
R45712.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
R45731/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
R45712.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
R45712.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
R4571/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
R45712.8	–	12.80	0.5039	60.0	107.0	45.0	14.00
R45713.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
R45733/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
R45713.3	–	13.30	0.5236	60.0	107.0	45.0	14.00
R45717/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
R45713.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
R45713.8	–	13.80	0.5433	60.0	107.0	45.0	14.00
R45735/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
R45714.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
R45714.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
R4579/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
R45714.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
R45737/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
R45714.8	–	14.80	0.5827	65.0	115.0	48.0	16.00
R45715.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
R45719/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
R45715.1	–	15.10	0.5945	65.0	115.0	48.0	16.00
R45715.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
R45739/64	39/64	15.48	0.6094	65.0	115.0	48.0	16.00
R45715.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
R45715.8	–	15.80	0.6220	65.0	115.0	48.0	16.00
R4575/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
R45716.0	–	16.00	0.6299	65.0	115.0	48.0	16.00
R45741/64	41/64	16.27	0.6406	73.0	123.0	48.0	18.00
R45716.5	–	16.50	0.6496	73.0	123.0	48.0	18.00
R45721/32	21/32	16.67	0.6563	73.0	123.0	48.0	18.00
R45717.0	–	17.00	0.6693	73.0	123.0	48.0	18.00
R45743/64	43/64	17.07	0.6720	73.0	123.0	48.0	18.00
R45711/16	11/16	17.46	0.6874	73.0	123.0	48.0	18.00
R45717.5	–	17.50	0.6890	73.0	123.0	48.0	18.00
R45745/64	45/64	17.86	0.7031	73.0	123.0	48.0	18.00
R45718.0	–	18.00	0.7087	73.0	123.0	48.0	18.00
R45723/32	23/32	18.26	0.7189	79.0	131.0	50.0	20.00
R45718.5	–	18.50	0.7283	79.0	131.0	50.0	20.00
R45747/64	47/64	18.65	0.7343	79.0	131.0	50.0	20.00
R45718.8	–	18.80	0.7402	79.0	131.0	50.0	20.00
R45719.0	–	19.00	0.7480	79.0	131.0	50.0	20.00
R4573/4	3/4	19.05	0.7500	79.0	131.0	50.0	20.00
R45719.5	–	19.50	0.7677	79.0	131.0	50.0	20.00
R45719.8	–	19.80	0.7795	79.0	131.0	50.0	20.00
R45720.0	–	20.00	0.7874	79.0	131.0	50.0	20.00

R454

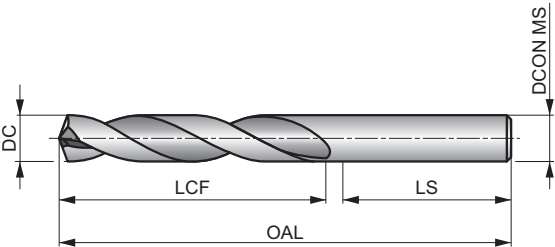




FORCE X solid hårdmetal 5XD bor, TiAlN belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9 hultolerance). Selvcenterende 140 °, 4-facets spidspunkt og CTW-skærkonstruktion for forbedret gennemtrængningshastighed. Kølemiddelhuller til forbedring af spånevakuering. TiAlN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE X



HM	DIN 6537L	5xD
		
		DC m7

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 134 V	■ 150 V	■ 155 V	■ 115 V	■ 101 V	■ 89 V	■ 100 V	■ 80 V	■ 68 V	■ 59 V	■ 50 V	■ 41 U	▣ 56 U	▣ 48 U
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
▣ 50 U	▣ 41 U	▣ 35 T	▣ 31 T	▣ 26 T	▣ 24 T	▣ 23 T	▣ 20 T	■ 83 W	■ 61 W	■ 46 W	■ 74 V	■ 60 V	■ 48 V
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■ 65 V	■ 50 V	■ 41 V	■ 61 V	■ 46 V	■ 34 V	■ 29 V	■ 24 V	■ 68 V	■ 52 V	■ 40 V	■ 188 W	■ 141 W	■ 94 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	H1.1	H2.1	H2.2	H3.1	H3.2
■ 231 V	■ 208 V	■ 150 V	■ 280 V	■ 165 V	■ 83 V	▣ 41 U	▣ 34 U	▣ 30 T	■ 42 U	▣ 25 U	▣ 23 U	▣ 28 U	▣ 23 U

DCON MS tolerance h6.

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4543.0	—	3.00	0.1181	28.0	66.0	36.0	6.00
R4543.1	—	3.10	0.1220	28.0	66.0	36.0	6.00
R4541/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
R4543.2	—	3.20	0.1260	28.0	66.0	36.0	6.00
R454N30	N30	3.26	0.1283	28.0	66.0	36.0	6.00
R4543.3	—	3.30	0.1299	28.0	66.0	36.0	6.00
R4543.4	—	3.40	0.1339	28.0	66.0	36.0	6.00
R454N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
R4543.5	—	3.50	0.1378	28.0	66.0	36.0	6.00
R454N28	N28	3.57	0.1406	28.0	66.0	36.0	6.00
R4549/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
R4543.6	—	3.60	0.1417	28.0	66.0	36.0	6.00
R454N27	N27	3.66	0.1441	28.0	66.0	36.0	6.00
R4543.7	—	3.70	0.1457	28.0	66.0	36.0	6.00
R454N26	N26	3.73	0.1469	36.0	74.0	36.0	6.00
R4543.8	—	3.80	0.1496	36.0	74.0	36.0	6.00
R454N24	N24	3.86	0.1520	36.0	74.0	36.0	6.00
R4543.9	—	3.90	0.1535	36.0	74.0	36.0	6.00
R4545/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
R4544.0	—	4.00	0.1575	36.0	74.0	36.0	6.00
R454N21	N21	4.04	0.1591	36.0	74.0	36.0	6.00
R454N20	N20	4.09	0.1610	36.0	74.0	36.0	6.00
R4544.1	—	4.10	0.1614	36.0	74.0	36.0	6.00
R4544.2	—	4.20	0.1654	36.0	74.0	36.0	6.00
R454N19	N19	4.22	0.1661	36.0	74.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4544.3	—	4.30	0.1693	36.0	74.0	36.0	6.00
R45411/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
R4544.4	—	4.40	0.1732	36.0	74.0	36.0	6.00
R4544.5	—	4.50	0.1772	36.0	74.0	36.0	6.00
R454N16	N16	4.50	0.1772	36.0	74.0	36.0	6.00
R454N15	N15	4.57	0.1799	36.0	74.0	36.0	6.00
R4544.6	—	4.60	0.1811	36.0	74.0	36.0	6.00
R454N14	N14	4.62	0.1819	36.0	74.0	36.0	6.00
R4544.7	—	4.70	0.1850	36.0	74.0	36.0	6.00
R4543/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
R4544.8	—	4.80	0.1890	44.0	82.0	36.0	6.00
R454N11	N11	4.85	0.1909	44.0	82.0	36.0	6.00
R4544.9	—	4.90	0.1929	44.0	82.0	36.0	6.00
R454N10	N10	4.92	0.1937	44.0	82.0	36.0	6.00
R454N9	N9	4.98	0.1961	44.0	82.0	36.0	6.00
R4545.0	—	5.00	0.1969	44.0	82.0	36.0	6.00
R454N8	N8	5.06	0.1992	44.0	82.0	36.0	6.00
R4545.1	—	5.10	0.2008	44.0	82.0	36.0	6.00
R454N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
R45413/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
R454N6	N6	5.18	0.2039	44.0	82.0	36.0	6.00
R4545.2	—	5.20	0.2047	44.0	82.0	36.0	6.00
R454N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
R454N4	N4	5.31	0.2091	44.0	82.0	36.0	6.00
R454N3	N3	5.41	0.2130	44.0	82.0	36.0	6.00
R4545.5	—	5.50	0.2165	44.0	82.0	36.0	6.00
R4547/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
R4545.6	—	5.60	0.2205	44.0	82.0	36.0	6.00
R454N2	N2	5.61	0.2209	44.0	82.0	36.0	6.00
R4545.7	—	5.70	0.2244	44.0	82.0	36.0	6.00
R454N1	N1	5.79	0.2280	44.0	82.0	36.0	6.00
R4545.8	—	5.80	0.2283	44.0	82.0	36.0	6.00
R454A	A	5.94	0.2339	44.0	82.0	36.0	6.00
R45415/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
R4546.0	—	6.00	0.2362	44.0	82.0	36.0	6.00
R454B	B	6.05	0.2380	53.0	91.0	36.0	8.00
R4546.1	—	6.10	0.2402	53.0	91.0	36.0	8.00
R454C	C	6.15	0.2421	53.0	91.0	36.0	8.00
R4546.2	—	6.20	0.2441	53.0	91.0	36.0	8.00
R454D	D	6.25	0.2461	53.0	91.0	36.0	8.00
R4546.3	—	6.30	0.2480	53.0	91.0	36.0	8.00
R4541/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
R454E	E	6.35	0.2500	53.0	91.0	36.0	8.00
R4546.4	—	6.40	0.2520	53.0	91.0	36.0	8.00
R4546.5	—	6.50	0.2559	53.0	91.0	36.0	8.00
R454F	F	6.53	0.2571	53.0	91.0	36.0	8.00
R4546.6	—	6.60	0.2598	53.0	91.0	36.0	8.00
R454G	G	6.63	0.2610	53.0	91.0	36.0	8.00
R4546.7	—	6.70	0.2638	53.0	91.0	36.0	8.00
R45417/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
R454H	H	6.76	0.2661	53.0	91.0	36.0	8.00
R4546.8	—	6.80	0.2677	53.0	91.0	36.0	8.00
R4546.9	—	6.90	0.2717	53.0	91.0	36.0	8.00
R454I	I	6.91	0.2720	53.0	91.0	36.0	8.00
R4547.0	—	7.00	0.2756	53.0	91.0	36.0	8.00
R454J	J	7.04	0.2772	53.0	91.0	36.0	8.00
R4547.1	—	7.10	0.2795	53.0	91.0	36.0	8.00
R4549/32	9/32	7.14	0.2813	53.0	91.0	36.0	8.00
R4547.3	—	7.30	0.2874	53.0	91.0	36.0	8.00
R454L	L	7.37	0.2902	53.0	91.0	36.0	8.00
R4547.4	—	7.40	0.2913	53.0	91.0	36.0	8.00
R4547.5	—	7.50	0.2953	53.0	91.0	36.0	8.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45419/64	19/64	7.54	0.2969	53.0	91.0	36.0	8.00
R4547.6	—	7.60	0.2992	53.0	91.0	36.0	8.00
R454N	N	7.67	0.3020	53.0	91.0	36.0	8.00
R4547.7	—	7.70	0.3031	53.0	91.0	36.0	8.00
R4547.8	—	7.80	0.3071	53.0	91.0	36.0	8.00
R4547.9	—	7.90	0.3110	53.0	91.0	36.0	8.00
R4545/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
R4548.0	—	8.00	0.3150	53.0	91.0	36.0	8.00
R4540	0	8.03	0.3161	61.0	103.0	40.0	10.00
R4548.1	—	8.10	0.3189	61.0	103.0	40.0	10.00
R4548.2	—	8.20	0.3228	61.0	103.0	40.0	10.00
R45421/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
R4548.4	—	8.40	0.3307	61.0	103.0	40.0	10.00
R454Q	Q	8.43	0.3319	61.0	103.0	40.0	10.00
R4548.5	—	8.50	0.3346	61.0	103.0	40.0	10.00
R4548.6	—	8.60	0.3386	61.0	103.0	40.0	10.00
R454R	R	8.61	0.3390	61.0	103.0	40.0	10.00
R4548.7	—	8.70	0.3425	61.0	103.0	40.0	10.00
R45411/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
R4548.8	—	8.80	0.3465	61.0	103.0	40.0	10.00
R454S	S	8.84	0.3480	61.0	103.0	40.0	10.00
R4548.9	—	8.90	0.3504	61.0	103.0	40.0	10.00
R4549.0	—	9.00	0.3543	61.0	103.0	40.0	10.00
R4549.1	—	9.10	0.3583	61.0	103.0	40.0	10.00
R45423/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
R4549.3	—	9.30	0.3661	61.0	103.0	40.0	10.00
R454U	U	9.35	0.3681	61.0	103.0	40.0	10.00
R4549.4	—	9.40	0.3701	61.0	103.0	40.0	10.00
R4549.5	—	9.50	0.3740	61.0	103.0	40.0	10.00
R4543/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
R4549.6	—	9.60	0.3780	61.0	103.0	40.0	10.00
R4549.7	—	9.70	0.3819	61.0	103.0	40.0	10.00
R4549.8	—	9.80	0.3858	61.0	103.0	40.0	10.00
R4549.9	—	9.90	0.3898	61.0	103.0	40.0	10.00
R454W	W	9.80	0.3858	61.0	103.0	40.0	10.00
R45425/64	25/64	9.92	0.3906	61.0	103.0	40.0	10.00
R45410.0	—	10.00	0.3937	61.0	103.0	40.0	10.00
R454X	X	10.08	0.3969	70.0	118.0	45.0	12.00
R45410.1	—	10.10	0.3976	70.0	118.0	45.0	12.00
R45410.2	—	10.20	0.4016	70.0	118.0	45.0	12.00
R454Y	Y	10.26	0.4039	70.0	118.0	45.0	12.00
R45410.3	—	10.30	0.4055	70.0	118.0	45.0	12.00
R45413/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
R45410.4	—	10.40	0.4094	70.0	118.0	45.0	12.00
R454Z	Z	10.49	0.4130	70.0	118.0	45.0	12.00
R45410.5	—	10.50	0.4134	70.0	118.0	45.0	12.00
R45410.6	—	10.60	0.4173	70.0	118.0	45.0	12.00
R45427/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00
R45411.0	—	11.00	0.4331	70.0	118.0	45.0	12.00
R4547/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
R45411.2	—	11.20	0.4409	70.0	118.0	45.0	12.00
R45411.4	—	11.40	0.4488	70.0	118.0	45.0	12.00
R45411.5	—	11.50	0.4528	70.0	118.0	45.0	12.00
R45429/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
R45411.6	—	11.60	0.4567	70.0	118.0	45.0	12.00
R45411.8	—	11.80	0.4646	70.0	118.0	45.0	12.00
R45415/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
R45412.0	—	12.00	0.4724	70.0	118.0	45.0	12.00
R45412.1	—	12.10	0.4764	76.0	124.0	45.0	14.00
R45412.2	—	12.20	0.4803	76.0	124.0	45.0	14.00
R45431/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
R45412.5	—	12.50	0.4921	76.0	124.0	45.0	14.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45412.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
R4541/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
R45412.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
R45413.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
R45433/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
R45417/32	17/32	13.49	0.5313	76.0	124.0	45.0	14.00
R45413.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
R45413.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
R45435/64	35/64	13.89	0.5469	76.0	124.0	45.0	14.00
R45414.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
R45414.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
R4549/16	9/16	14.29	0.5625	82.0	133.0	48.0	16.00
R45414.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
R45437/64	37/64	14.68	0.5781	82.0	133.0	48.0	16.00
R45414.8	–	14.80	0.5827	82.0	133.0	48.0	16.00
R45415.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
R45419/32	19/32	15.08	0.5938	82.0	133.0	48.0	16.00
R45415.1	–	15.10	0.5945	82.0	133.0	48.0	16.00
R45439/64	39/64	15.48	0.6094	82.0	133.0	48.0	16.00
R45415.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
R45415.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
R4545/8	5/8	15.88	0.6250	82.0	133.0	48.0	16.00
R45416.0	–	16.00	0.6299	82.0	133.0	48.0	16.00
R45441/64	41/64	16.27	0.6406	91.0	143.0	48.0	18.00
R45416.5	–	16.50	0.6496	91.0	143.0	48.0	18.00
R45421/32	21/32	16.67	0.6563	91.0	143.0	48.0	18.00
R45417.0	–	17.00	0.6693	91.0	143.0	48.0	18.00
R45443/64	43/64	17.07	0.6720	91.0	143.0	48.0	18.00
R45411/16	11/16	17.46	0.6874	91.0	143.0	48.0	18.00
R45417.5	–	17.50	0.6890	91.0	143.0	48.0	18.00
R45417.8	–	17.80	0.7008	91.0	143.0	48.0	18.00
R45445/64	45/64	17.86	0.7031	91.0	143.0	48.0	18.00
R45418.0	–	18.00	0.7087	91.0	143.0	48.0	18.00
R45423/32	23/32	18.26	0.7189	99.0	153.0	50.0	20.00
R45418.5	–	18.50	0.7283	99.0	153.0	50.0	20.00
R45447/64	47/64	18.65	0.7343	99.0	153.0	50.0	20.00
R45419.0	–	19.00	0.7480	99.0	153.0	50.0	20.00
R4543/4	3/4	19.05	0.7500	99.0	153.0	50.0	20.00
R45419.5	–	19.50	0.7677	99.0	153.0	50.0	20.00
R45419.8	–	19.80	0.7795	99.0	153.0	50.0	20.00
R45420.0	–	20.00	0.7874	99.0	153.0	50.0	20.00

R453

DORMER

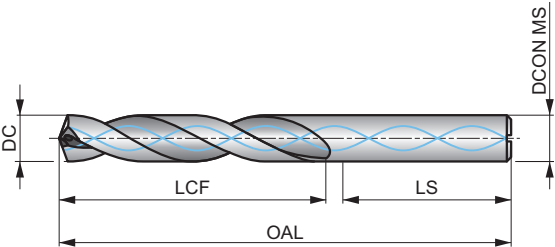


FORCE X solid hårdmetal 5XD bor med indvendig kølemiddeltilførsel, TiAlN belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9 hultolerance). Selvcentrerende 140 °, 4-facets spidspunkt og CTW-skærkonstruktion for forbedret gennemtrængningshastighed. Kølemiddelhuller til forbedring af spånevakuering. TiAlN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE X

HM	DIN 6537L	5xD
140°	TiAlN	DIN 6535HA
DC m7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 170 V	P1.2 ■ 190 V	P1.3 ■ 197 V	P2.1 ■ 145 V	P2.2 ■ 128 V	P2.3 ■ 113 V	P3.1 ■ 126 V	P3.2 ■ 102 V	P3.3 ■ 86 V	P4.1 ■ 75 V	P4.2 ■ 64 V	P4.3 ■ 52 U	M1.1 ▣ 71 V	M1.2 ▣ 61 V
M2.1 ▣ 64 V	M2.2 ▣ 52 V	M2.3 ▣ 44 U	M3.1 ▣ 39 V	M3.2 ▣ 33 V	M3.3 ▣ 30 V	M4.1 ▣ 29 U	M4.2 ▣ 25 U	K1.1 ■ 105 W	K1.2 ■ 77 W	K1.3 ■ 58 W	K2.1 ■ 93 V	K2.2 ■ 76 V	K2.3 ■ 61 V
K3.1 ■ 83 V	K3.2 ■ 64 V	K3.3 ■ 51 V	K4.1 ■ 77 V	K4.2 ■ 58 V	K4.3 ■ 43 V	K4.4 ■ 36 V	K4.5 ■ 30 V	K5.1 ■ 86 V	K5.2 ■ 66 V	K5.3 ■ 50 V	N1.1 ■ 238 W	N1.2 ■ 179 W	N1.3 ■ 119 W
N2.1 ■ 293 V	N2.2 ■ 263 V	N2.3 ■ 190 V	N3.1 ■ 354 W	N3.2 ■ 209 W	N3.3 ■ 105 W	S1.1 ■ 52 V	S1.2 ■ 43 V	S1.3 ■ 38 U	H1.1 ■ 53 U	H2.1 ▣ 31 U	H2.2 ▣ 29 U	H3.1 ▣ 35 U	H3.2 ▣ 29 U

DCON MS tolerance h6.

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4533.0	—	3.00	0.1181	28.0	66.0	36.0	6.00
R4533.1	—	3.10	0.1220	28.0	66.0	36.0	6.00
R4531/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
R4533.2	—	3.20	0.1260	28.0	66.0	36.0	6.00
R453N30	N30	3.26	0.1283	28.0	66.0	36.0	6.00
R4533.3	—	3.30	0.1299	28.0	66.0	36.0	6.00
R4533.4	—	3.40	0.1339	28.0	66.0	36.0	6.00
R453N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
R4533.5	—	3.50	0.1378	28.0	66.0	36.0	6.00
R453N28	N28	3.57	0.1406	28.0	66.0	36.0	6.00
R4539/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
R4533.6	—	3.60	0.1417	28.0	66.0	36.0	6.00
R453N27	N27	3.66	0.1441	28.0	66.0	36.0	6.00
R4533.7	—	3.70	0.1457	28.0	66.0	36.0	6.00
R453N26	N26	3.73	0.1469	36.0	74.0	36.0	6.00
R4533.8	—	3.80	0.1496	36.0	74.0	36.0	6.00
R453N24	N24	3.86	0.1520	36.0	74.0	36.0	6.00
R4533.9	—	3.90	0.1535	36.0	74.0	36.0	6.00
R453N23	N23	3.91	0.1539	36.0	74.0	36.0	6.00
R4535/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
R453N22	N22	3.99	0.1571	36.0	74.0	36.0	6.00
R4534.0	—	4.00	0.1575	36.0	74.0	36.0	6.00
R453N21	N21	4.04	0.1591	36.0	74.0	36.0	6.00
R4534.05	—	4.05	0.1594	36.0	74.0	36.0	6.00
R453N20	N20	4.09	0.1610	36.0	74.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4534.1	—	4.10	0.1614	36.0	74.0	36.0	6.00
R4534.2	—	4.20	0.1654	36.0	74.0	36.0	6.00
R453N19	N19	4.22	0.1661	36.0	74.0	36.0	6.00
R4534.3	—	4.30	0.1693	36.0	74.0	36.0	6.00
R453N18	N18	4.31	0.1697	36.0	74.0	36.0	6.00
R45311/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
R4534.4	—	4.40	0.1732	36.0	74.0	36.0	6.00
R4534.5	—	4.50	0.1772	36.0	74.0	36.0	6.00
R453N16	N16	4.50	0.1772	36.0	74.0	36.0	6.00
R453N15	N15	4.57	0.1799	36.0	74.0	36.0	6.00
R4534.6	—	4.60	0.1811	36.0	74.0	36.0	6.00
R453N14	N14	4.62	0.1819	36.0	74.0	36.0	6.00
R4534.7	—	4.70	0.1850	36.0	74.0	36.0	6.00
R4533/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
R4534.8	—	4.80	0.1890	44.0	82.0	36.0	6.00
R453N12	N12	4.80	0.1890	44.0	82.0	36.0	6.00
R453N11	N11	4.85	0.1909	44.0	82.0	36.0	6.00
R4534.9	—	4.90	0.1929	44.0	82.0	36.0	6.00
R453N10	N10	4.92	0.1937	44.0	82.0	36.0	6.00
R453N9	N9	4.98	0.1961	44.0	82.0	36.0	6.00
R4535.0	—	5.00	0.1969	44.0	82.0	36.0	6.00
R4535.05	—	5.05	0.1988	44.0	82.0	36.0	6.00
R453N8	N8	5.06	0.1992	44.0	82.0	36.0	6.00
R4535.1	—	5.10	0.2008	44.0	82.0	36.0	6.00
R453N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
R45313/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
R4535.2	—	5.20	0.2047	44.0	82.0	36.0	6.00
R453N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
R4535.3	—	5.30	0.2087	44.0	82.0	36.0	6.00
R453N4	N4	5.31	0.2091	44.0	82.0	36.0	6.00
R4535.4	—	5.40	0.2126	44.0	82.0	36.0	6.00
R453N3	N3	5.41	0.2130	44.0	82.0	36.0	6.00
R4535.5	—	5.50	0.2165	44.0	82.0	36.0	6.00
R4537/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
R4535.6	—	5.60	0.2205	44.0	82.0	36.0	6.00
R453N2	N2	5.61	0.2209	44.0	82.0	36.0	6.00
R4535.7	—	5.70	0.2244	44.0	82.0	36.0	6.00
R453N1	N1	5.79	0.2280	44.0	82.0	36.0	6.00
R4535.8	—	5.80	0.2283	44.0	82.0	36.0	6.00
R4535.9	—	5.90	0.2323	44.0	82.0	36.0	6.00
R453A	A	5.94	0.2339	44.0	82.0	36.0	6.00
R45315/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
R4536.0	—	6.00	0.2362	44.0	82.0	36.0	6.00
R453B	B	6.05	0.2380	53.0	91.0	36.0	8.00
R4536.05	—	6.05	0.2382	53.0	91.0	36.0	8.00
R4536.1	—	6.10	0.2402	53.0	91.0	36.0	8.00
R453C	C	6.15	0.2421	53.0	91.0	36.0	8.00
R4536.2	—	6.20	0.2441	53.0	91.0	36.0	8.00
R453D	D	6.25	0.2461	53.0	91.0	36.0	8.00
R4536.3	—	6.30	0.2480	53.0	91.0	36.0	8.00
R4531/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
R4536.4	—	6.40	0.2520	53.0	91.0	36.0	8.00
R4536.5	—	6.50	0.2559	53.0	91.0	36.0	8.00
R453F	F	6.53	0.2571	53.0	91.0	36.0	8.00
R4536.6	—	6.60	0.2598	53.0	91.0	36.0	8.00
R453G	G	6.63	0.2610	53.0	91.0	36.0	8.00
R4536.7	—	6.70	0.2638	53.0	91.0	36.0	8.00
R45317/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
R4536.8	—	6.80	0.2677	53.0	91.0	36.0	8.00
R4536.9	—	6.90	0.2717	53.0	91.0	36.0	8.00
R453I	I	6.91	0.2720	53.0	91.0	36.0	8.00
R4537.0	—	7.00	0.2756	53.0	91.0	36.0	8.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R453J	J	7.04	0.2772	53.0	91.0	36.0	8.00
R4537.1	—	7.10	0.2795	53.0	91.0	36.0	8.00
R453K	K	7.14	0.2811	53.0	91.0	36.0	8.00
R4539/32	9/32	7.14	0.2813	53.0	91.0	36.0	8.00
R4537.2	—	7.20	0.2835	53.0	91.0	36.0	8.00
R4537.3	—	7.30	0.2874	53.0	91.0	36.0	8.00
R453L	L	7.37	0.2902	53.0	91.0	36.0	8.00
R4537.4	—	7.40	0.2913	53.0	91.0	36.0	8.00
R453M	M	7.49	0.2949	53.0	91.0	36.0	8.00
R4537.5	—	7.50	0.2953	53.0	91.0	36.0	8.00
R45319/64	19/64	7.54	0.2969	53.0	91.0	36.0	8.00
R4537.6	—	7.60	0.2992	53.0	91.0	36.0	8.00
R453N	N	7.67	0.3020	53.0	91.0	36.0	8.00
R4537.7	—	7.70	0.3031	53.0	91.0	36.0	8.00
R4537.8	—	7.80	0.3071	53.0	91.0	36.0	8.00
R4537.9	—	7.90	0.3110	53.0	91.0	36.0	8.00
R4535/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
R4538.0	—	8.00	0.3150	53.0	91.0	36.0	8.00
R4530	O	8.03	0.3161	61.0	103.0	40.0	10.00
R4538.05	—	8.05	0.3169	61.0	103.0	40.0	10.00
R4538.1	—	8.10	0.3189	61.0	103.0	40.0	10.00
R4538.2	—	8.20	0.3228	61.0	103.0	40.0	10.00
R453P	P	8.20	0.3228	61.0	103.0	40.0	10.00
R4538.3	—	8.30	0.3268	61.0	103.0	40.0	10.00
R45321/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
R4538.4	—	8.40	0.3307	61.0	103.0	40.0	10.00
R453Q	Q	8.43	0.3319	61.0	103.0	40.0	10.00
R4538.5	—	8.50	0.3346	61.0	103.0	40.0	10.00
R4538.6	—	8.60	0.3386	61.0	103.0	40.0	10.00
R453R	R	8.61	0.3390	61.0	103.0	40.0	10.00
R4538.7	—	8.70	0.3425	61.0	103.0	40.0	10.00
R45311/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
R4538.8	—	8.80	0.3465	61.0	103.0	40.0	10.00
R453S	S	8.84	0.3480	61.0	103.0	40.0	10.00
R4538.9	—	8.90	0.3504	61.0	103.0	40.0	10.00
R4539.0	—	9.00	0.3543	61.0	103.0	40.0	10.00
R4539.1	—	9.10	0.3583	61.0	103.0	40.0	10.00
R45323/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
R4539.2	—	9.20	0.3622	61.0	103.0	40.0	10.00
R4539.3	—	9.30	0.3661	61.0	103.0	40.0	10.00
R453U	U	9.35	0.3681	61.0	103.0	40.0	10.00
R4539.4	—	9.40	0.3701	61.0	103.0	40.0	10.00
R4539.5	—	9.50	0.3740	61.0	103.0	40.0	10.00
R4533/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
R4539.6	—	9.60	0.3780	61.0	103.0	40.0	10.00
R4539.7	—	9.70	0.3819	61.0	103.0	40.0	10.00
R4539.8	—	9.80	0.3858	61.0	103.0	40.0	10.00
R453W	W	9.80	0.3858	61.0	103.0	40.0	10.00
R4539.9	—	9.90	0.3898	61.0	103.0	40.0	10.00
R45325/64	25/64	9.92	0.3906	61.0	103.0	40.0	10.00
R45310.0	—	10.00	0.3937	61.0	103.0	40.0	10.00
R45310.05	—	10.05	0.3957	70.0	118.0	45.0	12.00
R453X	X	10.08	0.3969	70.0	118.0	45.0	12.00
R45310.1	—	10.10	0.3976	70.0	118.0	45.0	12.00
R45310.2	—	10.20	0.4016	70.0	118.0	45.0	12.00
R453Y	Y	10.26	0.4039	70.0	118.0	45.0	12.00
R45310.3	—	10.30	0.4055	70.0	118.0	45.0	12.00
R45313/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
R45310.4	—	10.40	0.4094	70.0	118.0	45.0	12.00
R45310.5	—	10.50	0.4134	70.0	118.0	45.0	12.00
R45310.6	—	10.60	0.4173	70.0	118.0	45.0	12.00
R45327/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45310.8	–	10.80	0.4252	70.0	118.0	45.0	12.00
R45311.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
R4537/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
R45311.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
R45311.3	–	11.30	0.4449	70.0	118.0	45.0	12.00
R45311.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
R45311.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
R45329/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
R45311.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
R45311.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
R45315/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
R45312.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
R45312.05	–	12.05	0.4744	76.0	124.0	45.0	14.00
R45312.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
R45331/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
R45312.5	–	12.50	0.4921	76.0	124.0	45.0	14.00
R45312.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
R4531/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
R45312.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
R45313.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
R45333/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
R45313.3	–	13.30	0.5236	76.0	124.0	45.0	14.00
R45317/32	17/32	13.49	0.5313	76.0	124.0	45.0	14.00
R45313.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
R45313.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
R45335/64	35/64	13.89	0.5469	76.0	124.0	45.0	14.00
R45314.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
R45314.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
R4539/16	9/16	14.29	0.5625	82.0	133.0	48.0	16.00
R45314.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
R45337/64	37/64	14.68	0.5781	82.0	133.0	48.0	16.00
R45314.8	–	14.80	0.5827	82.0	133.0	48.0	16.00
R45315.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
R45319/32	19/32	15.08	0.5938	82.0	133.0	48.0	16.00
R45315.1	–	15.10	0.5945	82.0	133.0	48.0	16.00
R45315.3	–	15.30	0.6024	82.0	133.0	48.0	16.00
R45315.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
R45315.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
R4535/8	5/8	15.88	0.6250	82.0	133.0	48.0	16.00
R45316.0	–	16.00	0.6299	82.0	133.0	48.0	16.00
R45341/64	41/64	16.27	0.6406	91.0	143.0	48.0	18.00
R45316.5	–	16.50	0.6496	91.0	143.0	48.0	18.00
R45321/32	21/32	16.67	0.6563	91.0	143.0	48.0	18.00
R45317.0	–	17.00	0.6693	91.0	143.0	48.0	18.00
R45343/64	43/64	17.07	0.6720	91.0	143.0	48.0	18.00
R45311/16	11/16	17.46	0.6874	91.0	143.0	48.0	18.00
R45317.5	–	17.50	0.6890	91.0	143.0	48.0	18.00
R45317.8	–	17.80	0.7008	91.0	143.0	48.0	18.00
R45345/64	45/64	17.86	0.7031	91.0	143.0	48.0	18.00
R45318.0	–	18.00	0.7087	91.0	143.0	48.0	18.00
R45323/32	23/32	18.26	0.7189	99.0	153.0	50.0	20.00
R45318.5	–	18.50	0.7283	99.0	153.0	50.0	20.00
R45347/64	47/64	18.65	0.7343	99.0	153.0	50.0	20.00
R45319.0	–	19.00	0.7480	99.0	153.0	50.0	20.00
R4533/4	3/4	19.05	0.7500	99.0	153.0	50.0	20.00
R45319.5	–	19.50	0.7677	99.0	153.0	50.0	20.00
R45319.8	–	19.80	0.7795	99.0	153.0	50.0	20.00
R45320.0	–	20.00	0.7874	99.0	153.0	50.0	20.00

R459

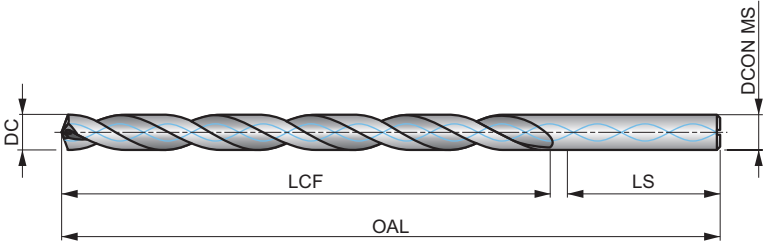


FORCE X solid hårdmetal 8XD bor med indvendig kølemiddeltilførsel, TiAIN belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9 hulltolerance). Selvcentrerende 140 °, 4-facets spidspunkt og CTW-skærkonstruktion for forbedret gennemtrængningshastighed. Kølemiddelhuller til forbedring af spånevakuering. TiAIN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE X

HM		8xD
		
		
DC m7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 143 V	P1.2 ■ 160 V	P1.3 ■ 166 V	P2.1 ■ 122 V	P2.2 ■ 108 U	P2.3 ■ 95 U	P3.1 ■ 106 U	P3.2 ■ 86 U	P3.3 ■ 72 U	P4.1 ■ 63 U	P4.2 ■ 54 U	P4.3 ■ 44 T	M1.1 ▣ 60 V	M1.2 ▣ 51 V
M2.1 ▣ 54 V	M2.2 ▣ 44 V	M2.3 ▣ 37 U	M3.1 ▣ 33 V	M3.2 ▣ 28 V	M3.3 ▣ 26 V	M4.1 ▣ 24 U	M4.2 ▣ 21 U	K1.1 ■ 88 W	K1.2 ■ 65 W	K1.3 ■ 49 W	K2.1 ■ 78 V	K2.2 ■ 64 V	K2.3 ■ 51 V
K3.1 ■ 70 V	K3.2 ■ 54 V	K3.3 ■ 43 V	K4.1 ■ 65 V	K4.2 ■ 49 V	K4.3 ■ 36 V	K4.4 ■ 30 V	K4.5 ■ 26 V	K5.1 ■ 73 V	K5.2 ■ 55 V	K5.3 ■ 42 V	N1.1 ▣ 1200 W	N1.2 ▣ 150 W	N1.3 ■ 100 W
N2.1 ■ 246 V	N2.2 ■ 222 V	N2.3 ■ 160 V	N3.1 ▣ 298 V	N3.2 ▣ 176 V	N3.3 ▣ 88 V								

DCON MS tolerance h6.

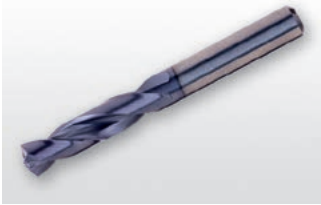
Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4593.0	—	3.00	0.1181	37.0	79.0	36.0	6.00
R4593.1	—	3.10	0.1220	37.0	79.0	36.0	6.00
R4591/8	1/8	3.18	0.1250	37.0	79.0	36.0	6.00
R4593.2	—	3.20	0.1260	37.0	79.0	36.0	6.00
R4593.3	—	3.30	0.1299	37.0	79.0	36.0	6.00
R4593.4	—	3.40	0.1339	37.0	79.0	36.0	6.00
R4593.5	—	3.50	0.1378	37.0	79.0	36.0	6.00
R4599/64	9/64	3.57	0.1406	37.0	79.0	36.0	6.00
R4593.6	—	3.60	0.1417	37.0	79.0	36.0	6.00
R4593.7	—	3.70	0.1457	37.0	79.0	36.0	6.00
R4593.8	—	3.80	0.1496	48.0	90.0	36.0	6.00
R4593.9	—	3.90	0.1535	48.0	90.0	36.0	6.00
R4595/32	5/32	3.97	0.1563	48.0	90.0	36.0	6.00
R4594.0	—	4.00	0.1575	48.0	90.0	36.0	6.00
R4594.1	—	4.10	0.1614	48.0	90.0	36.0	6.00
R4594.2	—	4.20	0.1654	48.0	90.0	36.0	6.00
R4594.3	—	4.30	0.1693	48.0	90.0	36.0	6.00
R45911/64	11/64	4.37	0.1719	48.0	90.0	36.0	6.00
R4594.4	—	4.40	0.1732	48.0	90.0	36.0	6.00
R4594.5	—	4.50	0.1772	48.0	90.0	36.0	6.00
R4594.6	—	4.60	0.1811	48.0	90.0	36.0	6.00
R4594.7	—	4.70	0.1850	62.0	104.0	36.0	6.00
R4593/16	3/16	4.76	0.1875	62.0	104.0	36.0	6.00
R4594.8	—	4.80	0.1890	62.0	104.0	36.0	6.00
R4594.9	—	4.90	0.1929	62.0	104.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4595.0	—	5.00	0.1969	62.0	104.0	36.0	6.00
R4595.1	—	5.10	0.2008	62.0	104.0	36.0	6.00
R45913/64	13/64	5.16	0.2031	62.0	104.0	36.0	6.00
R4595.2	—	5.20	0.2047	62.0	104.0	36.0	6.00
R4595.3	—	5.30	0.2087	62.0	104.0	36.0	6.00
R4595.4	—	5.40	0.2126	62.0	104.0	36.0	6.00
R4595.5	—	5.50	0.2165	62.0	104.0	36.0	6.00
R4597/32	7/32	5.56	0.2188	62.0	104.0	36.0	6.00
R4595.6	—	5.60	0.2205	62.0	104.0	36.0	6.00
R4595.7	—	5.70	0.2244	62.0	104.0	36.0	6.00
R4595.8	—	5.80	0.2283	62.0	104.0	36.0	6.00
R4595.9	—	5.90	0.2323	62.0	104.0	36.0	6.00
R45915/64	15/64	5.95	0.2344	62.0	104.0	36.0	6.00
R4596.0	—	6.00	0.2362	62.0	104.0	36.0	6.00
R4596.1	—	6.10	0.2402	84.0	126.0	36.0	8.00
R4596.2	—	6.20	0.2441	84.0	126.0	36.0	8.00
R4596.3	—	6.30	0.2480	84.0	126.0	36.0	8.00
R4591/4	1/4	6.35	0.2500	84.0	126.0	36.0	8.00
R4596.4	—	6.40	0.2520	84.0	126.0	36.0	8.00
R4596.5	—	6.50	0.2559	84.0	126.0	36.0	8.00
R4596.6	—	6.60	0.2598	84.0	126.0	36.0	8.00
R4596.7	—	6.70	0.2638	84.0	126.0	36.0	8.00
R45917/64	17/64	6.75	0.2656	84.0	126.0	36.0	8.00
R4596.8	—	6.80	0.2677	84.0	126.0	36.0	8.00
R4596.9	—	6.90	0.2717	84.0	126.0	36.0	8.00
R4597.0	—	7.00	0.2756	84.0	126.0	36.0	8.00
R4597.1	—	7.10	0.2795	84.0	126.0	36.0	8.00
R4599/32	9/32	7.14	0.2813	84.0	126.0	36.0	8.00
R4597.2	—	7.20	0.2835	84.0	126.0	36.0	8.00
R4597.3	—	7.30	0.2874	84.0	126.0	36.0	8.00
R4597.4	—	7.40	0.2913	84.0	126.0	36.0	8.00
R4597.5	—	7.50	0.2953	84.0	126.0	36.0	8.00
R45919/64	19/64	7.54	0.2969	84.0	126.0	36.0	8.00
R4597.6	—	7.60	0.2992	84.0	126.0	36.0	8.00
R4597.7	—	7.70	0.3031	84.0	126.0	36.0	8.00
R4597.8	—	7.80	0.3071	84.0	126.0	36.0	8.00
R4597.9	—	7.90	0.3110	84.0	126.0	36.0	8.00
R4595/16	5/16	7.94	0.3125	84.0	126.0	36.0	8.00
R4598.0	—	8.00	0.3150	84.0	126.0	36.0	8.00
R4598.1	—	8.10	0.3189	106.0	152.0	40.0	10.00
R4598.2	—	8.20	0.3228	106.0	152.0	40.0	10.00
R4598.3	—	8.30	0.3268	106.0	152.0	40.0	10.00
R45921/64	21/64	8.33	0.3281	106.0	152.0	40.0	10.00
R4598.4	—	8.40	0.3307	106.0	152.0	40.0	10.00
R4598.5	—	8.50	0.3346	106.0	152.0	40.0	10.00
R4598.6	—	8.60	0.3386	106.0	152.0	40.0	10.00
R4598.7	—	8.70	0.3425	106.0	152.0	40.0	10.00
R45911/32	11/32	8.73	0.3438	106.0	152.0	40.0	10.00
R4598.8	—	8.80	0.3465	106.0	152.0	40.0	10.00
R4598.9	—	8.90	0.3504	106.0	152.0	40.0	10.00
R4599.0	—	9.00	0.3543	106.0	152.0	40.0	10.00
R4599.1	—	9.10	0.3583	106.0	152.0	40.0	10.00
R45923/64	23/64	9.13	0.3594	106.0	152.0	40.0	10.00
R4599.2	—	9.20	0.3622	106.0	152.0	40.0	10.00
R4599.3	—	9.30	0.3661	106.0	152.0	40.0	10.00
R4599.4	—	9.40	0.3701	106.0	152.0	40.0	10.00
R4599.5	—	9.50	0.3740	106.0	152.0	40.0	10.00
R4593/8	3/8	9.53	0.3750	106.0	152.0	40.0	10.00
R4599.6	—	9.60	0.3780	106.0	152.0	40.0	10.00
R4599.7	—	9.70	0.3819	106.0	152.0	40.0	10.00
R4599.8	—	9.80	0.3858	106.0	152.0	40.0	10.00
R4599.9	—	9.90	0.3898	106.0	152.0	40.0	10.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45925/64	25/64	9.92	0.3906	106.0	152.0	40.0	10.00
R45910.0	–	10.00	0.3937	106.0	152.0	40.0	10.00
R45910.2	–	10.20	0.4016	128.0	180.0	45.0	12.00
R45910.3	–	10.30	0.4055	128.0	180.0	45.0	12.00
R45913/32	13/32	10.32	0.4063	128.0	180.0	45.0	12.00
R45910.4	–	10.40	0.4094	128.0	180.0	45.0	12.00
R45910.5	–	10.50	0.4134	128.0	180.0	45.0	12.00
R45927/64	27/64	10.72	0.4219	128.0	180.0	45.0	12.00
R45910.8	–	10.80	0.4252	128.0	180.0	45.0	12.00
R45911.0	–	11.00	0.4331	128.0	180.0	45.0	12.00
R4597/16	7/16	11.11	0.4375	128.0	180.0	45.0	12.00
R45911.2	–	11.20	0.4409	128.0	180.0	45.0	12.00
R45911.3	–	11.30	0.4449	128.0	180.0	45.0	12.00
R45911.5	–	11.50	0.4528	128.0	180.0	45.0	12.00
R45929/64	29/64	11.51	0.4531	128.0	180.0	45.0	12.00
R45911.8	–	11.80	0.4646	128.0	180.0	45.0	12.00
R45915/32	15/32	11.91	0.4688	128.0	180.0	45.0	12.00
R45912.0	–	12.00	0.4724	128.0	180.0	45.0	12.00
R45912.2	–	12.20	0.4803	151.0	202.0	48.0	14.00
R45931/64	31/64	12.30	0.4844	151.0	202.0	48.0	14.00
R45912.5	–	12.50	0.4921	151.0	202.0	48.0	14.00
R4591/2	1/2	12.70	0.5000	151.0	202.0	48.0	14.00
R45912.8	–	12.80	0.5039	151.0	202.0	48.0	14.00
R45913.0	–	13.00	0.5118	151.0	202.0	48.0	14.00
R45933/64	33/64	13.10	0.5156	151.0	202.0	48.0	14.00
R45917/32	17/32	13.49	0.5313	151.0	202.0	48.0	14.00
R45913.5	–	13.50	0.5315	151.0	202.0	48.0	14.00
R45935/64	35/64	13.89	0.5469	151.0	202.0	48.0	14.00
R45914.0	–	14.00	0.5512	151.0	202.0	48.0	14.00
R45914.25	–	14.25	0.5610	172.0	227.0	48.0	16.00
R4599/16	9/16	14.29	0.5625	172.0	227.0	48.0	16.00
R45914.5	–	14.50	0.5709	172.0	227.0	48.0	16.00
R45937/64	37/64	14.68	0.5781	172.0	227.0	48.0	16.00
R45915.0	–	15.00	0.5906	172.0	227.0	48.0	16.00
R45919/32	19/32	15.08	0.5938	172.0	227.0	48.0	16.00
R45915.1	–	15.10	0.5945	172.0	227.0	48.0	16.00
R45915.5	–	15.50	0.6102	172.0	227.0	48.0	16.00
R4595/8	5/8	15.88	0.6250	172.0	227.0	48.0	16.00
R45916.0	–	16.00	0.6299	172.0	227.0	48.0	16.00

R467



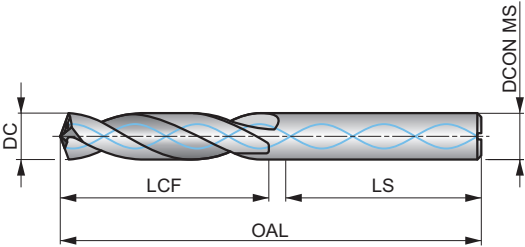


FORCE M massiv hårdmetal 3XD bor med indvendig kølemiddeltilførsel. TiAIN Belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændinger (H9-hultolerance i rustfrit stål og varmebestandige materialer). En spidspunkt på 140°, 4 facetter og CTW-skærkonstruktion. Kølemiddelhuller forbedrer spånevakuering. TiAIN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE M

HM	DIN 6537K	3xD
		
		
DC m7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	S1.1	S1.2	S1.3	S2.1
■ 117 G	■ 99 G	■ 104 G	■ 85 G	■ 71 E	■ 87 G	■ 75 G	■ 68 F	■ 60 F	■ 52 E	■ 55 V	■ 45 V	■ 40 U	■ 60 U
S2.2	S3.1	S3.2	S4.1	S4.2									
■ 56 U	■ 45 U	■ 40 U	■ 35 U	■ 32 U									

DCON MS tolerance h6.

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4673.0	—	3.00	0.1181	20.0	62.0	36.0	6.00
R4673.1	—	3.10	0.1220	20.0	62.0	36.0	6.00
R4671/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
R4673.2	—	3.20	0.1260	20.0	62.0	36.0	6.00
R4673.3	—	3.30	0.1299	20.0	62.0	36.0	6.00
R4673.4	—	3.40	0.1339	20.0	62.0	36.0	6.00
R467N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
R4673.5	—	3.50	0.1378	20.0	62.0	36.0	6.00
R4679/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
R4673.6	—	3.60	0.1417	20.0	62.0	36.0	6.00
R4673.7	—	3.70	0.1457	20.0	62.0	36.0	6.00
R4673.8	—	3.80	0.1496	24.0	66.0	36.0	6.00
R4673.9	—	3.90	0.1535	24.0	66.0	36.0	6.00
R4675/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
R4674.0	—	4.00	0.1575	24.0	66.0	36.0	6.00
R4674.05	—	4.05	0.1594	24.0	66.0	36.0	6.00
R4674.1	—	4.10	0.1614	24.0	66.0	36.0	6.00
R4674.2	—	4.20	0.1654	24.0	66.0	36.0	6.00
R4674.3	—	4.30	0.1693	24.0	66.0	36.0	6.00
R46711/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
R4674.4	—	4.40	0.1732	24.0	66.0	36.0	6.00
R4674.5	—	4.50	0.1772	24.0	66.0	36.0	6.00
R4674.6	—	4.60	0.1811	24.0	66.0	36.0	6.00
R4674.7	—	4.70	0.1850	24.0	66.0	36.0	6.00
R4673/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
R4674.8	—	4.80	0.1890	28.0	66.0	36.0	6.00
R4674.9	—	4.90	0.1929	28.0	66.0	36.0	6.00
R4675.0	—	5.00	0.1969	28.0	66.0	36.0	6.00
R4675.05	—	5.05	0.1988	28.0	66.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4675.1	—	5.10	0.2008	28.0	66.0	36.0	6.00
R467N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
R46713/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
R4675.2	—	5.20	0.2047	28.0	66.0	36.0	6.00
R467N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
R4675.3	—	5.30	0.2087	28.0	66.0	36.0	6.00
R4675.4	—	5.40	0.2126	28.0	66.0	36.0	6.00
R4675.5	—	5.50	0.2165	28.0	66.0	36.0	6.00
R4677/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
R4675.6	—	5.60	0.2205	28.0	66.0	36.0	6.00
R4675.7	—	5.70	0.2244	28.0	66.0	36.0	6.00
R4675.8	—	5.80	0.2283	28.0	66.0	36.0	6.00
R4675.9	—	5.90	0.2323	28.0	66.0	36.0	6.00
R46715/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
R4676.0	—	6.00	0.2362	28.0	66.0	36.0	6.00
R4676.05	—	6.05	0.2382	34.0	79.0	36.0	8.00
R4676.1	—	6.10	0.2402	34.0	79.0	36.0	8.00
R4676.2	—	6.20	0.2441	34.0	79.0	36.0	8.00
R4676.3	—	6.30	0.2480	34.0	79.0	36.0	8.00
R4671/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
R4676.4	—	6.40	0.2520	34.0	79.0	36.0	8.00
R4676.5	—	6.50	0.2559	34.0	79.0	36.0	8.00
R4676.6	—	6.60	0.2598	34.0	79.0	36.0	8.00
R4676.7	—	6.70	0.2638	34.0	79.0	36.0	8.00
R46717/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
R4676.8	—	6.80	0.2677	34.0	79.0	36.0	8.00
R4676.9	—	6.90	0.2717	34.0	79.0	36.0	8.00
R4677.0	—	7.00	0.2756	34.0	79.0	36.0	8.00
R4677.1	—	7.10	0.2795	41.0	79.0	36.0	8.00
R4679/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
R4677.2	—	7.20	0.2835	41.0	79.0	36.0	8.00
R4677.3	—	7.30	0.2874	41.0	79.0	36.0	8.00
R4677.4	—	7.40	0.2913	41.0	79.0	36.0	8.00
R4677.5	—	7.50	0.2953	41.0	79.0	36.0	8.00
R46719/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
R4677.6	—	7.60	0.2992	41.0	79.0	36.0	8.00
R4677.7	—	7.70	0.3031	41.0	79.0	36.0	8.00
R4677.8	—	7.80	0.3071	41.0	79.0	36.0	8.00
R4675/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
R4678.0	—	8.00	0.3150	41.0	79.0	36.0	8.00
R4678.05	—	8.05	0.3169	47.0	89.0	40.0	10.00
R4678.1	—	8.10	0.3189	47.0	89.0	40.0	10.00
R4678.2	—	8.20	0.3228	47.0	89.0	40.0	10.00
R4678.3	—	8.30	0.3268	47.0	89.0	40.0	10.00
R4678.4	—	8.40	0.3307	47.0	89.0	40.0	10.00
R4678.5	—	8.50	0.3346	47.0	89.0	40.0	10.00
R4678.6	—	8.60	0.3386	47.0	89.0	40.0	10.00
R4678.7	—	8.70	0.3425	47.0	89.0	40.0	10.00
R46711/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
R4678.8	—	8.80	0.3465	47.0	89.0	40.0	10.00
R4678.9	—	8.90	0.3504	47.0	89.0	40.0	10.00
R4679.0	—	9.00	0.3543	47.0	89.0	40.0	10.00
R4679.1	—	9.10	0.3583	47.0	89.0	40.0	10.00
R46723/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
R4679.3	—	9.30	0.3661	47.0	89.0	40.0	10.00
R4679.4	—	9.40	0.3701	47.0	89.0	40.0	10.00
R4679.5	—	9.50	0.3740	47.0	89.0	40.0	10.00
R4673/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
R4679.6	—	9.60	0.3780	47.0	89.0	40.0	10.00
R4679.7	—	9.70	0.3819	47.0	89.0	40.0	10.00
R4679.8	—	9.80	0.3858	47.0	89.0	40.0	10.00
R4679.9	—	9.90	0.3898	47.0	89.0	40.0	10.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R46725/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
R46710.0	—	10.00	0.3937	47.0	89.0	40.0	10.00
R46710.05	—	10.05	0.3957	55.0	102.0	45.0	12.00
R46710.1	—	10.10	0.3976	55.0	102.0	45.0	12.00
R46710.2	—	10.20	0.4016	55.0	102.0	45.0	12.00
R46710.3	—	10.30	0.4055	55.0	102.0	45.0	12.00
R46713/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
R46710.4	—	10.40	0.4094	55.0	102.0	45.0	12.00
R46710.5	—	10.50	0.4134	55.0	102.0	45.0	12.00
R46710.6	—	10.60	0.4173	55.0	102.0	45.0	12.00
R46727/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
R46710.9	—	10.90	0.4291	55.0	102.0	45.0	12.00
R46711.0	—	11.00	0.4331	55.0	102.0	45.0	12.00
R4677/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
R46711.2	—	11.20	0.4409	55.0	102.0	45.0	12.00
R46711.4	—	11.40	0.4488	55.0	102.0	45.0	12.00
R46711.5	—	11.50	0.4528	55.0	102.0	45.0	12.00
R46729/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
R46711.8	—	11.80	0.4646	55.0	102.0	45.0	12.00
R46715/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
R46712.0	—	12.00	0.4724	55.0	102.0	45.0	12.00
R46712.05	—	12.05	0.4744	60.0	107.0	45.0	14.00
R46712.1	—	12.10	0.4764	60.0	107.0	45.0	14.00
R46712.2	—	12.20	0.4803	60.0	107.0	45.0	14.00
R46731/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
R46712.5	—	12.50	0.4921	60.0	107.0	45.0	14.00
R46712.7	—	12.70	0.5000	60.0	107.0	45.0	14.00
R4671/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
R46713.0	—	13.00	0.5118	60.0	107.0	45.0	14.00
R46733/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
R46717/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
R46713.5	—	13.50	0.5315	60.0	107.0	45.0	14.00
R46735/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
R46714.0	—	14.00	0.5512	60.0	107.0	45.0	14.00
R46714.25	—	14.25	0.5610	65.0	115.0	48.0	16.00
R4679/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
R46714.5	—	14.50	0.5709	65.0	115.0	48.0	16.00
R46737/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
R46715.0	—	15.00	0.5906	65.0	115.0	48.0	16.00
R46719/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
R46715.1	—	15.10	0.5945	65.0	115.0	48.0	16.00
R46715.3	—	15.30	0.6024	65.0	115.0	48.0	16.00
R46715.5	—	15.50	0.6102	65.0	115.0	48.0	16.00
R4675/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
R46716.0	—	16.00	0.6299	65.0	115.0	48.0	16.00

R463

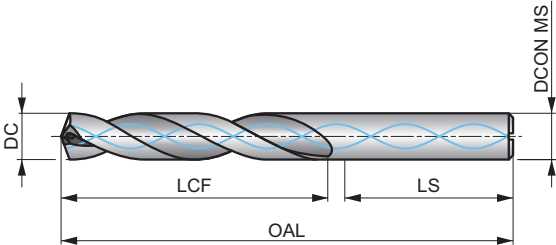


FORCE M massiv hårdmetal 5XD bor med indvendig kølemiddeltilførsel. TiAIN Belagt

Højtydende bor, der er i stand til at producere nøjagtige huller af høj kvalitet ved høje hastigheder og tilspændninger (H9-hultolerance i rustfrit stål og varmebestandige materialer). En spidspunkt på 140 °, 4 facetter og CTW-skærkonstruktion. Kølemiddelhuller forbedrer spånevakuering. TiAIN-belægning øger overfladens hårdhed og forbedrer værktøjets levetid.

FORCE M

HM	DIN 6537L	5xD
140°	TiAIN	DIN 6535HA
CTW	R	
DC m7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	S1.1	S1.2	S1.3	S2.1
■ 111 G	■ 94 G	■ 99 G	■ 81 G	■ 67 E	■ 83 G	■ 71 G	■ 65 F	■ 57 F	■ 49 E	■ 52 V	■ 43 V	■ 38 U	■ 57 U
S2.2	S3.1	S3.2	S4.1	S4.2									
■ 53 U	■ 43 U	■ 38 U	■ 33 U	■ 30 U									

DCON MS tolerance h6.

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4633.0	—	3.00	0.1181	28.0	66.0	36.0	6.00
R4633.1	—	3.10	0.1220	28.0	66.0	36.0	6.00
R4631/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
R4633.2	—	3.20	0.1260	28.0	66.0	36.0	6.00
R4633.3	—	3.30	0.1299	28.0	66.0	36.0	6.00
R4633.4	—	3.40	0.1339	28.0	66.0	36.0	6.00
R463N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
R4633.5	—	3.50	0.1378	28.0	66.0	36.0	6.00
R4639/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
R4633.6	—	3.60	0.1417	28.0	66.0	36.0	6.00
R4633.7	—	3.70	0.1457	28.0	66.0	36.0	6.00
R4633.8	—	3.80	0.1496	36.0	74.0	36.0	6.00
R4633.9	—	3.90	0.1535	36.0	74.0	36.0	6.00
R4635/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
R4634.0	—	4.00	0.1575	36.0	74.0	36.0	6.00
R4634.05	—	4.05	0.1594	36.0	74.0	36.0	6.00
R4634.1	—	4.10	0.1614	36.0	74.0	36.0	6.00
R4634.2	—	4.20	0.1654	36.0	74.0	36.0	6.00
R4634.3	—	4.30	0.1693	36.0	74.0	36.0	6.00
R46311/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
R4634.4	—	4.40	0.1732	36.0	74.0	36.0	6.00
R4634.5	—	4.50	0.1772	36.0	74.0	36.0	6.00
R4634.6	—	4.60	0.1811	36.0	74.0	36.0	6.00
R4634.7	—	4.70	0.1850	36.0	74.0	36.0	6.00
R4633/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
R4634.8	—	4.80	0.1890	44.0	82.0	36.0	6.00
R4634.9	—	4.90	0.1929	44.0	82.0	36.0	6.00
R4635.0	—	5.00	0.1969	44.0	82.0	36.0	6.00
R4635.05	—	5.05	0.1988	44.0	82.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4635.1	—	5.10	0.2008	44.0	82.0	36.0	6.00
R463N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
R46313/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
R4635.2	—	5.20	0.2047	44.0	82.0	36.0	6.00
R463N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
R4635.3	—	5.30	0.2087	44.0	82.0	36.0	6.00
R4635.5	—	5.50	0.2165	44.0	82.0	36.0	6.00
R4637/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
R4635.6	—	5.60	0.2205	44.0	82.0	36.0	6.00
R4635.7	—	5.70	0.2244	44.0	82.0	36.0	6.00
R4635.8	—	5.80	0.2283	44.0	82.0	36.0	6.00
R4635.9	—	5.90	0.2323	44.0	82.0	36.0	6.00
R46315/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
R4636.0	—	6.00	0.2362	44.0	82.0	36.0	6.00
R4636.05	—	6.05	0.2382	53.0	91.0	36.0	8.00
R4636.1	—	6.10	0.2402	53.0	91.0	36.0	8.00
R4636.2	—	6.20	0.2441	53.0	91.0	36.0	8.00
R4636.3	—	6.30	0.2480	53.0	91.0	36.0	8.00
R4631/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
R4636.4	—	6.40	0.2520	53.0	91.0	36.0	8.00
R4636.5	—	6.50	0.2559	53.0	91.0	36.0	8.00
R4636.6	—	6.60	0.2598	53.0	91.0	36.0	8.00
R4636.7	—	6.70	0.2638	53.0	91.0	36.0	8.00
R46317/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
R4636.8	—	6.80	0.2677	53.0	91.0	36.0	8.00
R4636.9	—	6.90	0.2717	53.0	91.0	36.0	8.00
R4637.0	—	7.00	0.2756	53.0	91.0	36.0	8.00
R4637.1	—	7.10	0.2795	53.0	91.0	36.0	8.00
R4637.2	—	7.20	0.2835	53.0	91.0	36.0	8.00
R4637.3	—	7.30	0.2874	53.0	91.0	36.0	8.00
R4637.4	—	7.40	0.2913	53.0	91.0	36.0	8.00
R4637.5	—	7.50	0.2953	53.0	91.0	36.0	8.00
R4637.6	—	7.60	0.2992	53.0	91.0	36.0	8.00
R4637.7	—	7.70	0.3031	53.0	91.0	36.0	8.00
R4637.8	—	7.80	0.3071	53.0	91.0	36.0	8.00
R4637.9	—	7.90	0.3110	53.0	91.0	36.0	8.00
R4635/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
R4638.0	—	8.00	0.3150	53.0	91.0	36.0	8.00
R4638.05	—	8.05	0.3169	61.0	103.0	40.0	10.00
R4638.1	—	8.10	0.3189	61.0	103.0	40.0	10.00
R4638.2	—	8.20	0.3228	61.0	103.0	40.0	10.00
R4638.3	—	8.30	0.3268	61.0	103.0	40.0	10.00
R46321/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
R4638.4	—	8.40	0.3307	61.0	103.0	40.0	10.00
R4638.5	—	8.50	0.3346	61.0	103.0	40.0	10.00
R4638.6	—	8.60	0.3386	61.0	103.0	40.0	10.00
R4638.7	—	8.70	0.3425	61.0	103.0	40.0	10.00
R46311/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
R4638.8	—	8.80	0.3465	61.0	103.0	40.0	10.00
R4638.9	—	8.90	0.3504	61.0	103.0	40.0	10.00
R4639.0	—	9.00	0.3543	61.0	103.0	40.0	10.00
R4639.1	—	9.10	0.3583	61.0	103.0	40.0	10.00
R46323/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
R4639.2	—	9.20	0.3622	61.0	103.0	40.0	10.00
R4639.3	—	9.30	0.3661	61.0	103.0	40.0	10.00
R4639.4	—	9.40	0.3701	61.0	103.0	40.0	10.00
R4639.5	—	9.50	0.3740	61.0	103.0	40.0	10.00
R4633/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
R4639.6	—	9.60	0.3780	61.0	103.0	40.0	10.00
R4639.7	—	9.70	0.3819	61.0	103.0	40.0	10.00
R4639.8	—	9.80	0.3858	61.0	103.0	40.0	10.00
R4639.9	—	9.90	0.3898	61.0	103.0	40.0	10.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R46310.0	–	10.00	0.3937	61.0	103.0	40.0	10.00
R46310.05	–	10.05	0.3957	70.0	118.0	45.0	12.00
R46310.1	–	10.10	0.3976	70.0	118.0	45.0	12.00
R46310.2	–	10.20	0.4016	70.0	118.0	45.0	12.00
R46310.3	–	10.30	0.4055	70.0	118.0	45.0	12.00
R46313/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
R46310.4	–	10.40	0.4094	70.0	118.0	45.0	12.00
R46310.5	–	10.50	0.4134	70.0	118.0	45.0	12.00
R46327/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00
R46310.8	–	10.80	0.4252	70.0	118.0	45.0	12.00
R46311.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
R4637/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
R46311.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
R46311.3	–	11.30	0.4449	70.0	118.0	45.0	12.00
R46311.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
R46311.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
R46329/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
R46311.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
R46311.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
R46315/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
R46312.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
R46312.05	–	12.05	0.4744	76.0	124.0	45.0	14.00
R46312.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
R46331/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
R46312.5	–	12.50	0.4921	76.0	124.0	45.0	14.00
R46312.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
R4631/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
R46312.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
R46313.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
R46333/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
R46313.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
R46313.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
R46314.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
R46314.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
R46314.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
R46315.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
R46315.3	–	15.30	0.6024	82.0	133.0	48.0	16.00
R46315.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
R46315.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
R46316.0	–	16.00	0.6299	82.0	133.0	48.0	16.00

R7131

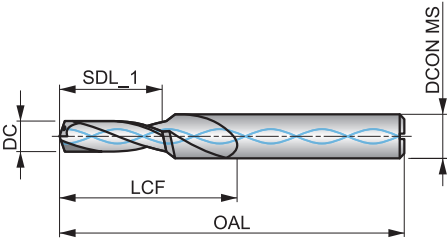
DORMER



Trinbor i hårdmetal, TiAlN belagt med indvendig kølemiddeltilførsel

Alsided med specifikke diametre og -længder til opnåelse af hulstørrelse og dybde for metriske gevind. Boring og affasning i en operation reducerer cykeltid og værktøjsopgørelse. En 140 ° spidstinkel og 90 ° forsækning. TiAlN-belægning forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til boring af mange materialer.

HM		3xD
90°	TiAlN	DIN 6535HA
λ 20-35°	R	
DC m7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ■ 139 W	P1.2 ■ 156 W	P1.3 ■ 161 W	P2.1 ■ 119 W	P2.2 ■ 105 W	P2.3 ■ 93 V	P3.1 ■ 96 V	P3.2 ■ 77 V	P3.3 ■ 65 V	P4.1 ■ 57 V	P4.2 ■ 48 V	M1.1 ■ 62 V	M1.2 ■ 52 V	M2.1 ■ 55 V
M2.2 ■ 45 V	M3.1 ■ 47 V	M3.2 ■ 40 V	M3.3 ■ 36 U	M4.1 ■ 35 U	K1.1 ■ 90 W	K1.2 ■ 67 W	K1.3 ■ 50 W	K2.1 ■ 92 V	K2.2 ■ 75 V	K2.3 ■ 60 V	K3.1 ■ 82 V	K3.2 ■ 62 V	K3.3 ■ 50 V
K4.1 ■ 76 V	K4.2 ■ 57 V	K4.3 ■ 42 V	K4.4 ■ 36 V	K4.5 ■ 30 V	K5.1 ■ 86 V	K5.2 ■ 64 V	K5.3 ■ 50 V	N1.1 ■ 250 W	N1.2 ■ 188 W	N1.3 ■ 125 W	N2.1 ■ 308 V	N2.2 ■ 277 V	N2.3 ■ 200 V
N3.1 ■ 373 W	N3.2 ■ 220 W	N3.3 ■ 110 W											

DCON MS tolerance h6.

Product	DC (mm)	DC (inch)	SDL_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	TDZ
R71313.3	3.30	0.1299	11.40	20.0	66.0	6.00	M4
R71314.2	4.20	0.1654	13.60	24.0	66.0	6.00	M5
R71315.0	5.00	0.1969	16.50	28.0	79.0	8.00	M6
R71316.8	6.80	0.2677	21.00	34.0	89.0	10.00	M8
R71318.5	8.50	0.3346	25.50	47.0	102.0	12.00	M10
R713110.2	10.20	0.4016	30.00	55.0	107.0	14.00	M12
R713110.4	10.40	0.4094	30.00	55.0	107.0	14.00	M12

Materiale kode (BMC)		HSS	HSS	HSS	HSS	HSS	HM	HM						
Grundlæggende standard-gruppe (BSG)														
Brugbar længde (ULDR)		1.5xD	3xD	5xD	8xD	12xD								
Anvendelsesvinkel														
Belægning														
Skaft														
Hånd (skæreretning)														
Køling (CSP)														
		HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA
Produktfamiliekode		H851	H853	H855	H858	H8512	R950	R960	H860	H861				
PSF skærediametre række-vidde		31/64 - 30.00	12.00 - 42.50	12.00 - 42.50	14.00 - 42.50	14.00 - 25.00	15/32 - 42.00	15/32 - 30.50	N1 - N7	N1 - N5				
P	P1						■	■						
	P2						■	■						
	P3						■	■						
	P4						■	■						
M	M1							■						
	M2							■						
	M3							■						
	M4							■						
K	K1							■						
	K2						■	■						
	K3						■	■						
	K4						■	■						
	K5						■	■						
N	N1													
	N2													
	N3													
	N4													
	N5													
S	S1							■						
	S2							■						
	S3							■						
	S4							■						
H	H1													
	H2													
	H3													
	H4													

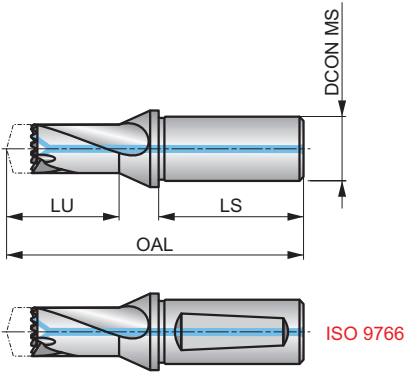
H851



HYDRA holder 1,5XD, med kølemiddeltilførsel, blank fornikling

Bruges med R950 og R960 HYDRA hoveder. En række hoveddiametre kan bruges med samme krop. Kølemiddelhuller på linje med hovederne giver effektiv køling. Flangeskaft forhindrer boret i at vandre i holderen. Forniklet overflade beskytter mod rust og korrosion og forbedrer spånevakuering.

HYDRA



HSS		1.5×D
Bright Ni		
		

Fire (4) skruer og en (1) skruetrækker er inkluderet med et borholder, DCON MS tolerance h6.

Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85131/64	5/8	15.88	25.50	88.5	47.6	Cylindrical
H85117/32	5/8	15.88	30.90	93.9	47.6	Cylindrical
H85112.0	—	16.00	25.50	88.5	48.0	ISO 9766
H85112.5	—	16.00	25.80	88.8	48.0	ISO 9766
H85113.0	—	16.00	27.00	90.0	48.0	ISO 9766
H85114.0	—	16.00	30.90	93.9	48.0	ISO 9766
H85139/64	3/4	19.05	32.30	97.3	50.8	Cylindrical
H85141/64	3/4	19.05	34.90	99.9	50.8	Cylindrical
H85111/16	3/4	19.05	36.40	101.4	50.8	Cylindrical
H85123/32	3/4	19.05	39.00	104.0	50.8	Cylindrical
H85115.0	—	20.00	32.30	97.3	50.0	ISO 9766
H85116.0	—	20.00	34.90	99.9	50.0	ISO 9766
H85117.0	—	20.00	36.40	101.4	50.0	ISO 9766
H85118.0	—	20.00	39.00	104.0	50.0	ISO 9766
H85119.0	—	25.00	40.40	111.4	56.0	ISO 9766
H85120.0	—	25.00	43.00	114.0	56.0	ISO 9766
H85121.0	—	25.00	44.50	115.5	56.0	ISO 9766
H85122.0	—	25.00	46.10	117.1	56.0	ISO 9766
H85123.0	—	25.00	47.00	118.0	56.0	ISO 9766
H85149/64	1"	25.40	40.40	111.4	57.1	Cylindrical
H85151/64	1"	25.40	43.00	114.0	57.1	Cylindrical
H85127/32	1"	25.40	44.50	115.5	57.1	Cylindrical
H85157/64	1"	25.40	46.10	117.1	57.1	Cylindrical
H85159/64	1"	25.40	47.00	118.0	57.1	Cylindrical
H85131/32	1"	25.40	49.30	124.3	57.1	Cylindrical
H8511.1/64	1.1/4	31.75	49.70	124.7	60.3	Cylindrical
H8511.3/64	1.1/4	31.75	52.30	127.3	60.3	Cylindrical
H8511.3/32	1.1/4	31.75	52.80	127.8	60.3	Cylindrical
H8511.3/16	1.1/4	31.75	58.40	133.4	60.3	Cylindrical
H85124.0	—	32.00	49.30	124.3	60.0	ISO 9766
H85125.0	—	32.00	49.70	124.7	60.0	ISO 9766
H85126.0	—	32.00	52.30	127.3	60.0	ISO 9766
H85127.0	—	32.00	52.80	127.8	60.0	ISO 9766
H85128.0	—	32.00	54.40	129.4	60.0	ISO 9766
H85129.0	—	32.00	55.80	130.8	60.0	ISO 9766
H85130.0	—	32.00	58.40	133.4	60.0	ISO 9766

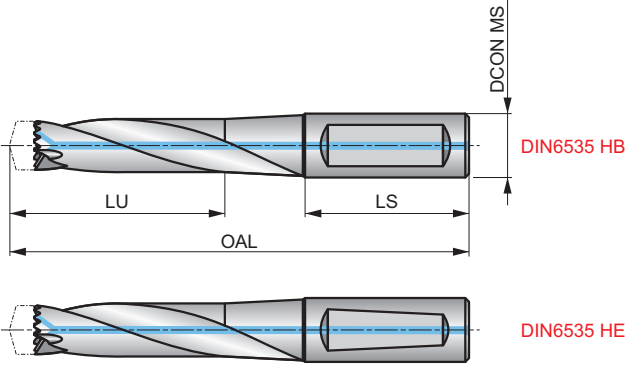
H853



HYDRA holder 3XD, med kølemiddeltilførsel, blank fornikling

Bruges med R950 og R960 HYDRA hoveder. En række hoveddiametre kan bruges med samme krop. Kølemiddelhuller på linje med hovederne giver effektiv køling. Blank forniklet overflade beskytter mod rust og korrosion og forbedrer spånevakuering.

HYDRA



HSS		3xD
	DIN 6535HB DIN 6535HE	
		

Fire (4) skruer og en (1) skruetrækker er inkluderet med et borholder, DCON MS tolerance h6.

Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85312.0	—	16.00	44.00	105.0	48.0	DIN6535HE
H85331/64	5/8	15.88	44.00	105.0	48.0	DIN6535HB
H85312.5	—	16.00	44.00	105.0	48.0	DIN6535HE
H8531/2	5/8	15.88	44.00	105.0	48.0	DIN6535HB
H85313.0	—	16.00	47.00	110.0	48.0	DIN6535HE
H85317/32	5/8	15.88	47.00	110.0	48.0	DIN6535HB
H85314.0	—	16.00	52.50	116.5	48.0	DIN6535HE
H8539/16	3/4	19.05	52.50	116.5	48.0	DIN6535HB
H85315.0	—	20.00	55.50	126.5	50.0	DIN6535HE
H85339/64	3/4	19.05	55.50	126.5	50.0	DIN6535HB
H85316.0	—	20.00	59.50	131.5	50.0	DIN6535HE
H85341/64	3/4	19.05	59.50	131.5	50.0	DIN6535HB
H85317.0	—	20.00	62.50	136.5	50.0	DIN6535HE
H85311/16	3/4	19.05	62.50	136.5	50.0	DIN6535HB
H85318.0	—	20.00	66.50	141.5	50.0	DIN6535HE
H85323/32	3/4	19.05	66.50	141.5	50.0	DIN6535HB
H85319.0	—	25.00	69.50	156.5	56.0	DIN6535HE
H85349/64	1"	25.40	69.50	156.5	56.0	DIN6535HB
H85320.0	—	25.00	73.50	156.5	56.0	DIN6535HE
H85351/64	1"	25.40	73.50	156.5	56.0	DIN6535HB
H85321.0	—	25.00	76.50	156.5	56.0	DIN6535HE
H85327/32	1"	25.40	76.50	156.5	56.0	DIN6535HB
H85322.0	—	25.00	80.10	161.5	56.0	DIN6535HE
H85357/64	1"	25.40	80.10	161.5	56.0	DIN6535HB
H85323.0	—	25.00	82.50	160.5	56.0	DIN6535HE
H85359/64	1"	25.40	82.50	160.5	56.0	DIN6535HB
H85324.0	—	32.00	86.20	170.2	60.0	DIN6535HE
H85331/32	1"	25.40	86.20	170.2	60.0	DIN6535HB
H85325.0	—	32.00	88.00	170.0	60.0	DIN6535HE
H8531.1/64	1.1/4	31.75	88.00	170.0	60.0	DIN6535HB
H85326.0	—	32.00	92.00	175.0	60.0	DIN6535HE
H8531.3/64	1.1/4	31.75	92.00	175.0	60.0	DIN6535HB
H85327.0	—	32.00	94.00	175.0	60.0	DIN6535HE
H8531.3/32	1.1/4	31.75	94.00	175.0	60.0	DIN6535HB

Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85328.0	–	32.00	97.00	180.0	60.0	DIN6535HE
H8531.1/8	1.1/4	31.75	97.00	180.0	60.0	DIN6535HB
H85329.0	–	32.00	100.00	185.0	60.0	DIN6535HE
H8531.11/64	1.1/4	31.75	100.00	185.0	60.0	DIN6535HB
H85330.0	–	32.00	104.00	185.0	60.0	DIN6535HE
H8531.3/16	1.1/4	31.75	104.00	185.0	60.0	DIN6535HB
H85332.0	–	32.00	111.50	196.5	60.0	DIN6535HE
H85333.5	–	32.00	116.50	201.5	60.0	DIN6535HE
H85335.0	–	40.00	121.50	216.5	70.0	DIN6535HB
H85336.5	–	40.00	125.50	221.5	70.0	DIN6535HB
H85338.0	–	40.00	131.50	226.5	70.0	DIN6535HB
H85339.5	–	40.00	136.50	231.5	70.0	DIN6535HB
H85341.0	–	40.00	146.50	246.5	70.0	DIN6535HB
H85342.5	–	40.00	151.60	251.6	70.0	DIN6535HB

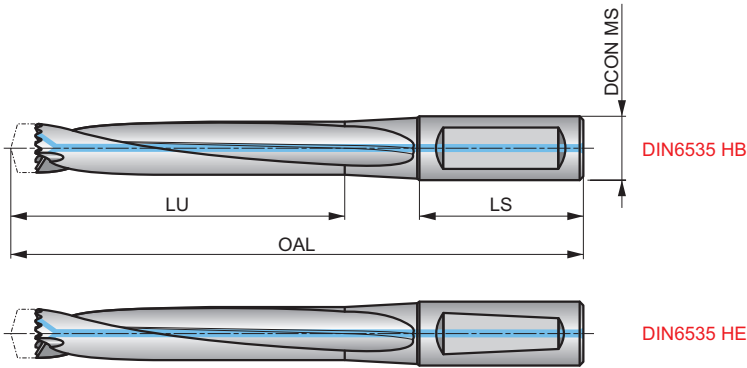
H855



HYDRA holder 5XD, med kølemiddeltilførsel, blank fornikling

Bruges med R950 og R960 HYDRA hoveder. En række hoveddiametre kan bruges med samme krop. Kølemiddelhuller på linje med hovederne giver effektiv køling. Blank forniklet overflade beskytter mod rust og korrosion og forbedrer spånevakuering.

HYDRA



HSS		5xD
	DIN 6535HB DIN 6535HE	
		

Fire (4) skruer og en (1) skruetrækker er inkluderet med et borholder, DCON MS tolerance h6.

Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85512.0	—	16.00	69.00	130.0	48.0	DIN6535HE
H85531/64	5/8	15.88	69.00	130.0	48.0	DIN6535HB
H85512.5	—	16.00	69.00	130.0	48.0	DIN6535HE
H8551/2	5/8	15.88	69.00	130.0	48.0	DIN6535HB
H85513.0	—	16.00	74.00	140.0	48.0	DIN6535HE
H85517/32	5/8	15.88	74.00	140.0	48.0	DIN6535HB
H85514.0	—	16.00	81.50	146.5	48.0	DIN6535HE
H8559/16	3/4	19.05	81.50	146.5	48.0	DIN6535HB
H85515.0	—	20.00	86.50	156.5	50.0	DIN6535HE
H85539/64	3/4	19.05	86.50	156.5	50.0	DIN6535HB
H85516.0	—	20.00	92.50	166.5	50.0	DIN6535HE
H85541/64	3/4	19.05	92.50	166.5	50.0	DIN6535HB
H85517.0	—	20.00	97.50	171.5	50.0	DIN6535HE
H85511/16	3/4	19.05	97.50	171.5	50.0	DIN6535HB
H85518.0	—	20.00	103.50	176.5	50.0	DIN6535HE
H85523/32	3/4	19.05	103.50	176.5	50.0	DIN6535HB
H85519.0	—	25.00	108.50	191.5	56.0	DIN6535HE
H85549/64	1"	25.40	108.50	191.5	56.0	DIN6535HB
H85520.0	—	25.00	114.50	196.5	56.0	DIN6535HE
H85551/64	1"	25.40	114.50	196.5	56.0	DIN6535HB
H85521.0	—	25.00	119.50	196.5	56.0	DIN6535HE
H85527/32	1"	25.40	119.50	196.5	56.0	DIN6535HB
H85522.0	—	25.00	125.10	201.1	56.0	DIN6535HE
H85557/64	1"	25.40	125.10	201.1	56.0	DIN6535HB
H85523.0	—	25.00	129.50	210.5	56.0	DIN6535HE
H85559/64	1"	25.40	129.50	210.5	56.0	DIN6535HB
H85524.0	—	32.00	135.20	220.2	60.0	DIN6535HE
H85531/32	1"	25.40	135.20	220.2	60.0	DIN6535HB
H85525.0	—	32.00	140.00	225.0	60.0	DIN6535HE
H8551.1/64	1.1/4	31.75	140.00	225.0	60.0	DIN6535HB
H85526.0	—	32.00	146.00	230.0	60.0	DIN6535HE
H8551.3/64	1.1/4	31.75	146.00	230.0	60.0	DIN6535HB
H85527.0	—	32.00	151.00	235.0	60.0	DIN6535HE
H8551.3/32	1.1/4	31.75	151.00	235.0	60.0	DIN6535HB

Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85528.0	–	32.00	157.00	240.0	60.0	DIN6535HE
H8551.1/8	1.1/4	31.75	157.00	240.0	60.0	DIN6535HB
H85529.0	–	32.00	162.00	245.0	60.0	DIN6535HE
H8551.11/64	1.1/4	31.75	162.00	245.0	60.0	DIN6535HB
H85530.0	–	32.00	167.00	255.0	60.0	DIN6535HE
H8551.3/16	1.1/4	31.75	167.00	255.0	60.0	DIN6535HB
H85532.0	–	32.00	176.50	261.5	60.0	DIN6535HE
H85533.5	–	32.00	186.50	271.5	60.0	DIN6535HE
H85535.0	–	40.00	196.50	291.5	70.0	DIN6535HB
H85536.5	–	40.00	201.50	296.5	70.0	DIN6535HB
H85538.0	–	40.00	211.50	306.5	70.0	DIN6535HB
H85539.5	–	40.00	221.50	316.5	70.0	DIN6535HB
H85541.0	–	40.00	226.50	325.6	70.0	DIN6535HB
H85542.5	–	40.00	236.50	336.5	70.0	DIN6535HB

H858

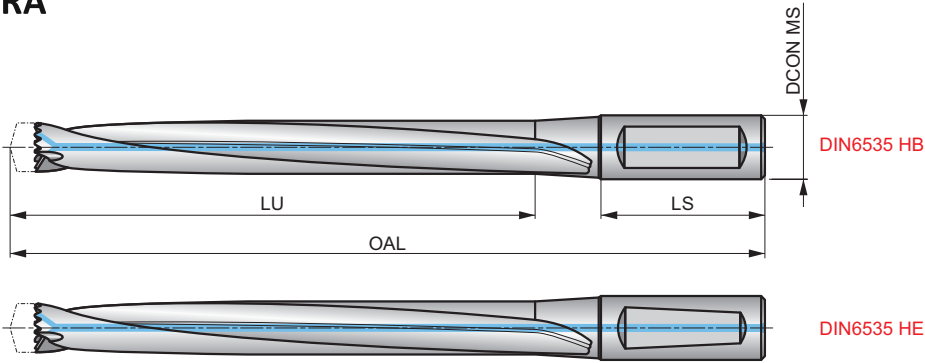
DORMER



HYDRA holder 8XD, med kølemiddeltilførsel, blank fornikling

Bruges med R950 og R960 HYDRA hoveder. En række hoveddiametre kan bruges med samme krop. Kølemiddelhuller på linje med hovederne giver effektiv køling. Blank forniklet overflade beskytter mod rust og korrosion og forbedrer spånevakuering.

HYDRA



HSS	 DORMER	8xD
Bright Ni	DIN 6535HB DIN 6535HE	
		

Fire (4) skruer og en (1) skruetrækker er inkluderet med et borholder, DCON MS tolerance h6.

Product	DCON MS	LU	OAL	LS	ADINTMS
	(mm)	(mm)	(mm)	(mm)	
H85814.0	16.00	124.50	191.5	48.0	DIN6535HE
H85815.0	20.00	133.50	201.5	50.0	DIN6535HE
H85816.0	20.00	141.50	211.5	50.0	DIN6535HE
H85817.0	20.00	150.50	221.5	50.0	DIN6535HE
H85818.0	20.00	158.50	226.5	50.0	DIN6535HE
H85819.0	25.00	167.50	251.5	56.0	DIN6535HE
H85820.0	25.00	175.50	264.5	56.0	DIN6535HE
H85821.0	25.00	184.50	266.5	56.0	DIN6535HE
H85822.0	25.00	192.10	271.1	56.0	DIN6535HE
H85823.0	25.00	200.50	280.5	56.0	DIN6535HE
H85824.0	32.00	208.20	295.2	60.0	DIN6535HE
H85825.0	32.00	217.00	300.0	60.0	DIN6535HE
H85826.0	32.00	225.00	310.0	60.0	DIN6535HE
H85827.0	32.00	234.00	320.0	60.0	DIN6535HE
H85828.0	32.00	242.00	325.0	60.0	DIN6535HE
H85829.0	32.00	251.00	335.0	60.0	DIN6535HE
H85830.0	32.00	259.00	345.0	60.0	DIN6535HE
H85832.0	32.00	271.50	356.5	60.0	DIN6535HE
H85833.5	32.00	286.50	371.5	60.0	DIN6535HE
H85835.0	40.00	301.50	396.5	70.0	DIN6535HB
H85836.5	40.00	311.50	406.5	70.0	DIN6535HB
H85838.0	40.00	326.50	421.5	70.0	DIN6535HB
H85839.5	40.00	336.50	431.5	70.0	DIN6535HB
H85841.0	40.00	351.50	451.5	70.0	DIN6535HB
H85842.5	40.00	361.50	461.5	70.0	DIN6535HB

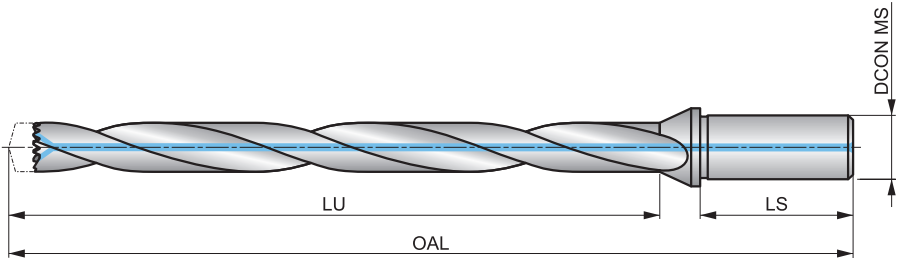
H8512



HYDRA holder 12XD, med kølemiddeltilførsel, blank fornikling

Bruges med R950 og R960 HYDRA hoveder. En række hoveddiametre kan bruges med samme krop. Kølemiddelhuller på linje med hovederne giver effektiv køling. Flangeskaft forhindrer boret i at vandre i holderen. Forniklet overflade beskytter mod rust og korrosion og forbedrer spånevakuering.

HYDRA



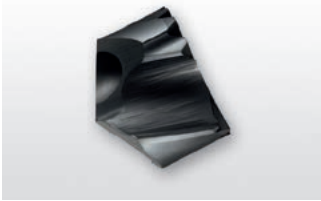
HSS		12×D
Bright Ni		
		

Fire (4) skruer og en (1) skruetrækker er inkluderet med et borholder, DCON MS tolerance h6.

Product	DCON MS	LU	OAL	LS
	(mm)	(mm)	(mm)	(mm)
H851214.0	16.00	168.00	236.0	48.0
H851215.0	20.00	180.00	250.3	50.0
H851216.0	20.00	192.00	262.6	50.0
H851217.0	20.00	204.00	275.0	50.0
H851218.0	20.00	216.00	287.2	50.0
H851219.0	25.00	228.00	305.6	56.0
H851220.0	25.00	240.00	317.8	56.0
H851221.0	25.00	252.00	330.1	56.0
H851222.0	25.00	264.00	343.0	56.0
H851223.0	25.00	276.00	354.8	56.0
H851224.0	32.00	288.00	371.7	60.0
H851225.0	32.00	300.00	383.8	60.0

R950

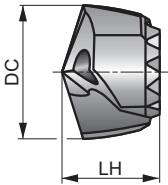
DORMER



HYDRA borehoved til stål, Ti-phon belagt

Meget omkostningseffektiv og nøjagtig udskiftelig hoved til høj ydeevne i stål og hårdere materialer. Et spidspunkt på 140 ° hjælper med selvcentrering og reducerer skærekrafter. Ti-phon-belægning forhindrer ophobning af kanter og forbedrer spånflowet i høj grad med overlegen slidstyrke og kantstyrke.

HYDRA



H851	Apply starting values for speed and feed with a correction factor of 1.10
H853	Apply starting values for speed and feed with a correction factor of 1.00
H855	Apply starting values for speed and feed with a correction factor of 0.80
H858	Apply starting values for speed and feed with a correction factor of 0.60
H8512	Apply starting values for speed and feed with a correction factor of 0.50

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1 ▣133 W	P1.2 ▣148 W	P1.3 ▣154 W	P2.1 ▣114 W	P2.2 ■100 W	P2.3 ■88 W	P3.1 ■125 W	P3.2 ■101 W	P3.3 ■85 W	P4.1 ■75 W	P4.2 ■63 W	P4.3 ■52 T	M2.3 ▣41 T	M4.2 ▣35 T
K2.1 ■108 V	K2.2 ■88 V	K2.3 ■70 V	K3.1 ■96 V	K3.2 ■73 V	K3.3 ■59 V	K4.1 ■89 V	K4.2 ■67 V	K4.3 ■49 V	K4.4 ■42 V	K4.5 ■35 V	K5.1 ■100 V	K5.2 ■76 V	K5.3 ■58 V

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R95015/32	15/32	11.91	0.4688	9.1
R95012.0	—	12.00	0.4724	9.1
R95012.1	—	12.10	0.4764	9.1
R95012.2	—	12.20	0.4803	9.1
R95031/64	31/64	12.30	0.4844	9.1
R95012.5	—	12.50	0.4921	9.4
R95012.6	—	12.60	0.4961	9.4
R9501/2	1/2	12.70	0.5000	9.4
R95012.8	—	12.80	0.5039	9.4
R95012.9	—	12.90	0.5079	9.4
R95013.0	—	13.00	0.5118	9.7
R95033/64	33/64	13.10	0.5156	9.7
R95013.2	—	13.20	0.5197	9.7
R95017/32	17/32	13.49	0.5313	9.7
R95013.5	—	13.50	0.5315	10.3
R95013.6	—	13.60	0.5354	10.3
R95013.7	—	13.70	0.5394	10.3
R95013.8	—	13.80	0.5433	10.3
R95035/64	35/64	13.89	0.5469	10.3
R95014.0	—	14.00	0.5512	10.3
R95014.1	—	14.10	0.5551	10.3
R95014.2	—	14.20	0.5591	10.3
R9509/16	9/16	14.29	0.5625	10.3
R95014.5	—	14.50	0.5709	10.3
R95014.6	—	14.60	0.5748	11.0
R95037/64	37/64	14.68	0.5781	11.0
R95014.7	—	14.70	0.5787	11.0
R95014.8	—	14.80	0.5827	11.0
R95015.0	—	15.00	0.5906	11.0
R95019/32	19/32	15.08	0.5938	11.0

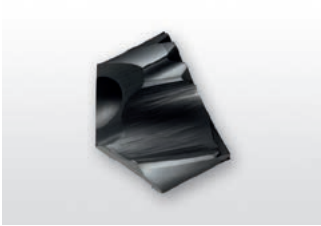
Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R95015.1	—	15.10	0.5945	11.0
R95015.2	—	15.20	0.5984	11.0
R95015.24	—	15.24	0.6000	11.0
R95039/64	39/64	15.48	0.6094	11.0
R95015.5	—	15.50	0.6102	11.0
R95015.6	—	15.60	0.6142	11.6
R95015.7	—	15.70	0.6181	11.6
R9505/8	5/8	15.88	0.6250	11.6
R95016.0	—	16.00	0.6299	11.6
R95016.08	—	16.08	0.6331	11.6
R95016.1	—	16.10	0.6339	11.6
R95016.2	—	16.20	0.6378	11.6
R95041/64	41/64	16.27	0.6406	11.6
R95016.3	—	16.30	0.6417	11.6
R95016.5	—	16.50	0.6496	11.6
R95016.6	—	16.60	0.6535	12.2
R95021/32	21/32	16.67	0.6563	12.2
R95016.7	—	16.70	0.6575	12.2
R95017.0	—	17.00	0.6693	12.2
R95043/64	43/64	17.07	0.6719	12.2
R95017.1	—	17.10	0.6732	12.2
R95017.2	—	17.20	0.6772	12.2
R95011/16	11/16	17.46	0.6875	12.2
R95017.5	—	17.50	0.6890	12.2
R95017.6	—	17.60	0.6929	12.9
R95017.7	—	17.70	0.6969	12.9
R95045/64	45/64	17.86	0.7031	12.9
R95018.0	—	18.00	0.7087	12.9
R95018.1	—	18.10	0.7126	12.9
R95018.2	—	18.20	0.7165	12.9

Product	DC	DC	DC	LH
	(inch)	(mm)	(inch)	(mm)
R95023/32	23/32	18.26	0.7188	12.9
R95018.5	—	18.50	0.7283	12.9
R95018.6	—	18.60	0.7323	13.5
R95047/64	47/64	18.65	0.7344	13.5
R95018.7	—	18.70	0.7362	13.5
R95018.9	—	18.90	0.7441	13.5
R95019.0	—	19.00	0.7480	13.5
R9503/4	3/4	19.05	0.7500	13.5
R95019.1	—	19.10	0.7520	13.5
R95019.2	—	19.20	0.7559	13.5
R95019.25	—	19.25	0.7579	13.5
R95019.3	—	19.30	0.7598	13.5
R95019.35	—	19.35	0.7618	13.5
R95049/64	49/64	19.45	0.7656	13.5
R95019.5	—	19.50	0.7677	13.5
R95019.6	—	19.60	0.7717	14.1
R95019.7	—	19.70	0.7756	14.1
R95025/32	25/32	19.84	0.7813	14.1
R95020.0	—	20.00	0.7874	14.1
R95051/64	51/64	20.24	0.7969	14.1
R95020.5	—	20.50	0.8071	14.1
R95013/16	13/16	20.64	0.8125	14.8
R95021.0	—	21.00	0.8268	14.8
R95053/64	53/64	21.03	0.8281	14.8
R95027/32	27/32	21.43	0.8438	14.8
R95021.5	—	21.50	0.8465	14.8
R95055/64	55/64	21.83	0.8594	15.0
R95022.0	—	22.00	0.8661	15.0
R9507/8	7/8	22.22	0.8750	15.0
R95022.5	—	22.50	0.8858	15.0
R95057/64	57/64	22.62	0.8906	15.0
R95022.7	—	22.70	0.8937	15.0
R95023.0	—	23.00	0.9055	15.1
R95029/32	29/32	23.02	0.9063	15.1
R95059/64	59/64	23.42	0.9219	15.1
R95023.5	—	23.50	0.9252	15.1
R95015/16	15/16	23.81	0.9375	15.4
R95024.0	—	24.00	0.9449	15.4
R95061/64	61/64	24.21	0.9531	15.4
R95024.5	—	24.50	0.9646	15.4
R95031/32	31/32	24.61	0.9688	15.4
R95025.0	—	25.00	0.9844	15.8
R95063/64	63/64	25.00	0.9844	15.8
R9501	1"	25.40	1.0000	15.8
R95025.5	—	25.50	1.0039	15.8
R95025.6	—	25.60	1.0079	15.8
R95025.65	—	25.65	1.0098	15.8
R9501.1/64	1.1/64	25.80	1.0156	15.8
R95026.0	—	26.00	1.0236	16.4
R9501.1/32	1.1/32	26.19	1.0313	16.4

Product	DC	DC	DC	LH
	(inch)	(mm)	(inch)	(mm)
R95026.5	—	26.50	1.0433	16.4
R9501.3/64	1.3/64	26.59	1.0469	16.4
R9501.1/16	1.1/16	26.99	1.0625	17.1
R95027.0	—	27.00	1.0630	17.1
R9501.5/64	1.5/64	27.38	1.0781	17.1
R95027.5	—	27.50	1.0827	17.1
R9501.3/32	1.3/32	27.78	1.0938	17.1
R95028.0	—	28.00	1.1024	17.7
R9501.7/64	1.7/64	28.18	1.1094	17.7
R95028.5	—	28.50	1.1220	17.7
R9501.1/8	1.1/8	28.58	1.1250	17.7
R9501.9/64	1.9/64	28.97	1.1406	18.3
R95029.0	—	29.00	1.1417	18.3
R9501.5/32	1.5/32	29.37	1.1563	18.3
R95029.5	—	29.50	1.1614	18.3
R9501.11/64	1.11/64	29.77	1.1719	18.3
R95030.0	—	30.00	1.1811	19.0
R9501.3/16	1.3/16	30.16	1.1875	19.0
R95030.5	—	30.50	1.2008	19.0
R9501.7/32	1.7/32	30.96	1.2188	21.0
R95031.0	—	31.00	1.2205	21.0
R9501.1/4	1.1/4	31.75	1.2500	21.0
R95032.0	—	32.00	1.2598	21.0
R95032.5	—	32.50	1.2795	21.0
R9501.19/64	1.19/64	32.94	1.2969	21.0
R95033.0	—	33.00	1.2992	21.0
R95033.5	—	33.50	1.3189	21.0
R95034.0	—	34.00	1.3386	23.0
R9501.11/32	1.11/32	34.13	1.3438	23.0
R95034.5	—	34.50	1.3583	23.0
R9501.3/8	1.3/8	34.93	1.3750	23.0
R95035.0	—	35.00	1.3780	23.0
R95036.0	—	36.00	1.4173	23.0
R9501.27/64	1.27/64	36.12	1.4219	23.0
R95036.5	—	36.50	1.4370	23.0
R95037.0	—	37.00	1.4567	25.0
R9501.15/32	1.15/32	37.31	1.4688	25.0
R95037.5	—	37.50	1.4764	25.0
R95038.0	—	38.00	1.4961	25.0
R9501.1/2	1.1/2	38.10	1.5000	25.0
R95038.5	—	38.50	1.5157	25.0
R9501.17/32	1.17/32	38.89	1.5313	25.0
R95039.0	—	39.00	1.5354	25.0
R95039.5	—	39.50	1.5551	25.0
R9501.9/16	1.9/16	39.69	1.5625	27.0
R95040.0	—	40.00	1.5748	27.0
R95041.0	—	41.00	1.6142	27.0
R9501.5/8	1.5/8	41.28	1.6250	27.0
R95042.0	—	42.00	1.6535	27.0

R960

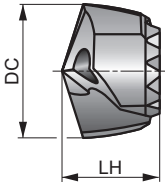
 DORMER



HYDRA borehoved til rustfri, Ti-phon belagt

Meget omkostningseffektiv og nøjagtig udskiftelig hoved til høj ydeevne i rustfrit stål. Et spidspunkt på 140 ° hjælper med selvcentrering og reducerer skærekrafter. Ti-phon-belægning forhindrer ophobning af kanter og forbedrer spånflowet i høj grad med overlegen slidstyrke og kantstyrke.

HYDRA



H851	Apply starting values for speed and feed with a correction factor of 1.10
H853	Apply starting values for speed and feed with a correction factor of 1.00
H855	Apply starting values for speed and feed with a correction factor of 0.80
H858	Apply starting values for speed and feed with a correction factor of 0.60
H8512	Apply starting values for speed and feed with a correction factor of 0.50

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2
■ 133 W	■ 148 W	■ 154 W	■ 114 W	■ 82 V	■ 70 V	■ 73 V	■ 60 V	▣ 50 T	■ 58 T	■ 50 T	■ 45 T	■ 40 T	▣ 34 T
K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5
■ 120 V	■ 89 V	■ 67 V	▣ 108 V	▣ 88 V	▣ 70 V	▣ 96 V	▣ 73 V	▣ 59 V	▣ 89 V	▣ 67 V	▣ 49 V	▣ 42 V	▣ 35 V
K5.1	K5.2	K5.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2		
▣ 100 V	▣ 76 V	▣ 58 V	▣ 45 T	▣ 35 T	▣ 30 S	▣ 40 S	▣ 35 S	▣ 30 S	▣ 25 S	▣ 23 S	▣ 20 S		

Product	DC	DC	DC	LH
	(inch)	(mm)	(inch)	(mm)
R96015/32	15/32	11.91	0.4688	9.1
R96012.0	—	12.00	0.4724	9.1
R96012.1	—	12.10	0.4764	9.1
R96012.2	—	12.20	0.4803	9.1
R96031/64	31/64	12.30	0.4844	9.1
R96012.5	—	12.50	0.4921	9.4
R96012.6	—	12.60	0.4961	9.4
R9601/2	1/2	12.70	0.5000	9.4
R96012.8	—	12.80	0.5039	9.4
R96012.9	—	12.90	0.5079	9.4
R96013.0	—	13.00	0.5118	9.7
R96033/64	33/64	13.10	0.5156	9.7
R96013.2	—	13.20	0.5197	9.7
R96017/32	17/32	13.49	0.5313	9.7
R96013.5	—	13.50	0.5315	10.3
R96013.6	—	13.60	0.5354	10.3
R96013.7	—	13.70	0.5394	10.3
R96013.8	—	13.80	0.5433	10.3
R96035/64	35/64	13.89	0.5469	10.3
R96014.0	—	14.00	0.5512	10.3
R96014.1	—	14.10	0.5551	10.3
R96014.2	—	14.20	0.5591	10.3
R9609/16	9/16	14.29	0.5625	10.3
R96014.5	—	14.50	0.5709	10.3
R96014.6	—	14.60	0.5748	11.0
R96037/64	37/64	14.68	0.5781	11.0
R96014.7	—	14.70	0.5787	11.0
R96014.8	—	14.80	0.5827	11.0

Product	DC	DC	DC	LH
	(inch)	(mm)	(inch)	(mm)
R96015.0	—	15.00	0.5906	11.0
R96019/32	19/32	15.08	0.5938	11.0
R96015.1	—	15.10	0.5945	11.0
R96015.2	—	15.20	0.5984	11.0
R96015.24	—	15.24	0.6000	11.0
R96039/64	39/64	15.48	0.6094	11.0
R96015.5	—	15.50	0.6102	11.0
R96015.6	—	15.60	0.6142	11.6
R96015.7	—	15.70	0.6181	11.6
R9605/8	5/8	15.88	0.6250	11.6
R96016.0	—	16.00	0.6299	11.6
R96016.08	—	16.08	0.6331	11.6
R96016.1	—	16.10	0.6339	11.6
R96016.2	—	16.20	0.6378	11.6
R96041/64	41/64	16.27	0.6406	11.6
R96016.3	—	16.30	0.6417	11.6
R96016.5	—	16.50	0.6496	11.6
R96016.6	—	16.60	0.6535	12.2
R96021/32	21/32	16.67	0.6563	12.2
R96016.7	—	16.70	0.6575	12.2
R96017.0	—	17.00	0.6693	12.2
R96043/64	43/64	17.07	0.6719	12.2
R96017.1	—	17.10	0.6732	12.2
R96017.2	—	17.20	0.6772	12.2
R96011/16	11/16	17.46	0.6875	12.2
R96017.5	—	17.50	0.6890	12.2
R96017.6	—	17.60	0.6929	12.9
R96017.7	—	17.70	0.6969	12.9

Product	DC	DC	DC	LH
	(inch)	(mm)	(inch)	(mm)
R96045/64	45/64	17.86	0.7031	12.9
R96018.0	—	18.00	0.7087	12.9
R96018.1	—	18.10	0.7126	12.9
R96018.2	—	18.20	0.7165	12.9
R96023/32	23/32	18.26	0.7188	12.9
R96018.5	—	18.50	0.7283	12.9
R96018.6	—	18.60	0.7323	13.5
R96047/64	47/64	18.65	0.7344	13.5
R96018.7	—	18.70	0.7362	13.5
R96018.9	—	18.90	0.7441	13.5
R96019.0	—	19.00	0.7480	13.5
R9603/4	3/4	19.05	0.7500	13.5
R96019.1	—	19.10	0.7520	13.5
R96019.2	—	19.20	0.7559	13.5
R96019.25	—	19.25	0.7579	13.5
R96019.3	—	19.30	0.7598	13.5
R96019.35	—	19.35	0.7618	13.5
R96049/64	49/64	19.45	0.7656	13.5
R96019.5	—	19.50	0.7677	13.5
R96019.6	—	19.60	0.7717	14.1
R96019.7	—	19.70	0.7756	14.1
R96025/32	25/32	19.84	0.7813	14.1
R96020.0	—	20.00	0.7874	14.1
R96051/64	51/64	20.24	0.7969	14.1
R96020.5	—	20.50	0.8071	14.1
R96013/16	13/16	20.64	0.8125	14.8
R96021.0	—	21.00	0.8268	14.8
R96053/64	53/64	21.03	0.8281	14.8
R96027/32	27/32	21.43	0.8438	14.8
R96021.5	—	21.50	0.8465	14.8
R96055/64	55/64	21.83	0.8594	15.0
R96022.0	—	22.00	0.8661	15.0
R9607/8	7/8	22.22	0.8750	15.0
R96022.5	—	22.50	0.8858	15.0
R96057/64	57/64	22.62	0.8906	15.0
R96022.7	—	22.70	0.8937	15.0

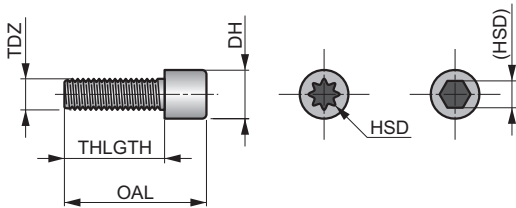
Product	DC	DC	DC	LH
	(inch)	(mm)	(inch)	(mm)
R96023.0	—	23.00	0.9055	15.1
R96029/32	29/32	23.02	0.9063	15.1
R96059/64	59/64	23.42	0.9219	15.1
R96023.5	—	23.50	0.9252	15.1
R96015/16	15/16	23.81	0.9375	15.4
R96024.0	—	24.00	0.9449	15.4
R96061/64	61/64	24.21	0.9531	15.4
R96024.5	—	24.50	0.9646	15.4
R96031/32	31/32	24.61	0.9688	15.4
R96025.0	—	25.00	0.9844	15.8
R96063/64	63/64	25.00	0.9844	15.8
R9601	1"	25.40	1.0000	15.8
R96025.5	—	25.50	1.0039	15.8
R96025.65	—	25.65	1.0098	15.8
R9601.1/64	1.1/64	25.80	1.0156	15.8
R96026.0	—	26.00	1.0236	16.4
R9601.1/32	1.1/32	26.19	1.0313	16.4
R96026.5	—	26.50	1.0433	16.4
R9601.3/64	1.3/64	26.59	1.0469	16.4
R9601.1/16	1.1/16	26.99	1.0625	17.1
R96027.0	—	27.00	1.0630	17.1
R9601.5/64	1.5/64	27.38	1.0781	17.1
R96027.5	—	27.50	1.0827	17.1
R9601.3/32	1.3/32	27.78	1.0938	17.1
R96028.0	—	28.00	1.1024	17.7
R9601.7/64	1.7/64	28.18	1.1094	17.7
R96028.5	—	28.50	1.1220	17.7
R9601.1/8	1.1/8	28.58	1.1250	17.7
R9601.9/64	1.9/64	28.97	1.1406	18.3
R96029.0	—	29.00	1.1417	18.3
R9601.5/32	1.5/32	29.37	1.1563	18.3
R96029.5	—	29.50	1.1614	18.3
R9601.11/64	1.11/64	29.77	1.1719	18.3
R96030.0	—	30.00	1.1811	19.0
R9601.3/16	1.3/16	30.16	1.1875	19.0
R96030.5	—	30.50	1.2008	19.0

H860



Hydra skrue
Udskiftningsskruer, der bruges til sikkert at holde HYDRA hoveder på plads.

HYDRA



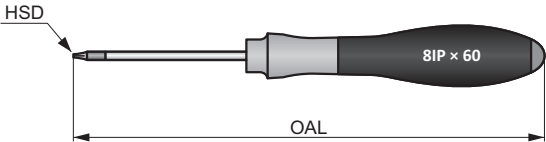
Product	Nr.	TDZ	OAL	THLGTH	DH	HSD
			(mm)	(mm)	(mm)	
H860N1	1	M2.2	7.5	5.70	3.5	8IP
H860N2	2	M2.5	9.0	7.00	4.1	10IP
H860N3	3	M3.0	10.5	8.00	4.9	15IP
H860N4	4	M3.5	11.5	8.80	5.5	15IP
H860N5	5	M4.0	12.5	9.50	6.0	20IP
H860N6	6	M4.5	14.3	10.80	6.8	25IP
H860N7	7	M5.0	20.0	15.00	8.5	4

H861



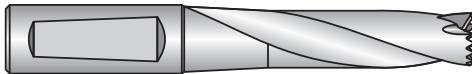
Hydra skrutrækker
Skrutetrækkere, der bruges til at stramme HYDRA-skruer.

HYDRA



Product	Nr.	HSD	OAL
			(mm)
H861N1	N1	8IP	164.0
H861N2	N2	10IP	191.0
H861N3	N3	15IP	191.0
H861N4	N4	20IP	218.0
H861N5	N5	25IP	218.0

HIGH PERFORMANCE REPLACEABLE HEAD DRILLS

SetUp									
	DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860
									
Range	12.00 – 30.50 15/32" – 1.3/16"	12.00 – 42.50 15/32" – 1.5/8"	12.00 – 42.50 15/32" – 1.5/8"	13.50 – 42.50 35/64" – 1.5/8"	13.50 – 25.65 35/64" – 1.1/64"	12.00 – 42.00 15/32" – 1.5/8"	12.00 – 30.50 15/32" – 1.3/16"	N1 – N7	N1 – N6
Pages	 218	 219	 221	 223	 224	 225	 227	 229	 229

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
15/32"	H85112.0 H85131/64	H85312.0 H85331/64	H85512.0 H85531/64	–	–	R95015/32	R96015/32	H860N1	H861N1
12.0						R95012.0	R96012.0		
12.1						R95012.1	R96012.1		
12.2						R95012.2	R96012.2		
31/64"	H85112.5 H85312.5 H8531/2	H85312.5 H8531/2	H85512.5 H8551/2	–	–	R95031/64	R96031/64		
12.5						R95012.5	R96012.5		
12.6						R95012.6	R96012.6		
1/2"						R9501/2	R9601/2		
12.8						R95012.8	R96012.8		
12.9						R95012.9	R96012.9		
13.0	H85113.0 H85117/32	H85313.0 H85317/32	H85513.0 H85517/32	–	–	R95013.0	R96013.0		
33/64"						R95033/64	R96033/64		
13.2						R95013.2	R96013.2		
17/32"						R95017/32	R96017/32		
13.5	H85114.0 H85314.0 H8539/16	H85314.0 H8539/16	H85514.0 H8559/16	H85814.0	H851214.0	R95013.5	R96013.5		
13.6						R95013.6	R96013.6		
13.7						R95013.7	R96013.7		
13.8						R95013.8	R96013.8		
35/64"						R95035/64	R96035/64		
14.0						R95014.0	R96014.0		
14.1						R95014.1	R96014.1		
14.2						R95014.2	R96014.2		
9/16"						R9509/16	R9609/16		
14.5						R95014.5	R96014.5		
14.6	H85115.0 H85139/64	H85315.0 H85339/64	H85515.0 H85539/64	H85815.0	H851215.0	R95014.6	R96014.6		
37/64"						R95037/64	R96037/64		
14.7						R95014.7	R96014.7		
14.8						R95014.8	R96014.8		
15.0						R95015.0	R96015.0		
19/32"						R95019/32	R96019/32		
15.1						R95015.1	R96015.1		
15.2						R95015.2	R96015.2		
15.24						R95015.24	R96015.24		
39/64"						R95039/64	R96039/64		
15.5						R95015.5	R96015.5		

HIGH PERFORMANCE REPLACEABLE HEAD DRILLS

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
15.6	H85116.0 H85141/64	H85316.0 H85341/64	H85516.0 H85541/64	H85816.0	H851216.0	R95015.6	R96015.6	H860N2	H861N2
15.7						R95015.7	R96015.7		
5/8"						R9505/8	R9605/8		
16.0						R95016.0	R96016.0		
16.08						R95016.08	R96016.08		
16.1						R95016.1	R96016.1		
16.2						R95016.2	R96016.2		
16.3						R95016.3	R96016.3		
41/64"						R95041/64	R96041/64		
16.5						R95016.5	R96016.5		
16.6	H85117.0 H85111/16	H85317.0 H85311/16	H85517.0 H85511/16	H85817.0	H851217.0	R95016.6	R96016.6		
21/32"						R95021/32	R96021/32		
16.7						R95016.7	R96016.7		
17.0						R95017.0	R96017.0		
43/64"						R95043/64	R96043/64		
17.1						R95017.1	R96017.1		
17.2						R95017.2	R96017.2		
11/16"						R95011/16	R96011/16		
17.5						R95017.5	R96017.5		
17.6						H85118.0 H85123/32	H85318.0 H85323/32		
17.7	R95017.7	R96017.7							
45/64"	R95045/64	R96045/64							
18.0	R95018.0	R96018.0							
18.1	R95018.1	R96018.1							
18.2	R95018.2	R96018.2							
23/32"	R95023/32	R96023/32							
18.5	R95018.5	R96018.5							
18.6	H85119.0 H85149/64	H85319.0 H85349/64	H85519.0 H85549/64	H85819.0	H851219.0	R95018.6	R96018.6		
47/64"						R95047/64	R96047/64		
18.7						R95018.7	R96018.7		
18.9						R95018.9	R96018.9		
19.0						R95019.0	R96019.0		
3/4"						R9503/4	R9603/4		
19.1						R95019.1	R96019.1		
19.2						R95019.2	R96019.2		
19.25						R95019.25	R96019.25		
19.3						R95019.3	R96019.3		
19.35						R95019.35	R96019.35		
49/64"						R95049/64	R96049/64		
19.5						R95019.5	R96019.5		
19.6	H85120.0 H85151/64	H85320.0 H85351/64	H85520.0 H85551/64	H85820.0	H851220.0	R95019.6	R96019.6		
19.7						R95019.7	R96019.7		
25/32"						R95025/32	R96025/32		
20.0						R95020.0	R96020.0		
51/64"						R95051/64	R96051/64		
20.5						R95020.5	R96020.5		
13/16"	H85121.0 H85127/32	H85321.0 H85327/32	H85521.0 H85527/32	H85821.0	H851221.0	R95013/16	R96013/16		
21.0						R95021.0	R96021.0		
53/64"						R95053/64	R96053/64		
27/32"						R95027/32	R96027/32		
21.5						R95021.5	R96021.5		
55/64"	H85122.0 H85157/64	H85322.0 H85357/64	H85522.0 H85557/64	H85822.0	H851222.0	R95055/64	R96055/64		
22.0						R95022.0	R96022.0		
7/8"						R9507/8	R9607/8		
22.5						R95022.5	R96022.5		
57/64"						R95057/64	R96057/64		
22.7						R95022.7	R96022.7		
23.0	H85123.0 H85159/64	H85323.0 H85359/64	H85523.0 H85559/64	H85823.0	H851223.0	R95023.0	R96023.0		
29/32"						R95029/32	R96029/32		
59/64"						R95059/64	R96059/64		
23.5						R95023.5	R96023.5		

HIGH PERFORMANCE REPLACEABLE HEAD DRILLS

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
15/16	H85124.0 H85131/32	H85324.0 H85331/32	H85524.0 H85531/32	H85824.0	H851224.0	R95015/16	R96015/16	H860N4	H861N3
24.0						R95024.0	R96024.0		
61/64						R95061/64	R96061/64		
24.5						R95024.5	R96024.5		
31/32"						R95031/32	R96031/32		
25.0	H85125.0 H8511.1/64	H85325.0 H8531.1/64	H85525.0 H8551.1/64	H85825.0	H851225.0	R95025.0	R96025.0	H860N5	H861N4
63/64"						R95063/64	R96063/64		
1"						R9501	R9601		
25.5						R95025.5	R96025.5		
25.6						R95025.6	—		
25.65						R95025.65	R96025.65		
1.1/64"						R9501.1/64	R9601.1/64		
26.0	H85126.0 H8511.3/64	H85326.0 H8531.3/64	H85526.0 H8551.3/64	H85826.0	—	R95026.0	R96026.0		
1.1/32"						R9501.1/32	R9601.1/32		
26.5						R95026.5	R96026.5		
1.3/64						R9501.3/64	R9601.3/64		
1.1/16"	H85127.0 H8511.3/32	H85327.0 H8531.3/32	H85527.0 H8551.3/32	H85827.0	—	R9501.1/16	R9601.1/16		
27.0						R95027.0	R96027.0		
1.5/64"						R9501.5/64	R9601.5/64		
27.5						R95027.5	R96027.5		
1.3/32"						R9501.3/32	R9601.3/32		
28.0	H85128.0	H85328.0 H8531.1/8	H85528.0 H8551.1/8	H85828.0	—	R95028.0	R96028.0	H860N6	H861N5
1.7/64"						R9501.7/64	R9601.7/64		
28.5						R95028.5	R96028.5		
1.1/8"						R9501.1/8	R9601.1/8		
1.9/64"	H85129.0	H85329.0 H8531.11/64	H85529.0 H8551.11/64	H85829.0	—	R9501.9/64	R9601.9/64		
29.0						R95029.0	R96029.0		
1.5/32"						R9501.5/32	R9601.5/32		
29.5						R95029.5	R96029.5		
1.11/64"						R9501.11/64	R9601.11/64		
30.0	H85130.0 H8511.3/16	H85330.0 H8531.3/16	H85530.0 H8551.3/16	H85830.0	—	R95030.0	R96030.0		
1.3/16"						R9501.3/16	R9601.3/16		
30.5						R95030.5	R96030.5		
1.7/32"	—	H85332.0	H85532.0	H85832.0	—	R9501.7/32	—		
31.0						R95031.0	—		
1.1/4"						R9501.1/4	—		
32.0						R95032.0	—		
32.5	—	H85333.5	H85533.5	H85833.5	—	R95032.5	—		
1.19/64"						R9501.19/64	—		
33.0						R95033.0	—		
33.5						R95033.5	—		
34.0	—	H85335.0	H85535.0	H85835.0	—	R95034.0	—	H860N7	H861N6
1.11/32"						R9501.11/32	—		
34.5						R95034.5	—		
1.3/8"						R9501.3/8	—		
35.0						R95035.0	—		
36.0	—	H85336.5	H85536.5	H85836.5	—	R95036.0	—		
1.27/64"						R9501.27/64	—		
36.5						R95036.5	—		
37.0	—	H85338.0	H85538.0	H85838.0	—	R95037.0	—		
1.15/32"						R9501.15/32	—		
37.5						R95037.5	—		
38.0						R95038.0	—		
1.1/2"	—	H85339.5	H85539.5	H85839.5	—	R9501.1/2	—		
38.5						R95038.5	—		
1.17/32"						R9501.17/32	—		
39.0						R95039.0	—		
39.5						R95039.5	—		
1.9/16"	—	H85341.0	H85541.0	H85841.0	—	R9501.9/16	—		
40.0						R95040.0	—		
41.0						R95041.0	—		

HIGH PERFORMANCE REPLACEABLE HEAD DRILLS

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
1.5/8"	–	H85342.5	H85542.5	H85842.5	–	R9501.5/8	–	H860N7	–
42.0						R95042.0	–		

Accessories

H860	H861	Hydra Head DC range			Wrench Size / Bit
		Metric (min. – max.)	Fractional (min. – max.)	Decimal (min. – max.)	
H860N1	H861N1	12.0 mm – 15.5 mm	15/32" – 39/64"	0.4688" – 0.6102"	8IP
H860N2	H861N2	15.6 mm – 18.5 mm	5/8" – 23/32"	0.6142" – 0.7283"	10IP
H860N3	H861N3	18.6 mm – 21.5 mm	47/64" – 27/32"	0.7323" – 0.8465"	15IP
H860N4	H861N3	22.0 mm – 24.5 mm	55/64" – 31/32"	0.8594" – 0.9688"	15IP
H860N5	H861N4	25.0 mm – 27.5 mm	63/64" – 1-3/32"	0.9843" – 1.0938"	20IP
H860N6	H861N5	28.0 mm – 33.5 mm	1-7/64" – 1-19/64"	1.1024" – 1.3189"	25IP
H860N7	–	34.0 mm – 42.0 mm	1-11/32" – 1-5/8"	1.3386" – 1.6535"	4 mm Hex

Materiale kode (BMC)	HSS	HSS	HSS	HSS								
Brugbar længde (ULDR)	2×D	3×D	4×D	5×D								
Belægning	Bright Ni	Bright Ni	Bright Ni	Bright Ni								
Skaft	ISO 9766	ISO 9766	ISO 9766	ISO 9766								
Hånd (skæreretning)	R	R	R	R								
Køling (CSP)												
Bortolerance	± 0.05	± 0.05	± 0.05	± 0.05								
Hultolerance *	0/+0.2	0/+0.3	0/+0.4	0/+0.5								
Overfladefinish *	2 – 6 µm	2 – 6 µm	2 – 6 µm	2 – 6 µm								
Produktfamiliekode	        											
	802D	803D	804D	805D	XPET..AP	SCET..-UD	XPET..AP-SD	SCET..-SD	EP			
	15.0 – 40.0	15.0 – 58.0	17.0 – 58.0	19.0 – 31.0								
	 236	 238	 241	 243	 246	 245	 246	 245	 247			
P	P1				■	■	■	■				
	P2				■	■	■	■				
	P3				■	■	■	■				
	P4				■	■	■	■				
M	M1						■	■				
	M2						■	■				
	M3						■	■				
	M4						■	■				
K	K1				■	■	■	■				
	K2				■	■	■	■				
	K3				■	■	■	■				
	K4				■	■	■	■				
	K5				■	■	■	■				
N	N1											
	N2											
	N3											
	N4											
	N5											
S	S1						■	■				
	S2						■	■				
	S3						■	■				
	S4						■	■				
H	H1											
	H2											

* Tolerancen for boret hul og overfladefinish afhænger i vidt omfang af maskinbearbejdningsforholdene

802D



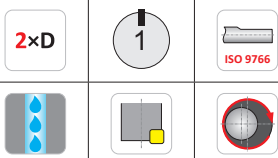
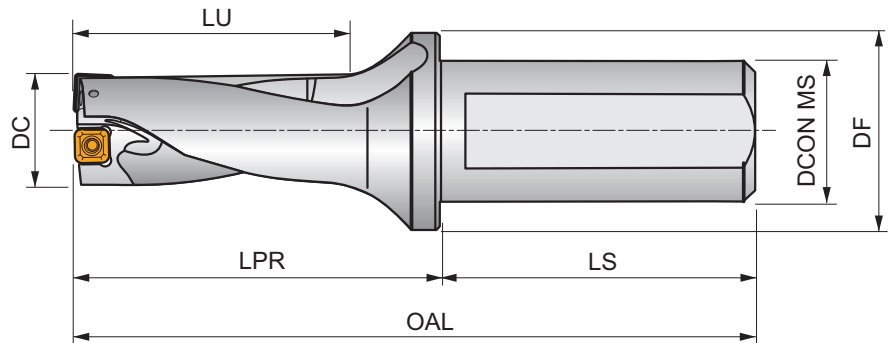
PRAMET

S



2xD 802D korthuls bor med indvendig kølevæskeindføring

Højtydende korthulsbor til boring af bund og gennemgående huller. Potentielt kryds hul, boring uden for midten, spiralformet interpolering, dybde, boring på konkave eller vinklede overflader, boring med afbrudte snit, affasning og boring.



Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF	$\bar{D}$	D^+				kg	
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)					
802D-15-30-S25	15	30.00	121	65	56	34.5	25	35	0.25	0.35	EP253253	GI300	GI313	0.32	HM001
802D-16-32-S25	16	32.00	123	67	56	37	25	35	0.15	0.45	EP253253	GI300	GI313	0.32	HM001
802D-17-34-S25	17	34.00	125	69	56	39.5	25	35	0.10	0.50	EP253253	GI300	GI313	0.31	HM001
802D-18-36-S25	18	36.00	127	71	56	42	25	35	0.35	0.25	EP253253	GI301	GI314	0.31	HM002
802D-19-38-S25	19	38.00	129	73	56	44.5	25	35	0.15	0.45	EP253253	GI301	GI314	0.32	HM002
802D-20-40-S25	20	40.00	131	75	56	47	25	35	0.10	0.45	EP253253	GI302	GI315	0.35	HM003
802D-21-42-S25	21	42.00	133	77	56	49.5	25	35	0.10	0.50	EP253253	GI302	GI315	0.34	HM003
802D-22-44-S25	22	44.00	135	79	56	52	25	35	0.45	0.50	EP253253	GI303	GI316	0.35	HM004
802D-23-46-S25	23	46.00	137	81	56	54.5	25	35	0.35	0.50	EP253253	GI304	GI317	0.36	HM005
802D-24-48-S25	24	48.00	139	83	56	57	25	35	0.15	0.50	EP253253	GI304	GI317	0.37	HM005
802D-25-50-S32	25	50.00	145	85	60	57	32	42	0.15	0.50	EP324058	GI304	GI317	0.57	HM005
802D-26-52-S32	26	52.00	147	87	60	59.5	32	42	0.10	0.50	EP324058	GI304	GI317	0.58	HM005
802D-27-54-S32	27	54.00	149	89	60	62	32	42	0.50	0.30	EP324058	GI305	GI318	0.59	HM006
802D-28-56-S32	28	56.00	151	91	60	64.5	32	42	0.30	0.50	EP324058	GI306	GI319	0.61	HM007
802D-29-58-S32	29	58.00	153	93	60	67	32	42	0.20	0.50	EP324058	GI306	GI319	0.62	HM007
802D-30-60-S32	30	60.00	155	95	60	69.5	32	42	0.15	0.50	EP324058	GI306	GI319	0.67	HM007
802D-32-64-S32	32	64.00	159	99	60	70	32	42	0.50	0.35	EP324058	GI307	GI320	0.68	HM008
802D-32-64-S40	32	64.00	167	99	68	70	40	50	0.50	0.35	—	GI307	GI320	1.03	HM008
802D-34-68-S32	34	68.00	163	103	60	75	32	42	0.25	0.50	EP324058	GI307	GI320	0.73	HM008
802D-34-68-S40	34	68.00	171	103	68	75	40	50	0.25	0.50	—	GI307	GI320	1.07	HM008
802D-36-72-S32	36	72.00	167	107	60	80	32	42	0.10	0.50	EP324058	GI308	GI321	0.76	HM009
802D-36-72-S40	36	72.00	173	105	68	77.5	40	50	0.10	0.50	—	GI308	GI321	1.11	HM009
802D-38-76-S32	38	76.00	171	111	60	85	32	42	0.50	0.50	EP324058	GI308	GI321	0.83	HM009
802D-38-76-S40	38	76.00	179	111	68	85	40	50	0.50	0.50	—	GI308	GI321	1.17	HM009
802D-40-80-S32	40	80.00	175	115	60	90	32	42	0.20	0.50	EP324058	GI309	GI322	0.94	HM009
802D-40-80-S40	40	80.00	183	115	68	90	40	50	0.20	0.50	—	GI309	GI322	1.25	HM009

		
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD
GI320	XPET 11T3AP-SD	SCET 09T308-SD
GI321	XPET 11T3AP-SD	SCET 120408-SD
GI322	XPET 12T3AP-SD	SCET 120408-SD

					
HM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
HM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
HM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P

803D



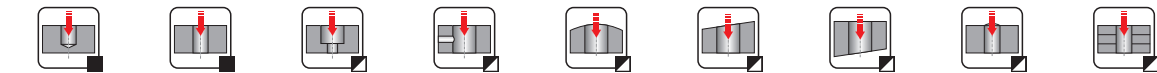
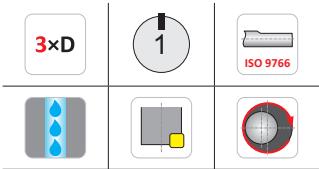
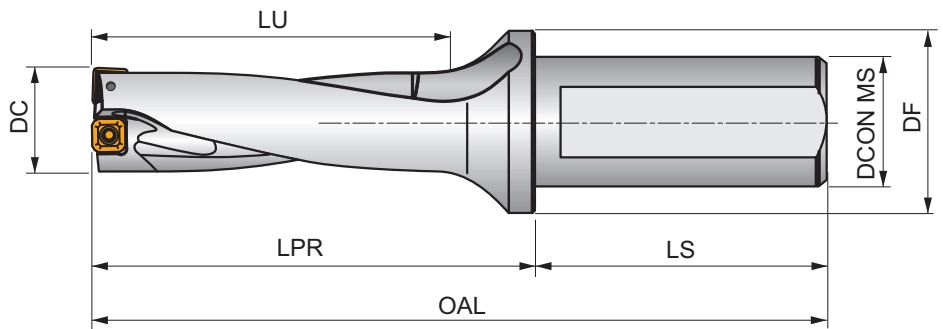
PRAMET

S



3xD 803D korthuls bor med indvendig kølevæskeindføring

Højtydende korthulsbor til boring af bund og gennemgående huller. Potentielt kryds hul, boring uden for midten, spiralformet interpolering, dybde, boring på konkave eller vinklede overflader, boring med afbrudte snit, affasning og boring.



Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF	$\bar{D}$	D^+					
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)					
803D-15-45-S25	15	45.00	136	80	56	49.5	25	35	0.25	0.35	EP253253	GI300	GI313	0.33	HM001
803D-15,5-46,5-S25	15.5	47.00	137.5	81.5	56	51.2	25	35	0.30	0.35	EP253253	GI300	GI313	0.31	HM001
803D-16-48-S25	16	48.00	139	83	56	53	25	35	0.15	0.45	EP253253	GI300	GI313	0.32	HM001
803D-16,5-49,5-S25	16.5	50.00	140.5	84.5	56	54.7	25	35	0.15	0.40	EP253253	GI300	GI313	0.32	HM001
803D-17-51-S25	17	51.00	142	86	56	56.5	25	35	0.10	0.50	EP253253	GI300	GI313	0.35	HM001
803D-17,5-52,5-S25	17.5	53.00	143.5	87.5	56	58.2	25	35	0.50	0.50	EP253253	GI301	GI314	0.32	HM002
803D-18-54-S25	18	54.00	145	89	56	60	25	35	0.35	0.25	EP253253	GI301	GI314	0.33	HM002
803D-18,5-55,5-S25	18.5	56.00	146.5	90.5	56	61.2	25	35	0.35	0.25	EP253253	GI301	GI314	0.34	HM002
803D-19-57-S25	19	57.00	148	92	56	63.5	25	35	0.15	0.45	EP253253	GI301	GI314	0.34	HM002
803D-19,5-58,5-S25	19.5	59.00	149.5	93.5	56	63.7	25	35	0.25	0.40	EP253253	GI302	GI315	0.34	HM003
803D-20-60-S25	20	60.00	151	95	56	67	25	35	0.10	0.45	EP253253	GI302	GI315	0.33	HM003
803D-20,5-61,5-S25	20.5	62.00	152.5	96.5	56	67.2	25	35	0.10	0.50	EP253253	GI302	GI315	0.36	HM003
803D-21-63-S25	21	63.00	154	98	56	70.5	25	35	0.10	0.50	EP253253	GI302	GI315	0.36	HM003
803D-21,5-64,5-S25	21.5	65.00	155.5	99.5	56	70.8	25	35	0.35	0.50	EP253253	GI303	GI316	0.37	HM004
803D-22-66-S25	22	66.00	157	101	56	74	25	35	0.45	0.50	EP253253	GI303	GI316	0.40	HM004
803D-22,5-67,5-S25	22.5	68.00	158.5	102.5	56	74.3	25	35	0.35	0.50	EP253253	GI304	GI317	0.42	HM005
803D-23-69-S25	23	69.00	160	104	56	77.5	25	35	0.35	0.50	EP253253	GI304	GI317	0.40	HM005
803D-23,5-70,5-S25	23.5	71.00	161.5	105.5	56	77.6	25	35	0.10	0.50	EP253253	GI304	GI317	0.40	HM005
803D-24-72-S25	24	72.00	163	107	56	81	25	35	0.15	0.50	EP253253	GI304	GI317	0.41	HM005
803D-24,5-73,5-S25	24.5	74.00	168.5	108.5	60	78.7	25	35	0.10	0.50	EP253253	GI304	GI317	0.45	HM005
803D-25-75-S32	25	75.00	170	110	60	82	32	42	0.15	0.50	EP324058	GI304	GI317	0.62	HM005
803D-25,5-76,5-S32	25.5	77.00	171.5	111.5	60	82.2	32	42	0.50	0.10	EP324058	GI304	GI317	0.63	HM005
803D-26-78-S32	26	78.00	173	113	60	85.5	32	42	0.10	0.50	EP324058	GI304	GI317	0.66	HM005
803D-26,5-79,5-S32	26.5	80.00	174.5	114.5	60	85.7	32	42	0.50	0.10	EP324058	GI305	GI318	0.67	HM006
803D-27-81-S32	27	81.00	176	116	60	89	32	42	0.50	0.30	EP324058	GI305	GI318	0.65	HM006
803D-28-84-S32	28	84.00	179	119	60	92.5	32	42	0.30	0.50	EP324058	GI306	GI319	0.68	HM007
803D-29-87-S32	29	87.00	182	122	60	96	32	42	0.20	0.50	EP324058	GI306	GI319	0.70	HM007

Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)					
803D-30-90-S32	30	90.00	185	125	60	99.5	32	42	0.15	0.50	EP324058	GI306	GI319	0.73	HM007
803D-31-93-S32	31	93.00	188	128	60	103	32	42	0.15	0.50	EP324058	GI306	GI319	0.76	HM007
803D-32-96-S32	32	96.00	191	131	60	102	32	42	0.50	0.30	EP324058	GI307	GI320	0.79	HM008
803D-32-96-S40	32	96.00	199	131	68	102	40	50	0.50	0.30	—	GI307	GI320	1.14	HM008
803D-33-99-S32	33	99.00	194	134	60	105.5	32	42	0.50	0.50	EP324058	GI307	GI320	0.83	HM008
803D-33-99-S40	33	99.00	202	134	68	105.5	40	50	0.50	0.50	—	GI307	GI320	1.18	HM008
803D-34-102-S32	34	102.00	197	137	60	109	32	42	0.25	0.50	EP324058	GI307	GI320	0.86	HM008
803D-34-102-S40	34	102.00	205	137	68	109	40	50	0.25	0.50	—	GI307	GI320	1.12	HM008
803D-35-105-S32	35	105.00	200	140	60	112.5	32	42	0.25	0.50	EP324058	GI308	GI321	0.90	HM009
803D-35-105-S40	35	105.00	208	140	68	112.5	40	50	0.25	0.50	—	GI308	GI321	1.24	HM009
803D-36-108-S32	36	108.00	203	143	60	116	32	42	0.10	0.50	EP324058	GI308	GI321	0.91	HM009
803D-36-108-S40	36	108.00	211	143	68	116	40	50	0.10	0.50	—	GI308	GI321	1.25	HM009
803D-37-111-S32	37	111.00	206	146	60	119.5	32	42	0.10	0.50	EP324058	GI308	GI321	0.95	HM009
803D-37-111-S40	37	111.00	214	146	68	119.5	40	50	0.10	0.50	—	GI308	GI321	1.29	HM009
803D-38-114-S32	38	114.00	199	139	60	124.5	32	42	0.50	0.50	EP324058	GI308	GI321	1.00	HM009
803D-38-114-S40	38	114.00	217	149	68	123	40	50	0.50	0.50	—	GI308	GI321	1.34	HM009
803D-39-117-S32	38	114.00	209	149	60	123	32	42	0.40	0.50	EP324058	GI309	GI322	1.06	HM009
803D-39-117-S40	39	117.00	220	152	68	126.5	40	50	0.40	0.50	—	GI309	GI322	1.40	HM009
803D-40-120-S32	40	120.00	215	155	60	130	32	42	0.20	0.50	EP324058	GI309	GI322	1.12	HM009
803D-40-120-S40	40	120.00	223	155	68	130	40	50	0.20	0.50	—	GI309	GI322	1.46	HM009
803D-41-123-S40	41	123.00	219	149	70	133	40	50	0.20	0.50	—	GI309	GI322	1.48	HM009
803D-42-126-S40	42	126.00	221.5	152	70	136	40	50	0.15	0.50	—	GI309	GI322	1.52	HM009
803D-43-129-S40	43	129.00	224	154	70	139	40	50	0.10	0.50	—	GI309	GI322	1.58	HM009
803D-44-132-S40	44	132.00	226.5	157	70	142	40	50	0.50	0.50	—	GI310	GI323	1.63	HM010
803D-45-135-S40	45	135.00	230.5	161	70	144	40	55	0.50	0.50	—	GI311	GI324	1.73	HM010
803D-46-138-S40	46	138.00	235	165	70	148	40	55	0.50	0.50	—	GI311	GI324	1.82	HM010
803D-47-141-S40	47	141.00	237.5	168	70	151	40	55	0.50	0.50	—	GI311	GI324	1.90	HM010
803D-48-144-S40	48	144.00	240	170	70	154	40	55	0.50	0.50	—	GI311	GI324	1.98	HM010
803D-49-147-S40	49	147.00	242.5	173	70	157	40	55	0.30	0.50	—	GI311	GI324	2.06	HM010
803D-50-150-S40	50	150.00	246.5	177	70	160	40	58	0.15	0.50	—	GI311	GI324	2.18	HM010
803D-51-153-S40	51	153.00	249	179	70	163	40	58	0.15	0.50	—	GI311	GI324	2.24	HM010
803D-52-156-S40	52	156.00	251.5	182	70	166	40	58	0.50	0.50	—	GI312	GI325	2.20	HM010
803D-53-159-S40	53	159.00	254	184	70	169	40	58	0.50	0.50	—	GI312	GI325	2.29	HM010
803D-54-162-S40	54	162.00	257.5	188	70	173	40	58	0.50	0.50	—	GI312	GI325	2.39	HM010
803D-55-165-S40	55	165.00	260	190	70	176	40	58	0.50	0.50	—	GI312	GI325	2.46	HM010
803D-56-168-S40	56	168.00	264	194	70	179	40	58	0.50	0.50	—	GI312	GI325	2.59	HM010
803D-57-171-S40	57	171.00	266.5	197	70	182	40	58	0.35	0.50	—	GI312	GI325	2.70	HM010
803D-58-174-S40	58	174.00	270	200	70	186	40	58	0.15	0.50	—	GI312	GI325	2.83	HM010

  		
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI310	XPET 1504AP	SCET 120408-UD
GI311	XPET 1504AP	SCET 150512-UD
GI312	XPET 1904AP	SCET 150512-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD

		
GI320	XPET 11T3AP-SD	SCET 09T308-SD
GI321	XPET 11T3AP-SD	SCET 120408-SD
GI322	XPET 12T3AP-SD	SCET 120408-SD
GI323	XPET 1504AP-SD	SCET 120408-SD
GI324	XPET 1504AP-SD	SCET 150512-SD
GI325	XPET 1904AP-SD	SCET 150512-SD

					
HM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
HM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
HM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
HM010	US 4011-T15P	3.5	US 5012-T15P	5.0	FLAG T15P

804D



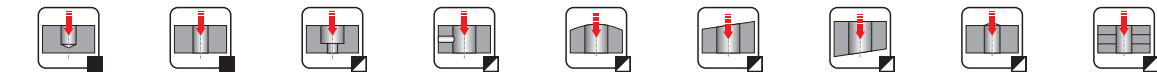
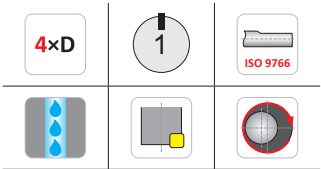
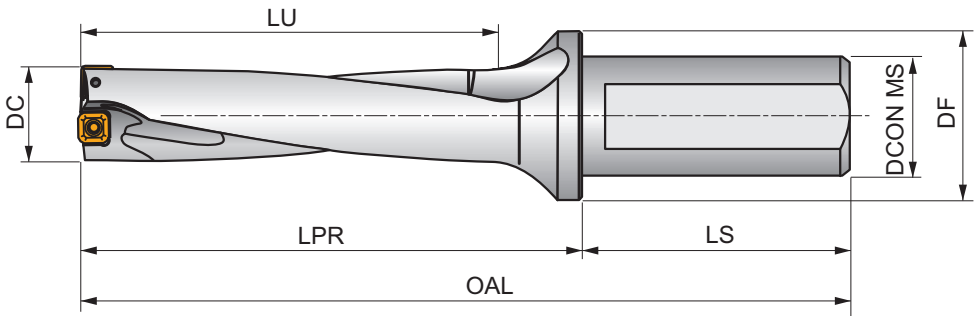
PRAMET

S



4xD 804D korthuls bor med indvendig kølevæskeindføring

Højtydende korthulsbor til boring af bund og gennemgående huller. Potentielt kryds hul, boring uden for midten, spiralformet interpolering, dybde, boring på konkave eller vinklede overflader, boring med afbrudte snit, affasning og boring.



Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF	$\overrightarrow{D^-}$	$\overrightarrow{D^+}$				kg	
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)					
804D-17-68-S25	17	68.00	149	93	56	73	25	35	0.10	0.50	–	GI300	GI313	0.34	HM001
804D-18-72-S25	18	72.00	153	97	56	77	25	35	0.35	0.25	–	GI301	GI314	0.35	HM002
804D-19-76-S25	19	76.00	157	101	56	81.5	25	35	0.15	0.45	–	GI301	GI314	0.36	HM002
804D-20-80-S25	20	80.00	161	105	56	85	25	35	0.10	0.45	–	GI302	GI315	0.37	HM003
804D-21-84-S25	21	84.00	165	109	56	89.5	25	35	0.10	0.50	–	GI302	GI315	0.43	HM003
804D-22-88-S25	22	88.00	169	113	56	94	25	35	0.45	0.50	–	GI303	GI316	0.45	HM004
804D-23-92-S25	23	92.00	173	117	56	98.5	25	35	0.35	0.50	–	GI304	GI317	0.44	HM005
804D-24-96-S25	24	96.00	177	121	56	103	25	35	0.15	0.50	–	GI304	GI317	0.45	HM005
804D-25-100-S32	25	100.00	185	125	60	105	32	42	0.15	0.50	–	GI304	GI317	0.67	HM005
804D-26-104-S32	26	104.00	189	129	60	109.5	32	42	0.10	0.50	–	GI304	GI317	0.70	HM005
804D-27-108-S32	27	108.00	193	133	60	114	32	42	0.50	0.30	–	GI305	GI318	0.71	HM006
804D-28-112-S32	28	112.00	197	137	60	118.5	32	42	0.30	0.50	–	GI306	GI319	0.75	HM007
804D-29-116-S32	29	116.00	201	141	60	123	32	42	0.20	0.50	–	GI306	GI319	0.78	HM007
804D-30-120-S32	30	120.00	205	145	60	127.5	32	42	0.15	0.50	–	GI306	GI319	0.82	HM007
804D-31-124-S32	31	124.00	209	149	60	132	32	42	0.15	0.50	–	GI306	GI319	0.85	HM007
804D-32-128-S32	32	128.00	213	153	60	136.5	32	42	0.50	0.30	–	GI307	GI320	0.90	HM008
804D-33-132-S32	33	132.00	217	157	60	141	32	42	0.50	0.50	–	GI307	GI320	0.95	HM008
804D-34-136-S32	34	136.00	221	161	60	145.5	32	42	0.25	0.50	–	GI307	GI320	0.99	HM008
804D-35-140-S32	35	140.00	225	165	60	149	32	42	0.25	0.50	–	GI308	GI321	1.04	HM009
804D-36-144-S32	36	144.00	229	169	60	153.5	32	42	0.10	0.50	–	GI308	GI321	1.05	HM009
804D-37-148-S32	37	148.00	233	173	60	158	32	42	0.10	0.50	–	GI308	GI321	1.11	HM009
804D-38-152-S32	38	152.00	237	177	60	162.5	32	42	0.50	0.50	–	GI308	GI321	1.18	HM009
804D-39-156-S32	39	156.00	241	181	60	167	32	42	0.40	0.50	–	GI309	GI322	1.25	HM009
804D-40-160-S32	40	160.00	245	185	60	171.5	32	42	0.20	0.50	–	GI309	GI322	1.33	HM009
804D-41-164-S40	41	164.00	259	189	70	172	40	50	0.20	0.50	–	GI309	GI322	1.68	HM009
804D-42-168-S40	42	168.00	263	193	70	176.5	40	50	0.15	0.50	–	GI309	GI322	1.76	HM009
804D-43-172-S40	43	172.00	267	197	70	181	40	50	0.10	0.50	–	GI309	GI322	1.83	HM009

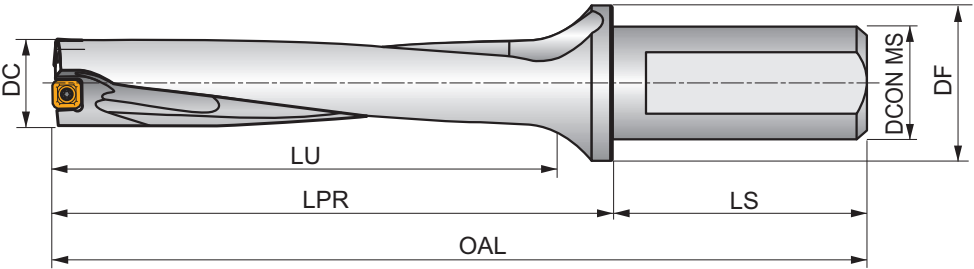
Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				kg	
804D-44-176-S40	44	176.00	271	201	70	185.5	40	50	0.50	0.50	–	GI310	GI323	1.91	HM010
804D-45-180-S40	45	180.00	275	205	70	187.5	40	55	0.50	0.50	–	GI311	GI324	2.02	HM010
804D-46-184-S40	46	184.00	279	209	70	192	40	55	0.50	0.50	–	GI311	GI324	2.12	HM010
804D-47-188-S40	47	188.00	283	213	70	196.5	40	55	0.50	0.50	–	GI311	GI324	2.22	HM010
804D-48-192-S40	48	192.00	287	217	70	201	40	55	0.50	0.50	–	GI311	GI324	2.33	HM010
804D-49-196-S40	49	196.00	291	221	70	205.5	40	55	0.30	0.50	–	GI311	GI324	2.45	HM010
804D-50-200-S40	50	200.00	295	225	70	208.5	40	58	0.15	0.50	–	GI311	GI324	2.58	HM010
804D-51-204-S40	51	204.00	299	229	70	213	40	58	0.15	0.50	–	GI311	GI324	2.68	HM010
804D-52-208-S40	52	208.00	303	233	70	217.5	40	58	0.50	0.50	–	GI312	GI325	2.64	HM010
804D-53-212-S40	53	212.00	307	237	70	222	40	58	0.50	0.50	–	GI312	GI325	2.76	HM010
804D-54-216-S40	54	216.00	311	241	70	226.5	40	58	0.50	0.50	–	GI312	GI325	2.90	HM010
804D-55-220-S40	55	220.00	315	245	70	231	40	58	0.50	0.50	–	GI312	GI325	3.00	HM010
804D-56-224-S40	56	224.00	319	249	70	235.5	40	58	0.50	0.50	–	GI312	GI325	3.15	HM010
804D-57-228-S40	57	228.00	323	253	70	240	40	58	0.35	0.50	–	GI312	GI325	3.30	HM010
804D-58-232-S40	58	232.00	327	257	70	244.5	40	58	0.15	0.50	–	GI312	GI325	3.46	HM010

		
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI310	XPET 1504AP	SCET 120408-UD
GI311	XPET 1504AP	SCET 150512-UD
GI312	XPET 1904AP	SCET 150512-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD
GI320	XPET 11T3AP-SD	SCET 09T308-SD
GI321	XPET 11T3AP-SD	SCET 120408-SD
GI322	XPET 12T3AP-SD	SCET 120408-SD
GI323	XPET 1504AP-SD	SCET 120408-SD
GI324	XPET 1504AP-SD	SCET 150512-SD
GI325	XPET 1904AP-SD	SCET 150512-SD

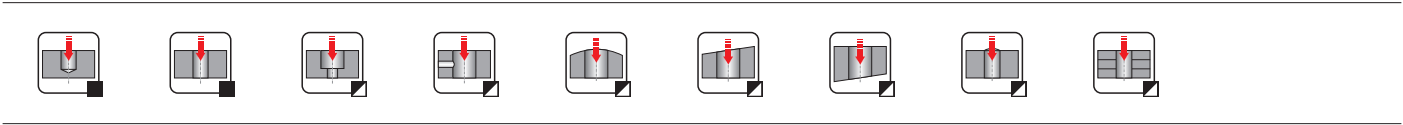
					
HM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
HM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
HM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
HM010	US 4011-T15P	3.5	US 5012-T15P	5.0	FLAG T15P



5xD 805D korthuls bor med indvendig kølevæskeindføring
Højtydende korthulsbor til boring af bund og gennemgående huller. Potentielt kryds hul, boring uden for midten, spiralformet interpolering, dybde, boring på konkave eller vinklede overflader, boring med afbrudte snit, affasning og boring.



5xD



Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)				kg	
805D-19-95-S25	19	95.00	176	120	56	100.5	25	35	0.15	0.45	–	GI301	GI314	0.38	HM002
805D-20-100-S25	20	100.00	181	125	56	105	25	35	0.10	0.45	–	GI302	GI315	0.40	HM003
805D-21-105-S25	21	105.00	186	130	56	110.5	25	35	0.10	0.50	–	GI302	GI315	0.42	HM003
805D-22-110-S25	22	110.00	191	135	56	116	25	35	0.45	0.50	–	GI303	GI316	0.45	HM004
805D-23-115-S25	23	115.00	196	140	56	121.5	25	35	0.35	0.50	–	GI304	GI317	0.48	HM005
805D-24-120-S25	24	120.00	201	145	56	127	25	35	0.15	0.50	–	GI304	GI317	0.49	HM005
805D-25-125-S32	25	125.00	210	150	60	130	32	42	0.15	0.50	–	GI304	GI317	0.72	HM005
805D-26-130-S32	26	130.00	215	155	60	135.5	32	42	0.10	0.50	–	GI304	GI317	0.82	HM005
805D-27-135-S32	27	135.00	220	160	60	141	32	42	0.50	0.30	–	GI305	GI318	0.78	HM006
805D-28-140-S32	28	140.00	225	165	60	146.5	32	42	0.30	0.50	–	GI306	GI319	0.82	HM007
805D-29-145-S32	29	145.00	230	170	60	152	32	42	0.20	0.50	–	GI306	GI319	0.86	HM007
805D-30-150-S32	30	150.00	235	175	60	157.5	32	42	0.15	0.50	–	GI306	GI319	0.90	HM007
805D-31-155-S32	31	155.00	240	180	60	163	32	42	0.15	0.50	–	GI306	GI319	0.95	HM007

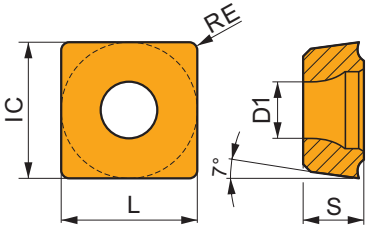
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GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD

		 Nm		 Nm	
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P

SCET

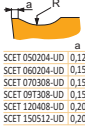
PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0502	5.556	2.40	5.56	2.38
0602	6.350	2.90	6.35	2.38
0703	7.937	3.50	7.94	3.18
09T3	9.525	4.50	9.53	3.97
1204	12.700	5.60	12.70	4.76
1505	15.875	5.60	15.88	5.56



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	Interrupted/ Continuous cut	RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)

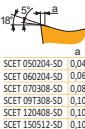


SCET 050204-UD 0,12
SCET 060204-UD 0,15
SCET 070308-UD 0,15
SCET 09T308-UD 0,15
SCET 120408-UD 0,20
SCET 150512-UD 0,20



UD-geometri med universelt design til periferiskær.

SCET 050204-UD:D8330	●	0.4	165	0.08	—	—	—	—	155	0.08	—	—	—	—	—	—	—	—	—	—
SCET 050204-UD:D9335	●	0.4	240	0.08	—	—	—	—	225	0.08	—	—	—	—	—	—	—	—	—	—
SCET 060204-UD:D8330	●	0.4	165	0.11	—	—	—	—	155	0.11	—	—	—	—	—	—	—	—	—	—
SCET 060204-UD:D9335	●	0.4	240	0.11	—	—	—	—	225	0.11	—	—	—	—	—	—	—	—	—	—
SCET 070308-UD:D8330	●	0.8	165	0.13	—	—	—	—	155	0.13	—	—	—	—	—	—	—	—	—	—
SCET 070308-UD:D9335	●	0.8	240	0.13	—	—	—	—	225	0.13	—	—	—	—	—	—	—	—	—	—
SCET 09T308-UD:D8330	●	0.8	165	0.14	—	—	—	—	155	0.14	—	—	—	—	—	—	—	—	—	—
SCET 09T308-UD:D9335	●	0.8	240	0.14	—	—	—	—	225	0.14	—	—	—	—	—	—	—	—	—	—
SCET 120408-UD:D8330	●	0.8	165	0.16	—	—	—	—	155	0.16	—	—	—	—	—	—	—	—	—	—
SCET 120408-UD:D9335	●	0.8	240	0.16	—	—	—	—	225	0.16	—	—	—	—	—	—	—	—	—	—
SCET 150512-UD:D8330	●	1.2	165	0.18	—	—	—	—	155	0.18	—	—	—	—	—	—	—	—	—	—
SCET 150512-UD:D9335	●	1.2	240	0.18	—	—	—	—	225	0.18	—	—	—	—	—	—	—	—	—	—



SCET 050204-SD 0,04
SCET 060204-SD 0,06
SCET 070308-SD 0,08
SCET 09T308-SD 0,10
SCET 120408-SD 0,10
SCET 150512-SD 0,10



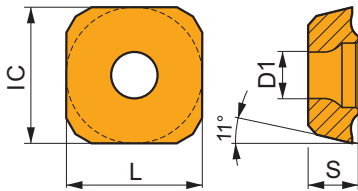
SD-geometri med positivt design til periferiskær.

SCET 050204-SD:D8330	●	0.4	165	0.08	—	95	0.07	—	155	0.08	—	—	—	—	40	0.06	—	—	—	—
SCET 050204-SD:D9335	●	0.4	240	0.08	—	140	0.07	—	225	0.08	—	—	—	—	60	0.06	—	—	—	—
SCET 060204-SD:D8330	●	0.4	165	0.11	—	95	0.09	—	155	0.11	—	—	—	—	40	0.07	—	—	—	—
SCET 060204-SD:D9335	●	0.4	240	0.11	—	140	0.09	—	225	0.11	—	—	—	—	60	0.07	—	—	—	—
SCET 070308-SD:D8330	●	0.8	165	0.13	—	95	0.11	—	155	0.13	—	—	—	—	40	0.09	—	—	—	—
SCET 070308-SD:D9335	●	0.8	240	0.13	—	140	0.11	—	225	0.13	—	—	—	—	60	0.09	—	—	—	—
SCET 09T308-SD:D8330	●	0.8	165	0.14	—	95	0.13	—	155	0.14	—	—	—	—	40	0.10	—	—	—	—
SCET 09T308-SD:D9335	●	0.8	240	0.14	—	140	0.13	—	225	0.14	—	—	—	—	60	0.10	—	—	—	—
SCET 120408-SD:D8330	●	0.8	165	0.16	—	95	0.14	—	155	0.16	—	—	—	—	40	0.11	—	—	—	—
SCET 120408-SD:D9335	●	0.8	240	0.16	—	140	0.14	—	225	0.16	—	—	—	—	60	0.11	—	—	—	—
SCET 150512-SD:D8330	●	1.2	165	0.18	—	95	0.16	—	155	0.18	—	—	—	—	40	0.12	—	—	—	—
SCET 150512-SD:D9335	●	1.2	240	0.18	—	140	0.16	—	225	0.18	—	—	—	—	60	0.12	—	—	—	—

XPET

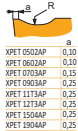
PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0502	5.556	2.40	5.56	2.38
0602	6.350	2.60	6.35	2.38
0703	7.937	2.90	7.94	3.18
0903	9.525	3.50	9.53	3.18
11T3	11.509	3.90	11.50	3.97
12T3	12.700	3.90	12.70	3.97
1504	15.875	4.50	15.88	4.76
1904	19.050	4.50	19.05	4.76



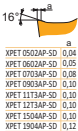
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	Interrupted/ Continuous cut	RE	P			M			K			N			S			H			
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
			(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)



Geometri med universelt design til centrale skær.

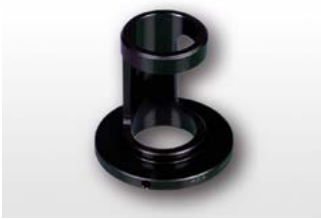
XPET 0502AP:D8345		—		165	0.08	—		—		—		155	0.08	—		—		—		—		—
XPET 0602AP:D8345		—		165	0.11	—		—		—		155	0.11	—		—		—		—		—
XPET 0703AP:D8345		—		165	0.13	—		—		—		155	0.13	—		—		—		—		—
XPET 0903AP:D8345		—		165	0.14	—		—		—		155	0.14	—		—		—		—		—
XPET 11T3AP:D8345		—		165	0.16	—		—		—		155	0.16	—		—		—		—		—
XPET 12T3AP:D8345		—		165	0.16	—		—		—		155	0.16	—		—		—		—		—
XPET 1504AP:D8345		—		165	0.18	—		—		—		155	0.18	—		—		—		—		—
XPET 1904AP:D8345		—		165	0.18	—		—		—		155	0.18	—		—		—		—		—



SD-geometri med positivt design til centrale skær.

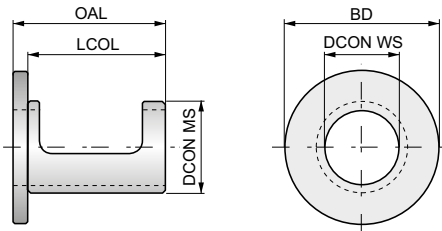
XPET 0502AP-SD:D8345		—		165	0.08	—		95	0.07	—		155	0.08	—		—		—		40	0.06	—		—
XPET 0602AP-SD:D8345		—		165	0.11	—		95	0.09	—		155	0.11	—		—		—		40	0.07	—		—
XPET 0703AP-SD:D8345		—		165	0.13	—		95	0.11	—		155	0.13	—		—		—		40	0.09	—		—
XPET 0903AP-SD:D8345		—		165	0.14	—		95	0.13	—		155	0.14	—		—		—		40	0.10	—		—
XPET 11T3AP-SD:D8345		—		165	0.16	—		95	0.14	—		155	0.16	—		—		—		40	0.11	—		—
XPET 12T3AP-SD:D8345		—		165	0.16	—		95	0.14	—		155	0.16	—		—		—		40	0.11	—		—
XPET 1504AP-SD:D8345		—		165	0.18	—		95	0.16	—		155	0.18	—		—		—		40	0.12	—		—
XPET 1904AP-SD:D8345		—		165	0.18	—		95	0.16	—		155	0.18	—		—		—		40	0.12	—		—

EP



EP - indekserbar justerings for indsatsbor

Bøsning til justering af finborediameter. Kan bruges i værktøjsholdere Ø32, Ø40 eller Ø50 mm. Den udvendige borediameter justeres ved at dreje bøsningen.



Diameterjusteringsområde er 0,4 - -0,2; centerhøjdejusteringsområde er 0,2 - -0,15.

Product	DCON WS	DCON MS	BD	OAL	LCOL	
	(mm)	(mm)	(mm)	(mm)	(mm)	
EP253253	25.00	32.00	53.00	53.0	48	0.15
EP324058	32.00	40.00	58.00	58.0	53	0.19
EP405085-F	40.00	50.00	76.00	85.0	80	0.25

Materiale kode (BMC)	HM	HM	HM	HM	HM										
Belægning															
Grundlæggende standard-gruppe (BSG)	DIN 8093	DIN 8093	DIN 8050	DIN 8094	DIN 8051										
Hånd (skæreretning)															
Skaft															
Rival form	B	B	A	B	A										
Opnåelig hultolerance (TCHA)	H7	$\begin{matrix} \varnothing 95.5 \\ +0.004 \\ \varnothing 5.51-12 \\ +0.005 \end{matrix}$	H7	H7	H7										
Produktfamiliekode	B400	B481	B441	B411	B442										
PSF skærediametre række-vidde	1.00 - 20.00	0.98 - 12.05	10.00 - 20.00	5.00 - 30.00	10.00 - 20.00										
	250	251	253	254	255										
P	P1	■	■	■	■										
	P2	■	■	■	■										
	P3	■	■	■	■										
	P4	■	■	■	■										
M	M1	▣	▣	▣	▣										
	M2	▣	▣	▣	▣										
	M3														
	M4														
K	K1	■	■	■	■										
	K2	■	■	■	■										
	K3	■	■	■	■										
	K4														
	K5	■	■	■	■										
N	N1	■	■	■	■										
	N2	■	■	■	■										
	N3	■	■	■	■										
	N4	▣	▣	▣	▣										
	N5														
S	S1														
	S2														
	S3														
	S4														
H	H1														
	H2														
	H3														
	H4														

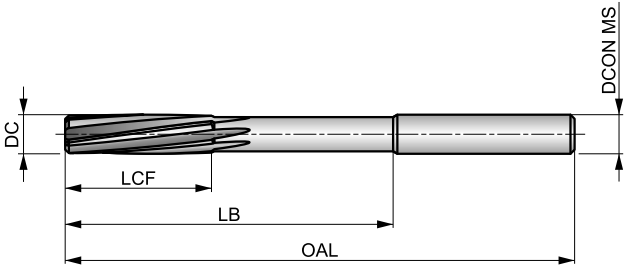
B400





HM ligeskærs maskin rival med H7-tolerance, blank finish

Designet til at give en finish inden for grænserne for H7 hul tolerance. For overlegen ydeevne og forlænget værktøjslevetid, når du river hårde og slibende materialer. Spiralskæret med ekstremt forskellig afstand mellem skærende reducerer vibrationer og forbedrer hulens rundhed, størrelse og overfladefinish.



HM	Bright	DIN 8093
R		B
H7		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 23 B	P1.2 ■ 26 B	P1.3 ■ 27 B	P2.1 ■ 20 B	P2.2 ■ 18 B	P2.3 ■ 16 C	P3.1 ■ 16 B	P3.2 ■ 13 B	P3.3 ■ 11 C	P4.1 ■ 10 B	P4.2 ■ 8 C	P4.3 ■ 7 C	M1.1 ▣ 10 C	M1.2 ▣ 8 C
M2.1 ▣ 9 C	M2.2 ▣ 7 C	M2.3 ▣ 6 B	K1.1 ■ 20 D	K1.2 ■ 15 D	K1.3 ■ 11 D	K2.1 ■ 21 D	K2.2 ■ 17 D	K2.3 ■ 14 D	K3.1 ■ 18 D	K3.2 ■ 14 D	K3.3 ■ 11 D	K5.1 ■ 19 D	K5.2 ■ 15 D
K5.3 ■ 11 D	N1.1 ▣ 60 D	N1.2 ■ 45 D	N1.3 ■ 30 D	N2.1 ■ 38 D	N2.2 ■ 35 D	N2.3 ■ 25 D	N3.1 ■ 64 E	N3.2 ■ 38 E	N3.3 ▣ 19 E	N4.1 ▣ 35 C	N4.2 ▣ 30 C		

DCON MS tolerance h6; DC> = 14 mm hårdmetal påloddet.

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B4001.0	1.00	34.0	5.5	15.00	3	1.00
B4001.2	1.20	38.0	7.5	16.50	3	1.20
B4001.4	1.40	40.0	8.0	18.00	3	1.50
B4001.5	1.50	40.0	8.0	18.00	3	1.50
B4001.6	1.60	43.0	9.0	20.00	3	1.60
B4001.8	1.80	46.0	10.0	22.00	4	1.80
B4002.0	2.00	49.0	11.0	24.00	4	2.00
B4002.2	2.20	53.0	12.0	25.00	4	2.20
B4002.5	2.50	57.0	14.0	29.00	4	2.50
B4002.8	2.80	61.0	15.0	33.00	6	3.00
B4003.0	3.00	61.0	15.0	33.00	6	3.00
B4003.2	3.20	65.0	16.0	37.00	6	3.20
B4003.5	3.50	70.0	18.0	42.00	6	3.50
B4004.0	4.00	75.0	19.0	47.00	6	4.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B4004.5	4.50	80.0	21.0	52.00	6	4.50
B4005.0	5.00	86.0	23.0	58.00	6	5.00
B4005.5	5.50	93.0	26.0	57.00	6	5.60
B4006.0	6.00	93.0	26.0	57.00	6	5.60
B4006.5	6.50	101.0	28.0	65.00	6	6.30
B4007.0	7.00	109.0	31.0	73.00	6	7.10
B4008.0	8.00	117.0	33.0	81.00	6	8.00
B4009.0	9.00	125.0	36.0	85.00	6	9.00
B40010.0	10.00	133.0	38.0	93.00	6	10.00
B40012.0	12.00	151.0	44.0	111.00	6	10.00
B40014.0	14.00	160.0	47.0	115.00	6	12.50
B40016.0	16.00	170.0	52.0	125.00	6	12.50
B40018.0	18.00	182.0	56.0	137.00	6	14.00
B40020.0	20.00	195.0	60.0	147.00	6	16.00

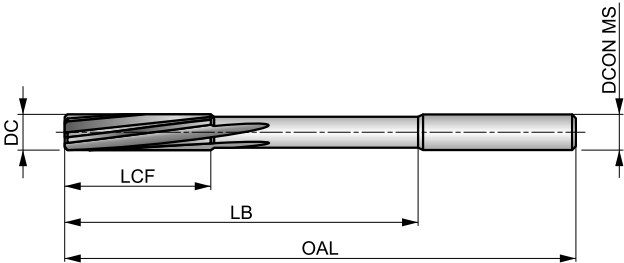
B481

 DORMER



Hårdmetal maskinerival - 0,01 mm intervaller, blank finish

Lige skaft til høj ydeevne ved CNC-bearbejdning. Forskellige stigningsstørrelser gør det muligt at producere nøjagtige hulstørrelser og tolerancer. Premium hårdmetal giver stærkt forbedret ydeevne og forlænget værktøjslevetid, når man river i hårde og slibende materialer. Ekstremt forskellig afstand på skær for at reducere vibrationer.



HM	Bright	DIN 8093
R	DIN 6535HA	B
ø 95-5.5 +0.004 ø 5.51-12 +0.005		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 23 B	P1.2 ■ 26 B	P1.3 ■ 27 B	P2.1 ■ 20 B	P2.2 ■ 18 B	P2.3 ■ 16 C	P3.1 ■ 16 B	P3.2 ■ 13 B	P3.3 ■ 11 C	P4.1 ■ 10 B	P4.2 ■ 8 C	P4.3 ■ 7 C	M1.1 ▣ 10 C	M1.2 ▣ 8 C
M2.1 ▣ 9 C	M2.2 ▣ 7 C	M2.3 ▣ 6 B	K1.1 ■ 20 D	K1.2 ■ 15 D	K1.3 ■ 11 D	K2.1 ■ 21 D	K2.2 ■ 17 D	K2.3 ■ 14 D	K3.1 ■ 18 D	K3.2 ■ 14 D	K3.3 ■ 11 D	K5.1 ■ 19 D	K5.2 ■ 15 D
K5.3 ■ 11 D	N1.1 ▣ 60 D	N1.2 ■ 45 D	N1.3 ■ 30 D	N2.1 ■ 38 D	N2.2 ■ 35 D	N2.3 ■ 25 D	N3.1 ■ 64 E	N3.2 ■ 38 E	N3.3 ▣ 19 E	N4.1 ▣ 35 C	N4.2 ▣ 30 C		

DCON MS tolerance h6.

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B4810.98	0.98	50.0	6.0	22.00	3	3.00
B4810.99	0.99	50.0	6.0	22.00	3	3.00
B4811.03	1.03	50.0	6.0	22.00	3	3.00
B4811.50	1.50	50.0	9.0	22.00	3	3.00
B4811.51	1.51	50.0	10.0	22.00	3	3.00
B4811.52	1.52	50.0	10.0	22.00	3	3.00
B4811.53	1.53	50.0	10.0	22.00	3	3.00
B4811.98	1.98	50.0	12.0	22.00	4	3.00
B4811.99	1.99	50.0	12.0	22.00	4	3.00
B4812.00	2.00	50.0	12.0	22.00	4	3.00
B4812.01	2.01	50.0	12.0	22.00	4	3.00
B4812.02	2.02	50.0	12.0	22.00	4	3.00
B4812.03	2.03	50.0	12.0	22.00	4	3.00
B4812.48	2.48	60.0	16.0	32.00	4	3.00
B4812.49	2.49	60.0	16.0	32.00	4	3.00
B4812.50	2.50	60.0	16.0	32.00	4	3.00
B4812.51	2.51	60.0	16.0	32.00	4	3.00
B4812.52	2.52	60.0	16.0	32.00	4	3.00
B4812.53	2.53	60.0	16.0	32.00	4	3.00
B4812.97	2.97	65.0	17.0	37.00	6	4.00
B4812.98	2.98	65.0	17.0	37.00	6	4.00
B4812.99	2.99	65.0	17.0	37.00	6	4.00
B4813.00	3.00	65.0	17.0	37.00	6	4.00
B4813.01	3.01	65.0	17.0	37.00	6	4.00
B4813.02	3.02	65.0	17.0	37.00	6	4.00
B4813.03	3.03	65.0	17.0	37.00	6	4.00
B4813.97	3.97	75.0	19.0	47.00	6	4.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B4813.98	3.98	75.0	19.0	47.00	6	4.00
B4813.99	3.99	75.0	19.0	47.00	6	4.00
B4814.00	4.00	75.0	19.0	47.00	6	4.00
B4814.01	4.01	75.0	19.0	47.00	6	4.00
B4814.02	4.02	75.0	19.0	47.00	6	4.00
B4814.03	4.03	75.0	19.0	47.00	6	4.00
B4814.97	4.97	93.0	23.0	57.00	6	6.00
B4814.98	4.98	93.0	23.0	57.00	6	6.00
B4814.99	4.99	93.0	23.0	57.00	6	6.00
B4815.00	5.00	93.0	23.0	57.00	6	6.00
B4815.01	5.01	93.0	23.0	57.00	6	6.00
B4815.02	5.02	93.0	23.0	57.00	6	6.00
B4815.03	5.03	93.0	23.0	57.00	6	6.00
B4815.97	5.97	93.0	26.0	57.00	6	6.00
B4815.98	5.98	93.0	26.0	57.00	6	6.00
B4815.99	5.99	93.0	26.0	57.00	6	6.00
B4816.00	6.00	93.0	26.0	57.00	6	6.00
B4816.01	6.01	93.0	26.0	57.00	6	6.00
B4816.02	6.02	93.0	26.0	57.00	6	6.00
B4816.03	6.03	93.0	26.0	57.00	6	6.00
B4817.97	7.97	117.0	33.0	81.00	6	8.00
B4817.98	7.98	117.0	33.0	81.00	6	8.00
B4817.99	7.99	117.0	33.0	81.00	6	8.00
B4818.00	8.00	117.0	33.0	81.00	6	8.00
B4818.01	8.01	117.0	33.0	81.00	6	8.00
B4818.02	8.02	117.0	33.0	81.00	6	8.00
B4818.03	8.03	117.0	33.0	81.00	6	8.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B4818.04	8.04	117.0	33.0	81.00	6	8.00
B4819.97	9.97	133.0	38.0	93.00	6	10.00
B4819.98	9.98	133.0	38.0	93.00	6	10.00
B4819.99	9.99	133.0	38.0	93.00	6	10.00
B48110.00	10.00	133.0	38.0	93.00	6	10.00
B48110.01	10.01	133.0	38.0	93.00	6	10.00
B48110.02	10.02	133.0	38.0	93.00	6	10.00
B48110.03	10.03	133.0	38.0	93.00	6	10.00
B48110.04	10.04	133.0	38.0	93.00	6	10.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B48110.05	10.05	133.0	38.0	93.00	6	10.00
B48111.98	11.98	151.0	44.0	106.00	6	12.00
B48111.99	11.99	151.0	44.0	106.00	6	12.00
B48112.00	12.00	151.0	44.0	106.00	6	12.00
B48112.01	12.01	151.0	44.0	106.00	6	12.00
B48112.02	12.02	151.0	44.0	106.00	6	12.00
B48112.03	12.03	151.0	44.0	106.00	6	12.00
B48112.04	12.04	151.0	44.0	106.00	6	12.00
B48112.05	12.05	151.0	44.0	106.00	6	12.00

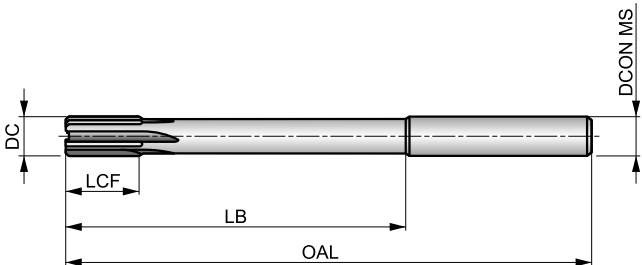
B441

 DORMER



Hårdmetalrival med lige skaft, H7-tolerance, blank finish

Den hårdlodde hårdmetalspids giver forlænget værktøjslevetid og en overlegen ydelse, når man river huller inden for grænserne for H7-hultolerance. Det yderst ulige design af skærreducerer vibrationer og forbedrer hulens rundhed, overfladefinish og størrelse. Værktøjet tilbyder fremragende ydelse i CNC-maskiner.



HM	Bright	DIN 8050
R		A
H7		

Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 23 B	■ 26 B	■ 27 B	■ 20 B	■ 18 B	■ 16 C	■ 16 B	■ 13 B	■ 11 C	■ 10 B	■ 8 C	■ 7 C	▣ 10 C	▣ 8 C
M2.1	M2.2	M2.3	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2
▣ 9 C	▣ 7 C	▣ 6 B	■ 20 D	■ 15 D	■ 11 D	■ 21 D	■ 17 D	■ 14 D	■ 18 D	■ 14 D	■ 11 D	■ 19 D	■ 15 D
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2		
■ 11 D	▣ 60 D	■ 45 D	■ 30 D	■ 38 D	■ 35 D	■ 25 D	■ 64 E	■ 38 E	▣ 19 E	▣ 35 C	▣ 30 C		

DCON MS tolerance h9; hårdmetal påloddet.

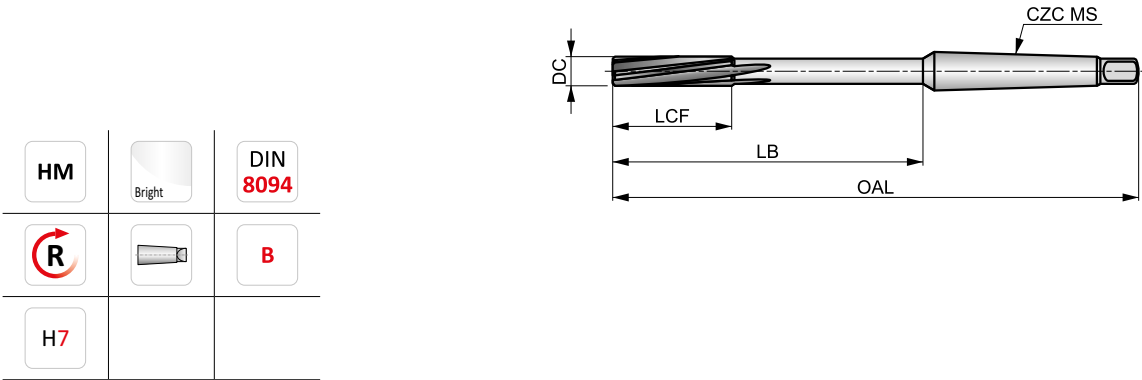
Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B44110.0	10.00	133.0	19.0	87.00	6	10.00
B44111.0	11.00	142.0	19.0	96.00	6	10.00
B44112.0	12.00	151.0	19.0	105.00	6	10.00
B44113.0	13.00	151.0	19.0	105.00	6	10.00
B44114.0	14.00	160.0	19.0	110.00	6	12.50
B44115.0	15.00	162.0	19.0	112.00	6	12.50
B44116.0	16.00	170.0	22.0	120.00	6	12.50
B44117.0	17.00	175.0	22.0	123.00	6	14.00
B44118.0	18.00	182.0	22.0	130.00	6	14.00
B44119.0	19.00	189.0	22.0	131.00	6	16.00
B44120.0	20.00	195.0	22.0	137.00	6	16.00

B411



Hårdmetalrival påloddet HM med lige skaft, H7-tolerance, blank finish

De hårdlodde hårdmetal-spids giver betydelige forbedringer i ydeevne og en længere værktøjslevetid, når du river hårde og slibende materialer. Spiralskærene har ulige mellemrum mellem dem, hvilket effektivt reducerer vibrationer og forbedrer hulsymmetri, størrelse og finish.



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 23 B	■ 26 B	■ 27 B	■ 20 B	■ 18 B	■ 16 C	■ 16 B	■ 13 B	■ 11 C	■ 10 B	■ 8 C	■ 7 C	▣ 10 C	▣ 8 C
M2.1	M2.2	M2.3	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K5.1	K5.2
▣ 9 C	▣ 7 C	▣ 6 B	■ 20 D	■ 15 D	■ 11 D	■ 21 D	■ 17 D	■ 14 D	■ 18 D	■ 14 D	■ 11 D	■ 19 D	■ 15 D
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2		
■ 11 D	▣ 60 D	■ 45 D	■ 30 D	■ 38 D	■ 35 D	■ 25 D	■ 64 E	■ 38 E	▣ 19 E	▣ 35 C	▣ 30 C		

DC <= 16mm hårdmetalhoved; DC> 16 mm hårdmetal påloddet.

Product	DC	OAL	LCF	LB	NOF	CZC MS
	(mm)	(mm)	(mm)	(mm)		
B4115.0	5.00	133.0	23.0	67.50	6	MK 1
B4116.0	6.00	138.0	26.0	72.50	6	MK 1
B4117.0	7.00	150.0	31.0	84.50	6	MK 1
B4118.0	8.00	156.0	33.0	90.50	6	MK 1
B4119.0	9.00	162.0	36.0	96.50	6	MK 1
B41110.0	10.00	168.0	38.0	102.50	6	MK 1
B41112.0	12.00	182.0	44.0	116.50	6	MK 1
B41114.0	14.00	189.0	47.0	123.50	8	MK 1
B41115.0	15.00	204.0	50.0	124.00	8	MK 2
B41116.0	16.00	210.0	52.0	130.00	8	MK 2
B41117.0	17.00	214.0	54.0	134.00	6	MK 2
B41118.0	18.00	219.0	56.0	139.00	6	MK 2
B41119.0	19.00	223.0	58.0	143.00	6	MK 2
B41120.0	20.00	228.0	60.0	148.00	6	MK 2
B41122.0	22.00	237.0	64.0	157.00	6	MK 2
B41124.0	24.00	268.0	68.0	169.00	8	MK 3
B41125.0	25.00	268.0	68.0	169.00	8	MK 3
B41126.0	26.00	273.0	70.0	174.00	8	MK 3
B41130.0	30.00	281.0	73.0	182.00	8	MK 3

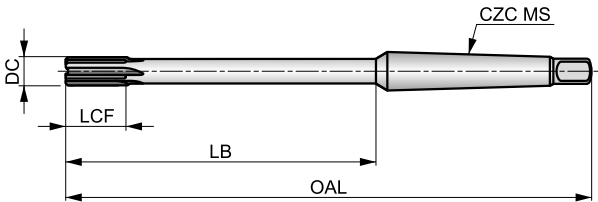
B442



HM rival med hårdmetalsskær med H7-tolerance, blank finish

Designet med ekstremt ulige skær for at reducere vibrationer og forbedre hulstørrelse, rundhed og overfladefinish. 45 ° skrældning sikrer nøjagtig placering og centrering for at give dig forbedret hulkvalitet og ydeevne. Den hårdlodde hårdmetalsskær giver forlænget værktøjslevetid og en overlegen ydelse.

HM	Bright	DIN 8051
R		A
H7		



Arbejdsemnets materialegruppes egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 279.

P1.1 ■ 23 B	P1.2 ■ 26 B	P1.3 ■ 27 B	P2.1 ■ 20 B	P2.2 ■ 18 B	P2.3 ■ 16 C	P3.1 ■ 16 B	P3.2 ■ 13 B	P3.3 ■ 11 C	P4.1 ■ 10 B	P4.2 ■ 8 C	P4.3 ■ 7 C	M1.1 ▣ 10 C	M1.2 ▣ 8 C
M2.1 ▣ 9 C	M2.2 ▣ 7 C	M2.3 ▣ 6 B	K1.1 ■ 20 D	K1.2 ■ 15 D	K1.3 ■ 11 D	K2.1 ■ 21 D	K2.2 ■ 17 D	K2.3 ■ 14 D	K3.1 ■ 18 D	K3.2 ■ 14 D	K3.3 ■ 11 D	K5.1 ■ 19 D	K5.2 ■ 15 D
K5.3 ■ 11 D	N1.1 ▣ 60 D	N1.2 ■ 45 D	N1.3 ■ 30 D	N2.1 ■ 38 D	N2.2 ■ 35 D	N2.3 ■ 25 D	N3.1 ■ 64 E	N3.2 ■ 38 E	N3.3 ▣ 19 E	N4.1 ▣ 35 C	N4.2 ▣ 30 C		

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	CZC MS
B44210.0	10.00	168.0	19.0	102.50	6	MK 1
B44212.0	12.00	182.0	19.0	116.50	6	MK 1
B44214.0	14.00	189.0	19.0	123.50	6	MK 1
B44215.0	15.00	204.0	19.0	124.00	6	MK 2
B44216.0	16.00	210.0	22.0	130.00	6	MK 2
B44217.0	17.00	214.0	22.0	134.00	6	MK 2
B44218.0	18.00	219.0	22.0	139.00	6	MK 2
B44219.0	19.00	223.0	22.0	143.00	6	MK 2
B44220.0	20.00	228.0	22.0	148.00	6	MK 2



PMK
NSH

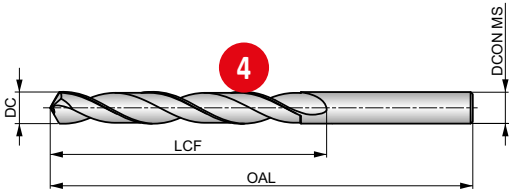
INSTRUKTIONER

DRILLS – PAGE OVERVIEW

1 R003



Arbejdsbor i massivt hårdmetal, TiN-spids belagt
Alsiddigt begynderbor med 120° spidsvinkel med firefacetteret splitspidsgeometri for reduceret trykkraft og CTW-sporkonstruktion for forbedret indtrængningshastighed. TiN-belægning på spidsen forbedrer ydeevnen og forlænger værktøjets levetid. Velegnet til både CNC-maskiner og konventionelle maskiner på tværs af en bred vifte af emnematerialer.



HM	DIN 338	4xD
120°	TiN-Tip	
λ 20-35°	R	DC h7

Arbejdsmetns materialegruppens egnethed, startværdier for skærehastighed (m / min) og tilførsel af Alpha-kode. Tabeller med feed pr. Omdrejning kan findes fra side 274.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 99 S	■ 111 S	■ 115 S	■ 85 S	■ 75 S	■ 66 S	■ 66 S	■ 53 S	■ 45 S	■ 40 S	■ 34 S	■ 27 S	■ 75 T	■ 56 T
K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	1.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2
■ 42 T	■ 68 T	■ 55 T	■ 44 T	■ 60 T	■ 46 T	■ 37 T	■ 55 T	■ 42 T	■ 31 T	■ 26 T	■ 22 T	■ 63 T	■ 47 T
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.1	N4.2	H1.1	H2.1	H3.1
■ 37 T	■ 150 V	■ 113 V	■ 75 V	■ 129 V	■ 116 V	■ 84 V	■ 317 V	■ 190 V	■ 60 U	■ 100 U	■ 34 S	■ 20 S	■ 22 S

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R0031.0	—	1.00	0.0394	12.0	34.0	1.00
R003N60	N60	1.02	0.0400	12.0	34.0	1.02
R0031.1	—	1.10	0.0433	14.0	36.0	1.10
R003N56	N56	1.18	0.0465	16.0	38.0	1.18
R003N54	3/64	1.19	0.0469	16.0	38.0	1.19
R0031.2	—	1.20	0.0472	16.0	38.0	1.20
R0031.3	—	1.30	0.0512	16.0	38.0	1.30
R003N54	N54	1.40	0.0550	18.0	40.0	1.40
R0031.4	—	1.40	0.0551	18.0	40.0	1.40
R0031.5	—	1.50	0.0591	18.0	40.0	1.50
R003N53	N53	1.51	0.0595	20.0	43.0	1.51
R0031/16	1/16	1.59	0.0625	20.0	43.0	1.59
R0031.6	—	1.60	0.0630	20.0	43.0	1.60
R003N52	N52	1.61	0.0635	20.0	43.0	1.61

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R0032.3	—	2.30	0.0906	27.0	53.0	2.30
R0033/32	3/32	2.38	0.0937	30.0	57.0	2.38
R0032.4	—	2.40	0.0945	30.0	57.0	2.40
R003N41	N41	2.44	0.0960	30.0	57.0	2.44
R0032.5	—	2.50	0.0984	30.0	57.0	2.50
R003N39	N39	2.53	0.0995	30.0	57.0	2.53
R003N38	N38	2.58	0.1015	30.0	57.0	2.58
R0032.6	—	2.60	0.1024	30.0	57.0	2.60
R003N37	N37	2.64	0.1040	30.0	57.0	2.64
R0032.7	—	2.70	0.1063	33.0	61.0	2.70
R003N36	N36	2.71	0.1065	33.0	61.0	2.71
R0037/64	7/64	2.78	0.1094	33.0	61.0	2.78
R0032.8	—	2.80	0.1102	33.0	61.0	2.80
R003N33	N33	2.87	0.1130	33.0	61.0	2.87

Pos.	Description
1	Designation of drill
2	Product description
3	Illustrative picture
4	Schematic drawing of tool

Pos.	Description
5	Product features
6	Material group recommendations incl. speed and feed guidance
7	Product code
8	Product dimensions

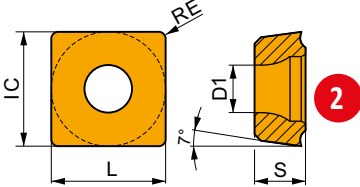
INSERTS – PAGE OVERVIEW

1

SCET



	IC	D1	L	S
	(mm)		(mm)	(mm)
0502	5.556	2.90	5.56	2.38
0602	6.350	2.90	6.35	2.38
0703	7.937	3.50	7.94	3.18
09T3	9.525	4.50	9.53	3.97
1204	12.700	5.60	12.70	4.76
1505	15.875	5.60	15.88	5.56



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Produkt	Interrupted/ Continuous cut	RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)			
 SCET 050204-UD SCET 060204-UD SCET 070308-UD SCET 09T308-UD SCET 120408-UD SCET 150512-UD	 SCET 050204-UD SCET 060204-UD SCET 070308-UD SCET 09T308-UD SCET 120408-UD SCET 150512-UD	 0.4 0.4 0.4 0.4 0.4 0.4	 165 240 165 240 240 165	 0.08 0.08 0.11 0.13 0.16 0.18	 — — — — — —	 — — — — — —	 155 225 155 225 225 155	 0.08 0.08 0.11 0.13 0.16 0.18	 — — — — — —	 — — — — — —	 — — — — — —	 — — — — — —								
 SCET 050204-SD SCET 060204-SD SCET 070308-SD SCET 09T308-SD SCET 120408-SD SCET 150512-SD	 SCET 050204-SD SCET 060204-SD SCET 070308-SD SCET 09T308-SD SCET 120408-SD SCET 150512-SD	 0.04 0.06 0.08 0.10 0.12 0.15	 165 240 165 240 240 165	 0.04 0.06 0.08 0.10 0.12 0.15	 — — — — — —	 — — — — — —	 155 225 155 225 225 155	 0.04 0.06 0.08 0.10 0.12 0.15	 — — — — — —	 — — — — — —	 — — — — — —	 — — — — — —								

Pos.	Description
1	Designation of insert
2	Schematic drawing of insert
3	Table with insert sizes (mm)
4	Picture of representative insert
5	Profile of main cutting edge
6	Icons – specific features and cutting edge type

Pos.	Description
7	ISO insert code: Grade
8	Working conditions
9	Insert radii (mm)
10	Geometry description
11	Application area of insert

INDEXABLE DRILLS – PAGE OVERVIEW

1

802D

P

M

K

N

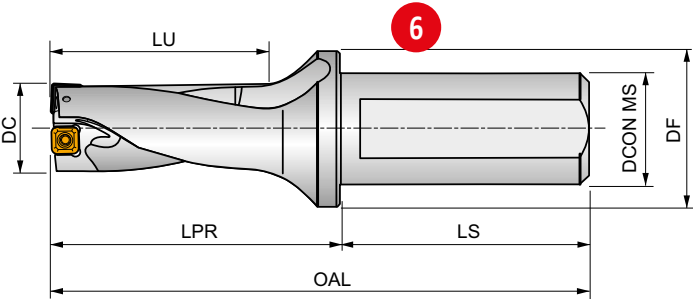
S

H

2



5

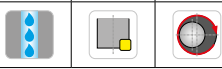


6

2xD

1

ISO 9766



7

3

S

4

2xD 802D korthuls bor med indvendig kølevæskeindføring

Højtydende korthulsbor til boring af bund og gennemgående huller. Potentielt kryds hul, boring uden for midten, spiralformet interpolering, dybde, boring på konkave eller vinklede overflader, boring med afbrudte snit, affasning og boring. Fås fra Ø15 op til Ø40 mm i 2xD.

4



Product	DC	APMX	OAL	LPR	LS	LU	DCON MS	DF	D ⁻	D ⁺				kg	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]					
802D-15-30-S25	15	30.00	121	65	56	34.5	25	35	0.25	0.35	EP253253	GI300	GI313	0.30	HM001
802D-16-32-S25	16	32.00	123	67	56	37	25	35	0.15	0.45	EP253253	GI300	GI313	0.30	HM001
802D-17-34-S25	17	34.00	125	69	56	39.5	25	35	0.15	0.50	EP253253	GI300	GI313	0.30	HM001
802D-18-36-S25	18	36.00	127	71	56	42	25	35	0.35	0.25	EP253253	GI301	GI314	0.31	HM002
802D-19-38-S25	19	38.00	129	73	56	44.5	25	35	0.15	0.45	EP253253	GI301	GI314	0.32	HM002
802D-20-40-S25	20	40.00	131	75	56	47	25	35	0.10	0.45	EP253253	GI302	GI315	0.33	HM003
802D-21-42-S25	21	42.00	133	77	56	49.5	25	35	0.10	0.50	EP253253	GI302	GI315	0.34	HM003
802D-22-44-S25	22	44.00	135	79	56	52	25	35	0.45	0.50	EP253253	GI303	GI316	0.35	HM004
802D-23-46-S25	23	46.00	137	81	56	54.5	25	35	0.35	0.50	EP253253	GI304	GI317	0.36	HM005
802D-24-48-S25	24	48.00	139	83	56	57	25	35	0.15	0.50	EP253253	GI304	GI317	0.37	HM005

		
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD

		
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD

INDEXABLE DRILLS – PAGE OVERVIEW

Pos.	Description	Pos.	Description
1	Designation of drill	11	Radial setting (mm)
2	Material group recommendations	12	Adjustable sleeve
3	Clamping system of insert	13	Group of compatible inserts with chip breaker UD ^{1), 2)}
4	Tool description	14	Group of compatible inserts with chip breaker SD ^{1), 2)}
5	Illustrative picture	15	Weight (kg)
6	Schematic drawing of tool	16	Group of spare parts ¹⁾
7	Product features	17	Compatible inserts with chip breaker UD
8	Product applications	18	Compatible inserts with chip breaker SD
9	Tool code	19	Spare parts
10	Tool dimensions		

¹⁾ Code of Group of compatible inserts and spare parts is used only for purposes of this catalogue. It cannot be used for orders.

²⁾ External (SCET) and internal (XPET) inserts must always have the same chip breaker (please note: UD chip breaker is not visibly included in designation of XPET inserts – e.g. XPET 0502AP); info needed for correct choice of chip breaker (UD vs SD) can be found on the insert packaging.

ICONS OVERVIEW

General icons

	Primary use		Possible use
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Grundlæggende standardgruppe (BSG)

DIN 1897 DIN 1897 – Stubboresstandard	DIN 6539 DIN 6539	DIN 212 DIN 212 – Maskin Rival Standard
DIN 1899 DIN 1899 – Micro Bor-standard	DIN 6537K DIN 6537 K	DIN 2179 DIN 2179 – Parallel skaft til koniske stiftrival-standarder
DIN 338 DIN 338 – Lige skaft bor standard	DIN 6537L DIN 6537 L	DIN 2180 DIN 2180 - Morsekonus Standard for konisk stiftrival
NAS 907 NAS907 – Aerospace bor Standard	DIN 333R DIN 333R - Lige skaft centerbor standard	DIN 311 DIN 311 - Morsekonus skaft rival standard
DIN 340 DIN 340 – Skaftlængde bor standard	DIN 333C DIN 333C - Lige skaft centerbor standard	DIN 8050 DIN 8050 – Parallel Skaft rival Standard
DIN 1869-1 DIN 1869 / 1 – Lige skaft ekstra lange bor standard	DIN 335A DIN 335 A - Lige skaft centerbor standard	DIN 8051 DIN 8051 – Morse konus Shank Rival-standard
DIN 1869-2 DIN 1869 / 2 – Lige skaft ekstra lange bor standard	DIN 335C DIN 335 C - Lige skaft centerbor standard	DIN 8093 DIN 8093 – Lige Skaft Rival Standard
DIN 1869-3 DIN 1869 / 60-100° undersækning – Lige skaft ekstra lange bor standard	DIN 333D DIN 333D - Morsekonus skaft centerbor standard	DIN 8094 DIN 8094 – Morsekonisk skaftrival standarder
DIN 1870(2) DIN 1870 (2) – Morse-konusskaft ekstra lang borestandard	DIN 335 d DIN 335 d - Morsekonus skaft centerbor standard	DIN 9 DIN – Standarder for taperstiftrivaler
DIN 345 DIN 341 – Morse-konusskaft bor standard	DIN 373 DIN 373 – centerbor standard	DIN ANSI DIN/ANSI Standard
DIN 8374 DIN 8374 – Trinbor Standard	BS 328 BS 328 – Standarder for bor og rivaler	ANSI ANSI – Tap Standarder
DIN 8376 DIN 8376 – Trinbor standard	DIN 206 DIN 206 – Hånd rival Standard	 DORMER Dormer Standard
DIN 333A DIN 333A – Centerbor standard	DIN 208 DIN 208 – Morse konisk Skaft Rival standard	

Brugbar længde (ULDR)

1×D 1×D Brugbar Værktøjsdybde til Diameter-forhold	3.5×D 60-100° undersækning, 5×D Anvendelig Værktøjsdybde til Diameter-forhold	12×D 12×D Anvendelig Værktøjsdybde til Diameter-forhold
1.25×D 1,25×D Anvendelig Værktøjsdybde til Diameter-forhold	4×D 4×D Anvendelig Værktøjsdybde til Diameter-forhold	15×D 15×D Anvendelig Værktøjsdybde til Diameter-forhold
1.5×D 1,5×D Anvendelig Værktøjsdybde til Diameter-forhold	5×D 5×D Anvendelig Værktøjsdybde til Diameter-forhold	20×D 20×D Anvendelig Værktøjsdybde til Diameter-forhold
2×D 2×D Anvendelig Værktøjsdybde til Diameter-forhold	6×D 6×D Anvendelig Værktøjsdybde til Diameter-forhold	25×D 25×D Anvendelig Værktøjsdybde til Diameter-forhold
2.5×D 2,5×D Anvendelig Værktøjsdybde til Diameter-forhold	8×D 8×D Anvendelig Værktøjsdybde til Diameter-forhold	
3×D 3×D Anvendelig Værktøjsdybde til Diameter-forhold	10×D 10×D Anvendelig Værktøjsdybde til Diameter-forhold	

ICONS OVERVIEW

Anvendelsesvinkel

	Borespids 118°		Borepunkt 120°		82° Undersækning
	Borespids 120°		Borepunkt 150°		90° Undersækning
	Borespids 122°		Forbor med 90° affasning (til gevind)		100° undersækning
	Borespids 130°		Trinbor (til fastgørelsesanordninger) 90 °		60-100° undersækning
	Borespids 135°		Trinbor (til fastgørelsesanordninger) 180 °		60° forsænker
	Borespids 140°		180° Undersækning		Radius Forsækningscenterbor
	Borepunkt 90°		20° konisk bor		
	Borepunkt 90°/120°		60° Undersækning		

Skaft

	Cylindrisk skaft / lige skaft		Cylindrisk skaft med firkantet		Universal skaft
	DIN 6535 HA Cylindrisk skaft		Cylindrisk skaft med sekskant		Cylindrisk skaft med flange
	Cylindrisk skaft med tang		Morse koniske skaft		ISO 9766 cylindrisk skaft (med eller uden flade)
	Cylindrisk skaft med 3 flader		Reduceret cylindrisk skaft		DIN 6535 – HB (Weldon) eller HE (Whistle Notch) skaft

Spiral form

	Kontinuerligt fortyndet webfskærsdesign		Hurtigt spiralskærsdesign		Standard spiralskærsdesign
	Hurtigt spiralskærsdesign		Specielt borespidsudtyndingsdesign		

Hånd (skæreretning)

	Venstrehåndsrotation/skæring		Højrehåndsrotation/skæring
--	------------------------------	---	----------------------------

Køling (CSP)

	Gennemgående værktøjskølevæske
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Skærediameter tolerance klasse (TCDC)

	h6 – Industri Standard værktøjs Tolerance (baseret på diameterområde)		h8 – Industri Standard værktøjs Tolerance (baseret på diameterområde)
	h7 – Industri Standard værktøjs Tolerance (baseret på diameterområde)		m7 – Industri Standard værktøjs Tolerance (baseret på diameterområde)

ICONS OVERVIEW

Opnåelig hultolerance (TCH)

	H7 – Industri Standard værktøj Tolerance (baseret på diameter)		k11 – Industri Standard værktøj Tolerance (baseret på diameter)		Højpræcisions-hul-tolerance (baseret på diameter)
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Rival form

	DIN Form A – Lige skærs, højrehåndsskåret		DIN Form B – Venstrehånds spiralskær, højrehåndsskåret
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Tilspidsningsgradient (hastighed for tilspidsning)

	Tilspidsning (1 mm pr. 50 mm tilspidsning)		Tilspidsning (1/4" pr. fod tilspidsning)
--	--	---	--

Drilling Operations

	Boring		Boring		Boring
	Boring		Boring		Boring
	Boring		Boring		Boring
	Boring		Boring		Boring
	Boring		Boring		Boring
	Boring		Boring		Boring

Insert Features

	Til hårde materialer (lang afskalning)		Universal bred vifte af muligheder
	Tunge arbejdsforhold		Afrundet skær med facet

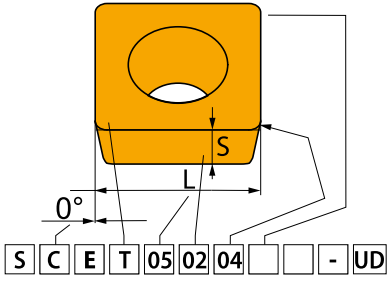
General Features of Tools

	1 effektive tænder pr. omdrejning		Monoblok design		Mulighed for anvendelse til excentrisk bearbejdning
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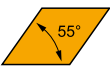
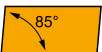
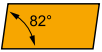
Other Icons

			S - Skrue fastspænding gennem hul		
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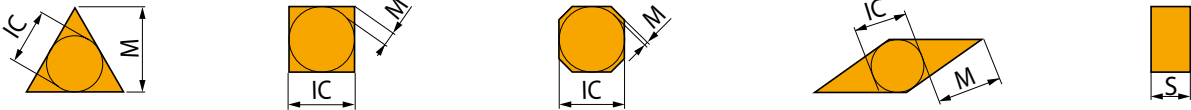
VENDESKÆR – ISO KODEBETEGNELSE



ISO	1	2	3	4
	S	C	E	T
ANSI	1	2	3	4
	S	C	E	T

1				2		4	
Skærform				Frivinkel for skær		Skærtype	
H	O	P	R	A	B	N	
						R	
S	T	C	D	C	D	F	
						A	
E	M	V	W	E	F	M	
						G	
L	A	B	K	G	N	W	
						T	
				P	O	Q	
						U	
						B	
						H	
						C	
						J	
						X	Speciel

3				3			
Tolerancer							
	(mm)			(")			
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)	
A	0.005	0.025	0.025	.0002"	.001"	.0010"	
F	0.005	0.025	0.013	.0002"	.001"	.0005"	
C	0.013	0.025	0.025	.0005"	.001"	.0010"	
H	0.013	0.025	0.013	.0005"	.001"	.0005"	
E	0.025	0.025	0.025	.0010"	.001"	.0010"	
G	0.025	0.130	0.025	.0010"	.005"	.0010"	
J	0.005	0.025	0.05 – 0.13	.0002"	.001"	.002 – 0.005"	
K	0.013	0.025	0.05 – 0.13	.0005"	.001"	.002 – 0.005"	
L	0.025	0.025	0.05 – 0.13	.0010"	.001"	.002 – 0.005"	
M	0.08 – 0.18	0.130	0.05 – 0.13	.003 – 0.007"	.005"	.002 – 0.005"	
N	0.08 – 0.18	0.025	0.05 – 0.13	.003 – 0.007"	.001"	.002 – 0.005"	
U	0.05 – 0.38	0.130	0.05 – 0.13	.005 – 0.015"	.005"	.003 – 0.010"	



VENDESKÆR – ISO KODEBETEGNELSE

5

6

7

8

9

10

05

02

04

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UD

5

6

7

8

9

10

1.8

1.5

1

–

UD

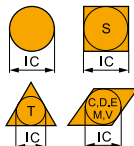
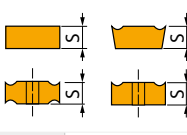
5					5					6					7									
Skærlængde (skærstørrelse)															Skærtykkelse					Næseradius				
d = I.C.		H	O	P	S	T	C	D	E	M	V	W	R	K										
(mm)	(in)																							
3.97	5/32"				03	06		04			06	02												
4.76	3/16"				04	08	04	05	04	04	08	L3												
5.56	7/32"				05	09	05	06	05	05	09	03												
6.35	1/4"	03	02	04	08	11	06	07	08	08	11	04	06											
7.94	5/16"	04	03	05	07	13	08	09	06	07	13	05	07											
9.525	3/8"	05	04	07	09	16	09	11	09	09	16	06	09	16										
12.7	1/2"	07	05	09	12	22	12	15	13	12	22	08	12											
15.875	5/8"	09	06	11	15	27	16	19	16	15	27	10	15											
19.05	3/4"	11	07	13	19	33	19	23	19	19	33	13	19											
25.40	1"	14	10	18	25	44	25	31	26	25	44	17	25											
31.75	1 1/4"	18	13	23	31	54	32	38	32	31	54	21	31											

RE		
	(mm)	(")
00	0	0"
02	0.2	1/128"
04	0.4	1/64"
08	0.8	1/32"
12	1.2	3/64"
16	1.6	1/16"
24	2.4	3/32"
32	3.2	1/8"

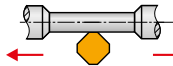
Runde skær		
d = I.C.		
(")		00
(mm)		M0





ANSI												
5			6			7						
Indskrevet cirkel			Skærtykkelse			Næseradius for skær						
												
Symbol	d = I.C.		Symbol	S		Symbol	RE					
	(mm)	(")		(mm)	(")		(mm)	(")				
1	3.175	1/8"	1	1.588	1/16"	0	0	0"				
1.2	3.969	5/32"	1.2	1.984	5/64"	0.2	0.099	1/256"				
1.5	4.763	3/16"	1.5	2.381	3/32"	0.5	0.198	1/128"				
1.8	5.556	7/32"	2	3.175	1/8"	1	0.397	1/64"				
2	6.350	1/4"	2.5	3.969	5/32"	2	0.794	1/32"				
2.5	7.938	5/16"	3	4.763	3/16"	3	1.191	3/64"				
3	9.525	3/8"	3.5	5.556	7/32"	4	1.588	1/16"				
4	12.700	1/2"	4	6.350	1/4"	5	1.984	5/64"				
5	15.875	5/8"	5	7.938	5/16"	6	2.381	3/32"				
6	19.050	3/4"	6	9.525	3/8"	7	2.778	7/64"				
7	22.225	7/8"	7	11.113	7/16"	8	3.175	1/8"				
8	25.400	1"	8	12.700	1/2"	10	3.969	5/32"				
10	31.750	5/4"	9	14.288	9/16"	12	4.763	3/16"				
12	38.100	6/4"	10	15.875	5/8"	14	5.556	7/32"				
						16	6.350	1/4"				

8		8	
Skærdesign			
 Skarpe skær	 Afrundede skær		
 Skær med facet	 Afrundede skær med facet		
 Skær med dobbelt facet	 Afrundede skær med dobbelt facet		

9		9	
Tilspændingsretning			
 Tilspænding			
	 Tilspænding		

10		10	
Spånbryderbetegnelse			

KODENØGLE FOR BOR

1	2	3	4	5	6	7
8	05	D	19	95	S	25



1	2	3	4
Værktøjstype	Omtrentlig længde	Variant	Skærediameter
8	02	D	15.5
	03		
	04		
	05		
Vendeskersbor		Bor	DC = 15.5 mm
			19
			DC = 19 mm

5	6	7
Maks. boreddybde	Skafttype	Skaftdiameter
35	E	25
95		32
140	S	40
35 mm	Whistle Notch	DCON MS = 25 mm
95 mm		DCON MS = 32 mm
140 mm	ISO 9766	DCON MS = 40 mm

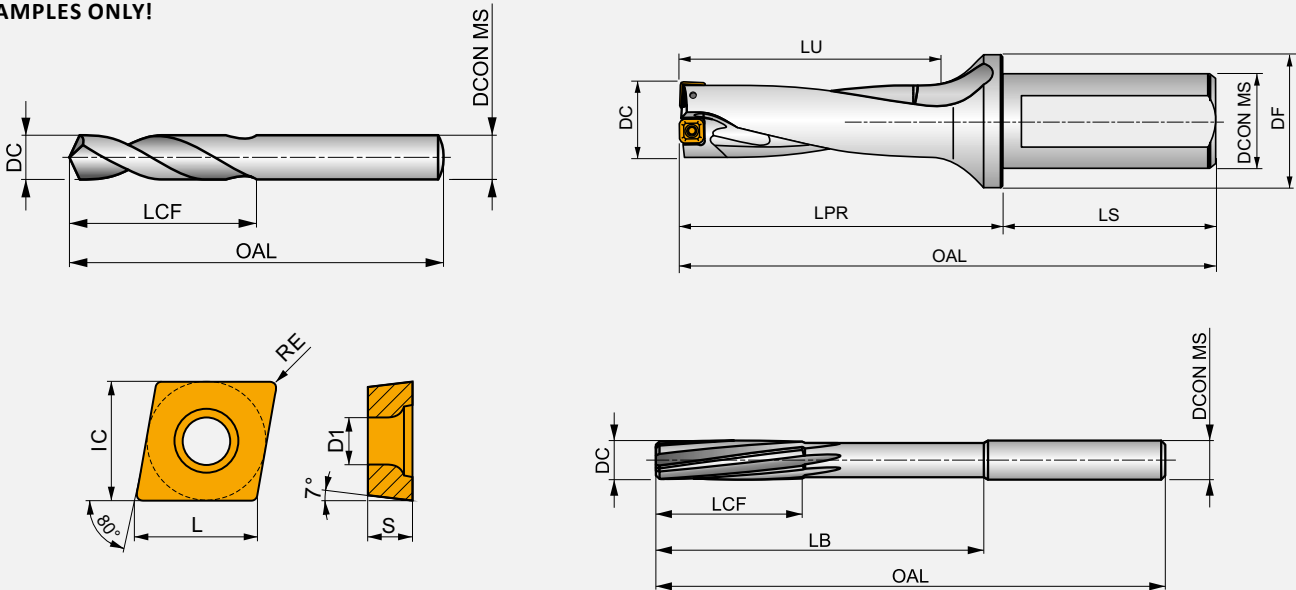
CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of

information run smoothly. By supporting a common language in our cutting tool descriptions will assist this system to system communication. It will save you significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using a ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

EXAMPLES ONLY!



ISO 13399	description
BD	Body diameter
BDX	Body diameter maximum
CZC MS	Connection size code machine side
D1	Fixing hole diameter
DC	Cutting diameter
DCN	Cutting diameter minimum
DCON MS	Connection diameter machine side
DCON WS	Connection diameter workpiece side
DCX	Cutting diameter maximum
DHUB	Hub diameter
FLGT	Flange thickness
IC	Inscribed circle diameter
L	Cutting edge length
LB	Body length
LF	Functional length
LPR	Protruding length
LU	Usable length
OAL	Overall length
RE	Corner radius
S	Insert thickness
WF	Functional width
APMX	Depth of cut maximum
D1	Fixing hole diameter
DC_1	Cutting diameter first cutting step
DC_2	Cutting diameter second cutting step

ISO 13399	description
DF	Flange diameter
DH	Head diameter
GPD	Guide pilot diameter
GPL	Guide pilot length
H	Shank height
HSD	Size of drive part
IC	Inscribed circle diameter
LCF	Length chip flute
LCOL	Collet length
LDC	Distance reference point PK
LH	Head length
LS	Shank length
LSC	Clamping length
NOF	Number of flutes
PLGL	Plug length
RCSK	Radius countersunk
RE	Corner radius
SDI	Step diameter increments
SDL	Step diameter length
SDL_1	Step diameter length first cutting step
SDL_2	Step diameter length second cutting step
TDZ	Thread diameter size
THLGTH	Thread length
WSC	Clamping width

NAVIGATOR TOOL MATERIALS

Tool materials		
High Speed Steel	HSS	A medium-alloyed high speed steel that has good machinability and good performance. HSS exhibits hardness, toughness and wear resistance characteristics that make it attractive in a wide range of applications, for example in drills and taps.
Cobalt High Speed Steel	HSS-E	This high speed steel contains cobalt for increased hot hardness. The composition of HSCo is a good combination of toughness and hardness. It has good machinability and good wear resistance, which makes it usable for drills, taps, milling cutters and reamers.
Carbide and High Speed Steel	HSS HM	Combined carbide and high speed steel materials typically joined together with high temperature braze alloy as the interface. This brazed combination of tool materials offers a solid carbide cutting portion which provides high compression strength, hardness and wear resistance attached to a high speed steel body which provides flexural strength and toughness in the tool body.
Carbide Materials (or Hard Materials)	HM	A sintered powder metallurgy substrate, consisting of a metallic carbide composite with binder metal. The most central raw material is tungsten carbide (WC). Tungsten carbide contributes to the hardness of the material. Tantalum carbide (TaC), titanium carbide (TiC) and niobium carbide (NbC) complements WC and adjusts the properties to what is desired. These three materials are called cubic carbides. Cobalt (Co) acts as a binder and keeps the material together. Carbide materials are often characterised by high compression strength, high hardness and therefore high wear resistance, but also by limited flexural strength and toughness. Carbide is used in taps, reamers, milling cutters, drills and thread milling cutters.

Surface Treatments		
Bright (uncoated)		Bright finish (uncoated surface) improves chip flow in soft or non-ferrous materials, plastics and composites while maintaining sharp cutting edges.
Bright Nickel Plating		Bright Nickel Plated surface protects hardened steel body from rust, corrosion and also improves chip evacuation.
Combination Bright and Steam Tempered		Combination of bright and steam tempering can be effective as the blue oxide more porous surface acts to retain and pull cutting fluid into the hole while the bright surface assists in chip evacuation. This combination is achieved by grinding the bright surface after tempering.
Steam Tempering		Steam tempering gives a strongly adhering blue oxide surface that acts to retain cutting fluid and prevent chip to tool welding, thereby counteracting the formation of a built-up edge. Steam tempering can be applied to any bright tool but is most effective on drills and taps.
Bronze Tempering		Bronze tempering creates a smooth thin bronze oxide layer on the tool surface. Similar to Steam Tempering it helps to prevent chip to tool welding and aids in chip evacuation. Bronze tempering can be applied to any bright tool and can also be applied in combination with Steam Tempering on some tools.
Combination Steam and Bronze Tempered Surface Treatment		Combination of steam and bronze tempering can be effective, as the blue oxide more porous surface acts to retain and pull cutting fluid into the hole while the bronze surface assists in chip evacuation. Both surface treatments add a degree of surface protection to the tool. These combinations are achieved by using two different tempering cycles.

Surface Coatings		
Bright and TiN (Tip Coating) Titanium Nitride (TiN)		Titanium Nitride is a gold coloured ceramic coating applied by physical vapor deposition (PVD). High hardness combined with low friction properties ensures longer tool life and/or better cutting performance over tools which have not been coated.
Titanium Aluminium Nitride coatings (TiAlN, TiAlN-Top & X-CEED)		Titanium Aluminium Nitride is a multi layer ceramic coating applied by PVD coating technology, which exhibits high toughness and oxidation stability. These properties make it ideal for higher speeds and feeds, while at the same time improving tool life. TiAlN is used in drilling, tapping, and milling applications and can be suitable for use when machining without coolant. TiAlN-Top coating is the same as TiAlN but with a post-coating process designed to smooth out imperfections, enhance chip flow and reduce built up edge.
Ti-phon (TiAlCrSiN)		Ti-phon Coating is a coating similar to TiAlN but with the addition of Chromium (Cr) and Silicon (Si) which is specially formulated for Hydra Heads to prevent edge build-up and greatly improve chip flow. This coating exhibits high hot hardness, high oxidation resistance and superior lubricity when used on tools for machining applications involving heavy mechanical and thermal stresses, high speeds and high feed rates. These coating properties translate into superior wear resistance and edge strength.
Aluminium Titanium Carbon Nitride (AlTiCN)		Aluminium Titanium Carbon-Nitride (AlTiCN) is a PVD coating which was specifically engineered to meet the rigorous requirements of the medical device industry. It is however equally applicable to certain cutting tool operations due to a high quality thin-film technology, with excellent micro-hardness and adhesion characteristics.

DRILLING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
D9335	P20 - P35					MT-CVD		FGM	+++	This grade is recommended for the peripheral insert in indexable drills, it is more suited to higher cutting speeds and feeds.
	M15 - M30									
	K15 - K35									
	S10 - S20									
D8330	P20 - P35					PVD		submicron H	+++	This is a universal grade for the peripheral insert in indexable drills, it can be used for most materials and stands out for it's operational reliability.
	M15 - M30									
	K15 - K35									
	S10 - S20									
D8345	P30 - P50					PVD		submicron H	+++	This grade is a universal grade for the central insert in indexable drills, it is an extremely tough suited to most materials.
	M20 - M40									
	K30 - K40									
	S20 - S30									

Substrat	
submicron H	WC-Co-baseret substrat fintkornet (< 1 µm)
FGM	Substrat med funktionel klassificering

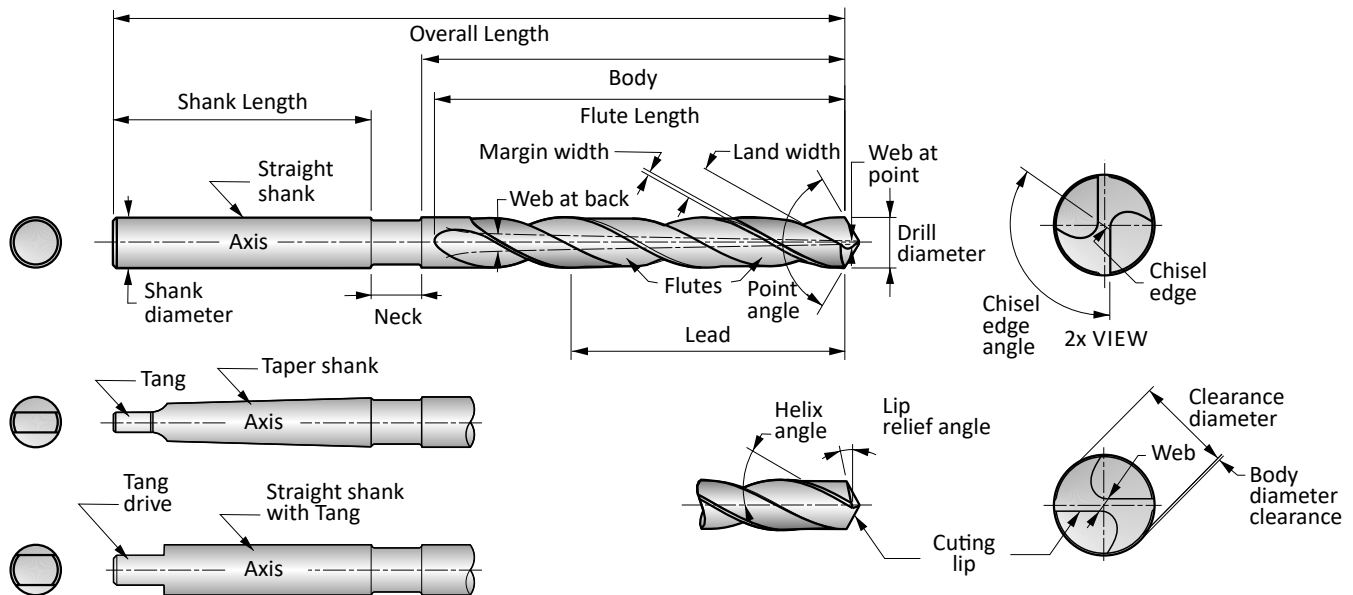
Coating	
MT-CVD	Kemikaliemetode til belægning ved mellemlæg temperatur
PVD	Fysisk metode til coating ved lav temperatur

Benefits of cutting fluid	
+++	Use of coolant is essential

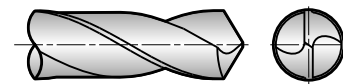


SOLID CARBIDE & HSS DRILLS – TECHNICAL INFO

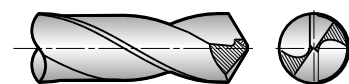
Drill Nomenclature



- **Axis** — The imaginary straight line which forms the longitudinal centre line of a drill.
- **Backtaper** — A slight decrease in diameter from front to back in the body of a drill.
- **Body** — The portion of a drill extending from the shank or neck to the outer corners of the cutting lips.
- **Body Clearance Diameter** — The portion of the land that has been cut away so it will not bind against the walls of the hole.
- **Chisel-Edge** — The edge at the end of the web that connects the cutting lips.
- **Chisel-Edge Angle** — The included angle between the chisel-edge and cutting lip, as viewed from the end of a drill.
- **Clearance Diameter** — The diameter over the cut away portion of the drill lands.
- **Drill** — A rotary end cutting tool having one or more cutting lips, and having one or more helical or straight flutes for the passage of chips and the admission of a cutting fluid.
- **Drill Diameter** — The diameter over the margins of a drill measured at the point.
- **Flute Length** — The length from the outer corners of the cutting lips to the extreme back of the flutes. Includes the sweep of the tool used to generate the flutes and therefore does not indicate the usable length of flutes.
- **Flutes** — Helical or straight grooves cut or formed in the body of a drill to provide cutting lips, permit removal of chips, and allow cutting fluid to reach the cutting lips.
- **Helix Angle** — The angle formed by the leading edge of the land with a plane containing the axis of a drill.
- **Land** — The peripheral portion of the body between adjacent flutes.
- **Land Width** — The distance between the leading edge and heel of the land; measured at a right angle to the leading edge.
- **Lead** — The axial advance of a leading edge of the land in one turn around the circumference.
- **Lip Relief Angle** — The axial relief angle at the outer corner of the lip; measured by projection to a plane tangent to the periphery at the outer corner of the lip.
- **Lips** — The cutting edges of a two flute drill extending from the chisel-edge to the periphery.
- **Margin** — The cylindrical portion of the land, which is not cut away, to provide clearance.
- **Neck** — The section of reduced diameter between the body and the shank of a drill.
- **Overall Length** — The length from the extreme end of the shank to the outer corners of the cutting lip. It does not include the conical shank end often used on straight shank drills, nor the conical cutting point used on both straight and taper shank drills.
- **Point** — The cutting end of a drill, made up of the ends of the lands and the web. In form, it resembles a cone, but departs from a true cone to furnish clearance behind the cutting lips.
- **Conventional** — Conventional Points with 118° included point angles are the most commonly used because they provide satisfactory results in a wide variety of materials. A possible limitation is that the straight chisel edge contributes to wandering at the drill point, often making it necessary to spot the hole for improved accuracy.

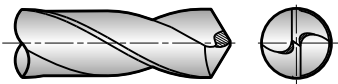


- **Split** — Split-Points (commonly called Crankshaft Points) were originally developed for use on drills designed for deep oil holes in automotive crankshafts. Since its inception, the split-point has gained widespread use and is applied to both 118° and 135° included point angles. Its main advantages are the ability to reduce thrust and eliminate wandering at the drill point. This is a distinct advantage when the drill is used in a portable drill or in drilling applications where bushings cannot be used. The split-point also has two positive rake cutting edges extending to the centre of the drill, which can assist as a chipbreaker to produce small chips which can readily be ejected.



SOLID CARBIDE & HSS DRILLS – TECHNICAL INFO

- Notched** — Notched Points were developed for drilling tough alloys. Commonly incorporated on heavy web drills, which allow the point to withstand the higher thrust loads required in drilling these materials. As with the split-point, the Notched Point contains two additional positive rake cutting edges extending toward the centre of the drill. These secondary cutting lips, which extend no further than half the original cutting lip, can assist in chip control and reduce the torque required in drilling tough materials. Notched Points can be incorporated on both 118° and 135° included point angles, making them suitable for drilling a wide variety of materials.



- Point Angle** — The included angle between the cutting lips projected upon a plane parallel to the drill axis and parallel to the two cutting lips.
- Relative Lip Height** — The difference in indicator reading between the cutting lips of a drill. Measured at a right angle to the cutting lip at a specific distance from the axis of the tool.
- Shank** — The part of a drill by which it is held and driven.
- Tang** — The flattened end of a taper shank, intended to fit into a driving slot in a socket.
- Tang Drive** — Two opposite parallel driving flats on the extreme end of a straight shank.
- Taper Shank** — Drills having conical shanks suitable for direct fitting in machine spindles, driving sleeves, or sockets. Tapered shanks generally have a tang.
- Web** — The central portion of the body that joins the lands. The extreme end of the web forms the chisel-edge on a two flute drill.
- Web Thickness** — The thickness of the web at the point, unless another specific location is indicated.

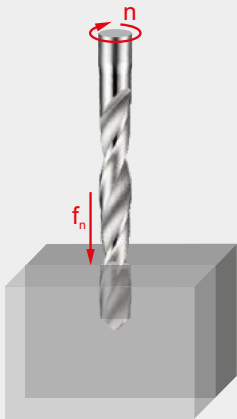
General hints on drilling

- Select the most appropriate drill for the application, bearing in mind the material to be machined, the capability of the machine tool and the coolant to be used.
- Flexibility within the component and machine tool spindle can cause damage to the drill as well as the component and machine - ensure maximum stability at all times. This can be improved by selecting the shortest possible drill for the application.
- Tool holding is an important aspect of the drilling operation and the drill cannot be allowed to slip or move in the tool holder.
- The correct use of Morse Taper Shank drills relies on an efficient fit between the taper surfaces of the tool and the tool holder. The use

of a soft-faced hammer should be used to drive the drill into the holder.

- The use of suitable coolants and lubricants are recommended as required by the particular drilling operation. When using coolants and lubricants, ensure a copious supply, especially at the drill point.
- Swarf evacuation whilst drilling is essential in ensuring the correct drilling procedure. Never allow the swarf to become stationary in the flute.
- When regrinding a drill, always make sure that the correct point geometry is produced and that any wear has been removed.

DRILLING FEED RATE CHART



Feed per revolution (f_n in mm/rev)
Depending on the working conditions
it might be necessary to adjust these
values $\pm 25\%$.

How to use this table to find the feed per revolution (f_n):

1. Find your Alpha Code on the product page (example: 46J, "J" is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per revolution (f_n).

		ø DC (mm)																		
		0.15	0.50	1.00	2.00	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	100.00
Feed rates (mm/rev)	A	0.003	0.006	0.012	0.023	0.029	0.032	0.036	0.042	0.054	0.062	0.069	0.082	0.086	0.110	0.125	0.135	0.155	0.175	0.263
	B	0.004	0.007	0.014	0.028	0.037	0.041	0.046	0.053	0.067	0.080	0.090	0.103	0.108	0.135	0.153	0.165	0.188	0.208	0.312
	C	0.004	0.008	0.015	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110	0.125	0.130	0.160	0.180	0.195	0.220	0.240	0.360
	D	0.004	0.008	0.016	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130	0.149	0.155	0.188	0.210	0.228	0.253	0.275	0.413
	E	0.004	0.009	0.017	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150	0.173	0.180	0.215	0.240	0.260	0.285	0.310	0.465
	F	0.005	0.009	0.018	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178	0.202	0.210	0.248	0.275	0.295	0.320	0.343	0.515
	G	0.005	0.010	0.019	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205	0.231	0.240	0.280	0.310	0.330	0.355	0.375	0.563
	H	0.005	0.010	0.020	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243	0.271	0.280	0.320	0.355	0.375	0.398	0.418	0.627
	I	0.005	0.011	0.021	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280	0.310	0.320	0.360	0.400	0.420	0.440	0.460	0.690
	J	0.006	0.012	0.024	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315	0.349	0.360	0.405	0.445	0.465	0.485	0.503	0.755
	K	0.007	0.013	0.026	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350	0.388	0.400	0.450	0.490	0.510	0.530	0.545	0.818
	L	0.007	0.014	0.028	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385	0.419	0.430	0.485	0.525	0.545	0.568	0.588	0.882
	M	0.008	0.015	0.030	0.110	0.180	0.202	0.225	0.260	0.330	0.390	0.420	0.450	0.460	0.520	0.560	0.580	0.605	0.630	0.945
	N	0.008	0.016	0.032	0.119	0.195	0.218	0.242	0.280	0.355	0.420	0.455	0.481	0.490	0.555	0.595	0.615	0.642	0.672	1.008
	S	0.002	0.004	0.008	0.014	0.020	0.025	0.030	0.037	0.050	0.080	0.100	0.123	0.130	0.150	0.170	0.190	0.220	0.240	–
	T	0.004	0.008	0.015	0.028	0.040	0.050	0.060	0.070	0.090	0.110	0.130	0.160	0.170	0.190	0.210	0.230	0.260	0.275	–
	U	0.007	0.013	0.026	0.048	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240	0.270	0.300	0.360	0.375	–
	V	0.010	0.019	0.038	0.069	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340	0.400	0.440	0.510	0.530	–
	W	0.012	0.025	0.049	0.089	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450	0.470	0.490	0.520	0.540	–
	X	0.014	0.028	0.056	0.103	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580	–	–	–	–	–
	Y	0.017	0.034	0.068	0.124	0.180	0.220	0.260	0.317	0.430	0.550	0.700	0.700	0.700	0.740	–	–	–	–	–
	Z	0.024	0.047	0.094	0.172	0.250	0.325	0.400	0.533	0.800	1.000	1.100	1.175	1.200	1.200	–	–	–	–	–

Formulas (Metric)			Terms		Formulas (Imperial)		
$v_c = \frac{n \times DC \times \pi}{1000}$ $n = \frac{v_c \times 1000}{DC \times \pi}$ $V_f = f_z \times z \times n$ $f_z = \frac{V_f}{z \times n}$ $Q = \frac{V_f \times a_p \times a_e}{1000}$	v_c	(m/min)	Cutting speed		SFM	(ft/min)	$SFM = \frac{RPM \times DC \times \pi}{12}$ $RPM = \frac{SFM \times 12}{DC \times \pi}$ $IPM = IPT \times T \times RPM$ $IPT = \frac{IPM}{T \times RPM}$ $MRR = IPM \times DOC \times WOC$
	n	(rev/min)	Spindle speed		RPM	(rev/min)	
	V_f	(mm/min)	Feed rate		IPM	(in/min)	
	f_z	(mm/tooth)	Feed per tooth		IPT	(in/tooth)	
	DC	(mm)	Cutting diameter		DC	(in)	
	z	(–)	Number of teeth		T	(–)	
	a_p	(mm)	Depth of cut		DOC	(in)	
	a_e	(mm)	Width of cut		WOC	(in)	
	Q	(cm³/min)	Metal removal rate		MRR	(in³/min)	

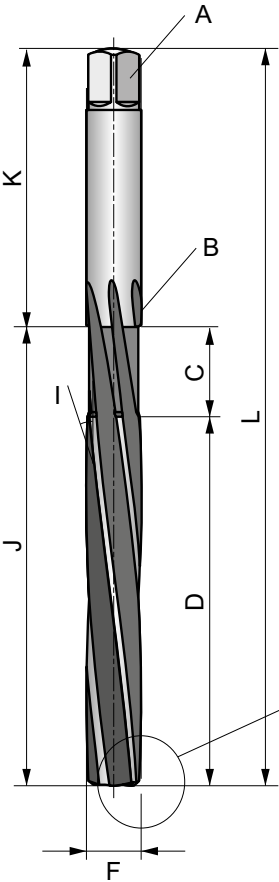
GENERAL – TECHNICAL INFO

Table of Cutting Speeds

		Vc															
m/min.		5	8	10	15	20	25	30	40	50	60	70	80	90	100	110	150
SFM (feet/min.)		16	26	32	50	66	82	98	130	165	197	230	262	296	330	362	495
Ø		RPM															
mm	inch																
1.00	–	1592	2546	3183	4775	6366	7958	9549	12732	15916	19099	22282	25465	28648	31831	35014	47747
1.50	–	1061	1698	2122	3183	4244	5305	6366	8488	10610	12732	14854	16977	19099	21221	23343	31831
2.00	–	796	1273	1592	2387	3183	3979	4775	6366	7958	9549	11141	12732	14324	15916	17507	23873
2.50	–	637	1019	1273	1910	2546	3183	3820	5093	6366	7639	8913	10186	11459	12732	14006	19099
3.00	–	531	849	1061	1592	2122	2653	3183	4244	5305	6366	7427	8488	9549	10610	11671	15916
3.18	1/8	500	801	1001	1501	2002	2502	3003	4004	5005	6006	7007	8008	9009	10010	11011	15015
3.50	–	455	728	909	1364	1819	2274	2728	3638	4547	5457	6366	7276	8185	9095	10004	13642
4.00	–	398	637	796	1194	1592	1989	2387	3183	3979	4775	5570	6366	7162	7958	8754	11937
4.50	–	354	566	707	1061	1415	1768	2122	2829	3537	4244	4951	5659	6366	7074	7781	10610
4.76	3/16	334	535	669	1003	1337	1672	2006	2675	3344	4012	4681	5350	6018	6687	7356	10031
5.00	–	318	509	637	955	1273	1592	1910	2546	3183	3820	4456	5093	5730	6366	7003	9549
6.00	–	265	424	531	796	1061	1326	1592	2122	2653	3183	3714	4244	4775	5305	5836	7958
6.35	1/4	251	401	501	752	1003	1253	1504	2005	2506	3008	3509	4010	4511	5013	5514	7519
7.00	–	227	364	455	682	909	1137	1364	1819	2274	2728	3183	3638	4093	4547	5002	6821
7.94	5/16	200	321	401	601	802	1002	1203	1604	2004	2405	2806	3207	3608	4009	4410	6013
8.00	–	199	318	398	597	796	995	1194	1592	1989	2387	2785	3183	3581	3979	4377	5968
9.00	–	177	283	354	531	707	884	1061	1415	1768	2122	2476	2829	3183	3537	3890	5305
9.53	3/8	167	267	334	501	668	835	1002	1336	1670	2004	2338	2672	3006	3340	3674	5010
10.00		159	255	318	477	637	796	955	1273	1592	1910	2228	2546	2865	3183	3501	4775
11.11	7/16	143	229	287	430	573	716	860	1146	1433	1719	2006	2292	2579	2865	3152	4298
12.00		133	212	265	398	531	663	796	1061	1326	1592	1857	2122	2387	2653	2918	3979
12.70	1/2	125	201	251	376	501	627	752	1003	1253	1504	1754	2005	2256	2506	2757	3760
14.00		114	182	227	341	455	568	682	909	1137	1364	1592	1819	2046	2274	2501	3410
14.29	9/16	111	178	223	334	446	557	668	891	1114	1337	1559	1782	2005	2228	2450	3341
15.00	–	106	170	212	318	424	531	637	849	1061	1273	1485	1698	1910	2122	2334	3183
15.88	5/8	100	160	200	301	401	501	601	802	1002	1203	1403	1604	1804	2004	2205	3007
16.00	–	99	159	199	298	398	497	597	796	995	1194	1393	1592	1790	1989	2188	2984
17.46	11/16	91	146	182	273	365	456	547	729	912	1094	1276	1458	1641	1823	2005	2735
18.00	–	88	141	177	265	354	442	531	707	884	1061	1238	1415	1592	1768	1945	2653
19.05	3/4	84	134	167	251	334	418	501	668	835	1003	1170	1337	1504	1671	1838	2506
20.00	–	80	127	159	239	318	398	477	637	796	955	1114	1273	1432	1592	1751	2387
24.00	–	66	106	133	199	265	332	398	531	663	796	928	1061	1194	1326	1459	1989
25.00	–	64	102	127	191	255	318	382	509	637	764	891	1019	1146	1273	1401	1910
27.00	–	59	94	118	177	236	295	354	472	589	707	825	943	1061	1179	1297	1768
30.00	–	53	85	106	159	212	265	318	424	531	637	743	849	955	1061	1167	1592
32.00	–	50	80	99	149	199	249	298	398	497	597	696	796	895	995	1094	1492
36.00	–	44	71	88	133	177	221	265	354	442	531	619	707	796	884	973	1326
40.00	–	40	64	80	119	159	199	239	318	398	477	557	637	716	796	875	1194
50.00	–	32	51	64	95	127	159	191	255	318	382	446	509	573	637	700	955

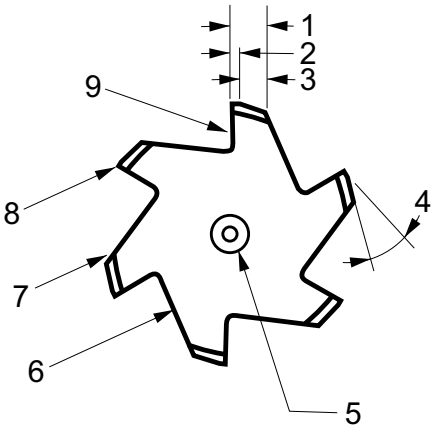
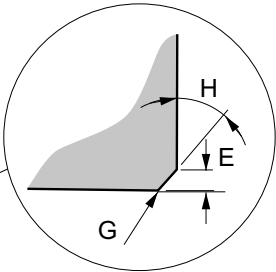
REAMING – TECHNICAL INFO

Reamer Definitions / Nomenclature

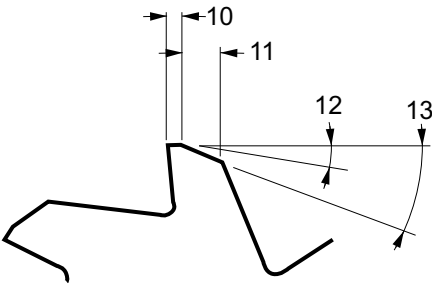


A	Tang or Square Drive
B	Recess Diameter
C	Recess Length
D	Cut Length
E	Bevel Lead Length
F	Diameter

G	Bevel Lead
H	Bevel Lead Angle
I	Helix Angle
J	Body Length
K	Shank Length
L	Overall Length



1	Width of Land
2	Circular Land
3	Clearance
4	Clearance Angle
5	Centre Hole
6	Flute
7	Heel
8	Cutting Edge
9	Face



10	Width of Primary Clearance
11	Width of Secondary Clearance
12	Primary Clearance Angle
13	Secondary Clearance Angle

REAMING – TECHNICAL INFO

Rivning

For at opnå det bedste resultat, når der anvendes rival (rømmere), er det vigtigt at de “har noget at arbejde med”.. Det er en almindelig fejl at forberede hullerne til rivning så der er for lidt materiale at arbejde med. Hvis der er for lidt materiale i hullet før der rives (rømmes), vil sænkeren skrabe på, hurtigt vise tegn på slitage. Men det er lige så vigtigt for et godt resultat, at der ikke er for meget arbejdsmateriale i hullet. (Se fjernelse af materiale nedenfor).

1. Vælg den optimale rival og de optimale skærehastigheder og tilspændinger til anvendelsen. Sørg for, at de forborede huller har den rigtige diameter.
2. Arbejdsemnet skal holdes helt fast, og maskinens spindel må ikke have spil.
3. Borepatronen, som en lige skaftrival opspændes i, skal være af en god kvalitet. Hvis rivalen glider i patronen og tilspændingen udføres automatisk, kan rivalen evt. knække.

4. Sørg for, at værktøjet har så lille en afstand som mulig mellem maskine og spindel.
5. Brug anbefalede smøremidler for at øge rivalens levetid, og sørg for, at væsken når ud til skærekantene. Da rivning ikke medfører svært spåntagende arbejde, er en opløselig olie i forholdet 40:1 normalt tilfredsstillende. Luftblæsning kan bruges i forbindelse med gråt støbejern, hvis bearbejdningen er tør.
6. Sørg for, at rivalens spor ikke tilstoppes af spåner.
7. Før rivalen slibes igen, skal koncentriciteten mellem centrene kontrolleres. I de fleste tilfælde er det kun skråkantens styrekant, der skal efterslibes.
8. Hold rivalen skarp. Der er god økonomi i at efterslibe ofte, men det er vigtigt at forstå, at sænkerne kun skærer med skråkantens- og spidsens styrekant og ikke med frigangen. Derfor er det kun disse styreskær, der skal efterslibes. En nøjagtig efterslibning er vigtig med henblik på hulkvalitet og værktøjets levetid.

Fjernelse af grundmateriale

Hvor meget grundmateriale der skal fjernes ved rivning, afhænger af emnets materiale og det forborede huls overfladefinsh. Der vises generelle retningslinjer for fjernelse af grundmateriale i de følgende tabeller:

Størrelse af sænkningshul(mm)	Såfremt forboret	Såfremt forkerneboret
Under 4	0.1	0.1
Over 4 til 11	0.2	0.15
Over 11 til 39	0.3	0.2
Over 39 til 50	0.4	0.3

Størrelse af rivningshul (inches)	Såfremt forboret	Såfremt forkerneboret
Under 3/16"	0.004"	0.004"
3/16" til 1/2"	0.008"	0.006"
1/2" til 1.1/2"	0.010"	0.008"
1.1/2" til 2"	0.016"	0.010"

Hand/Machine reaming

Although both hand and machine reamers offer the same capability regarding finished hole size, the use of each must be considered according to the application. A hand reamer, for reasons of alignment, has a long taper lead, whereas a machine reamer has only a 45 degree bevel lead. A machine reamer cuts only on the bevel lead while a hand reamer cuts on the bevel lead as well as the taper lead.

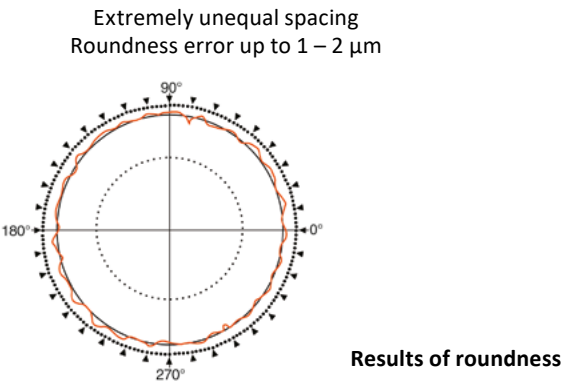
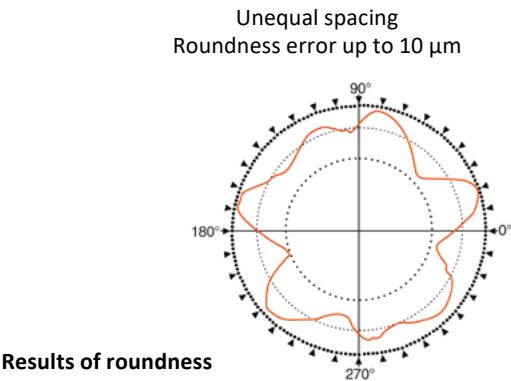
The most common types of reamers have a left-hand spiral because the main applications involve through holes requiring chips to be pushed forward. For blind holes, reamers with straight flutes or right hand spirals are recommended.

The most efficient reaming conditions depend on the application, material, quality of hole required, stock removal, lubrication and other factors. A general guide to surface speeds and feeds for

machine reamers is shown in the reamer WMG and feed charts (see Product Selector) and stock removal tables.

Extremely unequal spacing on reamers means that the divide is not the same for each tooth. As there are no two teeth diametrically opposite each other, the reamer produces a hole with a roundness variance of between 1 and 2 µm. This compared with a variance of up to 10µm with conventional unequal spacing.

Carbide Reamers – Comparison spacing / EU spacing



REAMING – TOLERANCE LIMITS – TECHNICAL INFO

Tolerancegrænser



1. PÅ STANDARDRIVALENS SKÆREDIAMETER
- Diameteren (DC) måles over den cirkulære frigang umiddelbart bag ved skråkantens eller spidsens styrekant. Tolerance iht. DIN 1420 er udlagt til at producere H7-huller.

Rivaltolerance			
Diameter (mm)		Tolerancegrænse (mm)	
Over	Op til og med	Høj +	Lav +
–	3	0.008	0.004
3	6	0.010	0.005
6	10	0.012	0.006
10	18	0.015	0.008

Rivaltolerance			
Diameter (mm)		Tolerancegrænse (mm)	
Over	Op til og med	Høj +	Lav +
18	30	0.017	0.009
30	50	0.021	0.012
50	80	0.025	0.014

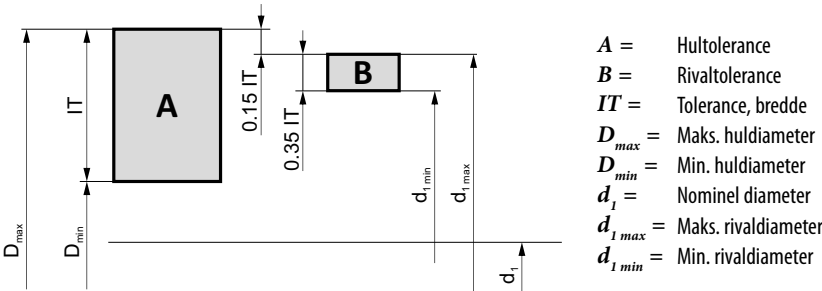
2. PÅ ET H7-HUL
- Den mest almindelige tolerance på et færdigt hul er H7 (se tabel nedenfor). Ved andre tolerancer kan illustrationen og skemaet ved siden af punkt 3 bruges til at beregne rivalens tolerance.

Hultolerance			
Diameter (mm)		Tolerancegrænse ((mm)	
Over	Op til og med	Høj +	Lav +
–	3	0.010	0
3	6	0.012	0
6	10	0.015	0
10	18	0.018	0

Hultolerance			
Diameter (mm)		Tolerancegrænse ((mm)	
Over	Op til og med	Høj +	Lav +
18	30	0.021	0
30	50	0.025	0
50	80	0.030	0

3. Hvis det er nødvendigt at definere målene på en specialrival, der skal skære med en specifik tolerance, f.eks. D8, kan følgende velafprøvede retningslinjer anvendes.

Diametertolerance, bredde (µm)								
Tolerance, bredde (my)	Over 1 inkl. 3	Over 3 inkl. 6	Over 6 inkl. 10	Over 10 inkl. 18	Over 18 inkl. 30	Over 30 inkl. 50	Over 50 inkl. 80	Over 80 inkl. 120
IT5	4	5	6	8	9	11	13	15
IT6	6	8	9	11	13	16	19	22
IT7	10	12	15	18	21	25	30	35
IT8	14	18	22	27	33	39	46	54
IT9	25	30	36	43	52	62	74	87
IT10	40	48	58	70	84	100	120	140
IT11	60	75	90	110	130	160	190	220
IT12	100	120	150	180	210	250	300	350



Dvs. et 10 mm-hul med tolerancen D8, maks dia = 10.062, min dia = 10.040, hultolerance (IT8) = 0.022

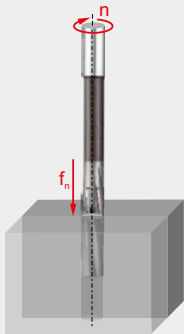
Maks. grænse: 0,15 x hultolerance (IT8) = 0.0033, oprundet = 0.004

Min. grænse: 0,35 x hultolerance (IT8) = 0.0077, oprundet = 0.008

Maks. grænse for sænker = 10.062 - 0.004 = 10.058

Min. grænse for sænker = 10.058 - 0.008 = 10.050

REAMERS FEED RATE CHART

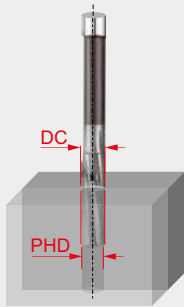


Feed per revolution (f_n in mm/rev)
Depending on the working conditions
it might be necessary to adjust these
values $\pm 15\%$.

How to use this table to find the feed per revolution (f_n):

1. Find your Alpha Code on the product page (example: 21C, "C" is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per revolution (f_n).

		ø DC (mm)																		
		1.00	1.50	2.00	3.00	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	80.00
Feed rates (mm/rev)	A	0.030	0.045	0.055	0.078	0.090	0.100	0.125	0.137	0.150	0.170	0.185	0.210	0.220	0.250	0.280	0.320	0.390	0.440	0.500
	B	0.035	0.055	0.072	0.110	0.130	0.150	0.165	0.172	0.180	0.210	0.240	0.270	0.280	0.310	0.360	0.400	0.500	0.550	0.600
	C	0.040	0.065	0.085	0.135	0.160	0.185	0.200	0.210	0.220	0.260	0.285	0.325	0.335	0.390	0.440	0.480	0.600	0.680	0.750
	D	0.050	0.080	0.110	0.160	0.180	0.200	0.235	0.253	0.270	0.320	0.360	0.400	0.410	0.470	0.540	0.600	0.730	0.850	0.950
	E	0.065	0.100	0.140	0.180	0.215	0.250	0.300	0.325	0.350	0.390	0.430	0.485	0.500	0.530	0.640	0.750	0.910	1.100	1.200
	F	0.090	0.140	0.180	0.260	0.305	0.350	0.395	0.417	0.440	0.500	0.550	0.610	0.630	0.700	0.800	0.930	1.200	1.500	1.650



Machining allowance when using
a **machine reamer** (MA in mm)
Premachined hole diameter
 $PHD = DC - MA$.

How to use this table to get to the right premachined hole diameter (PHD):

1. Find the diameter range for your cutting application in the top row of the table.
2. Find your ISO Group Code in the left column of the table (example: For Stainless Steel the ISO Group Code is "M")
3. The intersection (cell) of the Diameter Range and ISO Group Code is the Machining Allowance (MA)
4. Subtract the Machining Allowance from the reaming diameter to get to the premachined hole diameter (PHD).

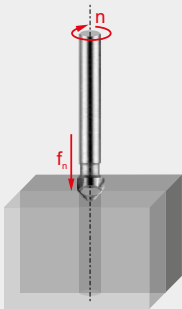
(example: for a 6mm hole in steel (P) the PHD is 5.85mm)

		ø DC (mm)										
		1.00	5.00	5.00	8.00	8.00	12.00	12.00	16.00	16.00	30.00	30.00
ISO group	P	0.10		0.15		0.20		0.20		0.30		0.30
	M	0.08		0.10		0.10		0.20		0.20		0.30
	K	0.10		0.15		0.20		0.20		0.30		0.30
	N	0.10		0.15		0.20		0.20		0.30		0.30
	S	0.05		0.10		0.10		0.15		0.20		0.20
	H	0.05		0.05		0.10		0.10		0.15		0.20

Be cautious with the machining tolerances of drills, the tool diameter is not the same as the hole diameter produced!

Note: The recommended allowance when using a hand reamer is 0.05 to 0.10 mm.

COUNTERSINKS FEED RATE CHART



Feed per revolution (f_n in mm/rev)
Depending on the working conditions
it might be necessary to adjust these
values $\pm 15\%$.

How to use this table to find the feed per revolution (f_n):

1. Find your Alpha Code on the product page (example: 23E, "E" is the Alpha Code).
2. Find the closest diameter for your cutting application in the top row of the table.
3. Find your Alpha Code in the left column of the table.
4. The intersection (cell) of the Diameter and Alpha Code is the feed per revolution (f_n).

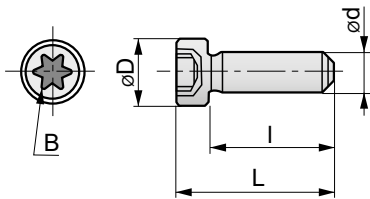
		ø DC (mm)									
		6.00	8.00	10.00	16.00	20.00	25.00	32.00	40.00	60.00	80.00
Feed rates (mm/rev)	A	0.030	0.040	0.050	0.060	0.080	0.090	0.100	0.120	0.140	0.160
	B	0.040	0.050	0.060	0.080	0.100	0.120	0.140	0.160	0.180	0.200
	C	0.050	0.060	0.080	0.100	0.120	0.140	0.160	0.180	0.200	0.220
	D	0.060	0.080	0.100	0.120	0.150	0.180	0.200	0.220	0.250	0.280
	E	0.080	0.100	0.120	0.150	0.180	0.200	0.250	0.270	0.300	0.320
	F	0.090	0.110	0.130	0.160	0.190	0.210	0.260	0.290	0.330	0.360
	G	0.100	0.120	0.150	0.180	0.200	0.220	0.280	0.320	0.360	0.400
	H	0.120	0.150	0.180	0.200	0.220	0.250	0.300	0.350	0.400	0.450

HYDRA – TECHNICAL INFO

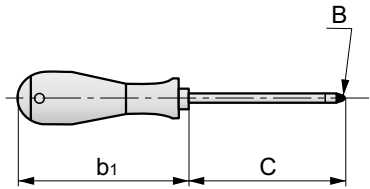
Torque table

					Torque Values Nm (Metric System)	Torque Values in/lbs (Inch System)
H860	H861	Hydra Head ø Metric Range	Hydra Head ø Fractional Range	Hydra Head ø Decimal Size Range (min. / max.)		
H860N1	H861N1	12.0 mm – 15.5 mm	15/32" – 39/64"	0.4688" – 0.6102"	0.75 – 0.99	6.6 – 8.8
H860N2	H861N2	15.6 mm – 18.5 mm	5/8" – 23/32"	0.6142" – 0.7283v	0.93 – 1.24	8.2 – 11.0
H860N3	H861N3	18.6 mm – 21.5 mm	47/64" – 27/32"	0.7323" – 0.8465"	1.84 – 2.44	16.3 – 21.6
H860N4	H861N3	22.0 mm – 24.5 mm	55/64" – 31/32"	0.8594" – 0.9688"	2.73 – 3.72	24.2 – 32.9
H860N5	H861N4	25.0 mm – 27.5 mm	63/64" – 1-3/32"	0.9843" – 1.0938"	4.14 – 5.52	36.6 – 48.8
H860N6	H861N5	28.0 mm – 33.5 mm	1-7/64" – 1-19/64"	1.1024" – 1.3189"	4.97 – 6.63	44.0 – 58.7
H860N7	H861N6	34.0 mm – 42.0 mm	1-11/32" – 1-5/8"	1.3386" – 1.6535"	7.2	63.7

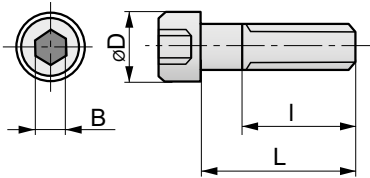
Screws and screw-driver data



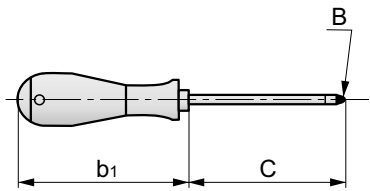
e-code	d	Pitch	L (mm)	I (mm)	D (mm)	B
H860N1	M2.2	0.45	7.5	5.7	3.5	8IP
H860N2	M2.5	0.45	9.0	7.0	4.1	10IP
H860N3	M3.0	0.50	10.5	8.0	4.9	15IP
H860N4	M3.5	0.60	11.5	8.8	5.5	15IP
H860N5	M4.0	0.70	12.5	9.5	6.0	20IP
H860N6	M4.5	0.75	14.3	10.8	6.8	25IP



e-code	B	C	b ₁
H861N1	8IP	60	104
H861N2	10IP	80	111
H861N3	15IP	80	111
H861N4	20IP	100	118
H861N5	25IP	100	118



e-code	d	Pitch	L (mm)	I (mm)	D (mm)	B
H860N7	M5.0	0.8	15	full	8.5	4

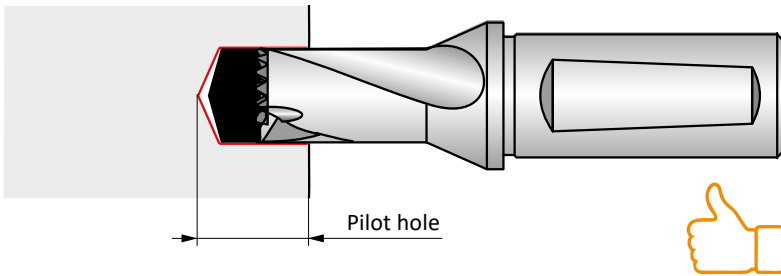


e-code	B	C	b ₁
H861N6	4	75	111

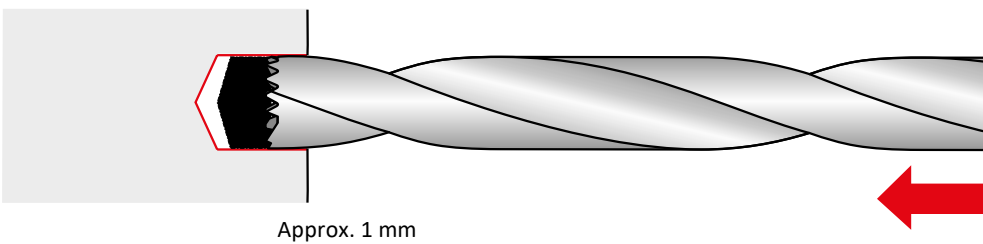


HYDRA – TECHNICAL INFO

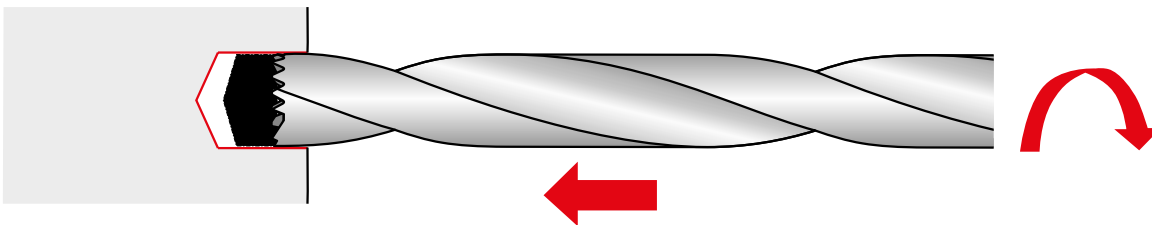
Apply special programming for 8xD and 12xD drilling



Drill a pilot hole (1.5xD to 3xD depth) with the same HYDRA head diameter (if needed check the runout of the drill max. +/- 0.05 mm).



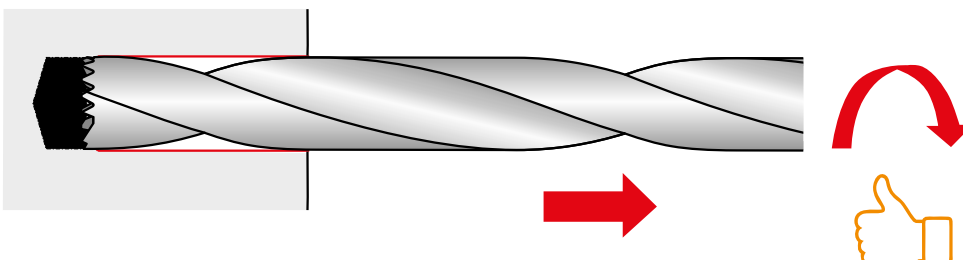
Enter the pilot hole with the 8xD or 12xD Body running a maximum of 500 rpm, to approximately 1mm above the pre-drilled pilot hole depth.



Start coolant flow and increase the rotational speed up to the recommended RPM.

Note: Apply a short dwell time don't start the feed before recommended RPM is reached.

Drill without pecking to the required depth.



When the required depth is reached, retract the drill by approximately 0.1 mm to 0.5 mm and reduce to 500 rpm followed by a complete retraction with normal feed. **Note: retracting the drill with a higher spindle speed may cause a shoulder damage from run out or destroy the hole surface and tolerance.**

HYDRA – TECHNICAL INFO

Drilling hints & tips with the hydra drill

Coolants

For maximum chip evacuation and tool performance, coolant use is recommended. Emulsion coolant concentration of 6 – 8% is recommended for most applications, with a coolant pressure of 20 bar (290 PSI) or higher. For high strength steel, stainless steels and tougher drilling applications, use a higher concentration of 10 – 12%. In these applications, particularly in stainless steels, it is recommended to use the maximum coolant pressure on the machine. The Hydra-drill coolant holes provide improved web strength and reduce heat at the cutting edges for increased productivity and longer tool life.

Holders

Always use tool holders and collets that provide good concentricity

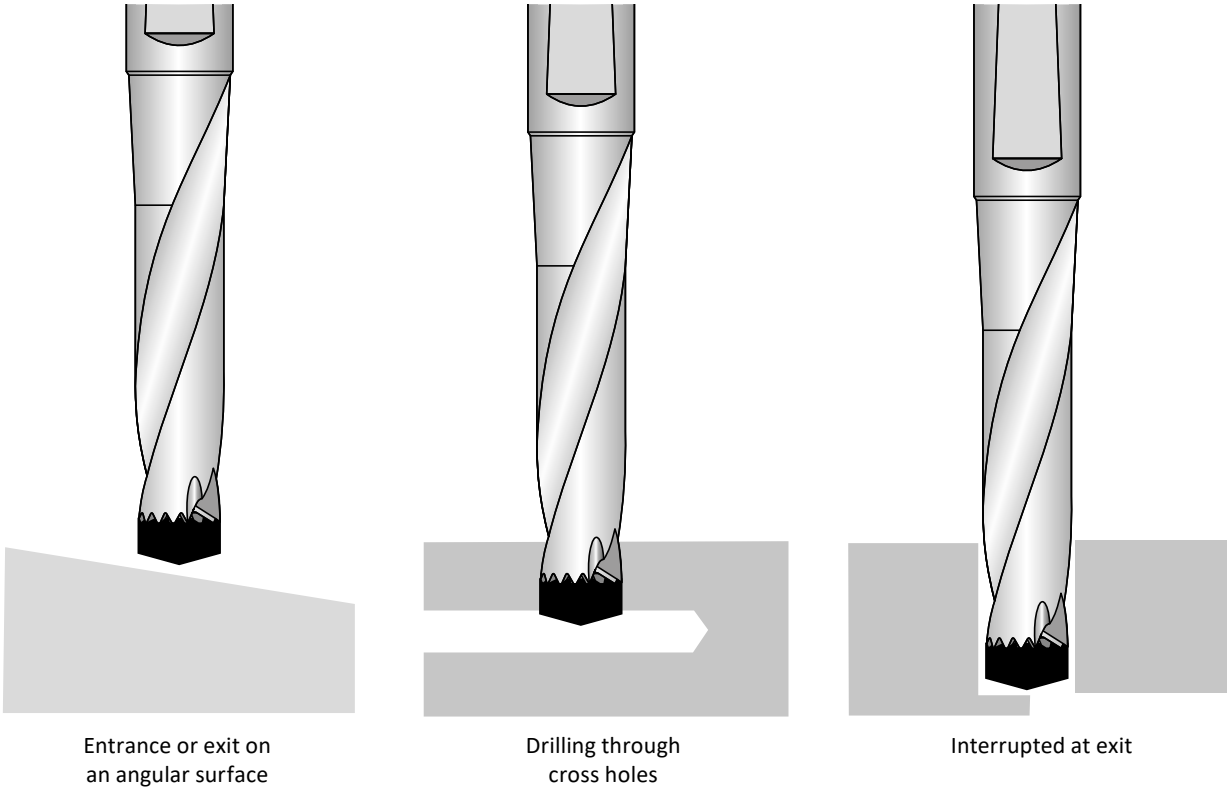
between the drill and the machine spindle. Use a positive stop to prevent the tool from backing up into the holder. Radial runout in the tool assembly must be accurately checked and maintained.

Workpiece

A secure and rigid workpiece will minimise deflection, and allow for better accuracy and true position of the hole.

Feeds

It is important not to underfeed the drill which will cause it to dwell and dull. This is particularly true in work hardening materials. Feed rates should be high enough for proper chip formation.



In these drilling scenarios, reducing feed rate to 1/3 (33%) is generally recommended. Drilling into an entry angle of more than 10° is NOT recommended – surface should be milled flat first.

MASKINBEARBEJDNINGSDATA FOR INDSATSBOR

Radial justering

Anbefaling for hul diameterjustering og opsætning

Radial justering er muligt med vendeskærsbor for at opnå en mindre eller større huldiameter end det faktiske bor.

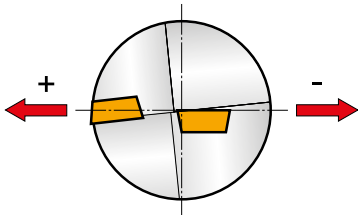
Radiale justeringsværdier kan findes i tabellerne med hovedboredata.

Roterende værktøj

Ved boring af huller med nøjagtighed IT10 og højere anbefales de justerbare holdere ved brug af 802D-, 803D-, 804D- og 805D-bor.

Stationært værktøj

Ved montering af boret skal borets midterlinje og arbejdsemnets midte være ud for hinanden. Forskyd boret for at opnå en større huldiameter, så den perifere vendeskær flytter et + væk fra arbejdsemnets midterlinje.



Værktøjslevetid

Vendskær skal skiftes, når flankslitagen måler 0,2 – 0,4 mm ved det største punkt.

Skæredataanbefalingerne i dette katalog har til formål at give en værktøjslevetid på 7 meter boredybde for den perifere skær. (20-30 min. kontakt).

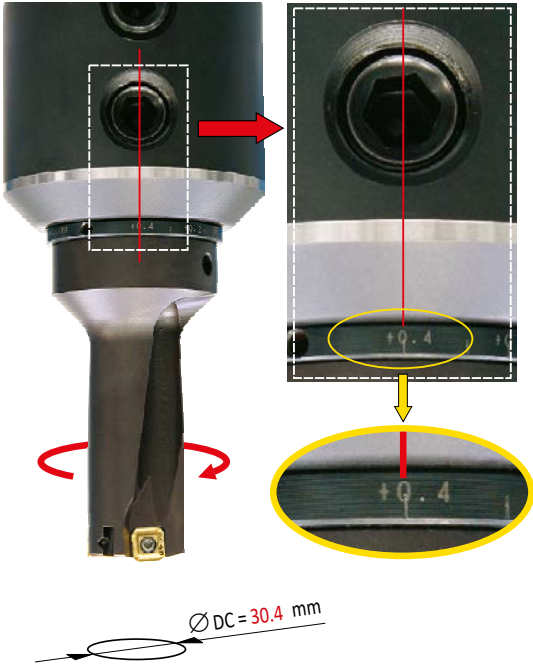
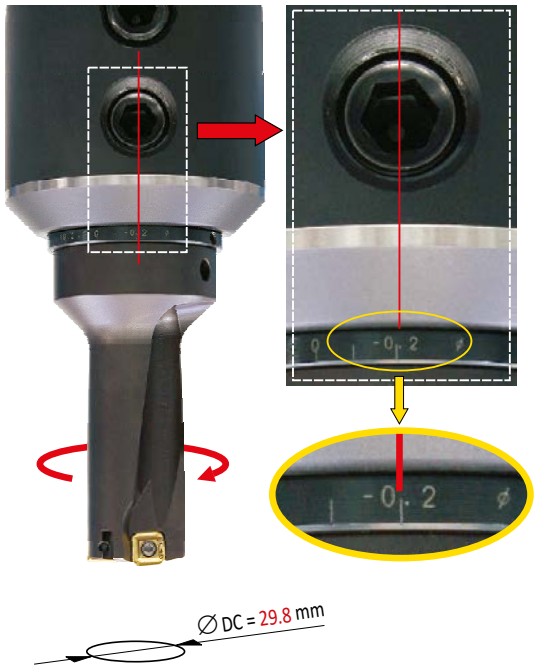
EP

JUSTERBAR HOLDER

Skaft-dia.	Bor-dia.	Område
25	15 – 24	+0.4 – -0.2
32	24.5 – 40	+0.4 – -0.2

For fræsemaskiner

Justeringsområde for diameter



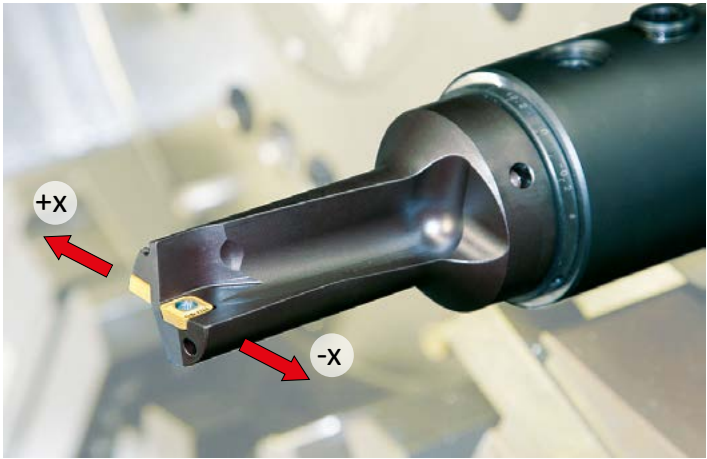
EP

JUSTERBAR HOLDER

Skaft-dia.	Bor-dia.	Område
25	15 – 24	+0.2 – -0.15
32	24.5 – 40	+0.2 – -0.15

Justering af midterhøjde
– for drejebæksoperation

Justeringsområde for midterhøjde



MASKINBEARBEJDNINGSDATA FOR VENDESKÆRSBOR

Anbefalet tryk for tilført skærevæske

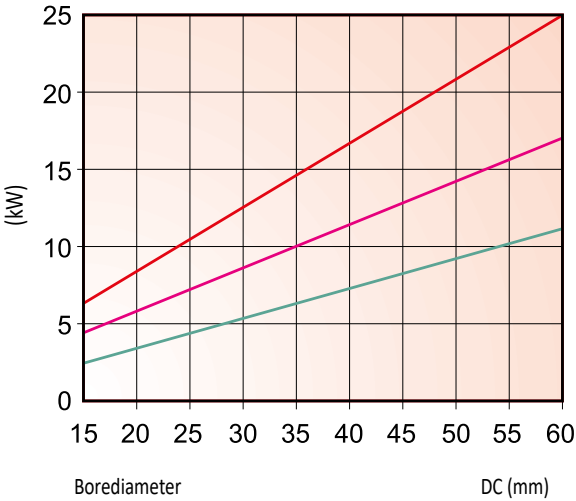
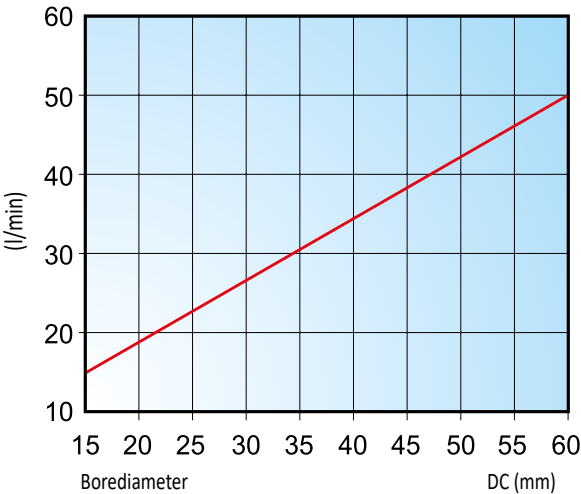
Borediameter DC (mm)	Tryk for skærevæske	
	Borelængde	
	2.0 – 2.5 DC	3.0 – 5.0 DC
15 – 25	6 bar	12 bar
26 – 40	4.5 bar	9 bar
> 40	3 bar	6 bar

Krav til kølemiddelmængde

TØRBORING

Trykluft gennem boret anbefales, når der bores uden kølemiddel i støbejern og stål

Nettostrømforbrug



	BORING AF BUNDHUL Ved boring af huller, der er dybere end 1D, er indvendig køling påkrævet.
	BORING AF GENNEMGÅENDE HUL Der kan blive produceret en skive, når det indekserbare bor forlader materialet. Denne skive kan blive slynget ud ved høj hastighed, når arbejdsområdet roterer. Det er afgørende, at maskinen er tilstrækkeligt sikret, så operatøren ikke kommer til skade.
	EKSCENTERBORING Reducer tilspændingen til den lavere anbefalede værdi for bestemte vendeskær. Se data for vendeskæret. Overskrid ikke de radiale justeringsværdier.
	START PÅ UJÆVNE OG STØBTE OVERFLADER Reducer tilspændingen med 50 % ved indgangen for vendeskærbor, indtil begge indsatser er aktiveret.
	UDBORING OG BORING I STYREHULLER Hvis et forboret hul har en større diameter end 1/4 bor, skal tilspændingen reduceres.
	BORING AF KRYDSHULLER Reducer tilspændingen med 50 % ved boring i et eksisterende hul. Diameteren for det eksisterende hul må ikke være større end 0,25 x D.
	AFBRUDT SKÆRING OG OPKRAVNING Reducer tilspændingen til den lavere anbefalede tilspænding for bestemte vendeskær. Se beskrivelsen af skær for vendeskærsbor.
	BORING PÅ BUET OVERFLADE Boring på midterlinjen kan foretages med reduceret tilspændingshastighed ned til 50 % under indgang og udgang.
	BORING PÅ VINKLEDE OVERFLADER Reducer tilspændingen med 50 % ved indgangen for vendeskærsbor, indtil begge skær er aktiveret, hvis indgangsvinklen er større end 5°.
	UDGANG PÅ VINKLET OVERFLADE Reducer tilspændingen med 50 % ved udgang, hvis udgangsvinklen er større end 5°.
	START PÅ EN SVEJSESØM Plandrejning anbefales før boring. Reducer tilspændingen med 50 % under boring i det svejsede materiale.
	DRILLING OF STACKED MATERIALS Avoid spaces larger than 0.2 mm between layers. The component must be securely fixed. If necessary reduce the feed.

INDEXABLE DRILLS – RECOMMENDED CUTTING CONDITIONS

802D, 803D (XPET..AP, SCET..-UD) f ⇒									
	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
P2	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
P3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
P4	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
K1	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K2	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K3	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K4	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K5	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34

802D, 803D (XPET..AP-SD, SCET..-SD) f ⇒									
	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.08	0.09	0.10	0.11	0.14	0.18
P2	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
P3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
P4	■	■	■	–	–	–	–	–	–
K1	▣	▣	▣	0.08	0.09	0.10	0.11	0.14	0.18
K2	▣	▣	▣	0.11	0.13	0.15	0.17	0.21	0.28
K3	▣	▣	▣	0.12	0.14	0.16	0.18	0.22	0.24
K4	▣	▣	▣	0.13	0.15	0.18	0.20	0.24	0.32
K5	▣	▣	▣	0.14	0.16	0.19	0.21	0.25	0.33
M1	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
M2	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
M3	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
M4	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
S1	▣	▣	▣	0.08	0.09	0.10	0.11	0.14	0.18
S2	▣	▣	▣	0.08	0.09	0.10	0.11	0.14	0.18
S3	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
S4	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16

804D (XPET..AP, SCET..-UD) f ⇒									
	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
K1	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K2	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K4	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K5	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32



INDEXABLE DRILLS – RECOMMENDED CUTTING CONDITIONS

804D (XPET..AP-SD, SCET..-SD)



	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	–	–	–	–	–	–
K1	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
K2	▣	▣	▣	0.10	0.12	0.14	0.16	0.19	0.25
K3	▣	▣	▣	0.11	0.13	0.15	0.17	0.20	0.27
K4	▣	▣	▣	0.12	0.14	0.16	0.18	0.22	0.30
K5	▣	▣	▣	0.14	0.16	0.19	0.21	0.25	0.33
M1	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
M2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
M3	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
M4	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
S1	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
S2	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
S3	▣	▣	▣	0.06	0.07	0.08	0.09	0.10	0.14
S4	▣	▣	▣	0.06	0.07	0.08	0.09	0.10	0.14

805D (XPET..AP, SCET..-UD)



	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
K1	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K2	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K4	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K5	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32

805D (XPET..AP-SD, SCET..-SD)



	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	–	–	–	–	–	–
K1	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
K2	▣	▣	▣	0.10	0.12	0.14	0.16	0.19	0.25
K3	▣	▣	▣	0.11	0.13	0.15	0.17	0.20	0.27
K4	▣	▣	▣	0.12	0.14	0.16	0.18	0.22	0.30
K5	▣	▣	▣	0.12	0.14	0.16	0.18	0.22	0.30
M1	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
M2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
M3	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
M4	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
S1	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
S2	▣	▣	▣	0.07	0.08	0.09	0.10	0.12	0.16
S3	▣	▣	▣	0.06	0.07	0.08	0.09	0.10	0.14
S4	▣	▣	▣	0.06	0.07	0.08	0.09	0.10	0.14

FORMEL TIL BEREGNING AF SKÆREPARAMETRE

NOMENKLATUR OG FORMEL		
Parameter	Formel e	Enhed
RPM	$n = \frac{v_c \cdot 1000}{DC \cdot \pi}$	(omdr./min)
Skærehastighed	$v_c = \frac{\pi \cdot DC \cdot n}{1000}$	(m/min)
Bordtilspænding	$v_f = n \cdot f$	(mm/min)
Hullets tværsnitsområde	$A = \frac{\pi \cdot DC^2}{4}$	(mm²)
Spånvolumen	$Q = \frac{v_f \cdot A}{1000}$	(cm³/min)
Maskinbearbejdningstid	$T_c = \frac{L + h}{v_f}$	(min/pièce)

DC Borediameter

f Tilspænding pr. omdrejning

(mm)

(mm/omdr.)

h Afstand fra borepunkt til arbejdsemne før tilspænding

L Huldylbde

(mm)

(mm)

ANBEFALEDE TILSPÆNDINGSMOMENTER FOR SKRUE

						
US 2245-T07P	0.9	FLAG T07P	M 2.2	5.3	D-T7P	MR-0.8-2.0 vario
US 2205-T07P	0.9	FLAG T07P	M2.2	5.4	D-T7P	MR-0.8-2.0 vario
US 2506-T07P	1.2	FLAG T07P	M 2.5	6	D-T7P	MR-0.8-2.0 vario
US 2507-T08P	1.2	FLAG T08P	M 2.5	7	D-T8P	MR-0.8-2.0 vario
US 3007-T08P	2.0	FLAG T08P	M 3	7	D-T8P	MR-1.0-5.0 vario
US 3007-T09P	2.0	FLAG T09P	M 3	7.4	D-T9P	MR-1.0-5.0 vario
US 3009-T09P	2.0	FLAG T09P	M 3	8.7	D-T9P	MR-1.0-5.0 vario
US 3508-T15P	3.0	FLAG T15P	M 3.5	8.3	D-T15P	MR-1.0-5.0 vario
US 3510-T15P	3.0	FLAG T15P	M 3.5	10.6	D-T15P	MR-1.0-5.0 vario
US 4011-T15P	3.5	FLAG T15P	M 4	10.7	D-T15P	MR-1.0-5.0 vario
US 5012-T15P	5.0	FLAG T15P	M 5	12.2	D-T15P	MR-1.0-5.0 vario

WMG (WORK MATERIAL GROUP)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830	
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620	
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620	
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620	
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830	
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030	
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620	
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900	
		P3.3			260 – 360 HB	> 900 ≤ 1240	
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900	
		P4.2		Hardened and tempered	26 – 39 HRC	> 900 ≤ 1240	
		P4.3			39 – 45 HRC	> 1240 ≤ 1450	
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520	
		M1.2			160 – 220 HB	> 520 ≤ 700	
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670	
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950	
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300	
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750	
		M3.2			200 – 260 HB	> 750 ≤ 870	
		M3.3			260 – 300 HB	> 870 ≤ 1040	
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990	
		M4.2	Precipitation hardening austenitic stainless steel		300 – 380 HB	≤ 1320	
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190	
		K1.2		Ferritic-pearlitic or pearlitic	180 – 240 HB	> 190 ≤ 310	
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390	
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400	
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550	
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660	
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560	
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680	
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800	
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190	
		K4.2	Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)		< 240 HB	≤ 740	
		K4.3	Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)	< 280 HB	> 840 ≤ 980		
		K4.4		280 – 320 HB	> 980 ≤ 1130		
		K4.5		320 – 360 HB	> 1130 ≤ 1280		
	K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	
		K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	
		K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500	
N	N1	N1.1	Commercially pure wrought aluminium	Half hard tempered Full hard tempered	< 60 HB	≤ 240	
		N1.2			60 – 100 HB	> 240 ≤ 400	
		N1.3			100 – 150 HB	> 400 ≤ 590	
	N2	N2.1	Cast aluminium alloys		< 75 HB	≤ 240	
		N2.2			75 – 90 HB	> 240 ≤ 270	
		N2.3			90 – 140 HB	> 270 ≤ 440	
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–	
		N3.2	Short-chip copper-alloys with good to moderate machining properties		–	–	
		N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties		–	–	
	N4	N4.1	Thermoplastic polymers		–	–	
		N4.2	Thermosetting polymers		–	–	
		N4.3	Reinforced polymers or composites		–	–	
	N5	N5.1	Graphite		–	–	
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660	
		S1.2			200 – 280 HB	> 660 ≤ 950	
		S1.3			280 – 360 HB	> 950 ≤ 1200	
	S2	S2.1	Fe-based high-temperature alloys		< 200 HB	≤ 690	
		S2.2			200 – 280 HB	> 690 ≤ 970	
	S3	S3.1	Ni-based high-temperature alloys		< 280 HB	≤ 940	
		S3.2			280 – 360 HB	> 940 ≤ 1200	
	S4	S4.1	Co-based high-temperature alloys		< 240 HB	≤ 800	
S4.2		240 – 320 HB			> 800 ≤ 1070		
H	H1	H1.1	Chilled cast iron		< 440 HB	–	
	H2	H2.1	Hardened cast iron		< 55 HRC	–	
		H2.2			> 55 HRC	–	
	H3	H3.1	Hardened steel < 55 HRC		< 51 HRC	–	
		H3.2			51 – 55 HRC	–	
	H4	H4.1	Hardened steel > 55 HRC		55 – 59 HRC	–	
H4.2		> 59 HRC			–		

OMREGNINGSTABEL FOR HÅRDHED

Styrke (MPa)	Hårdhed			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R _m	HB	HV	HRB	HRC
285	86	90	1190	–
320	95	100	56.2	–
350	105	110	62.3	–
385	114	120	66.7	–
415	124	130	71.2	–
450	133	140	75.0	–
480	143	150	78.7	–
510	152	160	81.7	–
545	162	170	85.8	–
575	171	180	87.1	–
610	181	190	89.5	–
640	190	200	91.5	–
675	199	210	93.5	–
705	209	220	95	–
740	219	230	96.7	–
770	228	240	98.1	–
800	238	250	99.5	–
820	242	255	–	23.1
850	252	265	–	24.8
880	261	275	–	26.4
900	266	280	–	27.1
930	276	290	–	28.5
950	280	295	–	29.2
995	295	310	–	31.0
1030	304	320	–	32.2
1060	314	330	–	33.3
1095	323	340	–	34.4
1125	333	350	–	35.5
1155	342	360	–	36.6

Styrke (MPa)	Hårdhed			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R _m	HB	HV	HRB	HRC
1190	352	370	–	37.7
1220	361	380	–	38.8
1255	371	390	–	39.8
1290	380	400	–	40.8
1320	390	410	–	41.8
1350	399	420	–	42.7
1385	409	430	–	43.6
1420	418	440	–	44.5
1455	428	450	–	45.3
1485	437	460	–	46.1
1520	447	470	–	46.9
1555	456	480	–	47.7
1595	466	490	–	48.4
1630	475	500	–	49.1
1665	485	510	–	49.8
1700	494	520	–	50.5
1740	504	530	–	51.1
1775	513	540	–	51.7
1810	523	550	–	52.3
1845	532	560	–	53.0
1880	542	570	–	53.6
1920	551	580	–	54.1
1955	561	590	–	54.7
1995	570	600	–	55.2
2030	580	610	–	55.7
2070	589	620	–	56.3
2105	599	630	–	56.8
2145	608	640	–	57.3
2180	618	650	–	57.8

SIMPLY RELIABLE

Som en professionel kan du vurdere kvaliteten af dit arbejde kun ved at studere metalspånen. Metalspånen har en ren og ukompliceret form, der fortæller en historie. Det er derfor, vi bruger dette symbol til at illustrere vores pålidelighed, «Simply Reliable».

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