

CATALOG &  
GHID TEHNIC  
2021.2



# PRELUCRAREA ALEZAJELOR

**SECO** 

>30.000

PRODUSE STANDARD



>75

DE ȚĂRI



>4.100

ANGAJAȚI DEDICAȚI



Având sediul central în Fagersta, Suedia, și fiind prezentă în peste 75 de țări, Seco Tools este un lider global în furnizarea de soluții de prelucrare prin așchiere pentru frezare, unelte staționare, prelucrarea alezajelor și sistemele de prelucrare.

Timp de peste 80 de ani, compania a furnizat tehnologii, procese și suport pe care producătorii se bazează pentru a obține productivitate și profitabilitate maxime.

Pentru mai multe informații despre modul în care produsele inovatoare și serviciile experte de la Seco susțin succesul producătorilor din toate segmentele industriale, vizitați site-ul [www.secotools.com](http://www.secotools.com).

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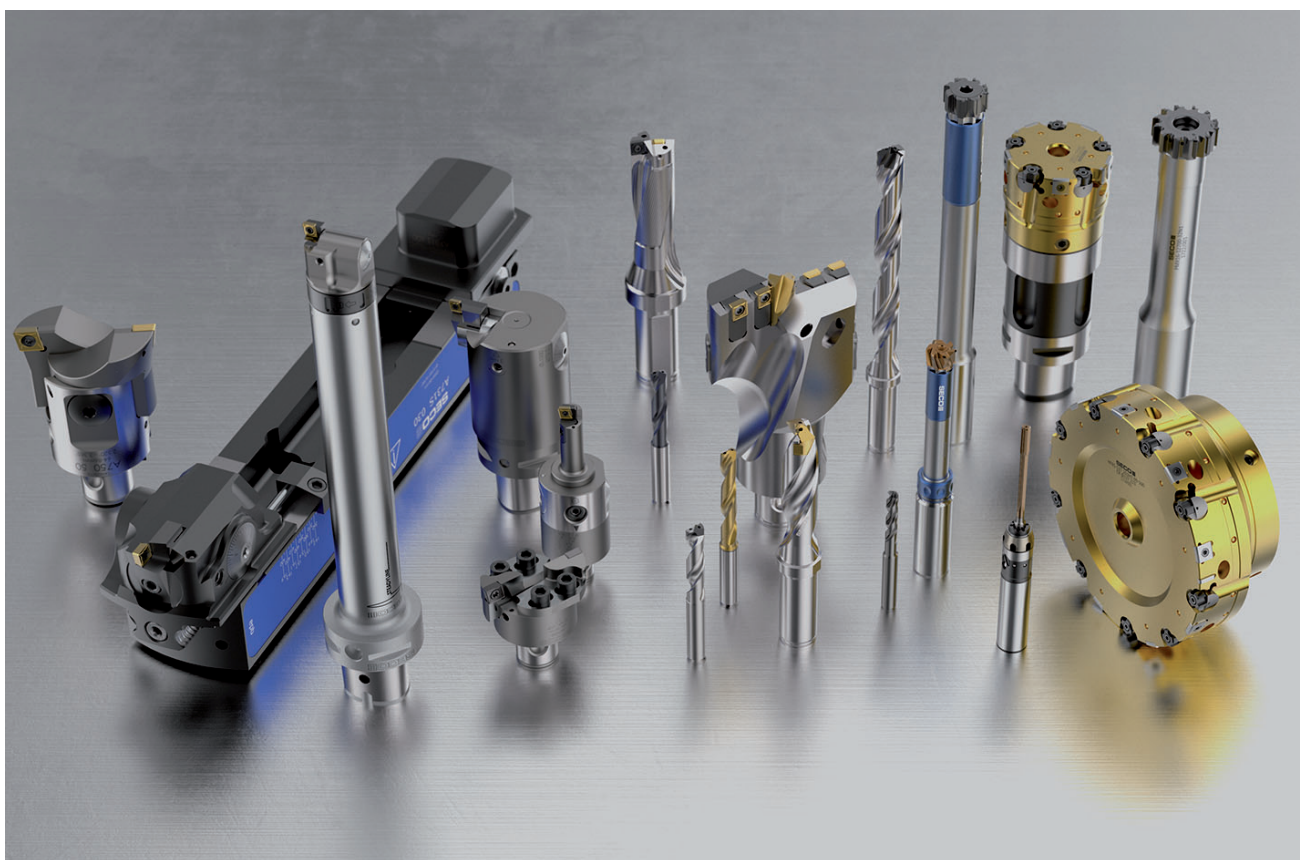
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## Depășiți orice dificultate în realizarea găurilor

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

Seco Tools este furnizorul dumneavoastră se sursă unică pentru soluții cuprinzătoare de realizare a găurilor. Cu ani de experiență în dezvoltarea de soluții de realizare a găurilor pentru aplicațiile dificile ale clienților, avem competența în cercetare și dezvoltare și prelucrare prin așchiere pentru a ajuta producătorii să obțină procese complet optime.

Suntem dedicați productivității clienților noștri în realizarea de găuri. Acest lucru înseamnă că puteți achiziționa scule, puteți beneficia de asistență tehnică, vă puteți consulta cu experți și puteți dezvolta soluții cu un singur furnizor și cu acces la cea mai cuprinzătoare gamă de burghie amovibile și solide, alezoare, dispozitive de filetat și capete de alezare din domeniu.





## De ce ai nevoie pentru a executa un alezaj?

	Găurire			Alezare				Alezare cu alezor reglabil			Filetare		
	Seco Universal Seco Feedmax™	Crownloc® Crownloc® Plus	Perfomax®	Precimaster™ Plus	Nanofix™	Bifix®	Xfix™	Alezare de degroșare	Alezare de finisare	Threadmaster™	Threadmaster™ Taps		Filet frezare 396.18/19/20
Pag.	25-173	174-227	228-323	329-367	368-397	398-424	425-465	555-576	577-622	Vezi catalogul Filetare			
IT	7-9	9-10	12	6-8	6-8	6-7	6-7	9-10	5-6	-	-	-	-
	0,02 mm (0.0008")	0,05 mm (0.002")	-	Urmărește pre-găurirea	Urmărește pre-găurirea	Urmărește pre-găurirea	Urmărește pre-găurirea	0,005 mm (0.0002")	0,005 mm (0.0002")	-	Urmărește pre-găurirea	Urmărește pre-găurirea	-
	0,02 mm (0.0008")	0,05 mm (0.002")	-	0,007 mm (0.0003")	0,007 mm (0.0003")	0,005 mm (0.0002")	0,005 mm (0.0002")	0,02 mm (0.0008")	0,01 mm (0.0004")	-	-	-	-
	1,0 μm (39 μin)	1,6 μm (63 μin)	2,0 μm (79 μin)	0,6 μm (24 μin)	0,6 μm (24 μin)	0,25 μm (10 μin)	0,8 μm (31 μin)	1,0 μm (39 μin)	0,6 μm (24 μin)	-	-	-	-
TCTR	-	-	-	-	-	-	-	-	-	-	6H 6HX 6G 2B Normal	5HX 2BX Normal-X 6HX 6GX	-
Forma filetului	-	-	-	-	-	-	-	-	-	M MF UNC UNF NPT NPTF BSP	M MF UNC UNF G NPT NPTF	M MF UNC UNF G	ISO UN W NPT NPTF BSPT



### Precizia poziționării

Seco Feedmax, capetele pentru alezare grosieră A750 precum și întreaga gamă de capete de alezare fină sculele de alezat care oferă cea mai bună precizie a poziționării.



### Geometria alezajului

Pentru o geometrie a alezajului excelentă, de exemplu cilindricitate și coliniaritate, pot fi alese oricare dintre sculele Seco pentru găurire și alezare. Capetele de alezare vor asigura cele mai bune rezultate la coliniaritate.



### Finisarea suprafeței

Pentru o prelucrare superioară a suprafeței Bifix este prima alegere, cu cele mai fine capete de alezat posibile.

TCTR

= Clasa de toleranță a filetului

IT

= Toleranța găurii

## Ghid pentru scule

Feedmax, Crownloc și Perfo-max sunt utilizate pentru a realiza găuri de la 0,1 la 160 mm diametru (0,004-6,299"), cu toleranțe de la IT7 la IT12.

Pentru găurile gata turnate, alezare de degroșare sau semifinisare la diametre mari se pot utiliza barele Bridge și barele Jumbo Bridge.

În final, alezajele de înaltă calitate sunt executate cu alezoare solide sau reglabile, în clasa de toleranță IT5 sau IT6.

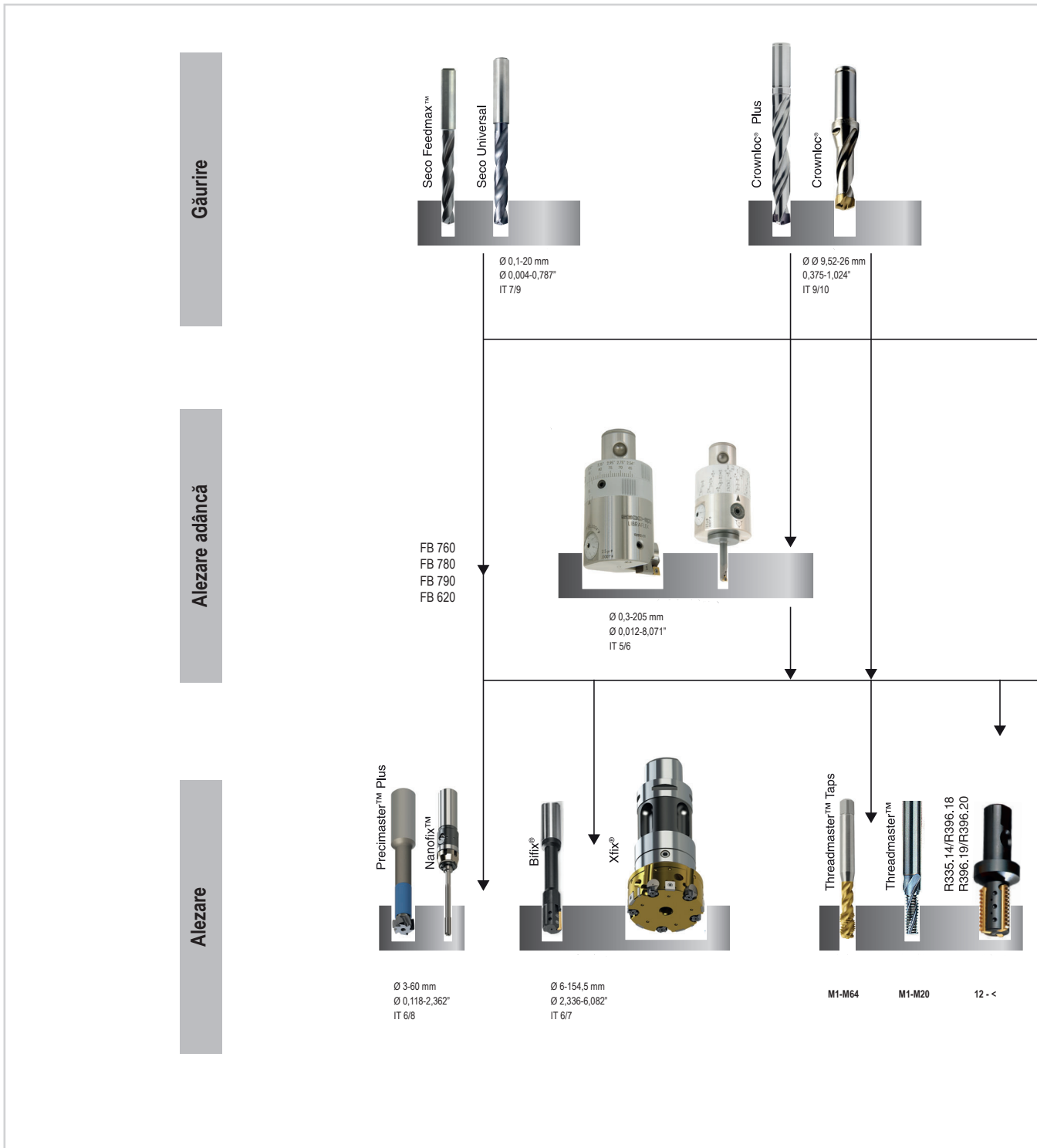
\* Degroșare IT9/10, \*\* De precizie IT 5/6

Threadmaster DTM, TM, TM2, 396.18 și 396.19;

Cu aceeași sculă așchietoare se pot prelucra fileturi pe dreapta și pe stânga. Versiunea Metric și UN sunt doar pentru filetarea interioară. De asemenea, se pot realiza toate tipurile de toleranțe cu aceeași sculă așchietoare.

Tarod Threadmaster:

Disponibil pentru majoritatea fileturilor și toleranțelor, relate prin așchiere sau prin formare.



Alezaje turnate



Perfomax®  
SD602

Ø 15-85 mm  
Ø 0,591-3,346"  
IT 12

Ø 60-160 mm  
Ø 2,362-6,299"  
IT 12

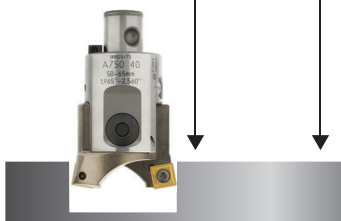
RB 750  
RB 610



Ø 18-205 mm  
Ø 0,709-8,071"  
IT 9/10

Alezare de degroșare

RB 750  
RB 610



Ø 18-205 mm  
Ø 0,709-8,071"  
IT 9/10



BB 731  
Jumbo

Ø 204-3205 mm  
Ø 8,031-126,181"  
\*IT 9/10  
\*\*IT 5/6

Alezare de finisare

FB 760  
FB 780  
FB 790  
FB 620



Ø 0,3-205 mm  
Ø 0,012-8,071"  
IT 5/10

# GĂURIRE



## PERFOMAX® GĂURIȚI CU PUTERE, STABILITATE ȘI PRECIZIE

Burghiile amovibile Perfomax® reprezintă alegerea firească pentru găurile cu diametru mare. Aceste burghie pot funcționa la viteze de așchiere și rate de avans mari, deoarece combină un concept robust, rigid, cu o gamă largă de plăcuțe disponibile.

### GAMA EXTINSĂ

- 2xD, 3xD, 4xD și 5xD
- Disponibile în cele mai comune tipuri de coadă
- Interval de diametre 15-160 mm (0,590-6,299 inci)

### EXCELENȚA CORPULUI DE BURGHIU

- Model nou de caneluri
- Model de val în caneluri
- Corp de burghiu șlefuit
- Călire cu laser

### CLASE ȘI GEOMETRII OPTIMIZATE PENTRU DIFERITE MATERIALE DE PIESĂ DE PRELUCRAT, ASIGURÂND O DURATĂ DE VIAȚĂ LUNGĂ ȘI PREVIZIBILĂ A SCULEI

- Plăcuțe pătrate cu patru muchii
- Model robust
- Face față ratelor de avans mari



## Plaja de găurire - Alegerea burghiului

### Burghie din carbură solidă Seco Feedmax™



#### PRODUCTIVITATE

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

### Burghie cu coroane interschimbabile Crownloc® şi Crownloc® Plus



#### FLEXIBILITATE

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

### Burghie cu plăcuţe amovibile Perfomax®



#### EFICIENŢA COSTURILOR

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

## SMG – Introducere

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

Baza pentru SMG este o clasificare a materialelor de piesă de prelucrat în funcție de tipul lor, mai degrabă decât prelucrabilitatea lor și, în consecință, conține materiale de piesă de prelucrat cum ar fi compozitele. Este suficient de cuprinzător, dar totuși ușor de identificat cărui SMG îi aparține un anumit material.

Fiecare SMG are un anumit standard de material într-o anumită stare alocat ca referință, pentru a permite reglarea ușoară regimurilor de frezare pentru orice material efectiv în comparație cu orice material de referință Seco, consultați paginile 662-673.

SMG	Descriere	Proprietăți	Referință
P4	Oțeluri structurale slab aliate, 0,25% < C < 0,67% wt Oțeluri slab aliate călite și temperate	520 < R <sub>m</sub> < 1200	C 45E R <sub>m</sub> = 660 N/mm <sup>2</sup>
P5	Oțeluri structurale, 0,25% < C < 0,67% wt Oțeluri călite și temperate	550 < R <sub>m</sub> < 1200	42 CrMo 4 R <sub>m</sub> = 700 N/mm <sup>2</sup>

SMG	Descriere	Proprietăți	Referință
H5	Oțeluri călite	38 < HRC < 56	42 CrMo 4 R <sub>m</sub> = 700 N/mm <sup>2</sup>

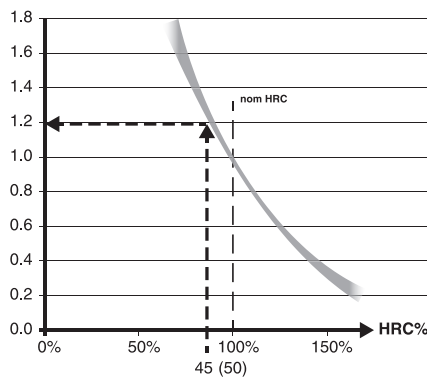
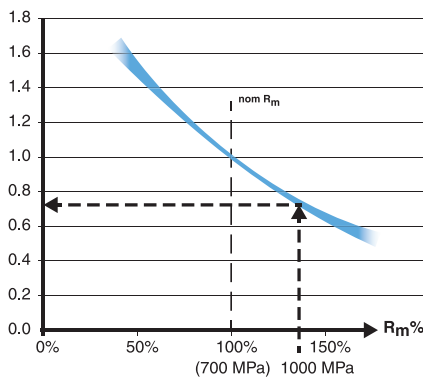
Concentrându-ne special pe EN 42 CrMo 4 în stare recoaptă, rezistența la tracțiune finală R<sub>m</sub> poate varia, de obicei, între R<sub>m</sub> = 630 N/mm<sup>2</sup> și R<sub>m</sub> = 780 N/mm<sup>2</sup>, ceea ce oferă un nivel de referință pentru SMG P5.

În stare călită și temperată, rezistența la tracțiune finală R<sub>m</sub> poate fi, de obicei, între R<sub>m</sub> = 900 N/mm<sup>2</sup> și R<sub>m</sub> = 1100 N/mm<sup>2</sup>, așadar ține tot de SMG P5. Totuși, dacă este călită peste R<sub>m</sub> = 1200 N/mm<sup>2</sup>, ține atunci de SMG H5.

SMG	EN	W.-Nr	AFNOR	BS	UNI	JIS	AISI/ASTM	GOST	Condiție	R <sub>m,nom</sub>	HRC <sub>nom</sub>
P4	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Recoapt	700	
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Călit și temperat	1000	
H5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Călit și temperat		45
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Călit și temperat		50

Oțelul călit și temperat EN 42CrMo4 ar putea fi utilizat pentru a ilustra dependența de prelucrabilitate a stării materialelor.

Graficele de mai jos indică modul în care pot fi reglate recomandările de viteză pentru condiții de material nominale pentru R<sub>m</sub> relativ (diagrama din stânga valabilă pentru ISO-P) și pentru HRC relativ (valabilă pentru ISO-H).



Pentru a ilustra în continuare modul în care v<sub>c</sub> nominală SMG P5 poate fi reglată la o v<sub>c</sub> recomandată mai precisă, avem nevoie de date R<sub>m</sub> de rezistență la tracțiune finală și în acest caz utilizăm EN 42 CrMo 4 călit și temperat la R<sub>m</sub> = 1000 N/mm<sup>2</sup>, conform tabelului de mai sus (săgeți albastre îngroșate). Să presupunem că descoperim v<sub>c</sub> nominală SMG P5 = 280 m/min pentru un anumit produs și o anumită prelucrare. Atunci, v<sub>c</sub> recomandată efectivă = 280 m/min x 0,75 = 210 m/min. În consecință, în SMG H5, v<sub>c</sub> nominală poate fi reglată utilizând EN 42 CrMo 4 călit la HRC 45 (săgețile gri mai mici).

Să presupunem că v<sub>c</sub> nominală SMG H5 = 50 m/min pentru un anumit produs și prelucrare utilizând o sculă din carbură cementată acoperită; atunci, v<sub>c</sub> recomandată efectivă = 50 m/min x 1,2 = 60 m/min. Pentru detalii suplimentare privind materialul piesei de prelucrat, consultați paginile 662-673 și regimurile de frezare sugerate la paginile aplicabile. Pentru gestionarea mai comodă a regimurilor de frezare, vă recomandăm sculele aplicabile în My Pages – Suggest pe [www.secotools.com](http://www.secotools.com)

## Atribute ISO

Atribut ISO	Explicație
ADJLN	Limita minimă de reglaj
ADJLX	Limita maximă de reglaj
ADJRG	Plaja de reglare
AN	Degajarea unghiului major
APMX	Adâncime de așchiere maximă
AZ	Adâncimea maximă axială
B	Lățimea cozii
BD	Diametrul corpului
BD1	Diametrul corpului 1
BD2	Diametrul corpului 2
BDX	Diametrul maxim al corpului
BHTA	Unghi de înclinație jumătatea corpului
BLQ	Codul calității echilibrării
BN	Lățimea feței
CBDP	Adâncimea alezajului conexiunii
CDX	Adâncimea maximă de așchiere
CEDC	Numărul de muchii de așchiere
CHA	Unghiul găurii traversate
CHW	Lățimea șanfrenului la colț
CNT	Mărimea filetului la intrarea agentului de răcire
CW	Lățimea de așchiere
CZC	Codul dimensiunii conexiunii
D1	Diametrul găurii de fixare
DC	Diametrul de așchiere
DCB	Diametrul alezajului conexiunii
DCBN	Diametrul minim al alezajului conexiunii
DCBX	Diametrul maxim al alezajului conexiunii
DCB1	Diametrul alezajului conexiunii 1
DCC	Codul configurației designului
DCINN	Diametrul minim de așchiere interior
DCINX	Diametrul maxim de așchiere interior
DCN	Diametrul minim de așchiere
DCON	Diametrul conexiunii
DCX	Diametrul maxim de așchiere
DF	Diametrul flanșei
DMM	Diametrul cozii
FLGW	Lățimea flanșei
GAN	Unghiul de degajare al plăcuței
GB	Unghiul feței
HTB	Înălțimea corpului
IC	Diametrul cercului înscris
INSD	Diametrul plăcuței
INSL	Lungimea plăcuței
KRINS	Unghiul major al muchiei de așchiere
L	Lungimea muchiei așchietoare
LB	Lungimea corpului
LB1	Lungimea corpului 1
LCF	Lungimea canelunii
LE	Lungimea efectivă a muchiei așchietoare
LF	Lungimea funcțională
LFS	Lungimea funcțională secundară
LH	Lungimea capului
LPR	Lungimea consolei
LS	Lungimea cozii
LSC	Lungimea prinderii
LU	Lungimea utilizabilă
LUX	Lungimea utilizabilă maximă
M	Dimensiunea-M
OAL	Lungimea totală
RE	Raza la colț
S	Grosimea plăcuței
TDZ	Mărimea diametrului filetului
WB	Lățimea corpului
WF	Lățimea funcțională

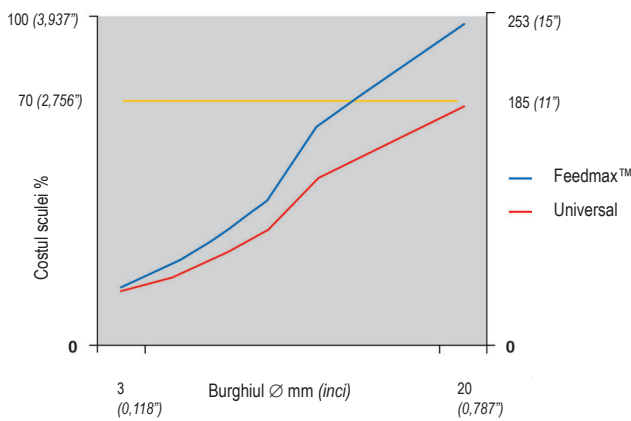
## Soluții de înaltă performanță și Universal

Ce urmăriți la aplicația de găurire cu burghiu din carbură?

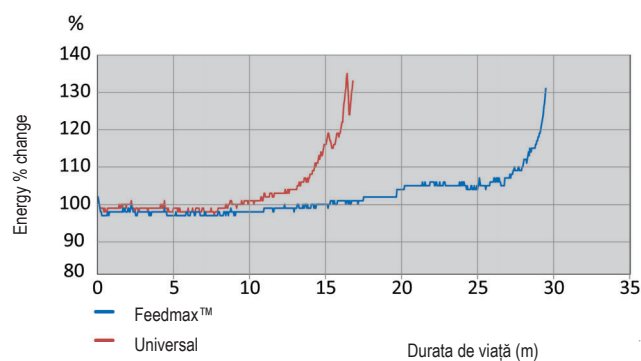
### Universal – burghiu de carbură solidă de uz general

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

MRR, rata de evacuare a metalului (cm<sup>3</sup>/min)



### Durata de viață, parametri de așchiere reduși



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

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

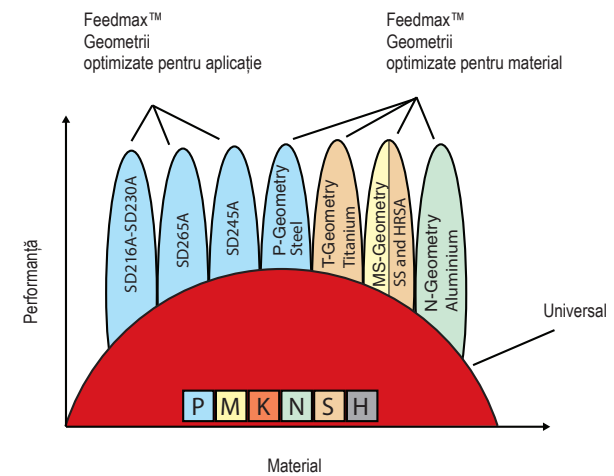
Material = SMG P5-P6, SS2244, DIN41CrMo4, AISI 4140

### Feedmax™ – burghiu din carbură solidă productiv de înaltă performanță

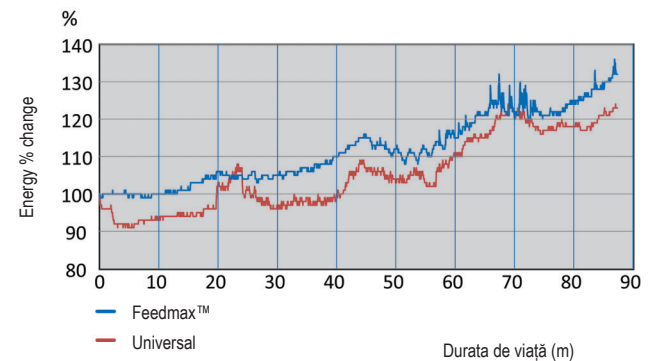
Feedmax™ oferă o combinație unică de tehnologii de carbură, acoperire și geometrie de ultimă oră.

Feedmax™ este conceput pentru productivitate ridicată și cost scăzut per gaură, cu avansuri mari de până la 0,70 mm/rot (0,028 in/rot) și viteze de așchiere mari de până la 220 m/min (720 sf/min). Cu capabilități excelente de centrare, se obține o calitate ridicată a găurii fără a fi necesare operațiuni de găurire centrală. Datorită acoperirii moderne cu o rezistență mare la căldură, a muchiiilor de așchiere protejate, a durității mari a barei de carbură, a capabilității excelente de evacuare a așchii precum și a calității muchiei de așchiere - se obține o durată de viață lungă și predictibilă.

Feedmax™ are o gamă largă de geometrii optimizate pentru diferite materiale și aplicații, pentru a obține o gaură de calitate bună, la cel mai scăzut preț.



### Durata de viață, parametri de așchiere ridicați



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

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

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



## Prezentare generală

Universal	Ø Gamă	Adâncimea de găurire	Toleranța Ø burghiului	Toleranța găurii (1)	Finisarea suprafeței (2)
<b>SD1103</b>  Pag. 26, 27, 28, 29, 30, 31	3-20 mm (0.118-0.787")	~ 3 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
<b>SD1103A</b>  Pag. 32, 33, 34, 35, 36, 37	3-20 mm (0.118-0.787")	~ 3 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
<b>SD1105A</b>  Pag. 38, 39, 40, 41, 42, 43, 44, 45	3-20 mm (0.118-0.787")	~ 5 x D	m7	IT 8-9	Ra 1-3 μm (Ra 39-118 μin)
<b>SD1108A</b>  Pag. 46, 47, 48, 49, 50	3-20 mm (0.118-0.787")	~ 8 x D	m7	IT 9	Ra 1-3 μm (Ra 39-118 μin)
<b>SD1112A</b>  Pag. 51, 52, 53, 54	3-20 mm (0.118-0.787")	~ 12 x D	m7	IT 9	Ra 1-3 μm (Ra 39-118 μin)

1) Pot apărea variații în funcție de material și de parametri de așchiere utilizați.

2) Adâncimea alezajului, parametrii de așchiere, presiunea lichidului de răcire și tipul de material pot influența negativ calitatea suprafeței.







## Prezentare generală

Feedmax™	Ø Gamă	Adâncimea de găurire	Toleranța Ø burghiului	Toleranța găurii (1)	Finisarea suprafeței (2)
<b>SD203A-P</b>  Pag. 56, 57, 58, 59, 60, 61, 62	2-20 mm (0.078-0.787")	~ 3 x D	m7	IT 8-9	Ra 1-2 µm (Ra 39-79 µin)
<b>SD205A-P</b>  Pag. 63, 64, 65, 66, 67, 68, 69, 70	2-20 mm (0.078-0.787")	~ 5 x D	m7	IT 8-9	Ra 1-2 µm (Ra 39-79 µin)
<b>SD206, SD206A</b>  Pag. 71, 72	0,7-2,0 mm (0.027-0.078")	~ 6 x D	h6	IT 9	Ra 1-2 µm (Ra 39-79 µin)
<b>SD207A-P</b>  Pag. 73, 74, 75	3-20 mm (0.118-0.787")	~ 7 x D	m7	IT 9	Ra 1-3 µm (Ra 39-118 µin)
<b>SD216A</b>  Pag. 76	3-12 mm (0.118-0.472")	~ 16 x D	m7	IT 9	Ra 1-3 µm (Ra 39-118 µin)
<b>SD230A</b>  Pag. 77	4-10 mm (0.157-0.393")	~ 30 x D	m7	IT 9	Ra 1-3 µm (Ra 39-118 µin)

1) Pot apărea variații în funcție de material și de parametri de aşchiere utilizați.

2) Adâncimea alezajului, parametrii de aşchiere, presiunea lichidului de răcire și tipul de material pot influența negativ calitatea suprafeței.







## Prezentare generală

Feedmax™	∅ Gamă	Adâncimea de găurire	Toleranța ∅ burghiului	Toleranța găurii (1)	Finisarea suprafeței (2)
SD245A 	5-14 mm (0.196-0.551")	~ 5 x D	m7	IT 8	Ra 1-2 μm (Ra 39-79 μin)
Pag. 79, 80					
SD265A 	6-16 mm (0.236-0.630")	~ 5 x D	js6	IT 7	Ra 1-2 μm (Ra 39-79 μin)
Pag. 82					
SD203A-MS 	2-20 mm (0.079-0.551")	~ 3 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
Pag. 89, 90, 91, 92, 93					
SD205A-MS 	2-20 mm (0.079-0.551")	~ 5 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
Pag. 94, 95, 96, 97					
SD203A-M Superalloys 	3-20 mm (0.098-0.551")	~ 3 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
Pag. 98, 99, 100					
SD205A-M Superalloys 	3-20 mm (0.098-0.551")	~ 5 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
Pag. 101, 102, 103					

1) Pot apărea variații în funcție de material și de parametri de așchiere utilizați.

2) Adâncimea alezajului, parametrii de așchiere, presiunea lichidului de răcire și tipul de material pot influența negativ calitatea suprafeței.

## Prezentare generală

Feedmax™	Ø Gamă	Adâncimea de găurire	Toleranța Ø burghiului	Toleranța găurii (1)	Finisarea suprafeței (2)
 Pag. 104, 105	3-20 mm (0.118-0.787")	~ 3 x D, ~ 5 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
 Pag. 112, 113	3-20 mm (0.118-0.787")	~ 3 x D	m7	IT 8-9	Ra 1-2 μm (Ra 39-79 μin)
 Pag. 114-116	3.2-12.7 mm (0.125-0.500")	~ 5 x D	m7	IT 9	-
 Pag. 94, 95, 96, 97	3.26-9.53 mm (0.128-0.375")	~ 5 x D	m7	IT 9	-
 Pag. 118, 119, 120, 121, 122, 123, 124	0.1-2.0 mm (0.004-0.079")	~ 2 x D	0,005/0 mm (+0.0002"/0)	-	-
 Pag. 125, 126, 127, 128, 129, 130, 131	0.1-2.0 mm (0.004-0.079")	~ 6 x D	0-0,04 mm (0/-0.0016")	-	-

1) Pot apărea variații în funcție de material și de parametri de așchiere utilizați.

2) Adâncimea alezajului, parametrii de așchiere, presiunea lichidului de răcire și tipul de material pot influența negativ calitatea suprafeței.

Introducere

Găurire

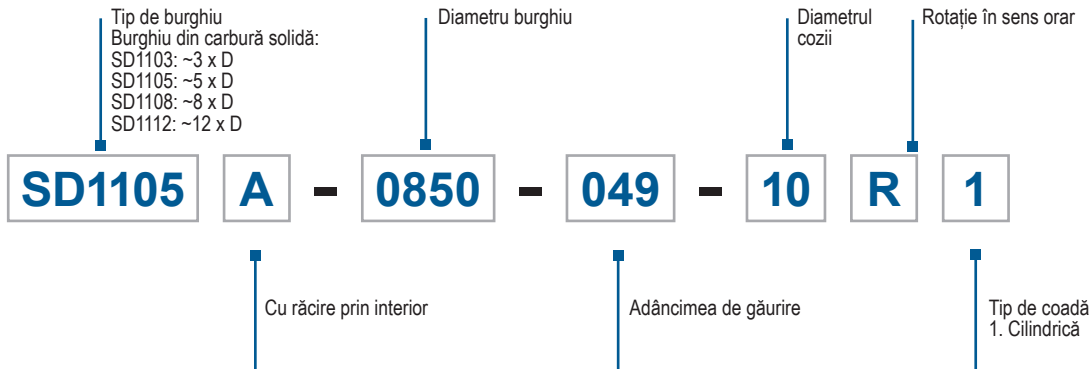
Alezare

Alezare adâncă

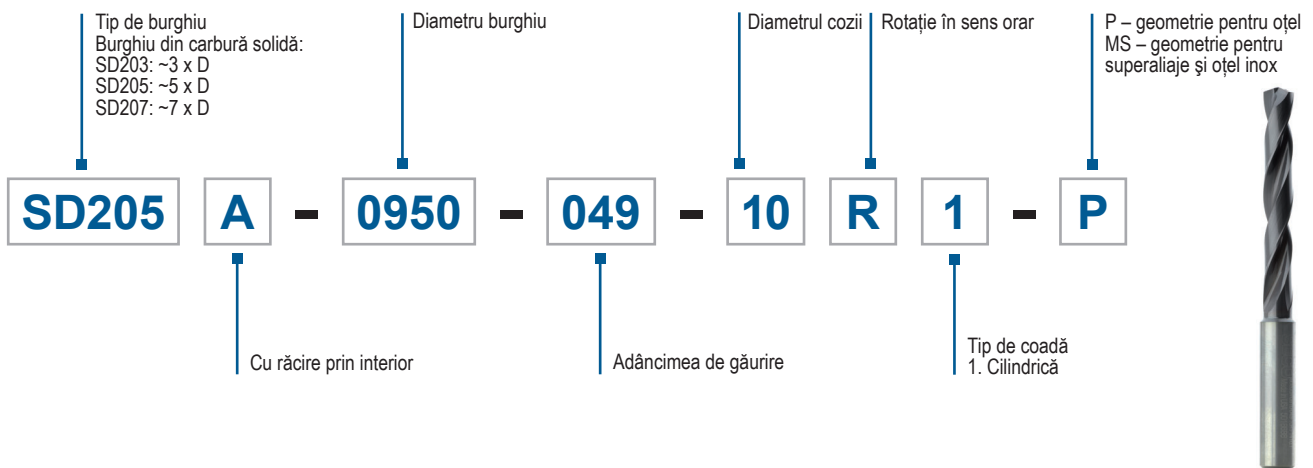
Anexă

Codificări

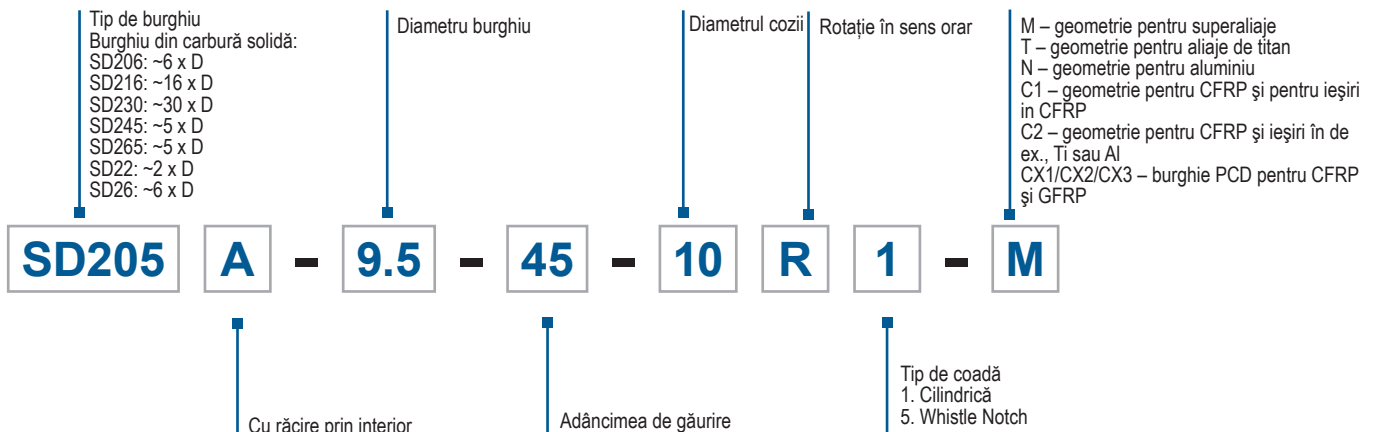
Universal



Feedmax™



Feedmax™



## Configurare

### Prindere/bătaie radială


Burghiile cu coadă cilindrică pot fi folosite împreună cu port-sculele Shrinkfit, mandrinele hidraulice sau mandrinele cu pensete. Mențineți bătaia radială indicată totală pentru burghiu sub 0,04 mm (0,0016") măsurată la capul de alezare. Pentru cele mai bune rezultate, mențineți bătaia radială sub 0,02 mm (0,0008").

### Stabilitate

Stabilitatea aplicației este importantă pentru a obține cea mai bună durată de viață a sculei și precizie a găurii. Verifică starea arborelui mașinii, fixarea și prinderea componentelor pentru a asigura un maxim de stabilitate și rigiditate. Condițiile instabile pot duce la distrugerea sculei.

### Durata de viață a sculei

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

Port-scule recomandate	
 <p>Max. 0,04 mm (0,0016")</p>	<p>Pentru cele mai bune rezultate utilizează conurile:                      Tip 5603 – port-scule Shrinkfit, tip DIN                      Tip 5834 – mandrine hidraulice                      Tip 5672 – mandrine cu pensete de înaltă precizie                      Pentru mai multe informații, consultați catalogul de port-scule</p>  <p>0,1-0,3 mm (0,004-0,012")</p>
<p><b>Port-sculă Shrinkfit</b> (doar pentru cozi cilindrice, R1)</p> 	<p><b>Mandrină hidraulică</b> (doar pentru cozi cilindrice, R1)</p> 
<p><b>Mandrine cu pensete de înaltă precizie</b> (doar pentru cozi cilindrice, R1)</p> 	

Introducere

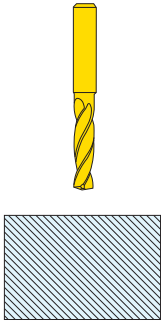

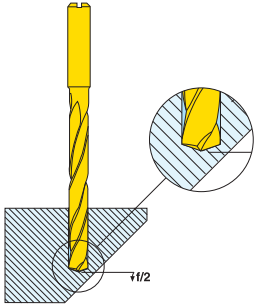
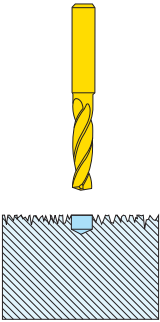

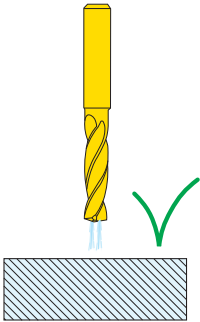
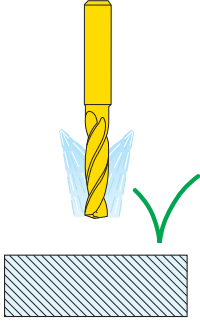
Găurire

Alezare

Alezare adâncă

Anexă

## Metode de prelucrare

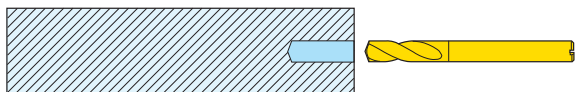
Port-scule recomandate		leșiri înclinate din gaură
<p>3-15 x D</p>  <p>Nu sunt necesare pregătirea sau condiții speciale la intrare.</p>	<p>&gt; 16 x D</p>  <p>Atunci când se utilizează un burghiu mai lung este recomandat să se execute o gaură de ghidare.</p>	<p>Înainte de ieșirea din gaură reduceți avansul/rotația cu 50%.</p>  <p>sau utilizați burghie SD245A.</p>
Intrarea neregulată/înclinată în gaură		
<p>La intrarea în gaură neregulată sau înclinată utilizați operații pregătitoare corespunzătoare</p>  <p>Intrare obișnuită în gaură</p> <p>Pre-găurire cu un burghiu standard Feedmax scurt.</p>	<p>Alternative de pre-prelucrare</p>  <p>Intrarea înclinată în gaură</p> <p>Prelucrați o suprafață plană cu o freză cilindro-frontală din gama Seco.</p>	
Recomandări privind lichidul de răcire		
<p>1.</p>  <p>Prima alegere</p>	<p>2.</p>  <p>≤ 5 x D</p>	<p>1. Presiunea lichidului de răcire*                      Presiune minimă recomandată a lichidului de răcire 10 bari cu ≤ 5 x D                      Presiune minimă recomandată a lichidului de răcire 30 bari cu &gt; 5 x D                      Presiune minimă recomandată a lichidului de răcire 40 bari cu &gt; 16 x D</p> <p>2. Amestec de lichid de răcire                      Amestec emulsie recomandat 6-8%.                      Când se găurește în oțel inox, superaliaje și oțeluri de înaltă rezistență se recomandă un amestec de 10%.</p>

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

## Metode de prelucrare

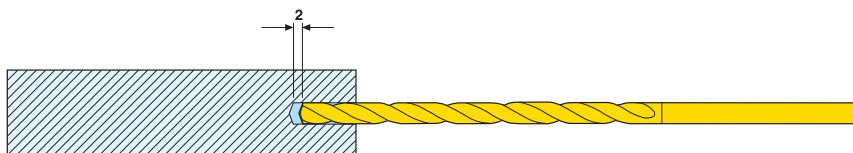
### SD216A (16 x D) până la SD230A (30 x D) – PAS CU PAS

1.



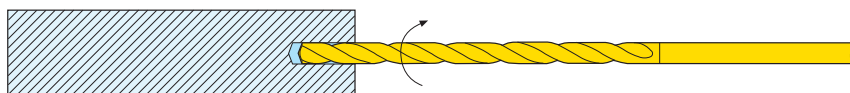
1. Executați o gaură de ghidare 2-3 x D. Utilizați un burghiu standard cu același diametru ex. SD203A sau SD1103 (cu 140° unghi la vârf).

2.



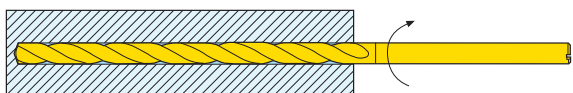
2. Intrați în gaură cu capul de alezare al utilajului oprit sau cu o turație mică (500). Opriți-vă la 2 mm (0,080") deasupra adâncimii găurii de ghidare.

3.



3. Porniți axul și răcirea mașinii, găuriți cu parametrii de așchiere recomandați. (Fără găurire cu retragere.)

4.

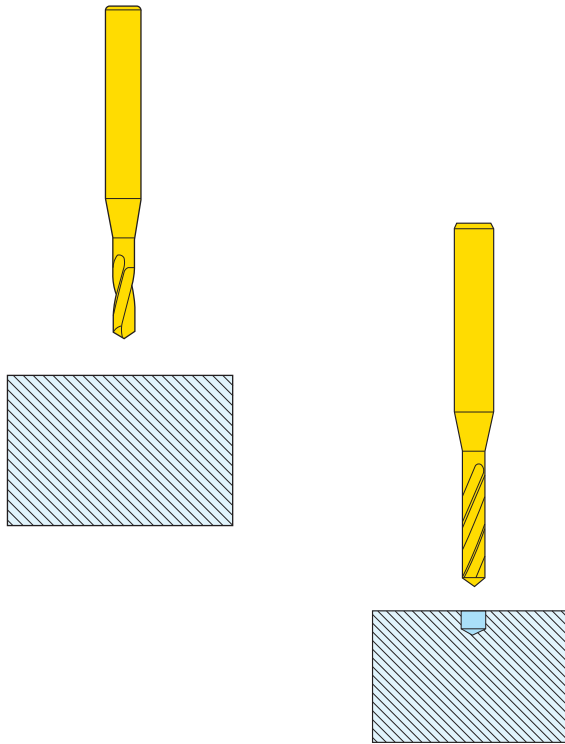


4. La atingerea adâncimii complete, reduceți turația la 500 și retrageți burghiul cu un avans de 4 ori mai mare decât avansul de lucru pentru a evita urmele de retragere.



## Metode de prelucrare – micro-burghie

## Gaură de ghidare



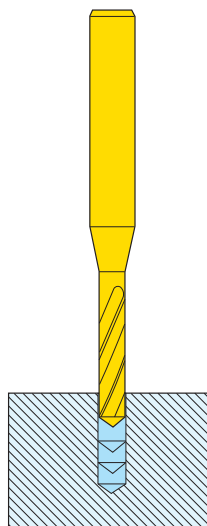
SD22

Pentru o toleranță a găurii și o precizie de poziționare optime, utilizați un burghiu de ghidare SD22 de același diametru.

SD26

Pentru diametru sub 1 mm (0,039") recomandăm insistent utilizarea unui burghiu de ghidare.

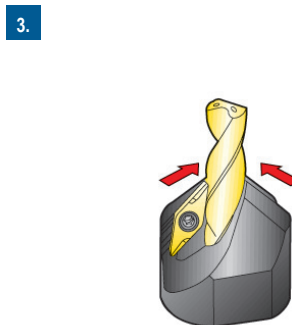
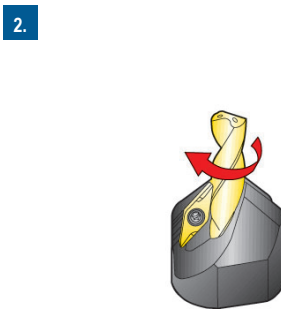
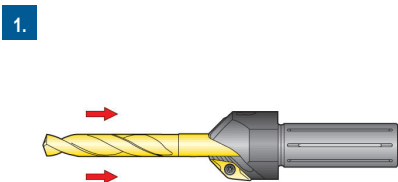
## Găurire cu retragere



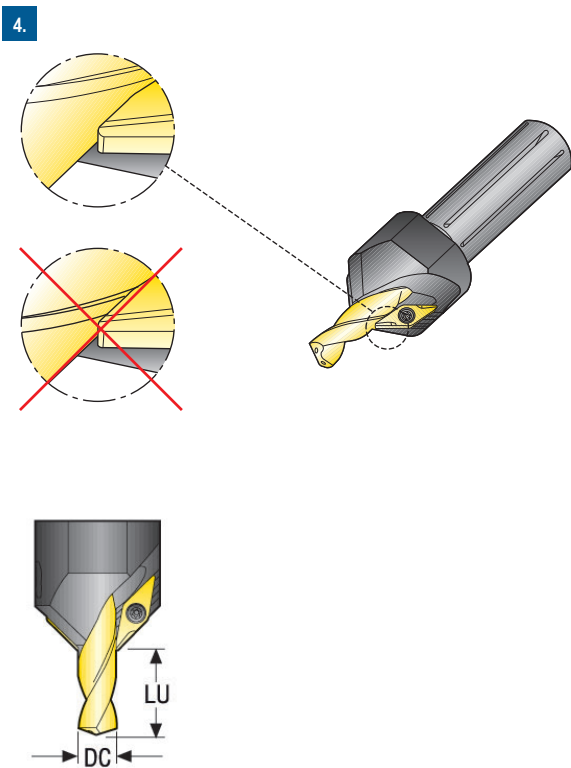
Pentru materialele care produc aşchii lungi, se recomandă un ciclu de retragere. În general se face o retragere la fiecare adâncime de 1 x D.

## Instrucțiuni de montare modul șanfrenare

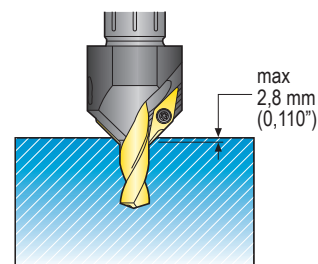
Introducere



Găurire



Adâncimea maximă a șanfrenului



Alezare

Alezare adâncă

Diametrul burghiului DC		LU Adâncimea de găurire (min-max)					
		SD1103 / SD203A		SD1105 / SD205A		SD207A	
mm	inci	mm	inci	mm	inci	mm	inci
4,00-4,75	.157-.187	4-17	.157-.669	10-27	.394-1.063	30-45	1.181-1.772
4,76-6,00	.187-.236	6-20	.236-.787	18-32	.709-1.260	30-45	1.181-1.772
6,01-8,00	.241-.315	15-27	.590-1.063	28-42	1.102-1.653	42-57	1.653-2.244
8,01-10,00	.315-.394	17-31	.669-1.220	34-48	1.338-1.890	47-62	1.850-2.441
10,01-12,00	.394-.472	21-36	.826-1.417	40-56	1.575-2.205	57-72	2.244-2.835
12,01-14,00	.473-.551	22-37	.866-1.457	43-59	1.693-2.323	68-83	2.677-3.268
14,01-16,00	.552-.630	23-39	.906-1.535	44-60	1.732-2.362	76-92	2.992-3.622

Se va folosi doar cu coadă cilindrică (R1).

Anexă



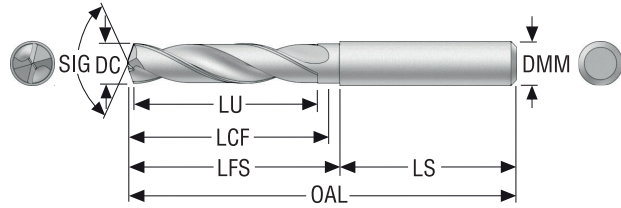
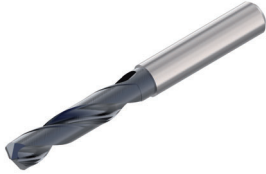
## Seco Universal – burghie cu diametru unic

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

- Geometrie a vârfului multifuncțională, cu 4 fațete, care oferă o capacitate excelentă de centrare
- Acoperirea TiAlN foarte rezistentă la uzură oferă protecție pentru o durată de viață îndelungată a sculei
- Pot fi utilizate în combinație cu tarozi Threadmaster™ și în operații de pregăurire cu Precimaster™ Plus

# SD-1103

Adâncimea de găurire ~ 3 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire exterioară
- Pentru regimurile de așchiere vezi pag. 142
- Pentru diametre intermediare vezi programul Custom Design.

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

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

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Anexă

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

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

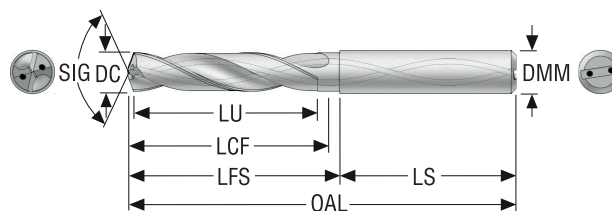
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD1103-1190-040-12R1 SD_DRILL_11.9MM_3XD	02899091	11,9 0.469	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT9
SD1103-1191-040-12R1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



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

## SD-1103A

Adâncimea de găurire ~ 3 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Pentru regimurile de așchiere vezi pag. 143
- Pentru diametre intermediare vezi programul Custom Design.

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD1103A-0300-014-06R1 SD_DRILL_3.0MM_3XD_A	02898244	3,0 0.118	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0310-014-06R1 SD_DRILL_3.1MM_3XD_A	02898245	3,1 0.122	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0318-014-06R1 SD_DRILL_1/8_3XD_A	02898246	3,175 0.125	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0320-014-06R1 SD_DRILL_3.2MM_3XD_A	02898247	3,2 0.126	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0325-014-06R1 SD_DRILL_3.25MM_3XD_A	02898248	3,25 0.128	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0330-014-06R1 SD_DRILL_3.3MM_3XD_A	02898249	3,3 0.130	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0340-014-06R1 SD_DRILL_3.4MM_3XD_A	02898250	3,4 0.134	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0350-014-06R1 SD_DRILL_3.5MM_3XD_A	02898251	3,5 0.138	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0357-014-06R1 SD_DRILL_9/64_3XD_A	02898252	3,572 0.141	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0360-014-06R1 SD_DRILL_3.6MM_3XD_A	02898253	3,6 0.142	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0365-014-06R1 SD_DRILL_3.65MM_3XD_A	02898254	3,65 0.144	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0370-014-06R1 SD_DRILL_3.7MM_3XD_A	02898255	3,7 0.146	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0380-017-06R1 SD_DRILL_3.8MM_3XD_A	02898256	3,8 0.150	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0390-017-06R1 SD_DRILL_3.9MM_3XD_A	02898257	3,9 0.154	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0397-017-06R1 SD_DRILL_5/32_3XD_A	02898258	3,969 0.156	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0400-017-06R1 SD_DRILL_4.0MM_3XD_A	02898259	4,0 0.157	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0410-017-06R1 SD_DRILL_4.1MM_3XD_A	02898260	4,1 0.161	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0420-017-06R1 SD_DRILL_4.2MM_3XD_A	02898261	4,2 0.165	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0430-017-06R1 SD_DRILL_4.3MM_3XD_A	02898262	4,3 0.169	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0437-017-06R1 SD_DRILL_11/64_3XD_A	02898263	4,366 0.172	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0450-017-06R1 SD_DRILL_4.5MM_3XD_A	02898264	4,5 0.177	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>			
SD1103A-0460-017-06R1 SD_DRILL_4.6MM_3XD_A	02898265	4,6 0.181	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0465-017-06R1 SD_DRILL_4.65MM_3XD_A	02898266	4,65 0.183	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0470-017-06R1 SD_DRILL_4.7MM_3XD_A	02898267	4,7 0.185	17,0 0.669	66,0 2.598	30,0 1.181	36,0 1.417	24,0 0.945	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0476-020-06R1 SD_DRILL_3/16_3XD_A	02898268	4,763 0.188	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0480-020-06R1 SD_DRILL_4.8MM_3XD_A	02898269	4,8 0.189	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0490-020-06R1 SD_DRILL_4.9MM_3XD_A	02898270	4,9 0.193	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0500-020-06R1 SD_DRILL_5.0MM_3XD_A	02898271	5,0 0.197	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0510-020-06R1 SD_DRILL_5.1MM_3XD_A	02898272	5,1 0.201	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0516-020-06R1 SD_DRILL_13/64_3XD_A	02898273	5,159 0.203	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0520-020-06R1 SD_DRILL_5.2MM_3XD_A	02898275	5,2 0.205	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0530-020-06R1 SD_DRILL_5.3MM_3XD_A	02898276	5,3 0.209	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0540-020-06R1 SD_DRILL_5.4MM_3XD_A	02898277	5,4 0.213	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0550-020-06R1 SD_DRILL_5.5MM_3XD_A	02898278	5,5 0.217	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0555-020-06R1 SD_DRILL_5.55MM_3XD_A	02898279	5,55 0.219	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0556-020-06R1 SD_DRILL_7/32_3XD_A	02898280	5,556 0.219	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0560-020-06R1 SD_DRILL_5.6MM_3XD_A	02898281	5,6 0.220	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0570-020-06R1 SD_DRILL_5.7MM_3XD_A	02898282	5,7 0.224	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0580-020-06R1 SD_DRILL_5.8MM_3XD_A	02898283	5,8 0.228	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0590-020-06R1 SD_DRILL_5.9MM_3XD_A	02898284	5,9 0.232	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0595-020-06R1 SD_DRILL_15/64_3XD_A	02898285	5,953 0.234	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0600-020-06R1 SD_DRILL_6.0MM_3XD_A	02898286	6,0 0.236	20,0 0.787	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	140°	TiAIN	IT8-9
SD1103A-0610-024-08R1 SD_DRILL_6.1MM_3XD_A	02898287	6,1 0.240	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0620-024-08R1 SD_DRILL_6.2MM_3XD_A	02898288	6,2 0.244	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0630-024-08R1 SD_DRILL_6.3MM_3XD_A	02898289	6,3 0.248	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0635-024-08R1 SD_DRILL_1/4_3XD_A	02898290	6,35 0.250	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0640-024-08R1 SD_DRILL_6.4MM_3XD_A	02898291	6,4 0.252	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0650-024-08R1 SD_DRILL_6.5MM_3XD_A	02898292	6,5 0.256	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0660-024-08R1 SD_DRILL_6.6MM_3XD_A	02898293	6,6 0.260	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0670-024-08R1 SD_DRILL_6.7MM_3XD_A	02898294	6,7 0.264	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0675-024-08R1 SD_DRILL_17/64_3XD_A	02898295	6,747 0.266	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0680-024-08R1 SD_DRILL_6.8MM_3XD_A	02898296	6,8 0.268	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD1103A-0690-024-08R1 SD_DRILL_6.9MM_3XD_A	02898297	6,9 0.272	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0700-024-08R1 SD_DRILL_7.0MM_3XD_A	02898298	7,0 0.276	24,0 0.945	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0710-029-08R1 SD_DRILL_7.1MM_3XD_A	02898299	7,1 0.280	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0714-029-08R1 SD_DRILL_9/32_3XD_A	02898300	7,144 0.281	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0720-029-08R1 SD_DRILL_7.2MM_3XD_A	02898301	7,2 0.283	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0730-029-08R1 SD_DRILL_7.3MM_3XD_A	02898302	7,3 0.287	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0740-029-08R1 SD_DRILL_7.4MM_3XD_A	02898303	7,4 0.291	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0750-029-08R1 SD_DRILL_7.5MM_3XD_A	02898304	7,5 0.295	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0754-029-08R1 SD_DRILL_19/64_3XD_A	02898305	7,541 0.297	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0755-029-08R1 SD_DRILL_7.55MM_3XD_A	02898306	7,55 0.297	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0760-029-08R1 SD_DRILL_7.6MM_3XD_A	02898307	7,6 0.299	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0770-029-08R1 SD_DRILL_7.7MM_3XD_A	02898308	7,7 0.303	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0780-029-08R1 SD_DRILL_7.8MM_3XD_A	02898309	7,8 0.307	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0790-029-08R1 SD_DRILL_7.9MM_3XD_A	02898310	7,9 0.311	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0794-029-08R1 SD_DRILL_5/16_3XD_A	02898311	7,938 0.313	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0800-029-08R1 SD_DRILL_8.0MM_3XD_A	02898312	8,0 0.315	29,0 1.142	79,0 3.110	43,0 1.693	36,0 1.417	41,0 1.614	8,0 0.315	140°	TiAIN	IT8-9
SD1103A-0810-035-10R1 SD_DRILL_8.1MM_3XD_A	02898313	8,1 0.319	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0820-035-10R1 SD_DRILL_8.2MM_3XD_A	02898314	8,2 0.323	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0830-035-10R1 SD_DRILL_8.3MM_3XD_A	02898315	8,3 0.327	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0833-035-10R1 SD_DRILL_21/64_3XD_A	02898316	8,334 0.328	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0840-035-10R1 SD_DRILL_8.4MM_3XD_A	02898317	8,4 0.331	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0850-035-10R1 SD_DRILL_8.5MM_3XD_A	02898318	8,5 0.335	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0860-035-10R1 SD_DRILL_8.6MM_3XD_A	02898319	8,6 0.339	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0870-035-10R1 SD_DRILL_8.7MM_3XD_A	02898320	8,7 0.343	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0873-035-10R1 SD_DRILL_11/32_3XD_A	02898321	8,731 0.344	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0880-035-10R1 SD_DRILL_8.8MM_3XD_A	02898322	8,8 0.346	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0890-035-10R1 SD_DRILL_8.9MM_3XD_A	02898323	8,9 0.350	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0900-035-10R1 SD_DRILL_9.0MM_3XD_A	02898324	9,0 0.354	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0910-035-10R1 SD_DRILL_9.1MM_3XD_A	02898325	9,1 0.358	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0913-035-10R1 SD_DRILL_23/64_3XD_A	02898326	9,128 0.359	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0920-035-10R1 SD_DRILL_9.2MM_3XD_A	02898327	9,2 0.362	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>			
SD1103A-0930-035-10R1 SD_DRILL_9.3MM_3XD_A	02898328	9,3 0.366	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0940-035-10R1 SD_DRILL_9.4MM_3XD_A	02898329	9,4 0.370	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0950-035-10R1 SD_DRILL_9.5MM_3XD_A	02898330	9,5 0.374	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0953-035-10R1 SD_DRILL_3/8_3XD_A	02898331	9,525 0.375	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0955-035-10R1 SD_DRILL_9.55MM_3XD_A	02898332	9,55 0.376	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0960-035-10R1 SD_DRILL_9.6MM_3XD_A	02898333	9,6 0.378	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0970-035-10R1 SD_DRILL_9.7MM_3XD_A	02898334	9,7 0.382	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0980-035-10R1 SD_DRILL_9.8MM_3XD_A	02898335	9,8 0.386	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0990-035-10R1 SD_DRILL_9.9MM_3XD_A	02898336	9,9 0.390	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-0992-035-10R1 SD_DRILL_25/64_3XD_A	02898337	9,922 0.391	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-1000-035-10R1 SD_DRILL_10.0MM_3XD_A	02898338	10,0 0.394	35,0 1.378	89,0 3.504	49,0 1.929	40,0 1.575	47,0 1.850	10,0 0.394	140°	TiAIN	IT8-9
SD1103A-1020-040-12R1 SD_DRILL_10.2MM_3XD_A	02898339	10,2 0.402	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1032-040-12R1 SD_DRILL_13/32_3XD_A	02898340	10,319 0.406	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1040-040-12R1 SD_DRILL_10.4MM_3XD_A	02898341	10,4 0.409	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1050-040-12R1 SD_DRILL_10.5MM_3XD_A	02898342	10,5 0.413	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1060-040-12R1 SD_DRILL_10.6MM_3XD_A	02898343	10,6 0.417	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1072-040-12R1 SD_DRILL_27/64_3XD_A	02898344	10,716 0.422	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1080-040-12R1 SD_DRILL_10.8MM_3XD_A	02898345	10,8 0.425	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1090-040-12R1 SD_DRILL_10.9MM_3XD_A	02898346	10,9 0.429	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1100-040-12R1 SD_DRILL_11.0MM_3XD_A	02898347	11,0 0.433	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1110-040-12R1 SD_DRILL_11.1MM_3XD_A	02898348	11,1 0.437	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1111-040-12R1 SD_DRILL_7/16_3XD_A	02898349	11,113 0.438	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1120-040-12R1 SD_DRILL_11.2MM_3XD_A	02898350	11,2 0.441	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1130-040-12R1 SD_DRILL_11.3MM_3XD_A	02898351	11,3 0.445	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1140-040-12R1 SD_DRILL_11.4MM_3XD_A	02898352	11,4 0.449	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1150-040-12R1 SD_DRILL_11.5MM_3XD_A	02898353	11,5 0.453	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1151-040-12R1 SD_DRILL_29/64_3XD_A	02898354	11,509 0.453	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1155-040-12R1 SD_DRILL_11.55MM_3XD_A	02898355	11,55 0.455	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1160-040-12R1 SD_DRILL_11.6MM_3XD_A	02898356	11,6 0.457	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1170-040-12R1 SD_DRILL_11.7MM_3XD_A	02898357	11,7 0.461	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1180-040-12R1 SD_DRILL_11.8MM_3XD_A	02898358	11,8 0.465	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD1103A-1190-040-12R1 SD_DRILL_11.9MM_3XD_A	02898359	11,9 0.469	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1191-040-12R1 SD_DRILL_15/32_3XD_A	02898360	11,906 0.469	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1200-040-12R1 SD_DRILL_12.0MM_3XD_A	02898361	12,0 0.472	40,0 1.575	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472	140°	TiAIN	IT8-9
SD1103A-1210-043-14R1 SD_DRILL_12.1MM_3XD_A	02898362	12,1 0.476	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1220-043-14R1 SD_DRILL_12.2MM_3XD_A	02898363	12,2 0.480	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1230-043-14R1 SD_DRILL_31/64_3XD_A	02898364	12,303 0.484	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1240-043-14R1 SD_DRILL_12.4MM_3XD_A	02898365	12,4 0.488	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1250-043-14R1 SD_DRILL_12.5MM_3XD_A	02898366	12,5 0.492	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1260-043-14R1 SD_DRILL_12.6MM_3XD_A	02898367	12,6 0.496	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1270-043-14R1 SD_DRILL_1/2_3XD_A	02898368	12,7 0.500	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1275-043-14R1 SD_DRILL_12.75MM_3XD_A	02898369	12,75 0.502	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1280-043-14R1 SD_DRILL_12.8MM_3XD_A	02898370	12,8 0.504	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1290-043-14R1 SD_DRILL_12.9MM_3XD_A	02898371	12,9 0.508	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1300-043-14R1 SD_DRILL_13.0MM_3XD_A	02898372	13,0 0.512	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1310-043-14R1 SD_DRILL_33/64_3XD_A	02898373	13,1 0.516	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1320-043-14R1 SD_DRILL_13.2MM_3XD_A	02898374	13,2 0.520	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1330-043-14R1 SD_DRILL_13.3MM_3XD_A	02898375	13,3 0.524	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1340-043-14R1 SD_DRILL_13.4MM_3XD_A	02898376	13,4 0.528	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1349-043-14R1 SD_DRILL_17/32_3XD_A	02898377	13,494 0.531	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1350-043-14R1 SD_DRILL_13.5MM_3XD_A	02898378	13,5 0.531	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1360-043-14R1 SD_DRILL_13.6MM_3XD_A	02898379	13,6 0.535	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1370-043-14R1 SD_DRILL_13.7MM_3XD_A	02898380	13,7 0.539	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1380-043-14R1 SD_DRILL_13.8MM_3XD_A	02898381	13,8 0.543	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1390-043-14R1 SD_DRILL_13.9MM_3XD_A	02898382	13,9 0.547	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1400-043-14R1 SD_DRILL_14.0MM_3XD_A	02898383	14,0 0.551	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551	140°	TiAIN	IT8-9
SD1103A-1420-045-16R1 SD_DRILL_14.2MM_3XD_A	02898384	14,2 0.559	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1429-045-16R1 SD_DRILL_9/16_3XD_A	02898385	14,288 0.563	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1450-045-16R1 SD_DRILL_14.5MM_3XD_A	02898386	14,5 0.571	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1470-045-16R1 SD_DRILL_14.7MM_3XD_A	02898387	14,7 0.579	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1475-045-16R1 SD_DRILL_14.75MM_3XD_A	02898388	14,75 0.581	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1480-045-16R1 SD_DRILL_14.8MM_3XD_A	02898389	14,8 0.583	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9

Introducere

Găuire

Alezare

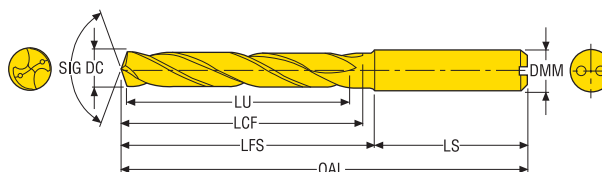
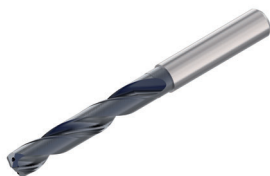
Alezare adâncă

Anexă

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>			
SD1103A-1500-045-16R1 <i>SD_DRILL_15.0MM_3XD_A</i>	02898390	15,0 0.591	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1510-045-16R1 <i>SD_DRILL_15.1MM_3XD_A</i>	02898391	15,1 0.594	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1530-045-16R1 <i>SD_DRILL_15.3MM_3XD_A</i>	02898392	15,3 0.602	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1550-045-16R1 <i>SD_DRILL_15.5MM_3XD_A</i>	02898393	15,5 0.610	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1570-045-16R1 <i>SD_DRILL_15.7MM_3XD_A</i>	02898394	15,7 0.618	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1580-045-16R1 <i>SD_DRILL_15.8MM_3XD_A</i>	02898395	15,8 0.622	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1588-045-16R1 <i>SD_DRILL_5/8_3XD_A</i>	02898396	15,875 0.625	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1600-045-16R1 <i>SD_DRILL_16.0MM_3XD_A</i>	02898397	16,0 0.630	45,0 1.772	115,0 4.528	67,0 2.638	48,0 1.890	65,0 2.559	16,0 0.630	140°	TiAIN	IT8-9
SD1103A-1650-051-18R1 <i>SD_DRILL_16.5MM_3XD_A</i>	02898398	16,5 0.650	51,0 2.008	123,0 4.843	75,0 2.953	48,0 1.890	73,0 2.874	18,0 0.709	140°	TiAIN	IT8-9
SD1103A-1700-051-18R1 <i>SD_DRILL_17.0MM_3XD_A</i>	02898399	17,0 0.669	51,0 2.008	123,0 4.843	75,0 2.953	48,0 1.890	73,0 2.874	18,0 0.709	140°	TiAIN	IT8-9
SD1103A-1750-051-18R1 <i>SD_DRILL_17.5MM_3XD_A</i>	02898400	17,5 0.689	51,0 2.008	123,0 4.843	75,0 2.953	48,0 1.890	73,0 2.874	18,0 0.709	140°	TiAIN	IT8-9
SD1103A-1800-051-18R1 <i>SD_DRILL_18.0MM_3XD_A</i>	02898401	18,0 0.709	51,0 2.008	123,0 4.843	75,0 2.953	48,0 1.890	73,0 2.874	18,0 0.709	140°	TiAIN	IT8-9
SD1103A-1850-055-20R1 <i>SD_DRILL_18.5MM_3XD_A</i>	02898402	18,5 0.728	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787	140°	TiAIN	IT8-9
SD1103A-1900-055-20R1 <i>SD_DRILL_19.0MM_3XD_A</i>	02898403	19,0 0.748	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787	140°	TiAIN	IT8-9
SD1103A-1905-055-20R1 <i>SD_DRILL_3/4_3XD_A</i>	02898404	19,05 0.750	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787	140°	TiAIN	IT8-9
SD1103A-1950-055-20R1 <i>SD_DRILL_19.5MM_3XD_A</i>	02898405	19,5 0.768	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787	140°	TiAIN	IT8-9
SD1103A-2000-055-20R1 <i>SD_DRILL_20.0MM_3XD_A</i>	02898406	20,0 0.787	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787	140°	TiAIN	IT8-9

## SD-1105A

Adâncimea de găurire ~ 5 x D



- Coadă cilindrică DIN 6537A
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 144
- Pentru diametre intermediare vezi programul Custom Design.

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				
SD1105A-0300-023-06R1 SD_DRILL_3.0MM_5XD_A	02897845	3,0 0.118	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0310-023-06R1 SD_DRILL_3.1MM_5XD_A	02897846	3,1 0.122	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0318-023-06R1 SD_DRILL_1/8_5XD_A	02897847	3,175 0.125	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0320-023-06R1 SD_DRILL_3.2MM_5XD_A	02897848	3,2 0.126	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0325-023-06R1 SD_DRILL_3.25MM_5XD_A	02897849	3,25 0.128	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0330-023-06R1 SD_DRILL_3.3MM_5XD_A	02897850	3,3 0.130	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0340-023-06R1 SD_DRILL_3.4MM_5XD_A	02897851	3,4 0.134	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0350-023-06R1 SD_DRILL_3.5MM_5XD_A	02897852	3,5 0.138	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0357-023-06R1 SD_DRILL_9/64_5XD_A	02897853	3,572 0.141	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0360-023-06R1 SD_DRILL_3.6MM_5XD_A	02897854	3,6 0.142	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0365-023-06R1 SD_DRILL_3.65MM_5XD_A	02897855	3,65 0.144	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0370-023-06R1 SD_DRILL_3.7MM_5XD_A	02897856	3,7 0.146	23,0 0.906	66,0 2.598	30,0 1.181	36,0 1.417	28,0 1.102	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0380-029-06R1 SD_DRILL_3.8MM_5XD_A	02897857	3,8 0.150	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0390-029-06R1 SD_DRILL_3.9MM_5XD_A	02897858	3,9 0.154	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0397-029-06R1 SD_DRILL_5/32_5XD_A	02897859	3,969 0.156	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0400-029-06R1 SD_DRILL_4.0MM_5XD_A	02897860	4,0 0.157	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0410-029-06R1 SD_DRILL_4.1MM_5XD_A	02897861	4,1 0.161	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0420-029-06R1 SD_DRILL_4.2MM_5XD_A	02897862	4,2 0.165	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0430-029-06R1 SD_DRILL_4.3MM_5XD_A	02897863	4,3 0.169	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0437-029-06R1 SD_DRILL_11/64_5XD_A	02897864	4,366 0.172	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0440-029-06R1 SD_DRILL_4.4MM_5XD_A	02897865	4,4 0.173	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0450-029-06R1 SD_DRILL_4.5MM_5XD_A	02897866	4,5 0.177	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9



Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>			
SD1105A-0460-029-06R1 SD_DRILL_4.6MM_5XD_A	02897867	4,6 0.181	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0465-029-06R1 SD_DRILL_4.65MM_5XD_A	02897868	4,65 0.183	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0470-029-06R1 SD_DRILL_4.7MM_5XD_A	02897869	4,7 0.185	29,0 1.142	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0476-035-06R1 SD_DRILL_3/16_5XD_A	02897870	4,763 0.188	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0480-035-06R1 SD_DRILL_4.8MM_5XD_A	02897871	4,8 0.189	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0490-035-06R1 SD_DRILL_4.9MM_5XD_A	02897872	4,9 0.193	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0500-035-06R1 SD_DRILL_5.0MM_5XD_A	02897873	5,0 0.197	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0510-035-06R1 SD_DRILL_5.1MM_5XD_A	02897874	5,1 0.201	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0516-035-06R1 SD_DRILL_13/64_5XD_A	02897875	5,159 0.203	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0520-035-06R1 SD_DRILL_5.2MM_5XD_A	02897876	5,2 0.205	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0530-035-06R1 SD_DRILL_5.3MM_5XD_A	02897877	5,3 0.209	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0540-035-06R1 SD_DRILL_5.4MM_5XD_A	02897878	5,4 0.213	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0550-035-06R1 SD_DRILL_5.5MM_5XD_A	02897879	5,5 0.217	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0555-035-06R1 SD_DRILL_5.55MM_5XD_A	02897880	5,55 0.219	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0556-035-06R1 SD_DRILL_7/32_5XD_A	02897881	5,56 0.219	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0560-035-06R1 SD_DRILL_5.6MM_5XD_A	02897882	5,6 0.220	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0570-035-06R1 SD_DRILL_5.7MM_5XD_A	02897883	5,7 0.224	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0580-035-06R1 SD_DRILL_5.8MM_5XD_A	02897884	5,8 0.228	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0590-035-06R1 SD_DRILL_5.9MM_5XD_A	02897885	5,9 0.232	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0595-035-06R1 SD_DRILL_15/64_5XD_A	02897886	5,953 0.234	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0600-035-06R1 SD_DRILL_6.0MM_5XD_A	02897887	6,0 0.236	35,0 1.378	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236	m7	140°	TiAIN	IT8-9
SD1105A-0610-043-08R1 SD_DRILL_6.1MM_5XD_A	02897888	6,1 0.240	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0620-043-08R1 SD_DRILL_6.2MM_5XD_A	02897889	6,2 0.244	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0630-043-08R1 SD_DRILL_6.3MM_5XD_A	02897890	6,3 0.248	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0635-043-08R1 SD_DRILL_1/4_5XD_A	02897891	6,35 0.250	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0640-043-08R1 SD_DRILL_6.4MM_5XD_A	02897892	6,4 0.252	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0650-043-08R1 SD_DRILL_6.5MM_5XD_A	02897893	6,5 0.256	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0660-043-08R1 SD_DRILL_6.6MM_5XD_A	02897894	6,6 0.260	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0670-043-08R1 SD_DRILL_6.7MM_5XD_A	02897895	6,7 0.264	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0675-043-08R1 SD_DRILL_17/64_5XD_A	02897896	6,747 0.266	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0680-043-08R1 SD_DRILL_6.8MM_5XD_A	02897897	6,8 0.268	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm	140°	TiAIN	IT8-9
SD1105A-0690-043-08R1 SD_DRILL_6.9MM_5XD_A	02897898	6,9 0.272	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0700-043-08R1 SD_DRILL_7.0MM_5XD_A	02897899	7,0 0.276	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0710-043-08R1 SD_DRILL_7.1MM_5XD_A	02897900	7,1 0.280	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0714-043-08R1 SD_DRILL_9/32_5XD_A	02897901	7,144 0.281	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0720-043-08R1 SD_DRILL_7.2MM_5XD_A	02897902	7,2 0.283	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0730-043-08R1 SD_DRILL_7.3MM_5XD_A	02897903	7,3 0.287	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0740-043-08R1 SD_DRILL_7.4MM_5XD_A	02897904	7,4 0.291	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0750-043-08R1 SD_DRILL_7.5MM_5XD_A	02897905	7,5 0.295	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0754-043-08R1 SD_DRILL_19/64_5XD_A	02897906	7,541 0.297	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0755-043-08R1 SD_DRILL_7.55MM_5XD_A	02897907	7,55 0.297	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0760-043-08R1 SD_DRILL_7.6MM_5XD_A	02897908	7,6 0.299	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0770-043-08R1 SD_DRILL_7.7MM_5XD_A	02897909	7,7 0.303	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0780-043-08R1 SD_DRILL_7.8MM_5XD_A	02897910	7,8 0.307	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0790-043-08R1 SD_DRILL_7.9MM_5XD_A	02897911	7,9 0.311	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0794-043-08R1 SD_DRILL_5/16_5XD_A	02897912	7,938 0.313	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0800-043-08R1 SD_DRILL_8.0MM_5XD_A	02897913	8,0 0.315	43,0 1.693	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315	m7	140°	TiAIN	IT8-9
SD1105A-0810-049-10R1 SD_DRILL_8.1MM_5XD_A	02897914	8,1 0.319	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0820-049-10R1 SD_DRILL_8.2MM_5XD_A	02897915	8,2 0.323	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0830-049-10R1 SD_DRILL_8.3MM_5XD_A	02897916	8,3 0.327	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0833-049-10R1 SD_DRILL_21/64_5XD_A	02897917	8,334 0.328	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0840-049-10R1 SD_DRILL_8.4MM_5XD_A	02897918	8,4 0.331	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0850-049-10R1 SD_DRILL_8.5MM_5XD_A	02897919	8,5 0.335	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0860-049-10R1 SD_DRILL_8.6MM_5XD_A	02897920	8,6 0.339	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0870-049-10R1 SD_DRILL_8.7MM_5XD_A	02897921	8,7 0.343	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0873-049-10R1 SD_DRILL_11/32_5XD_A	02897922	8,731 0.344	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0880-049-10R1 SD_DRILL_8.8MM_5XD_A	02897923	8,8 0.346	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0890-049-10R1 SD_DRILL_8.9MM_5XD_A	02897924	8,9 0.350	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0900-049-10R1 SD_DRILL_9.0MM_5XD_A	02897925	9,0 0.354	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0910-049-10R1 SD_DRILL_9.1MM_5XD_A	02897926	9,1 0.358	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0913-049-10R1 SD_DRILL_23/64_5XD_A	02897927	9,128 0.359	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0920-049-10R1 SD_DRILL_9.2MM_5XD_A	02897928	9,2 0.362	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD1105A-0930-049-10R1 SD_DRILL_9.3MM_5XD_A	02897929	9,3 0.366	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0940-049-10R1 SD_DRILL_9.4MM_5XD_A	02897930	9,4 0.370	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0950-049-10R1 SD_DRILL_9.5MM_5XD_A	02897931	9,5 0.374	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0953-049-10R1 SD_DRILL_9.525_5XD_A	02897932	9,525 0.375	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0955-049-10R1 SD_DRILL_9.55MM_5XD_A	02897933	9,55 0.376	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0960-049-10R1 SD_DRILL_9.6MM_5XD_A	02897934	9,6 0.378	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0970-049-10R1 SD_DRILL_9.7MM_5XD_A	02897935	9,7 0.382	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0980-049-10R1 SD_DRILL_9.8MM_5XD_A	02897936	9,8 0.386	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0990-049-10R1 SD_DRILL_9.9MM_5XD_A	02897937	9,9 0.390	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-0992-049-10R1 SD_DRILL_9.922_5XD_A	02897938	9,922 0.391	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-1000-049-10R1 SD_DRILL_10.0MM_5XD_A	02897939	10,0 0.394	49,0 1.929	103,0 4.055	63,0 2.480	40,0 1.575	61,0 2.402	10,0 0.394	m7	140°	TiAIN	IT8-9
SD1105A-1010-056-12R1 SD_DRILL_10.1MM_5XD_A	02897940	10,1 0.398	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1020-056-12R1 SD_DRILL_10.2MM_5XD_A	02897941	10,2 0.402	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1030-056-12R1 SD_DRILL_10.3MM_5XD_A	02897942	10,3 0.406	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1032-056-12R1 SD_DRILL_10.32_5XD_A	02897943	10,319 0.406	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1040-056-12R1 SD_DRILL_10.4MM_5XD_A	02897944	10,4 0.409	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1050-056-12R1 SD_DRILL_10.5MM_5XD_A	02897945	10,5 0.413	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1060-056-12R1 SD_DRILL_10.6MM_5XD_A	02897946	10,6 0.417	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1070-056-12R1 SD_DRILL_10.7MM_5XD_A	02897947	10,7 0.421	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1072-056-12R1 SD_DRILL_10.716_5XD_A	02897948	10,716 0.422	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1080-056-12R1 SD_DRILL_10.8MM_5XD_A	02897949	10,8 0.425	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1090-056-12R1 SD_DRILL_10.9MM_5XD_A	02897951	10,9 0.429	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1100-056-12R1 SD_DRILL_11.0MM_5XD_A	02897952	11,0 0.433	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1110-056-12R1 SD_DRILL_11.1MM_5XD_A	02897953	11,1 0.437	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1111-056-12R1 SD_DRILL_11.113_5XD_A	02897954	11,113 0.438	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1120-056-12R1 SD_DRILL_11.2MM_5XD_A	02897955	11,2 0.441	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1130-056-12R1 SD_DRILL_11.3MM_5XD_A	02897956	11,3 0.445	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1140-056-12R1 SD_DRILL_11.4MM_5XD_A	02897957	11,4 0.449	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1150-056-12R1 SD_DRILL_11.5MM_5XD_A	02897958	11,5 0.453	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1151-056-12R1 SD_DRILL_11.509_5XD_A	02897959	11,509 0.453	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1155-056-12R1 SD_DRILL_11.55MM_5XD_A	02897960	11,55 0.455	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm	°		
SD1105A-1160-056-12R1 SD_DRILL_11.6MM_5XD_A	02897961	11,6 0.457	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1170-056-12R1 SD_DRILL_11.7MM_5XD_A	02897962	11,7 0.461	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1180-056-12R1 SD_DRILL_11.8MM_5XD_A	02897963	11,8 0.465	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1190-056-12R1 SD_DRILL_11.9MM_5XD_A	02897964	11,9 0.469	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1191-056-12R1 SD_DRILL_15/32_5XD_A	02897965	11,906 0.469	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1200-056-12R1 SD_DRILL_12.0MM_5XD_A	02897966	12,0 0.472	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472	m7	140°	TiAIN	IT8-9
SD1105A-1210-060-14R1 SD_DRILL_12.1MM_5XD_A	02897967	12,1 0.476	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1220-060-14R1 SD_DRILL_12.2MM_5XD_A	02897968	12,2 0.480	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1225-060-14R1 SD_DRILL_12.25MM_5XD_A	02897969	12,25 0.482	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1230-060-14R1 SD_DRILL_31/64_5XD_A	02897970	12,303 0.484	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1240-060-14R1 SD_DRILL_12.4MM_5XD_A	02897972	12,4 0.488	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1250-060-14R1 SD_DRILL_12.5MM_5XD_A	02897973	12,5 0.492	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1260-060-14R1 SD_DRILL_12.6MM_5XD_A	02897974	12,6 0.496	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1270-060-14R1 SD_DRILL_1/2_5XD_A	02897950	12,7 0.500	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1275-060-14R1 SD_DRILL_12.75MM_5XD_A	02897976	12,75 0.502	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1280-060-14R1 SD_DRILL_12.8MM_5XD_A	02897977	12,8 0.504	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1290-060-14R1 SD_DRILL_12.9MM_5XD_A	02897978	12,9 0.508	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1300-060-14R1 SD_DRILL_13.0MM_5XD_A	02897979	13,0 0.512	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1310-060-14R1 SD_DRILL_33/64_5XD_A	02897980	13,1 0.516	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1320-060-14R1 SD_DRILL_13.2MM_5XD_A	02897981	13,2 0.520	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1330-060-14R1 SD_DRILL_13.3MM_5XD_A	02897982	13,3 0.524	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1340-060-14R1 SD_DRILL_13.4MM_5XD_A	02897983	13,4 0.528	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1349-060-14R1 SD_DRILL_17/32_5XD_A	02897984	13,494 0.531	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1350-060-14R1 SD_DRILL_13.5MM_5XD_A	02897985	13,5 0.531	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1360-060-14R1 SD_DRILL_13.6MM_5XD_A	02897986	13,6 0.535	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1370-060-14R1 SD_DRILL_13.7MM_5XD_A	02897987	13,7 0.539	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1380-060-14R1 SD_DRILL_13.8MM_5XD_A	02897988	13,8 0.543	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1390-060-14R1 SD_DRILL_35/64_5XD_A	02897989	13,9 0.547	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1400-060-14R1 SD_DRILL_14.0MM_5XD_A	02897990	14,0 0.551	60,0 2.362	124,0 4.882	79,0 3.110	45,0 1.772	77,0 3.031	14,0 0.551	m7	140°	TiAIN	IT8-9
SD1105A-1410-063-16R1 SD_DRILL_14.1MM_5XD_A	02897991	14,1 0.555	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1420-063-16R1 SD_DRILL_14.2MM_5XD_A	02897992	14,2 0.559	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9

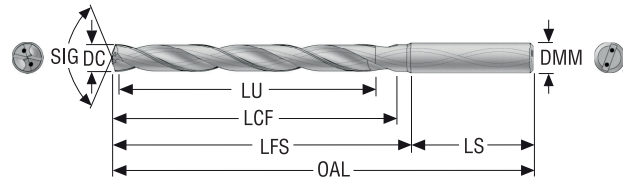
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD1105A-1429-063-16R1 SD_DRILL_9/16_5XD_A	02897993	14,288 0.563	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1430-063-16R1 SD_DRILL_14.3MM_5XD_A	02897994	14,3 0.563	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1440-063-16R1 SD_DRILL_14.4MM_5XD_A	02897995	14,4 0.567	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1450-063-16R1 SD_DRILL_14.5MM_5XD_A	02897996	14,5 0.571	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1460-063-16R1 SD_DRILL_14.6MM_5XD_A	02897997	14,6 0.575	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1470-063-16R1 SD_DRILL_14.7MM_5XD_A	02897998	14,7 0.579	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1475-063-16R1 SD_DRILL_14.75MM_5XD_A	02897999	14,75 0.581	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1480-063-16R1 SD_DRILL_14.8MM_5XD_A	02898000	14,8 0.583	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1490-063-16R1 SD_DRILL_14.9MM_5XD_A	02898001	14,9 0.587	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1500-063-16R1 SD_DRILL_15.0MM_5XD_A	02898002	15,0 0.591	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1510-063-16R1 SD_DRILL_15.1MM_5XD_A	02898003	15,1 0.594	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1520-063-16R1 SD_DRILL_15.2MM_5XD_A	02898004	15,2 0.598	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1530-063-16R1 SD_DRILL_15.3MM_5XD_A	02898005	15,3 0.602	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1540-063-16R1 SD_DRILL_15.4MM_5XD_A	02898006	15,4 0.606	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1550-063-16R1 SD_DRILL_15.5MM_5XD_A	02898007	15,5 0.610	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1560-063-16R1 SD_DRILL_15.6MM_5XD_A	02898008	15,6 0.614	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1570-063-16R1 SD_DRILL_15.7MM_5XD_A	02898009	15,7 0.618	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1580-063-16R1 SD_DRILL_15.8MM_5XD_A	02898010	15,8 0.622	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1588-063-16R1 SD_DRILL_5/8_5XD_A	02898011	15,875 0.625	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1590-063-16R1 SD_DRILL_15.9MM_5XD_A	02898012	15,9 0.626	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1600-063-16R1 SD_DRILL_16.0MM_5XD_A	02898013	16,0 0.630	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630	m7	140°	TiAIN	IT8-9
SD1105A-1610-071-18R1 SD_DRILL_16.1MM_5XD_A	02898014	16,1 0.634	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1620-071-18R1 SD_DRILL_16.2MM_5XD_A	02898015	16,2 0.638	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1630-071-18R1 SD_DRILL_16.3MM_5XD_A	02898016	16,3 0.642	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1640-071-18R1 SD_DRILL_16.4MM_5XD_A	02898017	16,4 0.646	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1650-071-18R1 SD_DRILL_16.5MM_5XD_A	02898018	16,5 0.650	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1660-071-18R1 SD_DRILL_16.6MM_5XD_A	02898019	16,6 0.654	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1670-071-18R1 SD_DRILL_16.7MM_5XD_A	02898020	16,7 0.657	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1675-071-18R1 SD_DRILL_16.75MM_5XD_A	02898021	16,75 0.659	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1680-071-18R1 SD_DRILL_16.8MM_5XD_A	02898022	16,8 0.661	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1690-071-18R1 SD_DRILL_16.9MM_5XD_A	02898023	16,9 0.665	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm	°		
SD1105A-1700-071-18R1 SD_DRILL_17.0MM_5XD_A	02898024	17,0 0.669	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1710-071-18R1 SD_DRILL_17.1MM_5XD_A	02898025	17,1 0.673	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1720-071-18R1 SD_DRILL_17.2MM_5XD_A	02898026	17,2 0.677	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1730-071-18R1 SD_DRILL_17.3MM_5XD_A	02898027	17,3 0.681	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1740-071-18R1 SD_DRILL_17.4MM_5XD_A	02898028	17,4 0.685	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1750-071-18R1 SD_DRILL_17.5MM_5XD_A	02898029	17,5 0.689	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1760-071-18R1 SD_DRILL_17.6MM_5XD_A	02898030	17,6 0.693	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1770-071-18R1 SD_DRILL_17.7MM_5XD_A	02898031	17,7 0.697	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1780-071-18R1 SD_DRILL_17.8MM_5XD_A	02898032	17,8 0.701	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1790-071-18R1 SD_DRILL_17.9MM_5XD_A	02898033	17,9 0.705	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1800-071-18R1 SD_DRILL_18.0MM_5XD_A	02898034	18,0 0.709	71,0 2.795	143,0 5.630	95,0 3.740	48,0 1.890	93,0 3.661	18,0 0.709	m7	140°	TiAIN	IT8-9
SD1105A-1810-077-20R1 SD_DRILL_18.1MM_5XD_A	02898035	18,1 0.713	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1820-077-20R1 SD_DRILL_18.2MM_5XD_A	02898036	18,2 0.717	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1830-077-20R1 SD_DRILL_18.3MM_5XD_A	02898037	18,3 0.720	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1840-077-20R1 SD_DRILL_18.4MM_5XD_A	02898038	18,4 0.724	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1850-077-20R1 SD_DRILL_18.5MM_5XD_A	02898039	18,5 0.728	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1860-077-20R1 SD_DRILL_18.6MM_5XD_A	02898040	18,6 0.732	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1870-077-20R1 SD_DRILL_18.7MM_5XD_A	02898041	18,7 0.736	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1880-077-20R1 SD_DRILL_18.8MM_5XD_A	02898042	18,8 0.740	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1890-077-20R1 SD_DRILL_18.9MM_5XD_A	02898043	18,9 0.744	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1900-077-20R1 SD_DRILL_19.0MM_5XD_A	02898044	19,0 0.748	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1905-077-20R1 SD_DRILL_3/4_5XD_A	02898045	19,05 0.750	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1910-077-20R1 SD_DRILL_19.1MM_5XD_A	02898046	19,1 0.752	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1920-077-20R1 SD_DRILL_19.2MM_5XD_A	02898047	19,2 0.756	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1930-077-20R1 SD_DRILL_19.3MM_5XD_A	02898048	19,3 0.760	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1940-077-20R1 SD_DRILL_19.4MM_5XD_A	02898049	19,4 0.764	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1950-077-20R1 SD_DRILL_19.5MM_5XD_A	02898050	19,5 0.768	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1960-077-20R1 SD_DRILL_19.6MM_5XD_A	02898051	19,6 0.772	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1970-077-20R1 SD_DRILL_19.7MM_5XD_A	02898052	19,7 0.776	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-1980-077-20R1 SD_DRILL_19.8MM_5XD_A	02898053	19,8 0.780	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM	Toleranța DC	Unghiul la vârf:	Acoperire	Toleranța găurii
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>				
SD1105A-1990-077-20R1 SD_DRILL_19.9MM_5XD_A	02898054	19,9 0.783	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9
SD1105A-2000-077-20R1 SD_DRILL_20.0MM_5XD_A	02898055	20,0 0.787	77,0 3.031	153,0 6.024	103,0 4.055	50,0 1.969	101,0 3.976	20,0 0.787	m7	140°	TiAIN	IT8-9

## SD-1108A

Adâncimea de găuire ~ 8 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Pentru regimurile de așchiere vezi pag. 145
- Pentru diametre intermediare vezi programul Custom Design.

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



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

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

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

Introducere

Găuire

Alegere

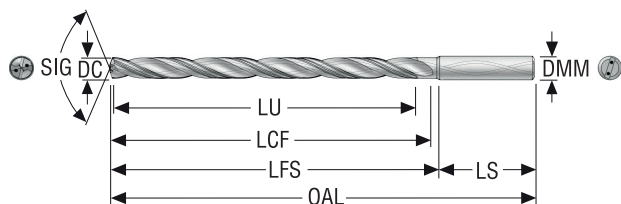
Alegere adâncă

Anexă

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

# SD-1112A

Adâncimea de găurire ~ 12 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 146
- Pentru diametre intermediare vezi programul Custom Design.

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

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

Introducere

Găuire

Alezare

Alezare adâncă

Anexă

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

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





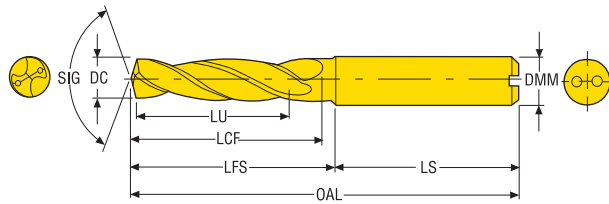
## Feedmax -P – burghie cu diametru unic

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

- Geometrie cu autocentrare pentru găuri de înaltă calitate, fără a fi necesară o operație de găurire centrală.
- O acoperire specială TiAlN conferă burghiilor Seco Feedmax o duritate ridicată la temperatură ridicată care, în combinație cu o muchie așchietoare robustă, asigură o durată de viață lungă și previzibilă a sculei

## SD-203A-P

Adâncimea de găurire ~ 3 x D – Metric



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN
- Toleranța găurii: IT8-9
- Pentru regimurile de aşchiere vezi pag. 147-163
- Pentru diametre intermediare vezi programul MyDesign.

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

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

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

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

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

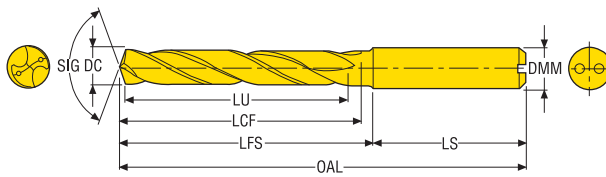
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD203A-1340-043-14R1-P	03046034	13,4 0.528	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772	60,0 2.362	14,0 0.551
SD203A-1349-043-14R1-P	03046086	13,494 0.531	43,0 1.693	107,0 4.213	62,0 2.441	45,0 1.772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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>
SD203A-1980-055-20R1-P	03138156	19,8 0.780	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787
SD203A-2000-055-20R1-P	03046060	20,0 0.787	55,0 2.165	131,0 5.157	81,0 3.189	50,0 1.969	79,0 3.110	20,0 0.787



## SD-205A-P

Adâncimea de găurire ~ 5 x D – Metric



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN
- Toleranța găurii: IT8-9
- Pentru regimurile de așchiere vezi pag. 149-165
- Pentru diametre intermediare vezi programul MyDesign.

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

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

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

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

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

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

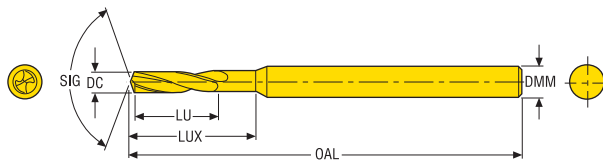
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD205A-1540-063-16R1-P	03046277	15,4 0.606	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890	83,0 3.268	16,0 0.630
SD205A-1550-063-16R1-P	03046278	15,5 0.610	63,0 2.480	133,0 5.236	85,0 3.346	48,0 1.890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

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



## SD-206

Adâncimea de găurire ~ 6 x D

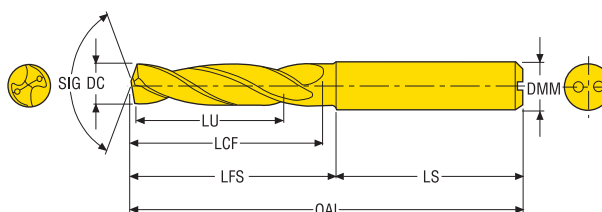


- Coadă cilindrică
- Răcire exterioră
- Unghiul la vârf: 140°
- Acoperire: TiAIN
- Toleranța găurii: IT9
- Pentru regimurile de așchiere vezi pag. 151

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

## SD-206A

Adâncimea de găurire ~ 6 x D

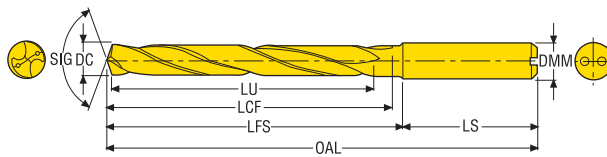


- Coadă cilindrică
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN
- Toleranța găurii: IT9
- Pentru regimurile de aşchiere vezi pag. 152

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

## SD-207A-P

Adâncimea de găurire ~ 7 x D – Metric



- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN
- Toleranța găurii: IT9
- Pentru regimurile de aşchiere vezi pag. 153
- Pentru diametre intermediare vezi programul MyDesign.

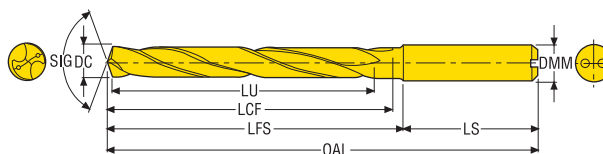
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD207A-0300-030-06R1-P	03046358	3,0 0.118	30,0 1.181	74,0 2.913	38,0 1.496	36,0 1.417	36,0 1.417	6,0 0.236
SD207A-0330-030-06R1-P	03046359	3,3 0.130	30,0 1.181	74,0 2.913	38,0 1.496	36,0 1.417	36,0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

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

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

## SD-216A

Adâncimea de găurire ~ 16 x D

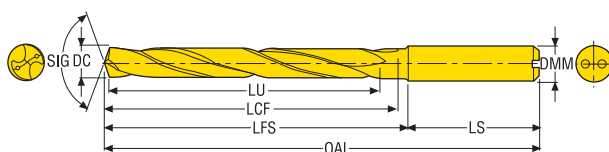


- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 136°
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT9
- Pentru regimurile de aşchiere vezi pag. 154
- Pentru diametre intermediare vezi programul MyDesign.

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

## SD-230A

Adâncimea de găurire ~ 30 x D



- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 136°
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT9
- Pentru regimurile de aşchiere vezi pag. 155
- Pentru diametre intermediare vezi programul MyDesign.

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



## Feedmax™ SD245A

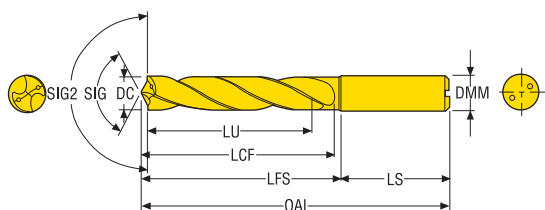
Burghiile din carbură solidă Seco Feedmax SD245A oferă niveluri ridicate de stabilitate și performanțe generale de prelucrare îmbunătățite pentru aplicații de alezare cu ieșiri neregulate și întreruperi pe parcursul găurii. Următoarele caracteristici permit utilizatorului să obțină o geometrie bună a găurilor:

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



## SD-245A

Adâncimea de găurire ~ 5 x D



- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 140°/180°
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT8
- Pentru regimurile de așchiere vezi pag. 156
- Pentru diametre intermediare vezi programul MyDesign.

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

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



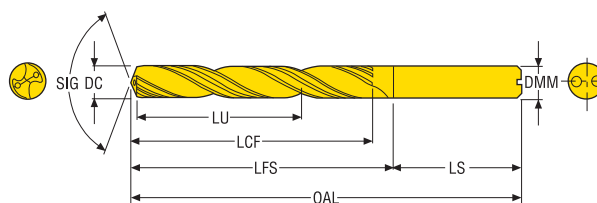
## Feedmax™ SD265A

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

- Geometrie îmbunătățită a burghiului și vârf cu autocentrare
- 6 muchii de așezare în total
- Toleranțe de fabricație mici ( $\pm 3\mu$ )
- Acoperire TiAlN pentru frecare redusă și rezistență excelentă la uzură

## SD-265A

Adâncimea de găurire ~ 5 x D



- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT7
- Pentru regimurile de aşchiere vezi pag. 157
- Pentru diametre intermediare vezi programul MyDesign.
- Diblu standard ANSI / ASME B18.8.2-1995.

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

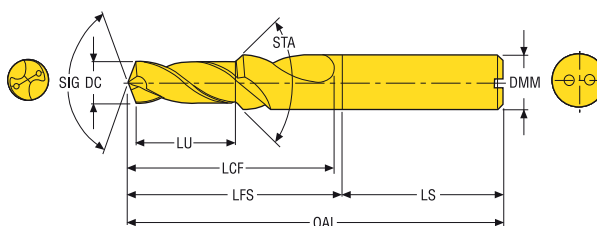


## Feedmax™ – burghie pentru șanfrenat

Burghiile pentru șanfrenat Seco Feedmax™ combină găurirea și șanfrenarea într-un singur proces pentru a maximiza eficiența. Gama standard din stoc acoperă aplicații de pregătire pentru filete metrice standard comune, de la M4 până la M16.

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

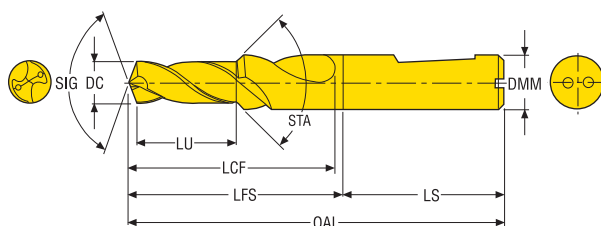
## M4 - M16 Thread



- Coadă cilindrică DIN 6537A
- Răcire interioară
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT8-9
- Inclused chamfer angle = 90°
- Pentru regimurile de aşchiere vezi pag. 147, 148

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

M4 - M16 Thread

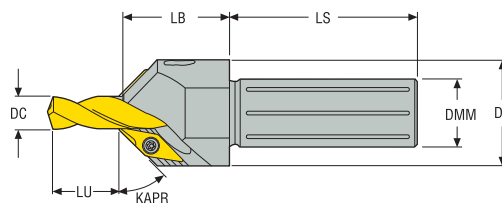


- Coadă Whistle Notch DIN 6537B
- Răcire interioară
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT8-9
- Included chamfer angle = 90°
- Pentru regimurile de aşchiere vezi pag. 147, 148

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

## Chamfer module for Universal and Feedmax drills

Metric



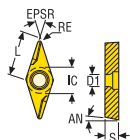
### Adâncimea de găurire LU

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

### Piese de schimb

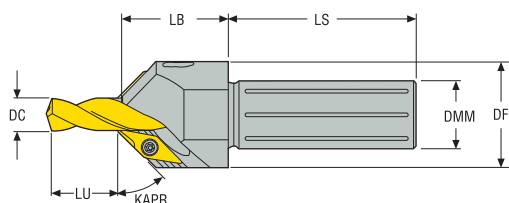
Pentru burghiu dia (mm)	Cheie plăcuță	Șurubul plăcuței	Cheie de blocare	Șurub de blocare	Casetă
	Plăcuță amovibilă	Plăcuță amovibilă	Modul	Modul	Modul
4,00 - 16,00	T07P-2	C02205-T07P	H1.5-2D	SH3040	SD200-3x7.3

Toleranța: mm	Mărimea	IC mm	L mm	S mm	D1 mm	RE mm
IC = ±0,025 S = ±0,07 RE = ±0,10	C45	5,556	9,000	2,500	2,900	0,200
	Calitate: T400D					
	Reper Nr.: SD200-C45					
	Număr reper: 02510325					





## Chamfer module for Universal and Feedmax drills



Descriere	Număr reper	DC	Adâncimea de găurire LU			Adâncime max. șanfren	DF	LB	LS	DMM	KAPR°
			3 x D LU (min-max)	5 x D LU (min-max)	7 x D LU (min-max)						
			Inci	Inci	Inci						
SD200-C45-6-500R1	02510287	0.158-0.240	0.157-0.669	0.394-1.063	1.181-1.772	0.110	0.827	0.984	1.614	0.500	45
SD200-C45-8-625R1	02510289	0.237-0.315	0.591-1.063	0.945-1.378	1.654-2.244	0.110	0.984	0.984	1.752	0.625	45
SD200-C45-10-625R1	02510291	0.315-0.394	0.669-1.220	1.339-1.890	1.850-2.441	0.110	0.984	0.984	1.752	0.625	45
SD200-C45-12-750R1	02510292	0.394-0.472	0.827-1.417	1.575-2.205	2.244-2.835	0.110	1.102	0.984	1.831	0.750	45
SD200-C45-14-750R1	02510293	0.473-0.551	0.866-1.457	1.693-2.323	2.677-3.268	0.110	1.181	0.984	1.831	0.750	45
SD200-C45-16-1000R1	02510295	0.552-0.630	0.906-1.535	1.732-2.362	2.992-3.622	0.110	1.260	1.339	2.087	1.000	45

### Piese de schimb

Pentru burghii dia (inch)	Cheie plăcuță	Șurubul plăcuței	Cheie de blocare	Casetă
	Plăcuță amovibilă	Plăcuță amovibilă	Modul	Modul
0.1574 - 0.6299	T07P-2	C02205-T07P	H1.5-2D	SD200-3x7.3

Toleranța: inci	Mărimea	IC inci	L inci	S inci	D1 inci	RE inci
<p>IC = ±0.001 S = ±0.0027 RE = ±0.004</p>	C45	0.2187	0.3543	0.0984	0.1141	0.0078
	Calitate: T400D					
	Reper Nr.: SD200-C45					
	Număr reper: 02510325					

## Instrucțiuni de montare modul șanfrenare

**1.**

**2.**

**3.**

**4.**

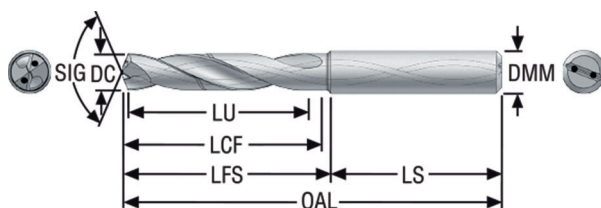
**Adâncimea maximă a șanfrenului**

Diametrul burghiului DC	LU Adâncimea de găurire (min-max)						
	SD1103 / SD203A		SD1105 / SD205A		SD207A		
mm		mm	inci	mm	inci	mm	inci
4,00-4,75	.157-.187	4-17	.157-.669	10-27	.394-1.063	30-45	1.181-1.772
4,76-6,00	.187-.236	6-20	.236-.787	18-32	.709-1.260	30-45	1.181-1.772
6,01-8,00	.241-.315	15-27	.590-1.063	28-42	1.102-1.653	42-57	1.653-2.244
8,01-10,00	.315-.394	17-31	.669-1.220	34-48	1.338-1.890	47-62	1.850-2.441
10,01-12,00	.394-.472	21-36	.826-1.417	40-56	1.575-2.205	57-72	2.244-2.835
12,01-14,00	.473-.551	22-37	.866-1.457	43-59	1.693-2.323	68-83	2.677-3.268
14,01-16,00	.552-.630	23-39	.906-1.535	44-60	1.732-2.362	76-92	2.992-3.622

Se va folosi doar cu coadă cilindrică (R1).

## SD203A, -MS

Adâncimea de găurire ~ 3 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN +NbN
- Toleranța găurii: IT8-9
- Pentru regimurile de așchiere vezi pag. 158-159
- Pentru diametre intermediare vezi programul MyDesign.

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

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

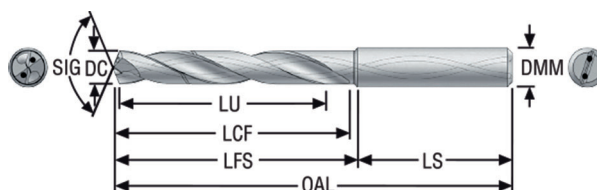
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD203A-0660-023-08R1-MS	10004123	6,6 0.260	23,0 0.906	79,0 3.110	43,0 1.693	36,0 1.417	34,0 1.339	8,0 0.315
SD203A-0675-025-08R1-MS	10004124	6,75 0.266	25,0 0.984	79,0 3.110	43,0 1.693	36,0 1.417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

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

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

## SD205A, -MS

Adâncimea de găurire ~ 5 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN +NbN
- Toleranța găurii: IT8-9
- Pentru regimurile de aşchiere vezi pag. 160-161
- Pentru diametre intermediare vezi programul MyDesign.

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



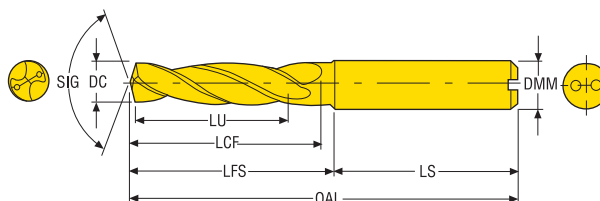
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD205A-0420-027-06R1-MS	10004200	4,2 0.165	27,0 1.063	74,0 2.913	38,0 1.496	36,0 1.417	34,0 1.339	6,0 0.236
SD205A-0430-027-06R1-MS	10004201	4,3 0.169	27,0 1.063	74,0 2.913	38,0 1.496	36,0 1.417	34,0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

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

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

## SD203A, -M

Adâncimea de găurire ~ 3 x D – Metric



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAIN + TiN
- Toleranța găurii: IT8-9
- Pentru regimurile de aşchiere vezi pag. 147, 148
- Pentru diametre intermediare vezi programul MyDesign.

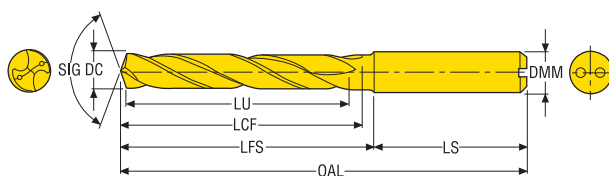
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>
SD203A-3.0-14-6R1-M	02569995	3,0 0.118	14,0 0.551	62,0 2.441	26,0 1.024	36,0 1.417	20,0 0.787	6,0 0.236
SD203A-3.1-14-6R1-M	02570998	3,1 0.122	14,0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

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

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

## SD205A, -M

Adâncimea de găurire ~ 5 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire: TiAlN + TiN
- Toleranța găurii: IT8-9
- Pentru regimurile de aşchiere vezi pag. 149, 150
- Pentru diametre intermediare vezi programul MyDesign.

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

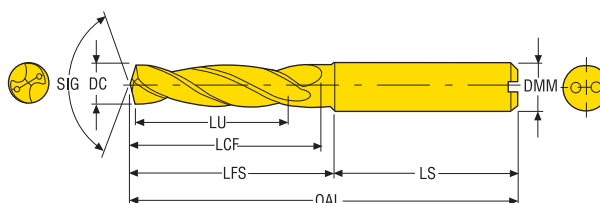
Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD205A-5.9-32-6R1-M	02539334	5,9 0.232	32,0 1.260	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732	6,0 0.236
SD205A-6.0-32-6R1-M	02450035	6,0 0.236	32,0 1.260	82,0 3.228	46,0 1.811	36,0 1.417	44,0 1.732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



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

## SD203A, -T

Adâncimea de găurire ~ 3 x D



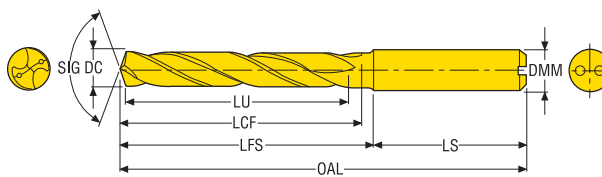
- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Neacoperite
- Toleranța găurii: IT8-9
- Regimuri de aşchiere - [www.secotools.com](http://www.secotools.com)
- Pentru diametre intermediare vezi programul MyDesign.

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

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>
SD203A-11.5-33-12R1-T	02567385	11,5 0.453	33,0 1.299	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472
SD203A-12.0-36-12R1-T	02562784	12,0 0.472	36,0 1.417	102,0 4.016	57,0 2.244	45,0 1.772	55,0 2.165	12,0 0.472

## SD205A, -T

Adâncimea de găurire ~ 5 x D

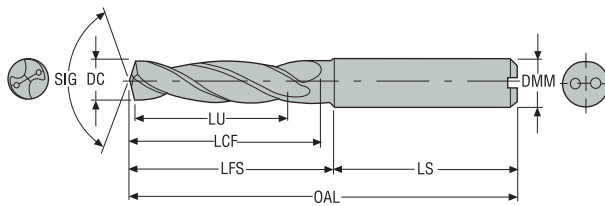


- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Neacoperite
- Toleranța găurii: IT8-9
- Regimuri de aşchiere - [www.secotools.com](http://www.secotools.com)
- Pentru diametre intermediare vezi programul MyDesign.

Reper Nr.	Număr reper	DC	LU	OAL	LFS	LS	LCF	DMM
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>
SD205A-8.0-42-8R1-T	02569164	8,0 0.315	42,0 1.654	91,0 3.583	55,0 2.165	36,0 1.417	53,0 2.087	8,0 0.315
SD205A-12.0-56-12R1-T	02527621	12,0 0.472	56,0 2.205	118,0 4.646	73,0 2.874	45,0 1.772	71,0 2.795	12,0 0.472

## SD203A, -N

Adâncimea de găurire ~ 3 x D



- Coadă cilindrică DIN 6537A
- Toleranța DC m7
- Răcire interioară
- Unghiul la vârf: 140°
- Acoperire DLC
- Toleranța găurii: IT8-9
- Pentru regimurile de aşchiere vezi pag. 147, 148
- Pentru diametre intermediare vezi programul Custom Design.

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

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



## Găurire de compozite

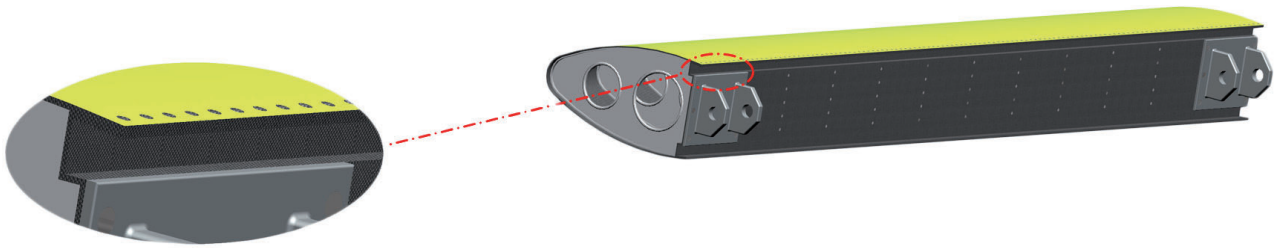
Seco oferă două soluții distincte pentru găurirea de compozite: burghie acoperite cu diamant și burghie din diamant policristalin (PCD). Aceste scule dispun de geometrii care sunt optimizate special pentru compozite obișnuite sau materiale suprapuse.

- Vârful de burghiu cu geometrie plată al C2 și CX2 prelucrează materiale compozite suprapuse care încorporează straturi de aluminiu sau titan
- CX1 și CX2 sunt burghie din diamant policristalin (PCD) care oferă o productivitate și o durată de viață a sculei îmbunătățite față de burghiile convenționale la prelucrarea materialelor compozite
- Atât C1 cât și C2 sunt burghie din carbură acoperite cu diamant, dispunând de o acoperire cu diamant Dura care oferă o duritate și o rezistență la abraziune foarte bune

## Prelucrare compozită

Introducere

Găurire



### Atunci când cea mai importantă este calitatea găurii

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

- Fără delaminare la intrare
- Fără delaminare la ieşire

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



Alezare

Alezare adâncă

### Model de aplicație

Material CFRP/GFRP simplu  
(ieşire în material compozit)



Geometrie  
CX1



Material suprapus  
(ieşire în Al/Ti)



Geometrie  
CX2



CX31 geometrie PCD  
Geometrie universală pentru  
materiale simple CFRP/GFRP și  
materiale suprapuse

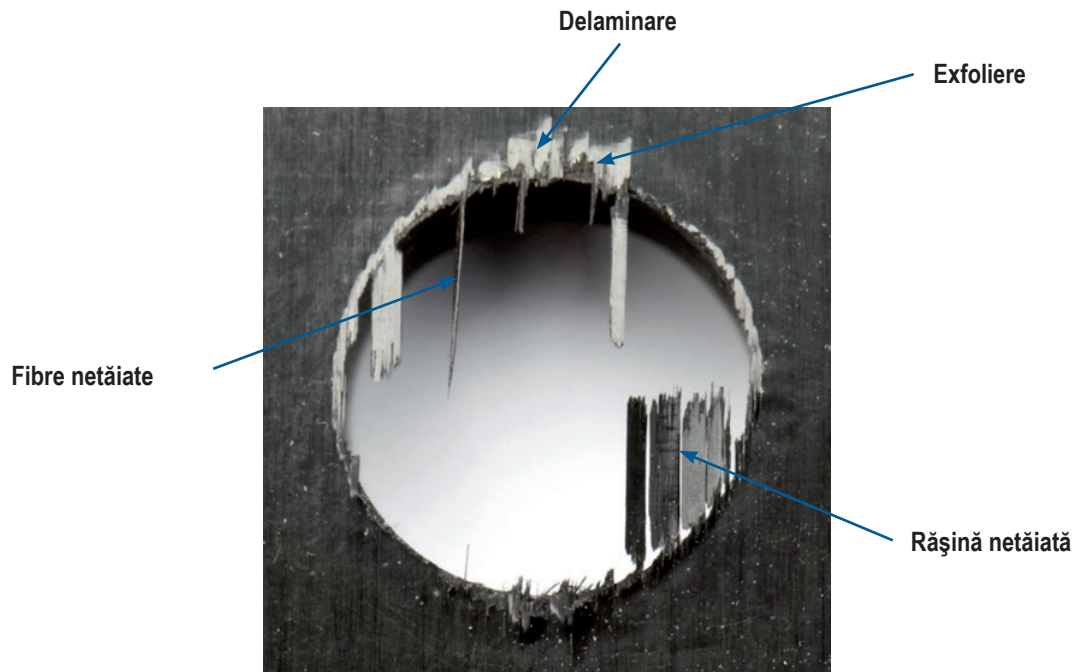


CFRP = plastic ranforsat cu fibră de carbon  
GFRP = plastic ranforsat cu fibră de sticlă

Anexă



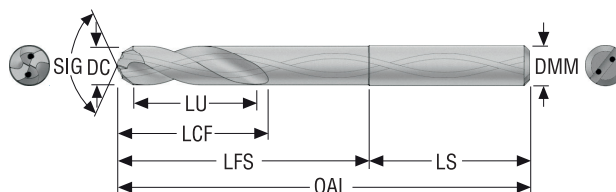
Depanare – ieșirea din gaură



Problemă:	Delaminare (exfoliere / umflare)	Exfoliere	Fibre netăiate	Rășină netăiată
Soluție:	<p><b>Exfoliere</b></p> <ul style="list-style-type: none"> <li>Utilizați o sculă cu o geometrie mai negativă</li> <li>Reduceți avansul/rotația</li> </ul> <p><b>Umflare</b></p> <ul style="list-style-type: none"> <li>Reduceți avansul/rotația</li> </ul>	<ul style="list-style-type: none"> <li>Utilizați o sculă cu o geometrie mai pozitivă</li> <li>Reduceți avansul/rotația</li> </ul>	<ul style="list-style-type: none"> <li>Utilizați o sculă cu o geometrie mai ascuțită</li> <li>Reduceți avansul/rotația</li> </ul>	<ul style="list-style-type: none"> <li>Utilizați o sculă cu o geometrie mai ascuțită</li> <li>Reduceți avansul/rotația</li> <li>Reduceți viteza de așchiere</li> </ul>
Problemă:	Rășină topită (prea multă căldură)	Viață scurtă a sculei		
Soluție:	<ul style="list-style-type: none"> <li>Reduceți viteza de așchiere</li> </ul>	<ul style="list-style-type: none"> <li>Reduceți viteza de așchiere</li> </ul>		

## SD205A-C1

Adâncimea de găurire ~ 5 x D

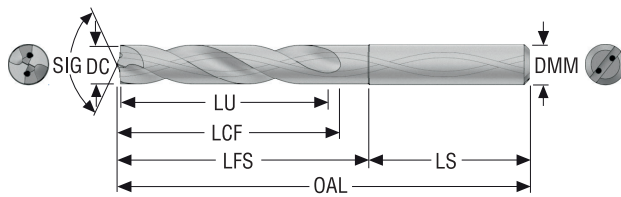


- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 60°/130°
- Acoperire Dura diamond
- Pentru regimurile de aşchiere vezi pag. 149, 150

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

## SD205A-C2

Adâncimea de găurire ~ 5 x D

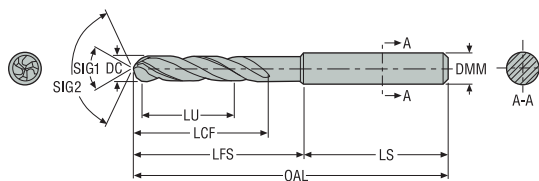


- Coadă cilindrică DIN 6537A
- Răcire interioară
- Unghiul la vârf: 140°/180°
- Acoperire Dura diamond
- Pentru regimurile de aşchiere vezi pag. 149, 150

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

## SD203-CX1

Adâncimea de găurire ~ 3 x D

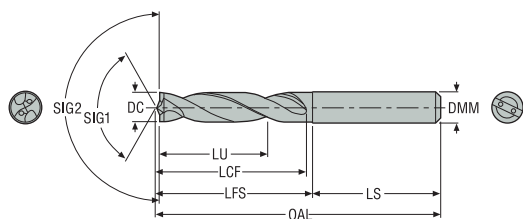


- Coadă cilindrică DIN 6537A
- Muchii de aşchiere PCD.
- Unghiul la vârf: 60°/130°
- Pentru regimurile de aşchiere vezi pag. 147, 148

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

## SD203A-CX2

Adâncimea de găurire ~ 3 x D

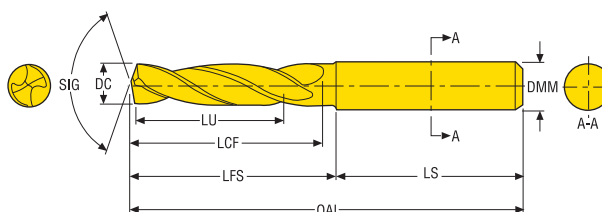


- Coadă cilindrică DIN 6537A
- Muchii de aşchiere PCD.
- Unghiul la vârf: 120°/180°
- Pentru regimurile de aşchiere vezi pag. 149, 150

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

## SD205-CX31

Adâncimea de găurire ~ 5 x D



- Coadă cilindrică DIN 6537A
- Muchii de aşchiere PCD.
- Unghiul la vârf: 120°
- Pentru regimurile de aşchiere vezi pag. 149

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



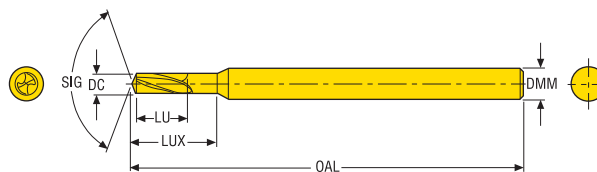
## Micro-găurire

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

- Capabile să ofere creșteri spectaculoase de performanță în comparație cu burghiile HSS tradiționale
- Adecvate pentru aplicații din industria auto și medicală, precum și pentru producție de piese mici din industria generală mecanică

## SD22

Adâncimea de găurire 2 x D (Burghiu pilot)



- Coadă cilindrică
- Răcire exterioară
- Unghiul la vârf: 130°
- Neacoperite
- Pentru regimurile de aşchiere vezi pag. 169-173

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



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

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

Introducere

Găurire

Alezare

Alezare adâncă

Anexă

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

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

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

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

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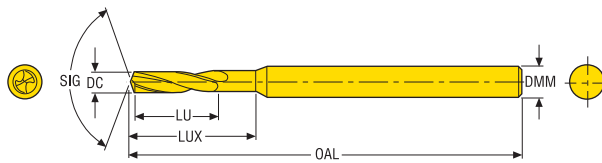
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## SD26

Adâncimea de găurire ~ 6 x D



- Coadă cilindrică
- Răcire exterioră
- Unghiul la vârf: 130°
- Neacoperite
- Pentru regimurile de aşchiere vezi pag. 169-173

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

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

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

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

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

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

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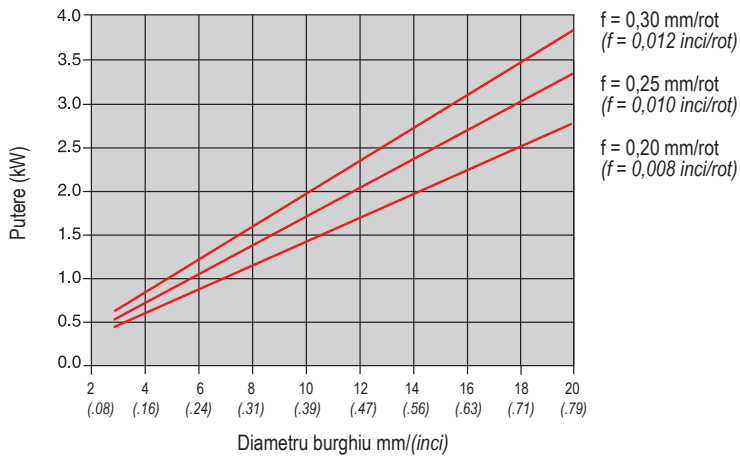
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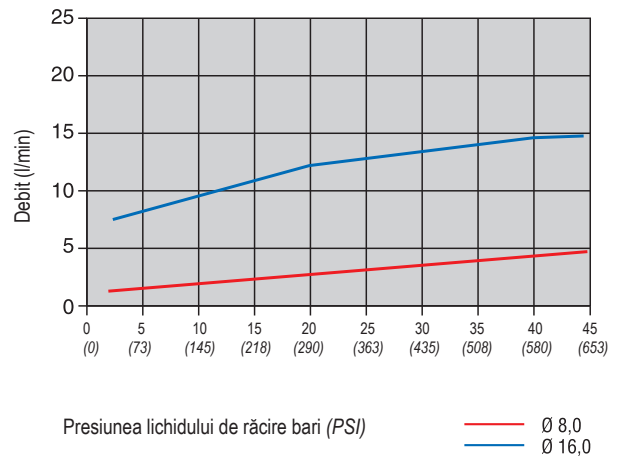
Reper Nr.	Număr reper	DC	LU	OAL	LUX	DMM
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
SD26-1.86-11.20-3R1	02730773	1,86 0.073	11,2 0.441	38,0 1.496	13,4 0.528	3,0 0.118
SD26-1.87-11.20-3R1	02730774	1,87 0.074	11,2 0.441	38,0 1.496	13,4 0.528	3,0 0.118
SD26-1.88-11.20-3R1	02730775	1,88 0.074	11,2 0.441	38,0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

## Parametri de prelucrare

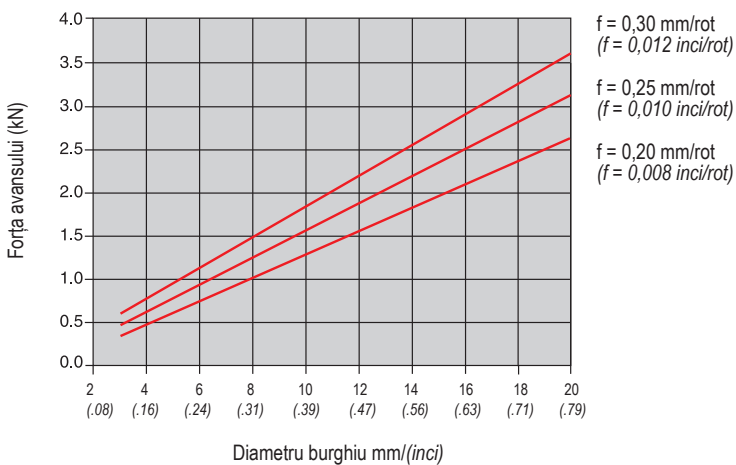
### Consumul net de putere



### Debitul lichidului de răcire la diferite presiuni



### Forța avansului



Metodă:  
Măriți sau micșorați avansul pentru a obține cea mai bună formare a așchiilor.  
Un avans/rotație mai mare duce la așchii mai scurte.

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

### Parametri de prelucrare

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

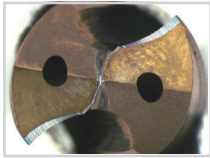
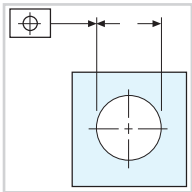
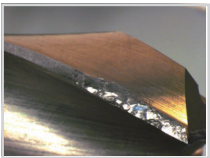
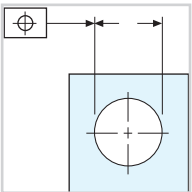

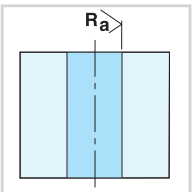
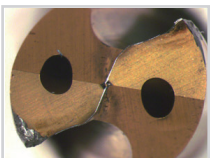
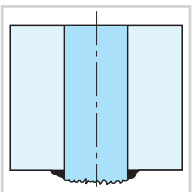

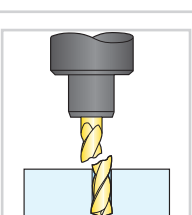
Burghiu Ø DC (mm)	Toleranța IT9 (μm)	Toleranța IT10 (μm)	Burghiu Ø DC (inci)	Toleranța IT9 (inci)	Toleranța IT10 (inci)
< 3	14	25	-0.118	0.0006	0.0010
3-6	18	30	> 0.118-0.236	0.0007	0.0012
6-10	22	36	> 0.236-0.394	0.0009	0.0014
10-18	27	43	> 0.394-0.709	0.0011	0.0017
> 18	33	52	> 0.709	0.0013	0.0020

\*Deteriorarea finisării suprafeței poate apărea când găuriți în oțel cu conținut redus de carbon sau în oțel inoxidabil.

## Depanare – puncte de verificare inițiale

- Stabilitatea prinderii
- Starea arborelui mașinii
- Starea port-sculei
- Prinderea sculei:
  - bătaie radială maximă 0,04 TIR
  - dacă se utilizează pregăurire maxim 0,04 TIR

- Îndepărtarea așchiilor:
  - regimuri de frezare
- Lichid de răcire:
  - Presiune
  - Debit
  - Concentrație

<p><b>Uzură rapidă a părților laterale</b></p> <ul style="list-style-type: none"> <li>• Reduceți viteza de așchiere</li> <li>• Mărește concentrația lichidului de răcire</li> </ul>		<p><b>Toleranța diametrului nesatisfăcătoare</b></p> <ul style="list-style-type: none"> <li>• Măriți avansul/rotația</li> <li>• Utilizați o operație de alezare, consultați paginile 328</li> <li>• Utilizați o operație de alezare adâncă, consultați paginile 492-493</li> </ul>	
<p><b>Uzură/Așezare periferică</b></p> <ul style="list-style-type: none"> <li>• Reduceți viteza de așchiere</li> <li>• Mărește concentrația lichidului de răcire</li> </ul>		<p><b>Poziționarea găurii nesatisfăcătoare</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotația la intrare</li> <li>• Reduceți avansul/rotația</li> <li>• Utilizați o operațiune de alezare, consultați paginile 492-493</li> <li>• Dacă găuriți prin suprafețe tari, neregulate și înclinate, reduceți avansul cu 30%-50% la intrare și la ieșire</li> <li>• Centrați burghiul cu un unghi la vârf de 140°</li> </ul>	
<p><b>Ciobituri/Centru</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotația la intrare</li> <li>• Reduceți avansul/rotația</li> <li>• Utilizați o operațiune de alezare, consultați paginile 492-493</li> </ul>		<p><b>Finisare slabă a suprafeței</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotația</li> <li>• Măriți viteza de așchiere</li> <li>• Utilizați o operațiune de alezare, consultați paginile 328</li> </ul>	
<p><b>Ciobituri/Colț exterior, muchia de așchiere</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul la intrare/ieșire</li> <li>• Reduceți viteza de așchiere</li> <li>• Măriți concentrația lichidului de răcire</li> <li>• Reascuțiți burghiul</li> </ul>		<p><b>Bavuri la ieșire</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotația la ieșire</li> <li>• Micșorați lățimea pregătirii muchiei (BN)</li> </ul>	
<p><b>Aderențe pe tăiș</b></p> <ul style="list-style-type: none"> <li>• Dacă este aproape de periferie, măriți viteză de așchiere</li> <li>• Dacă este aproape de centru, măriți avansul</li> <li>• Dacă burghiul este uzat, trebuie reascuțit</li> </ul>		<p><b>Ruperea burghiului la contact/la terminarea găurii</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotația la intrare/ieșire</li> <li>• Reglați regimul de frezare pentru o îndepărtare mai bună a așchiilor</li> </ul>	

## Instrucțiuni de reascuțire pentru SD1103, SD1103A, SD1105A, SD1108A și SD1112A

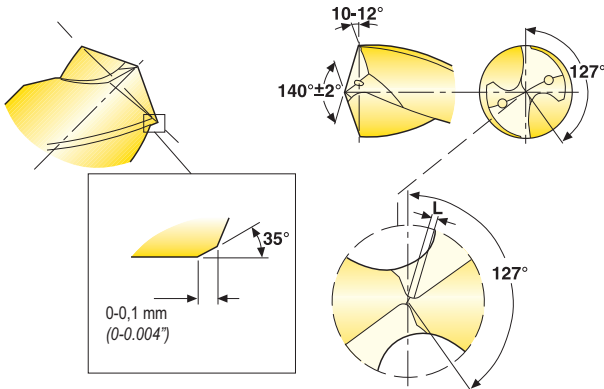
**Specificații:**

Specificațiile propuse pentru discul de diamant:  
Degajarea vârfului: Forma roții 12A2 Granulația D54 (fig. 1).  
Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).  
Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).  
Tratamentul muchiei: ascuțire K-land sau rectificarea (figura 4).

**Important:**

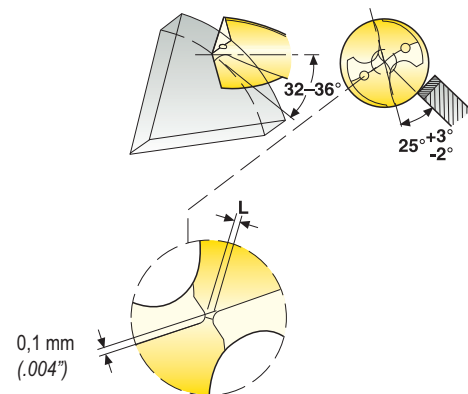
- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

### 1. Vârf cu patru fațete



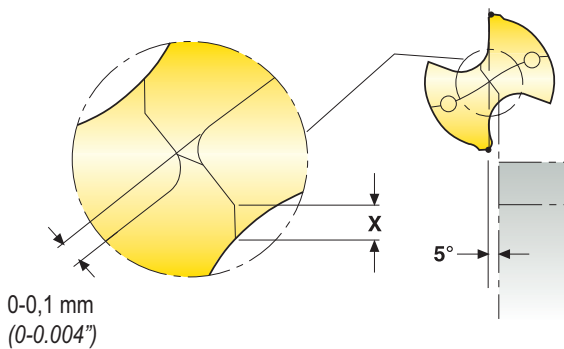
Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm (0,008")

### 2. Web thinning



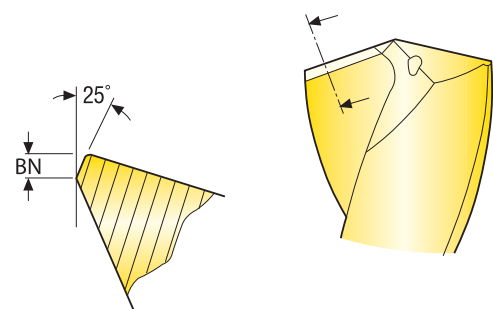
Burghiu Ø DC mm	L mm	Burghiu Ø DC inci	L inci
2-10	0,1-0,3	0.079-0.394	0.004-0.012
10-20	0,2-0,4	0.394-0.787	0.008-0.016

### 3. Grinding of flat X



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

### 4. Pregătirea muchiei



Materialul semifabricatului	BN			
	Burghiu Ø ≤ 10 mm	Burghiu Ø > 10 mm	Burghiu Ø ≤ 0.394 inci	Burghiu Ø > 0.394 inci
Oțel	0,05	0,10	0.002	0.004
Oțel inoxidabil	0,05	0,05	0.002	0.002
Fontă	0,05	0,10	0.002	0.004

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



## Instrucțiuni de reascuțire pentru SD203A, SD205A și SD207A geometrie P

**Specificații:**

Specificațiile propuse pentru discul de diamant:

Ajustaj conic: Forma roții 12A2 Granulația D54 (fig.1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificarea (figura 4).

**Important:**

- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

### 1. Flanc conic

Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm (0,008")

### 2. Web thinning

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

### 3. Grinding of flat X

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

### 4. Pregătirea muchiei

Materialul semifabricatului	BN			
	Burghiu Ø ≤ 10 mm	Burghiu Ø > 10 mm	Burghiu Ø ≤ 0.394 inci	Burghiu Ø > 0.394 inci
Oțel	0,05	0,10	0.002	0.004
Oțel inoxidabil	0,05	0,05	0.002	0.002
Fontă	0,05	0,10	0.002	0.004

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

## Instrucțiuni de reascuțire pentru burghie pentru șanfrenare.

Instrucțiunile de reascuțire sunt identice cu cele pentru SD203, SD203A, SD205A și SD207A cu excepția șanfrenului.

Introducere

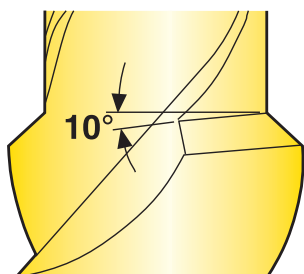
Găurire

Alezare

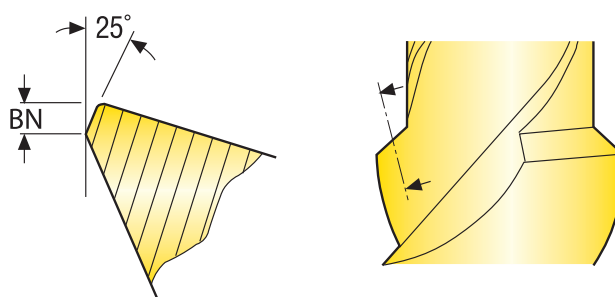
Alezare adâncă

Anexă

### 1. Degajarea șanfrenului



### 2. Pregătirea muchiei, șanfren



Materialul semifabricatului	BN			
	Burghiu $\varnothing \leq 10$ mm	Burghiu $\varnothing > 10$ mm	Burghiu $\varnothing \leq 0.394$ inci	Burghiu $\varnothing > 0.394$ inci
Oțel	0,05	0,10	0.002	0.004
Oțel inoxidabil	0,05	0,05	0.002	0.002
Fontă	0,05	0,10	0.002	0.004

## Instrucțiuni de reascuțire pentru SD212A, SD216A, SD220A, SD225A și SD230A

**Specificații:**

Specificațiile propuse pentru discul de diamant:

Degajarea vârfului: Forma roții 11V9 Granulația D54 (fig. 1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificarea (figura 4).

**Important:**

- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

### 1. Flanc conic

Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm (0,008")

### 2. Web thinning

Burghiu Ø DC mm	L mm	Burghiu Ø DC inci	L inci
2-10	0,2	0.079-0.394	0.008
10-20	0,4	0.394-0.787	0.016

### 3. Grinding of flat X

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

### 4. Pregătirea muchiei

Materialul semifabricatului	BN			
	Burghiu Ø ≤ 10 mm	Burghiu Ø > 10 mm	Burghiu Ø ≤ 0.394 inci	Burghiu Ø > 0.394 inci
Oțel	0,05	0,10	0.002	0.004
Oțel inoxidabil	0,05	0,05	0.002	0.002
Fontă	0,05	0,10	0.002	0.004

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

## Instrucțiuni de reascuțire pentru SD265A

Specificații:

Specificațiile propuse pentru discul de diamant:

Ajustaj conic: Forma roții 12A2 Granulația D54 (fig.1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

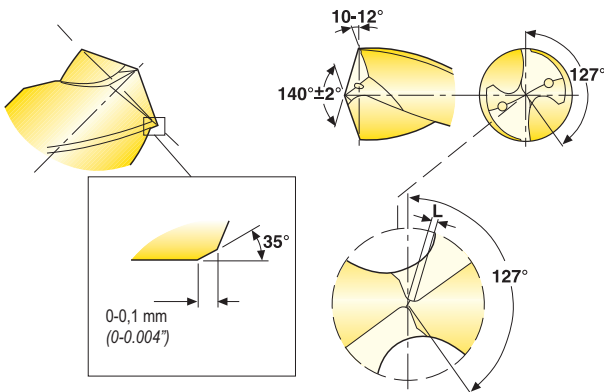
Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificare (figura 4).

Important:

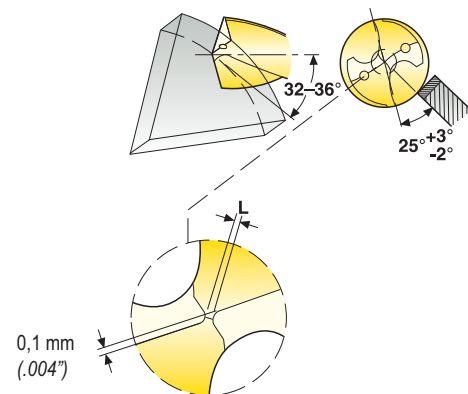
- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

### 1. Flanc conic



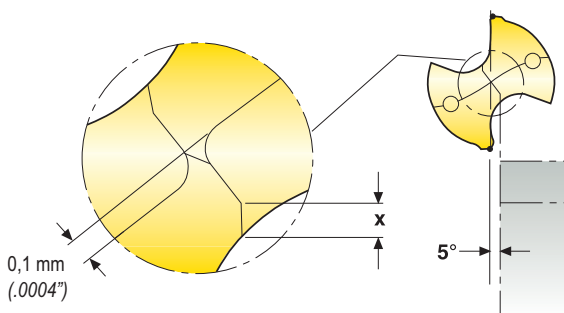
Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm (0,008")

### 2. Web thinning



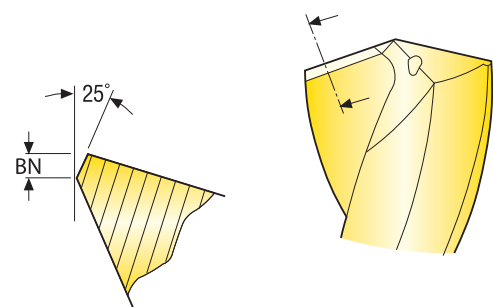
Burghiu Ø DC mm	L mm	Burghiu Ø DC inci	L inci
2-10	0,2	0.079-0.394	0.008
10-20	0,4	0.394-0.787	0.016

### 3. Grinding of flat X



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

### 4. Pregătirea muchiei



Materialul semifabricatului	BN			
	Burghiu Ø ≤ 10 mm	Burghiu Ø > 10 mm	Burghiu Ø ≤ 0.394 inci	Burghiu Ø > 0.394 inci
Oțel	0,05	0,10	0.002	0.004
Oțel inoxidabil	0,05	0,05	0.002	0.002
Fontă	0,05	0,10	0.002	0.004

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

## Instrucțiuni de reascuțire pentru geometria - MS

**Specificații:**

Specificațiile propuse pentru discul de diamant:

Ajustaj conic: Forma roții 12A2 Granulația D54 (fig.1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificare (figura 4).

**Important:**

- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

**1. Patru fațete**

Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,02 mm (0,008\"

**2. Ascuțirea razei R**

**3. Web thinning**

**4. Pregătirea muchiei**

Burghiu Ø DC mm	BN mm	Burghiu Ø DC inci	BN inci
2-3	0,2	0.079-0.118	0.00787
3-6	0,025	0.118-0.236	0.00098
6-10	0,04	0.236-0.394	0.00157
10-20	0,055	0.394-0.787	0.00216
20-	0,07	0.787-	0.00275

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

## Instrucțiuni de reascuțire pentru geometriile -M și -T

Specificații:

Specificațiile propuse pentru discul de diamant:

Ajustaj conic: Forma roții 12A2 Granulația D54 (fig.1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

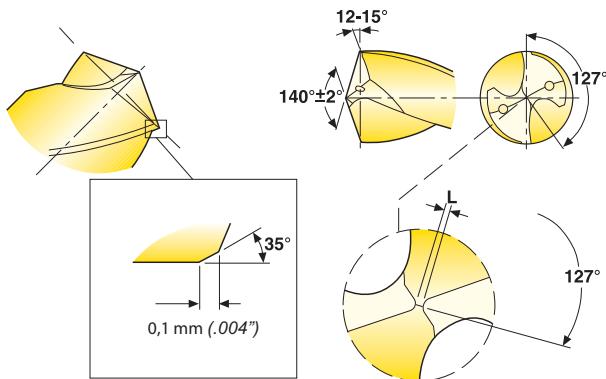
Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificarea (figura 4).

Important:

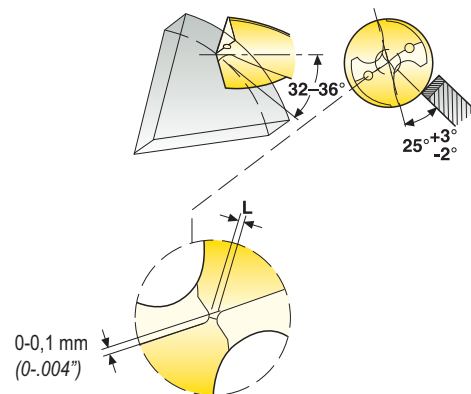
- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

### 1. Flanc conic



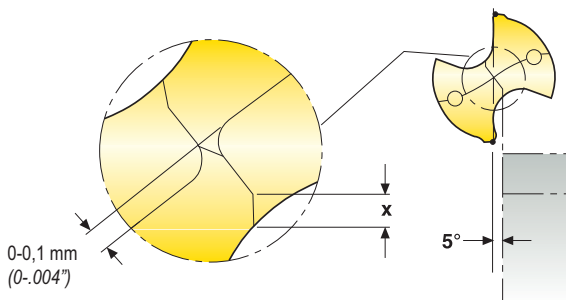
Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,01 mm (0,0004")

### 2. Web thinning

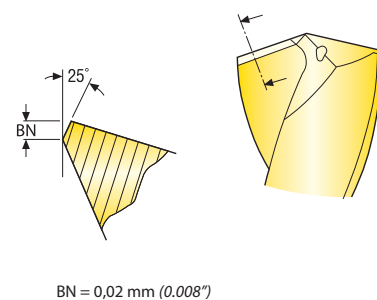


Burghiu Ø DC mm	L mm	Burghiu Ø DC inci	L inci
3-6	0,1-0,2	0.118-0.236	0.004-0.008
6-10	0,13-0,27	0.236-0.394	0.005-0.011
10-20	0,2-0,4	0.394-0.787	0.008-0.016

### 3. Grinding of flat X



### 4. Pregătirea muchiei



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

## Instrucțiuni de reascuțire pentru geometria -N

**Generalități:**

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

**Specificații:**

Specificațiile propuse pentru discul de diamant:

Ajustaj conic: Forma roții 12A2 Granulația D54 (fig.1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificarea (figura 4).

**Important:**

- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

### 1. Flanc conic

Distanța înălțimii buzei (bătaia radială) trebuie să fie maxim 0,01 mm (0,0004")

### 2. Web thinning

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

### 3. Grinding of flat X

### 4. Pregătirea muchiei

BN = 0,01-0,02 mm (0,004-0,008")

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

SD1103 – Ø 3-20 mm / 0.118-0.787 inci

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pomire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

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SD1105A – Ø 3-20 mm / 0.118-0.787 inci

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

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

SD112 – Ø 3-20 mm / 0.118-0.787 inci

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

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

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SD203A – Ø 2-8 mm / 0.079-0.315 inci

SMG		f						v <sub>c</sub>
		Ø2,00 Ø 0.079	Ø3,00 Ø 0.118	Ø4,00 Ø 0.157	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	
P1	P	0,14	0,17	0,20	0,24	0,26	0,32	185
	P	0.0055	0.0065	0.0080	0.0095	0.010	0.013	610
P2	P	0,14	0,17	0,20	0,24	0,26	0,32	180
	P	0.0055	0.0065	0.0080	0.0095	0.010	0.013	590
P3	P	0,14	0,16	0,19	0,22	0,25	0,32	155
	P	0.0055	0.0065	0.0075	0.0085	0.010	0.013	510
P4	P	0,10	0,13	0,15	0,17	0,19	0,24	210
	P	0.0040	0.0050	0.0060	0.0065	0.0075	0.0095	690
P5	P	0,10	0,12	0,14	0,17	0,19	0,22	205
	P	0.0040	0.0048	0.0055	0.0065	0.0075	0.0085	670
P6	P	0,10	0,12	0,14	0,16	0,19	0,22	230
	P	0.0040	0.0048	0.0055	0.0065	0.0075	0.0085	750
P7	P	0,10	0,12	0,14	0,16	0,19	0,22	215
	P	0.0040	0.0048	0.0055	0.0065	0.0075	0.0085	710
P8	P	0,11	0,13	0,15	0,17	0,19	0,24	200
	P	0.0044	0.0050	0.0060	0.0065	0.0075	0.0095	660
P11	P	0,060	0,075	0,085	0,10	0,11	0,14	105
	P	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	345
P12	P	0,060	0,075	0,085	0,10	0,11	0,14	75
	P	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	245
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	110
	MS	0.0030	0.0038	0.0044	0.0050	0.0060	0.0075	360
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	90
	MS	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	295
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	45
	MS	0.0038	0.0044	0.0050	0.0060	0.0065	0.0080	160
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	50
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	165
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	42
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	140
K1	P	0,15	0,18	0,22	0,25	0,28	0,36	175
	P	0.0060	0.0070	0.0085	0.010	0.011	0.014	570
K2	P	0,14	0,17	0,20	0,22	0,26	0,32	150
	P	0.0055	0.0065	0.0080	0.0085	0.010	0.013	490
K3	P	0,14	0,17	0,20	0,22	0,26	0,32	125
	P	0.0055	0.0065	0.0080	0.0085	0.010	0.013	410
K4	P	0,14	0,17	0,20	0,22	0,26	0,32	120
	P	0.0055	0.0065	0.0080	0.0085	0.010	0.013	395
K5	P	0,12	0,15	0,18	0,20	0,24	0,28	70
	P	0.0048	0.0060	0.0070	0.0080	0.0095	0.011	230
N1	N	0,13	0,16	0,19	0,22	0,26	0,32	350
	N	0.0050	0.0065	0.0075	0.0085	0.010	0.013	1150
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	225
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	740
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	150
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	490
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	285
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	940
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	39
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	130
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S11	MS	0,070	0,085	0,095	0,11	0,12	0,14	70
	MS	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	230
S12	MS	0,070	0,085	0,095	0,11	0,12	0,14	55
	MS	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	180
S13	MS	0,065	0,075	0,085	0,095	0,10	0,12	43
	MS	0.0026	0.0030	0.0034	0.0038	0.0040	0.0048	140
H3	P	0,055	0,070	0,080	0,090	0,10	0,12	28
	P	0.0022	0.0028	0.0032	0.0036	0.0040	0.0048	90
H5	P	0,085	0,10	0,12	0,13	0,15	0,18	55
	P	0.0034	0.0040	0.0048	0.0050	0.0060	0.0070	180
H7	P	0,055	0,070	0,080	0,090	0,10	0,12	28
	P	0.0022	0.0028	0.0032	0.0036	0.0040	0.0048	90
H8	P	0,065	0,080	0,090	0,10	0,12	0,14	55
	P	0.0026	0.0032	0.0036	0.0040	0.0048	0.0055	180
H11	P	0,085	0,10	0,12	0,13	0,15	0,18	65
	P	0.0034	0.0040	0.0048	0.0050	0.0060	0.0070	215
H12	P	0,065	0,080	0,090	0,10	0,12	0,14	80
	P	0.0026	0.0032	0.0036	0.0040	0.0048	0.0055	260
H21	P	0,065	0,080	0,090	0,10	0,12	0,14	55
	P	0.0026	0.0032	0.0036	0.0040	0.0048	0.0055	180

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pomire

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

SMG		f						V <sub>c</sub>
		Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P1	P	0,38	0,44	0,48	0,50	0,55	0,55	185
	P	0.015	0.017	0.019	0.020	0.022	0.022	610
P2	P	0,38	0,44	0,48	0,50	0,55	0,60	180
	P	0.015	0.017	0.019	0.020	0.022	0.024	590
P3	P	0,36	0,42	0,46	0,50	0,50	0,55	155
	P	0.014	0.017	0.018	0.020	0.020	0.022	510
P4	P	0,28	0,30	0,34	0,36	0,38	0,40	210
	P	0.011	0.012	0.013	0.014	0.015	0.016	690
P5	P	0,26	0,30	0,32	0,34	0,36	0,38	205
	P	0.010	0.012	0.013	0.013	0.014	0.015	670
P6	P	0,26	0,30	0,32	0,34	0,36	0,38	230
	P	0.010	0.012	0.013	0.013	0.014	0.015	750
P7	P	0,26	0,30	0,32	0,34	0,36	0,38	215
	P	0.010	0.012	0.013	0.013	0.014	0.015	710
P8	P	0,28	0,32	0,34	0,36	0,38	0,40	200
	P	0.011	0.013	0.013	0.014	0.015	0.016	660
P11	P	0,16	0,18	0,20	0,22	0,24	0,24	105
	P	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	345
P12	P	0,16	0,18	0,20	0,22	0,24	0,24	75
	P	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	245
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	110
	MS	0.0085	0.010	0.011	0.012	0.012	0.013	360
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	90
	MS	0.0080	0.0085	0.010	0.010	0.011	0.012	295
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	45
	MS	0.0095	0.010	0.011	0.012	0.013	0.013	150
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	50
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	165
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	42
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	140
K1	P	0,42	0,48	0,50	0,55	0,60	0,65	175
	P	0.017	0.019	0.020	0.022	0.024	0.026	570
K2	P	0,38	0,42	0,48	0,50	0,55	0,55	150
	P	0.015	0.017	0.019	0.020	0.022	0.022	490
K3	P	0,38	0,42	0,48	0,50	0,55	0,55	125
	P	0.015	0.017	0.019	0.020	0.022	0.022	410
K4	P	0,38	0,42	0,48	0,50	0,55	0,55	120
	P	0.015	0.017	0.019	0.020	0.022	0.022	395
K5	P	0,34	0,38	0,42	0,46	0,48	0,50	70
	P	0.013	0.015	0.017	0.018	0.019	0.020	230
N1	N	0,38	0,42	0,46	0,50	0,55	0,55	350
	N	0.015	0.017	0.018	0.020	0.022	0.022	1150
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	225
	MS	0.015	0.017	0.018	0.020	0.022	0.022	740
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	150
	MS	0.015	0.017	0.018	0.020	0.022	0.022	490
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	285
	MS	0.015	0.017	0.018	0.020	0.022	0.022	940
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	39
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	130
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S11	MS	0,17	0,19	0,22	0,24	0,25	0,26	70
	MS	0.0065	0.0075	0.0085	0.0095	0.010	0.010	230
S12	MS	0,17	0,19	0,22	0,24	0,25	0,26	55
	MS	0.0065	0.0075	0.0085	0.0095	0.010	0.010	180
S13	MS	0,15	0,17	0,19	0,20	0,22	0,22	43
	MS	0.0060	0.0065	0.0075	0.0080	0.0085	0.0085	140
H3	P	0,14	0,16	0,18	0,19	0,20	0,20	28
	P	0.0055	0.0065	0.0070	0.0075	0.0080	0.0080	90
H5	P	0,22	0,24	0,26	0,28	0,30	0,32	55
	P	0.0085	0.0095	0.010	0.011	0.012	0.013	180
H7	P	0,14	0,16	0,18	0,19	0,20	0,20	28
	P	0.0055	0.0065	0.0070	0.0075	0.0080	0.0080	90
H8	P	0,16	0,19	0,20	0,22	0,24	0,24	55
	P	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	180
H11	P	0,22	0,24	0,26	0,28	0,30	0,32	65
	P	0.0085	0.0095	0.010	0.011	0.012	0.013	215
H12	P	0,16	0,19	0,20	0,22	0,24	0,24	80
	P	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	260
H21	P	0,16	0,19	0,20	0,22	0,24	0,24	55
	P	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	180

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pomire

SD205A – Ø 2-8 mm / 0.079-0.315 inci

SMG		f						v <sub>c</sub>
		Ø2,00 Ø 0.079	Ø3,00 Ø 0.118	Ø4,00 Ø 0.157	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	
P1	P	0,14	0,17	0,20	0,24	0,26	0,32	170
	P	0.0055	0.0065	0.0080	0.0095	0.010	0.013	560
P2	P	0,14	0,17	0,20	0,24	0,26	0,32	165
	P	0.0055	0.0065	0.0080	0.0095	0.010	0.013	540
P3	P	0,14	0,16	0,19	0,22	0,25	0,32	140
	P	0.0055	0.0065	0.0075	0.0085	0.010	0.013	460
P4	P	0,10	0,13	0,15	0,17	0,19	0,24	195
	P	0.0040	0.0050	0.0060	0.0065	0.0075	0.0095	640
P5	P	0,10	0,12	0,14	0,17	0,19	0,22	185
	P	0.0040	0.0048	0.0055	0.0065	0.0075	0.0085	610
P6	P	0,10	0,12	0,14	0,16	0,19	0,22	210
	P	0.0040	0.0048	0.0055	0.0065	0.0075	0.0085	690
P7	P	0,10	0,12	0,14	0,16	0,19	0,22	200
	P	0.0040	0.0048	0.0055	0.0065	0.0075	0.0085	660
P8	P	0,11	0,13	0,15	0,17	0,19	0,24	185
	P	0.0044	0.0050	0.0060	0.0065	0.0075	0.0095	610
P11	P	0,060	0,075	0,085	0,10	0,11	0,14	95
	P	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	310
P12	P	0,060	0,075	0,085	0,10	0,11	0,14	65
	P	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	215
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	110
	MS	0.0030	0.0038	0.0044	0.0050	0.0060	0.0075	360
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	90
	MS	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	295
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	150
	MS	0.0038	0.0044	0.0050	0.0060	0.0065	0.0080	160
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	50
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	165
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	42
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	140
K1	P	0,15	0,18	0,22	0,25	0,28	0,36	160
	P	0.0060	0.0070	0.0085	0.010	0.011	0.014	520
K2	P	0,14	0,17	0,20	0,22	0,26	0,32	135
	P	0.0055	0.0065	0.0080	0.0085	0.010	0.013	445
K3	P	0,14	0,17	0,20	0,22	0,26	0,32	115
	P	0.0055	0.0065	0.0080	0.0085	0.010	0.013	375
K4	P	0,14	0,17	0,20	0,22	0,26	0,32	110
	P	0.0055	0.0065	0.0080	0.0085	0.010	0.013	360
K5	P	0,12	0,15	0,18	0,20	0,24	0,28	65
	P	0.0048	0.0060	0.0070	0.0080	0.0095	0.011	215
N1	N	0,13	0,16	0,19	0,22	0,26	0,32	350
	N	0.0050	0.0065	0.0075	0.0085	0.010	0.013	1150
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	225
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	740
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	150
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	490
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	285
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	940
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	39
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	130
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S11	MS	0,070	0,085	0,095	0,11	0,12	0,14	70
	MS	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	230
S12	MS	0,070	0,085	0,095	0,11	0,12	0,14	55
	MS	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	180
S13	MS	0,065	0,075	0,085	0,095	0,10	0,12	43
	MS	0.0026	0.0030	0.0034	0.0038	0.0040	0.0048	140
H3	P	0,055	0,070	0,080	0,090	0,10	0,12	26
	P	0.0022	0.0028	0.0032	0.0036	0.0040	0.0048	85
H5	P	0,085	0,10	0,12	0,13	0,15	0,18	48
	P	0.0034	0.0040	0.0048	0.0050	0.0060	0.0070	155
H7	P	0,055	0,070	0,080	0,090	0,10	0,12	26
	P	0.0022	0.0028	0.0032	0.0036	0.0040	0.0048	85
H8	P	0,065	0,080	0,090	0,10	0,12	0,14	48
	P	0.0026	0.0032	0.0036	0.0040	0.0048	0.0055	155
H11	P	0,085	0,10	0,12	0,13	0,15	0,18	60
	P	0.0034	0.0040	0.0048	0.0050	0.0060	0.0070	195
H12	P	0,065	0,080	0,090	0,10	0,12	0,14	70
	P	0.0026	0.0032	0.0036	0.0040	0.0048	0.0055	230
H21	P	0,065	0,080	0,090	0,10	0,12	0,14	48
	P	0.0026	0.0032	0.0036	0.0040	0.0048	0.0055	155

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pomire

Introducere

Găuire

Alezare

Alezare adâncă

Anexă

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

SMG		f						V <sub>c</sub>
		Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P1	P	0,38	0,44	0,48	0,50	0,55	0,55	170
	P	0.015	0.017	0.019	0.020	0.022	0.022	560
P2	P	0,38	0,44	0,48	0,50	0,55	0,60	165
	P	0.015	0.017	0.019	0.020	0.022	0.024	540
P3	P	0,36	0,42	0,46	0,50	0,50	0,55	140
	P	0.014	0.017	0.018	0.020	0.020	0.022	460
P4	P	0,28	0,30	0,34	0,36	0,38	0,40	195
	P	0.011	0.012	0.013	0.014	0.015	0.016	640
P5	P	0,26	0,30	0,32	0,34	0,36	0,38	185
	P	0.010	0.012	0.013	0.013	0.014	0.015	610
P6	P	0,26	0,30	0,32	0,34	0,36	0,38	210
	P	0.010	0.012	0.013	0.013	0.014	0.015	690
P7	P	0,26	0,30	0,32	0,34	0,36	0,38	200
	P	0.010	0.012	0.013	0.013	0.014	0.015	660
P8	P	0,28	0,32	0,34	0,36	0,38	0,40	185
	P	0.011	0.013	0.013	0.014	0.015	0.016	610
P11	P	0,16	0,18	0,20	0,22	0,24	0,24	95
	P	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	310
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	110
	MS	0.0085	0.010	0.011	0.012	0.012	0.013	360
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	90
	MS	0.0080	0.0085	0.010	0.010	0.011	0.012	295
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	45
	MS	0.0095	0.010	0.011	0.012	0.013	0.013	150
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	50
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	165
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	42
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	140
K1	P	0,42	0,48	0,50	0,55	0,60	0,65	160
	P	0.017	0.019	0.020	0.022	0.024	0.026	520
K2	P	0,38	0,42	0,48	0,50	0,55	0,55	135
	P	0.015	0.017	0.019	0.020	0.022	0.022	445
K3	P	0,38	0,42	0,48	0,50	0,55	0,55	115
	P	0.015	0.017	0.019	0.020	0.022	0.022	375
K4	P	0,38	0,42	0,48	0,50	0,55	0,55	110
	P	0.015	0.017	0.019	0.020	0.022	0.022	360
K5	P	0,34	0,38	0,42	0,46	0,48	0,50	65
	P	0.013	0.015	0.017	0.018	0.019	0.020	215
N1	N	0,38	0,42	0,46	0,50	0,55	0,55	350
	N	0.015	0.017	0.018	0.020	0.022	0.022	1150
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	225
	MS	0.015	0.017	0.018	0.020	0.022	0.022	740
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	150
	MS	0.015	0.017	0.018	0.020	0.022	0.022	490
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	285
	MS	0.015	0.017	0.018	0.020	0.022	0.022	940
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	39
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	130
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S11	MS	0,17	0,19	0,22	0,24	0,25	0,26	70
	MS	0.0065	0.0075	0.0085	0.0095	0.010	0.010	230
S12	MS	0,17	0,19	0,22	0,24	0,25	0,26	55
	MS	0.0065	0.0075	0.0085	0.0095	0.010	0.010	180
S13	MS	0,15	0,17	0,19	0,20	0,22	0,22	43
	MS	0.0060	0.0065	0.0075	0.0080	0.0085	0.0085	140
H3	P	0,14	0,16	0,18	0,19	0,20	0,20	26
	P	0.0055	0.0065	0.0070	0.0075	0.0080	0.0080	85
H5	P	0,22	0,24	0,26	0,28	0,30	0,32	48
	P	0.0085	0.0095	0.010	0.011	0.012	0.013	155
H7	P	0,14	0,16	0,18	0,19	0,20	0,20	26
	P	0.0055	0.0065	0.0070	0.0075	0.0080	0.0080	85
H8	P	0,16	0,19	0,20	0,22	0,24	0,24	48
	P	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	155
H11	P	0,22	0,24	0,26	0,28	0,30	0,32	60
	P	0.0085	0.0095	0.010	0.011	0.012	0.013	195
H12	P	0,16	0,19	0,20	0,22	0,24	0,24	70
	P	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	230
H21	P	0,16	0,19	0,20	0,22	0,24	0,24	48
	P	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	155

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pomire



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

SMG		f			v <sub>c</sub>
		Ø0,70 Ø 0.0276	Ø1,00 Ø 0.0394	Ø2,00 Ø 0.0787	
P1	P	0,080	0,090	0,11	140
	P	0,0032	0,0036	0,0044	460
P2	P	0,085	0,090	0,12	140
	P	0,0034	0,0036	0,0048	460
P3	P	0,080	0,085	0,11	120
	P	0,0032	0,0034	0,0044	395
P4	P	0,080	0,085	0,11	105
	P	0,0032	0,0034	0,0044	345
P5	P	0,075	0,085	0,11	100
	P	0,0030	0,0034	0,0044	330
P6	P	0,075	0,080	0,10	110
	P	0,0030	0,0032	0,0040	360
P7	P	0,075	0,080	0,10	105
	P	0,0030	0,0032	0,0040	345
P8	P	0,080	0,085	0,11	100
	P	0,0032	0,0034	0,0044	330
P11	P	0,075	0,080	0,10	105
	P	0,0030	0,0032	0,0040	345
P12	P	0,050	0,055	0,070	60
	P	0,0020	0,0022	0,0028	195
K1	P	0,085	0,090	0,12	100
	P	0,0034	0,0036	0,0048	330
K2	P	0,075	0,085	0,11	85
	P	0,0030	0,0034	0,0044	280
K3	P	0,075	0,085	0,11	75
	P	0,0030	0,0034	0,0044	245
K4	P	0,075	0,085	0,11	70
	P	0,0030	0,0034	0,0044	230
K5	P	0,070	0,075	0,095	42
	P	0,0028	0,0030	0,0038	140

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

SD207A – Ø 3-20 mm / 0.118-0.787 inci

SMG		f										v <sub>c</sub>
		Ø3,00 Ø 0.118	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P1	P	0,17	0,24	0,26	0,32	0,38	0,44	0,48	0,50	0,55	0,55	155
	P	0.0065	0.0095	0.010	0.013	0.015	0.017	0.019	0.020	0.022	0.022	510
P2	P	0,17	0,24	0,26	0,32	0,38	0,44	0,48	0,50	0,55	0,60	155
	P	0.0065	0.0095	0.010	0.013	0.015	0.017	0.019	0.020	0.022	0.024	510
P3	P	0,16	0,22	0,25	0,32	0,36	0,42	0,46	0,50	0,50	0,55	130
	P	0.0065	0.0085	0.010	0.013	0.014	0.017	0.018	0.020	0.020	0.022	425
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	0,34	0,36	0,38	0,40	180
	P	0.0050	0.0065	0.0075	0.0095	0.011	0.012	0.013	0.014	0.015	0.016	590
P5	P	0,12	0,17	0,19	0,22	0,26	0,30	0,32	0,34	0,36	0,38	175
	P	0.0048	0.0065	0.0075	0.0085	0.010	0.012	0.013	0.013	0.014	0.015	570
P6	P	0,12	0,16	0,19	0,22	0,26	0,30	0,32	0,34	0,36	0,38	195
	P	0.0048	0.0065	0.0075	0.0085	0.010	0.012	0.013	0.013	0.014	0.015	640
P7	P	0,12	0,16	0,19	0,22	0,26	0,30	0,32	0,34	0,36	0,38	185
	P	0.0048	0.0065	0.0075	0.0085	0.010	0.012	0.013	0.013	0.014	0.015	610
P8	P	0,13	0,17	0,19	0,24	0,28	0,32	0,34	0,36	0,38	0,40	175
	P	0.0050	0.0065	0.0075	0.0095	0.011	0.013	0.013	0.014	0.015	0.016	570
P11	P	0,075	0,10	0,11	0,14	0,16	0,18	0,20	0,22	0,24	0,24	90
	P	0.0030	0.0040	0.0044	0.0055	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	295
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	0,28	0,30	0,30	0,32	50
	P	0.0038	0.0050	0.0060	0.0075	0.0085	0.010	0.011	0.012	0.012	0.013	165
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	0,25	0,26	0,28	0,30	41
	P	0.0034	0.0048	0.0055	0.0065	0.0080	0.0085	0.010	0.010	0.011	0.012	135
M3	P	0,065	0,095	0,11	0,14	0,16	0,18	0,20	0,22	0,22	0,24	31
	P	0.0026	0.0038	0.0044	0.0055	0.0065	0.0070	0.0080	0.0085	0.0085	0.0095	100
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	0,17	0,19	0,20	0,20	24
	P	0.0024	0.0034	0.0038	0.0048	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	80
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	0,17	0,19	0,20	0,20	20
	P	0.0024	0.0034	0.0038	0.0048	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	65
K1	P	0,18	0,25	0,28	0,36	0,42	0,48	0,50	0,55	0,60	0,65	150
	P	0.0070	0.010	0.011	0.014	0.017	0.019	0.020	0.022	0.024	0.026	490
K2	P	0,17	0,22	0,26	0,32	0,38	0,42	0,48	0,50	0,55	0,55	130
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	0.019	0.020	0.022	0.022	425
K3	P	0,17	0,22	0,26	0,32	0,38	0,42	0,48	0,50	0,55	0,55	110
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	0.019	0.020	0.022	0.022	360
K4	P	0,17	0,22	0,26	0,32	0,38	0,42	0,48	0,50	0,55	0,55	105
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	0.019	0.020	0.022	0.022	345
K5	P	0,15	0,20	0,24	0,28	0,34	0,38	0,42	0,46	0,48	0,50	60
	P	0.0060	0.0080	0.0095	0.011	0.013	0.015	0.017	0.018	0.019	0.020	195
H3	P	0,070	0,090	0,10	0,12	0,14	0,16	0,18	0,19	0,20	0,20	24
	P	0.0028	0.0036	0.0040	0.0048	0.0055	0.0065	0.0070	0.0075	0.0080	0.0080	80
H5	P	0,10	0,13	0,15	0,18	0,22	0,24	0,26	0,28	0,30	0,32	45
	P	0.0040	0.0050	0.0060	0.0070	0.0085	0.0095	0.010	0.011	0.012	0.013	150
H7	P	0,070	0,090	0,10	0,12	0,14	0,16	0,18	0,19	0,20	0,20	24
	P	0.0028	0.0036	0.0040	0.0048	0.0055	0.0065	0.0070	0.0075	0.0080	0.0080	80
H8	P	0,080	0,10	0,12	0,14	0,16	0,19	0,20	0,22	0,24	0,24	45
	P	0.0032	0.0040	0.0048	0.0055	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	150
H11	P	0,10	0,13	0,15	0,18	0,22	0,24	0,26	0,28	0,30	0,32	60
	P	0.0040	0.0050	0.0060	0.0070	0.0085	0.0095	0.010	0.011	0.012	0.013	195
H12	P	0,080	0,10	0,12	0,14	0,16	0,19	0,20	0,22	0,24	0,24	65
	P	0.0032	0.0040	0.0048	0.0055	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	215
H21	P	0,080	0,10	0,12	0,14	0,16	0,19	0,20	0,22	0,24	0,24	45
	P	0.0032	0.0040	0.0048	0.0055	0.0065	0.0075	0.0080	0.0085	0.0095	0.0095	150

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pomire

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

SMG		f								v <sub>c</sub>
		Ø3,00 Ø 0.118	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551		
P1	P	0,13	0,18	0,20	0,25	0,30	0,32	0,36	125	
	P	0.0050	0.0070	0.0080	0.010	0.012	0.013	0.014	410	
P2	P	0,14	0,18	0,20	0,26	0,30	0,34	0,36	120	
	P	0.0055	0.0070	0.0080	0.010	0.012	0.013	0.014	395	
P3	P	0,13	0,17	0,20	0,24	0,28	0,32	0,34	105	
	P	0.0050	0.0065	0.0080	0.0095	0.011	0.013	0.013	345	
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	0,34	90	
	P	0.0050	0.0065	0.0075	0.0095	0.011	0.012	0.013	295	
P5	P	0,12	0,17	0,19	0,24	0,28	0,30	0,34	85	
	P	0.0048	0.0065	0.0075	0.0095	0.011	0.012	0.013	280	
P6	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	95	
	P	0.0048	0.0065	0.0075	0.0095	0.010	0.012	0.013	310	
P7	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	90	
	P	0.0048	0.0065	0.0075	0.0095	0.010	0.012	0.013	295	
P8	P	0,13	0,17	0,20	0,24	0,28	0,32	0,34	85	
	P	0.0050	0.0065	0.0080	0.0095	0.011	0.013	0.013	280	
P11	P	0,12	0,17	0,19	0,24	0,26	0,30	0,32	90	
	P	0.0048	0.0065	0.0075	0.0095	0.010	0.012	0.013	295	
P12	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	55	
	P	0.0034	0.0044	0.0050	0.0065	0.0070	0.0080	0.0085	180	
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	0,28	65	
	P	0.0038	0.0050	0.0060	0.0075	0.0085	0.010	0.011	215	
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	0,25	55	
	P	0.0034	0.0048	0.0055	0.0065	0.0080	0.0085	0.010	180	
M3	P	0,070	0,095	0,11	0,14	0,16	0,18	0,20	41	
	P	0.0028	0.0038	0.0044	0.0055	0.0065	0.0070	0.0080	135	
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	0,18	31	
	P	0.0024	0.0034	0.0038	0.0048	0.0055	0.0065	0.0070	100	
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	0,18	25	
	P	0.0024	0.0034	0.0038	0.0048	0.0055	0.0065	0.0070	80	
K1	P	0,15	0,22	0,24	0,30	0,36	0,40	0,44	80	
	P	0.0060	0.0085	0.0095	0.012	0.014	0.016	0.017	260	
K2	P	0,14	0,19	0,22	0,28	0,32	0,36	0,40	70	
	P	0.0055	0.0075	0.0085	0.011	0.013	0.014	0.016	230	
K3	P	0,14	0,19	0,22	0,28	0,32	0,36	0,40	60	
	P	0.0055	0.0075	0.0085	0.011	0.013	0.014	0.016	195	
K4	P	0,14	0,19	0,22	0,28	0,32	0,36	0,40	55	
	P	0.0055	0.0075	0.0085	0.011	0.013	0.014	0.016	180	
K5	P	0,12	0,17	0,20	0,25	0,30	0,32	0,36	33	
	P	0.0048	0.0065	0.0080	0.010	0.012	0.013	0.014	110	
N2	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	135	
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	0.018	445	
N3	P	0,16	0,22	0,26	0,32	0,38	0,42	0,46	90	
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	0.018	295	
H3	P	0,055	0,075	0,085	0,10	0,12	0,14	0,15	22	
	P	0.0022	0.0030	0.0034	0.0040	0.0048	0.0055	0.0060	70	
H5	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	40	
	P	0.0034	0.0044	0.0050	0.0065	0.0070	0.0080	0.0085	130	
H7	P	0,055	0,075	0,085	0,10	0,12	0,14	0,15	22	
	P	0.0022	0.0030	0.0034	0.0040	0.0048	0.0055	0.0060	70	
H8	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	40	
	P	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	0.0065	130	
H11	P	0,085	0,11	0,13	0,16	0,18	0,20	0,22	50	
	P	0.0034	0.0044	0.0050	0.0065	0.0070	0.0080	0.0085	165	
H12	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	31	
	P	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	0.0065	100	
H21	P	0,065	0,085	0,10	0,12	0,14	0,16	0,17	40	
	P	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	0.0065	130	

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

SD230A – Ø 3-12 mm / 0.118-0.472 inci

SMG		f						v <sub>c</sub>
		Ø3,00 Ø 0.118	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	
P1	P	0,13	0,18	0,20	0,25	0,30	0,32	90
	P	0.0050	0.0070	0.0080	0.010	0.012	0.013	295
P2	P	0,14	0,18	0,20	0,26	0,30	0,34	90
	P	0.0055	0.0070	0.0080	0.010	0.012	0.013	295
P3	P	0,13	0,17	0,20	0,24	0,28	0,32	75
	P	0.0050	0.0065	0.0080	0.0095	0.011	0.013	245
P4	P	0,13	0,17	0,19	0,24	0,28	0,30	70
	P	0.0050	0.0065	0.0075	0.0095	0.011	0.012	230
P5	P	0,12	0,17	0,19	0,24	0,28	0,30	65
	P	0.0048	0.0065	0.0075	0.0095	0.011	0.012	215
P6	P	0,12	0,17	0,19	0,24	0,26	0,30	75
	P	0.0048	0.0065	0.0075	0.0095	0.010	0.012	245
P7	P	0,12	0,17	0,19	0,24	0,26	0,30	70
	P	0.0048	0.0065	0.0075	0.0095	0.010	0.012	230
P8	P	0,13	0,17	0,20	0,24	0,28	0,32	65
	P	0.0050	0.0065	0.0080	0.0095	0.011	0.013	215
P11	P	0,12	0,17	0,19	0,24	0,26	0,30	65
	P	0.0048	0.0065	0.0075	0.0095	0.010	0.012	215
P12	P	0,085	0,11	0,13	0,16	0,18	0,20	39
	P	0.0034	0.0044	0.0050	0.0065	0.0070	0.0080	130
M1	P	0,095	0,13	0,15	0,19	0,22	0,25	50
	P	0.0038	0.0050	0.0060	0.0075	0.0085	0.010	165
M2	P	0,085	0,12	0,14	0,17	0,20	0,22	40
	P	0.0034	0.0048	0.0055	0.0065	0.0080	0.0085	130
M3	P	0,070	0,095	0,11	0,14	0,16	0,18	30
	P	0.0028	0.0038	0.0044	0.0055	0.0065	0.0070	100
M4	P	0,060	0,085	0,095	0,12	0,14	0,16	23
	P	0.0024	0.0034	0.0038	0.0048	0.0055	0.0065	75
M5	P	0,060	0,085	0,095	0,12	0,14	0,16	19
	P	0.0024	0.0034	0.0038	0.0048	0.0055	0.0065	60
K1	P	0,15	0,22	0,24	0,30	0,36	0,40	60
	P	0.0060	0.0085	0.0095	0.012	0.014	0.016	195
K2	P	0,14	0,19	0,22	0,28	0,32	0,36	50
	P	0.0055	0.0075	0.0085	0.011	0.013	0.014	165
K3	P	0,14	0,19	0,22	0,28	0,32	0,36	44
	P	0.0055	0.0075	0.0085	0.011	0.013	0.014	145
K4	P	0,14	0,19	0,22	0,28	0,32	0,36	42
	P	0.0055	0.0075	0.0085	0.011	0.013	0.014	140
K5	P	0,12	0,17	0,20	0,25	0,30	0,32	25
	P	0.0048	0.0065	0.0080	0.010	0.012	0.013	80
N2	P	0,16	0,22	0,26	0,32	0,38	0,42	100
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	330
N3	P	0,16	0,22	0,26	0,32	0,38	0,42	65
	P	0.0065	0.0085	0.010	0.013	0.015	0.017	215
H3	P	0,055	0,075	0,085	0,10	0,12	0,14	16
	P	0.0022	0.0030	0.0034	0.0040	0.0048	0.0055	50
H5	P	0,085	0,11	0,13	0,16	0,18	0,20	30
	P	0.0034	0.0044	0.0050	0.0065	0.0070	0.0080	100
H7	P	0,055	0,075	0,085	0,10	0,12	0,14	16
	P	0.0022	0.0030	0.0034	0.0040	0.0048	0.0055	50
H8	P	0,065	0,085	0,10	0,12	0,14	0,16	30
	P	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	100
H11	P	0,085	0,11	0,13	0,16	0,18	0,20	39
	P	0.0034	0.0044	0.0050	0.0065	0.0070	0.0080	130
H12	P	0,065	0,085	0,10	0,12	0,14	0,16	24
	P	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	80
H21	P	0,065	0,085	0,10	0,12	0,14	0,16	30
	P	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	100

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

SD245A – Ø 4-16 mm / 0.157-0.630 inci

SMG		f							v <sub>c</sub>
		Ø4,00 Ø 0.157	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	
P1	P	0,11	0,15	0,19	0,22	0,26	0,28	0,32	185
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.011	0.013	610
P2	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	180
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.012	0.013	590
P3	P	0,11	0,14	0,18	0,22	0,25	0,28	0,30	155
	P	0.0044	0.0055	0.0070	0.0085	0.010	0.011	0.012	510
P4	P	0,11	0,14	0,18	0,22	0,24	0,26	0,30	135
	P	0.0044	0.0055	0.0070	0.0085	0.0095	0.010	0.012	445
P5	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	130
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	425
P6	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	145
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	475
P7	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	140
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	460
P8	P	0,11	0,14	0,18	0,22	0,25	0,28	0,30	130
	P	0.0044	0.0055	0.0070	0.0085	0.010	0.011	0.012	425
P11	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	135
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	445
P12	P	0,070	0,095	0,12	0,14	0,16	0,18	0,20	80
	P	0.0028	0.0038	0.0048	0.0055	0.0065	0.0070	0.0080	260
M1	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	100
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.012	0.013	330
M2	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	80
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	260
K1	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	120
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.012	0.013	395
K2	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	105
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	345
K3	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	90
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	295
K4	P	0,10	0,14	0,17	0,20	0,24	0,26	0,28	85
	P	0.0040	0.0055	0.0065	0.0080	0.0095	0.010	0.011	280
K5	P	0,095	0,12	0,16	0,19	0,22	0,24	0,26	50
	P	0.0038	0.0048	0.0065	0.0075	0.0085	0.0095	0.010	165
N2	P	0,14	0,19	0,24	0,28	0,34	0,38	0,40	200
	P	0.0055	0.0075	0.0095	0.011	0.013	0.015	0.016	660
N3	P	0,14	0,19	0,24	0,28	0,34	0,38	0,40	135
	P	0.0055	0.0075	0.0095	0.011	0.013	0.015	0.016	445
N11	P	0,14	0,19	0,24	0,28	0,34	0,38	0,40	255
	P	0.0055	0.0075	0.0095	0.011	0.013	0.015	0.016	840

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pomire

SD265A – Ø 4-16 mm / 0.157-0.630 inci

SMG		f							V <sub>c</sub>
		Ø4,00 Ø 0.157	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	
P1	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	180
	P	0.0048	0.0065	0.0080	0.0095	0.011	0.012	0.013	590
P2	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	175
	P	0.0048	0.0065	0.0080	0.0095	0.011	0.012	0.013	570
P3	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	150
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.012	0.013	490
P4	P	0,11	0,15	0,19	0,22	0,26	0,28	0,32	135
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.011	0.013	445
P5	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	130
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	425
P6	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	145
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	475
P7	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	135
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	445
P8	P	0,11	0,15	0,19	0,22	0,26	0,30	0,32	130
	P	0.0044	0.0060	0.0075	0.0085	0.010	0.012	0.013	425
P11	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	130
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	425
P12	P	0,075	0,10	0,12	0,15	0,17	0,19	0,20	80
	P	0.0030	0.0040	0.0048	0.0060	0.0065	0.0075	0.0080	260
M1	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	100
	P	0.0048	0.0065	0.0080	0.0095	0.011	0.012	0.013	330
M2	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	80
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	260
K1	P	0,12	0,16	0,20	0,24	0,28	0,30	0,34	120
	P	0.0048	0.0065	0.0080	0.0095	0.011	0.012	0.013	395
K2	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	100
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	330
K3	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	85
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	280
K4	P	0,11	0,15	0,18	0,22	0,25	0,28	0,30	85
	P	0.0044	0.0060	0.0070	0.0085	0.010	0.011	0.012	280
K5	P	0,10	0,13	0,17	0,20	0,22	0,25	0,28	49
	P	0.0040	0.0050	0.0065	0.0080	0.0085	0.010	0.011	160
N2	P	0,15	0,20	0,26	0,30	0,36	0,40	0,42	195
	P	0.0060	0.0080	0.010	0.012	0.014	0.016	0.017	640
N3	P	0,15	0,20	0,26	0,30	0,36	0,40	0,42	130
	P	0.0060	0.0080	0.010	0.012	0.014	0.016	0.017	425
N11	P	0,15	0,20	0,26	0,30	0,36	0,40	0,42	250
	P	0.0060	0.0080	0.010	0.012	0.014	0.016	0.017	820

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

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

SMG		f						V <sub>c</sub>
		Ø2,00 Ø 0.079	Ø3,00 Ø 0.118	Ø4,00 Ø 0.157	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	
P11	MS	0,060	0,080	0,10	0,12	0,14	0,18	90
	MS	0.0024	0.0032	0.0040	0.0048	0.0055	0.0070	295
P12	MS	0,060	0,070	0,080	0,090	0,10	0,12	65
	MS	0.0024	0.0028	0.0032	0.0036	0.0040	0.0048	215
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	110
	MS	0.0030	0.0038	0.0044	0.0050	0.0060	0.0075	360
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	90
	MS	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	295
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	45
	MS	0.0038	0.0044	0.0050	0.0060	0.0065	0.0080	150
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	50
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	165
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	42
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	140
N1	MS	0,13	0,16	0,19	0,22	0,26	0,32	345
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	1125
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	225
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	740
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	150
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	490
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	285
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	940
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	39
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	130
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	28
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S11	MS	0,070	0,085	0,095	0,11	0,12	0,14	70
	MS	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	230
S12	MS	0,070	0,085	0,095	0,11	0,12	0,14	55
	MS	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	180
S13	MS	0,065	0,075	0,085	0,095	0,10	0,12	43
	MS	0.0026	0.0030	0.0034	0.0038	0.0040	0.0048	140
H3	MS	0,046	0,055	0,065	0,075	0,085	0,10	36
	MS	0.0018	0.0022	0.0026	0.0030	0.0034	0.0040	120
H5	MS	0,070	0,085	0,10	0,11	0,13	0,16	65
	MS	0.0028	0.0034	0.0040	0.0044	0.0050	0.0065	215
H7	MS	0,046	0,055	0,065	0,075	0,085	0,10	36
	MS	0.0018	0.0022	0.0026	0.0030	0.0034	0.0040	120
H8	MS	0,055	0,065	0,075	0,085	0,095	0,12	65
	MS	0.0022	0.0026	0.0030	0.0034	0.0038	0.0048	215
H11	MS	0,070	0,085	0,10	0,11	0,13	0,16	85
	MS	0.0028	0.0034	0.0040	0.0044	0.0050	0.0065	280
H12	MS	0,055	0,065	0,075	0,085	0,095	0,12	80
	MS	0.0022	0.0026	0.0030	0.0034	0.0038	0.0048	260
H21	MS	0,055	0,065	0,075	0,085	0,095	0,12	65
	MS	0.0022	0.0026	0.0030	0.0034	0.0038	0.0048	215

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire



SD203A -MS Ø 10-20 mm / 0.394-0.787 inci

SMG		f						v <sub>c</sub>
		Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P11	MS	0,22	0,24	0,26	0,30	0,30	0,32	90
	MS	0.0085	0.0095	0.010	0.012	0.012	0.013	295
P12	MS	0,14	0,15	0,16	0,18	0,18	0,19	65
	MS	0.0055	0.0060	0.0065	0.0070	0.0070	0.0075	215
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	110
	MS	0.0085	0.010	0.011	0.012	0.012	0.013	360
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	90
	MS	0.0080	0.0085	0.010	0.010	0.011	0.012	295
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	45
	MS	0.0095	0.010	0.011	0.012	0.013	0.013	150
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	50
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	165
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	42
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	140
N1	MS	0,38	0,42	0,46	0,50	0,55	0,55	345
	MS	0.015	0.017	0.018	0.020	0.022	0.022	1125
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	225
	MS	0.015	0.017	0.018	0.020	0.022	0.022	740
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	150
	MS	0.015	0.017	0.018	0.020	0.022	0.022	490
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	285
	MS	0.015	0.017	0.018	0.020	0.022	0.022	940
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	39
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	130
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	28
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S11	MS	0,17	0,19	0,22	0,24	0,25	0,26	70
	MS	0.0065	0.0075	0.0085	0.0095	0.010	0.010	230
S12	MS	0,17	0,19	0,22	0,24	0,25	0,26	55
	MS	0.0065	0.0075	0.0085	0.0095	0.010	0.010	180
S13	MS	0,15	0,17	0,19	0,20	0,22	0,22	43
	MS	0.0060	0.0065	0.0075	0.0080	0.0085	0.0085	140
H3	MS	0,12	0,13	0,15	0,16	0,17	0,17	36
	MS	0.0048	0.0050	0.0060	0.0065	0.0065	0.0065	120
H5	MS	0,18	0,20	0,22	0,24	0,25	0,26	65
	MS	0.0070	0.0080	0.0085	0.0095	0.010	0.010	215
H7	MS	0,12	0,13	0,15	0,16	0,17	0,17	36
	MS	0.0048	0.0050	0.0060	0.0065	0.0065	0.0065	120
H8	MS	0,14	0,16	0,17	0,18	0,19	0,20	65
	MS	0.0055	0.0065	0.0065	0.0070	0.0075	0.0080	215
H11	MS	0,18	0,20	0,22	0,24	0,25	0,26	85
	MS	0.0070	0.0080	0.0085	0.0095	0.010	0.010	280
H12	MS	0,14	0,16	0,17	0,18	0,19	0,20	80
	MS	0.0055	0.0065	0.0065	0.0070	0.0075	0.0080	260
H21	MS	0,14	0,16	0,17	0,18	0,19	0,20	65
	MS	0.0055	0.0065	0.0065	0.0070	0.0075	0.0080	215

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

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

SMG		f						V <sub>c</sub>
		Ø2,00 Ø 0.079	Ø3,00 Ø 0.118	Ø4,00 Ø 0.157	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	
P11	MS	0,060	0,080	0,10	0,12	0,14	0,18	80
	MS	0.0024	0.0032	0.0040	0.0048	0.0055	0.0070	260
P12	MS	0,060	0,070	0,080	0,090	0,10	0,12	60
	MS	0.0024	0.0028	0.0032	0.0036	0.0040	0.0048	195
M1	MS	0,075	0,095	0,11	0,13	0,15	0,19	100
	MS	0.0030	0.0038	0.0044	0.0050	0.0060	0.0075	330
M2	MS	0,065	0,085	0,10	0,12	0,14	0,17	80
	MS	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	260
M3	MS	0,095	0,11	0,13	0,15	0,17	0,20	40
	MS	0.0038	0.0044	0.0050	0.0060	0.0065	0.0080	130
M4	MS	0,048	0,060	0,070	0,085	0,095	0,12	46
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	150
M5	MS	0,048	0,060	0,070	0,085	0,095	0,12	38
	MS	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	125
N1	MS	0,13	0,16	0,19	0,22	0,26	0,32	310
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	1025
N2	MS	0,13	0,16	0,19	0,22	0,26	0,32	200
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	660
N3	MS	0,13	0,16	0,19	0,22	0,26	0,32	135
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	445
N11	MS	0,13	0,16	0,19	0,22	0,26	0,32	255
	MS	0.0050	0.0065	0.0075	0.0085	0.010	0.013	840
S1	MS	0,040	0,048	0,055	0,065	0,075	0,095	35
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	115
S2	MS	0,040	0,048	0,055	0,065	0,075	0,095	25
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	80
S3	MS	0,040	0,048	0,055	0,065	0,075	0,095	25
	MS	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	80
S11	MS	0,020	0,030	0,040	0,050	0,060	0,080	45
	MS	0.00080	0.0012	0.0016	0.0020	0.0024	0.0032	150
S12	MS	0,020	0,030	0,040	0,050	0,060	0,080	35
	MS	0.00080	0.0012	0.0016	0.0020	0.0024	0.0032	115
S13	MS	0,017	0,026	0,035	0,044	0,050	0,070	27
	MS	0.00068	0.0010	0.0014	0.0018	0.0020	0.0028	90
H3	MS	0,046	0,055	0,065	0,075	0,085	0,10	33
	MS	0.0018	0.0022	0.0026	0.0030	0.0034	0.0040	110
H5	MS	0,070	0,085	0,10	0,11	0,13	0,16	60
	MS	0.0028	0.0034	0.0040	0.0044	0.0050	0.0065	195
H7	MS	0,046	0,055	0,065	0,075	0,085	0,10	33
	MS	0.0018	0.0022	0.0026	0.0030	0.0034	0.0040	110
H8	MS	0,055	0,065	0,075	0,085	0,095	0,12	60
	MS	0.0022	0.0026	0.0030	0.0034	0.0038	0.0048	195
H11	MS	0,070	0,085	0,10	0,11	0,13	0,16	75
	MS	0.0028	0.0034	0.0040	0.0044	0.0050	0.0065	245
H12	MS	0,055	0,065	0,075	0,085	0,095	0,12	70
	MS	0.0022	0.0026	0.0030	0.0034	0.0038	0.0048	230
H21	MS	0,055	0,065	0,075	0,085	0,095	0,12	60
	MS	0.0022	0.0026	0.0030	0.0034	0.0038	0.0048	195

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

SD205A -MS Ø 10-20 mm / 0.394-0.787 inci

SMG		f						v <sub>c</sub>
		Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P11	MS	0,22	0,24	0,26	0,30	0,30	0,32	80
	MS	0.0085	0.0095	0.010	0.012	0.012	0.013	260
P12	MS	0,14	0,15	0,16	0,18	0,18	0,19	60
	MS	0.0055	0.0060	0.0065	0.0070	0.0070	0.0075	195
M1	MS	0,22	0,25	0,28	0,30	0,30	0,32	100
	MS	0.0085	0.010	0.011	0.012	0.012	0.013	330
M2	MS	0,20	0,22	0,25	0,26	0,28	0,30	80
	MS	0.0080	0.0085	0.010	0.010	0.011	0.012	260
M3	MS	0,24	0,26	0,28	0,30	0,32	0,34	40
	MS	0.0095	0.010	0.011	0.012	0.013	0.013	130
M4	MS	0,14	0,16	0,17	0,19	0,20	0,20	46
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	150
M5	MS	0,14	0,16	0,17	0,19	0,20	0,20	38
	MS	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	125
N1	MS	0,38	0,42	0,46	0,50	0,55	0,55	310
	MS	0.015	0.017	0.018	0.020	0.022	0.022	1025
N2	MS	0,38	0,42	0,46	0,50	0,55	0,55	200
	MS	0.015	0.017	0.018	0.020	0.022	0.022	660
N3	MS	0,38	0,42	0,46	0,50	0,55	0,55	135
	MS	0.015	0.017	0.018	0.020	0.022	0.022	445
N11	MS	0,38	0,42	0,46	0,50	0,55	0,55	255
	MS	0.015	0.017	0.018	0.020	0.022	0.022	840
S1	MS	0,11	0,13	0,15	0,16	0,17	0,19	35
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	115
S2	MS	0,11	0,13	0,15	0,16	0,17	0,19	25
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	80
S3	MS	0,11	0,13	0,15	0,16	0,17	0,19	25
	MS	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	80
S11	MS	0,10	0,12	0,14	0,16	0,18	0,20	45
	MS	0.0040	0.0048	0.0055	0.0065	0.0070	0.0080	150
S12	MS	0,10	0,12	0,14	0,16	0,18	0,20	35
	MS	0.0040	0.0048	0.0055	0.0065	0.0070	0.0080	115
S13	MS	0,085	0,11	0,12	0,14	0,16	0,17	27
	MS	0.0034	0.0044	0.0048	0.0055	0.0065	0.0070	90
H3	MS	0,12	0,13	0,15	0,16	0,17	0,17	33
	MS	0.0048	0.0050	0.0060	0.0065	0.0065	0.0065	110
H5	MS	0,18	0,20	0,22	0,24	0,25	0,26	60
	MS	0.0070	0.0080	0.0085	0.0095	0.010	0.010	195
H7	MS	0,12	0,13	0,15	0,16	0,17	0,17	33
	MS	0.0048	0.0050	0.0060	0.0065	0.0065	0.0065	110
H8	MS	0,14	0,16	0,17	0,18	0,19	0,20	60
	MS	0.0055	0.0065	0.0065	0.0070	0.0075	0.0080	195
H11	MS	0,18	0,20	0,22	0,24	0,25	0,26	75
	MS	0.0070	0.0080	0.0085	0.0095	0.010	0.010	245
H12	MS	0,14	0,16	0,17	0,18	0,19	0,20	70
	MS	0.0055	0.0065	0.0065	0.0070	0.0075	0.0080	230
H21	MS	0,14	0,16	0,17	0,18	0,19	0,20	60
	MS	0.0055	0.0065	0.0065	0.0070	0.0075	0.0080	195

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

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

SMG		f						V <sub>c</sub>
		Ø2,00 Ø 0.079	Ø3,00 Ø 0.118	Ø4,00 Ø 0.157	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	
P11	M	0,060	0,075	0,085	0,10	0,11	0,14	150
	M	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	490
P12	M	0,060	0,075	0,085	0,10	0,11	0,14	90
	M	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	295
M1	M	0,075	0,095	0,11	0,13	0,15	0,19	110
	M	0.0030	0.0038	0.0044	0.0050	0.0060	0.0075	360
M2	M	0,065	0,085	0,10	0,12	0,14	0,17	90
	M	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	295
M3	M	0,055	0,065	0,080	0,095	0,11	0,14	70
	M	0.0022	0.0026	0.0032	0.0038	0.0044	0.0055	230
M4	M	0,048	0,060	0,070	0,085	0,095	0,12	50
	M	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	165
M5	M	0,048	0,060	0,070	0,085	0,095	0,12	42
	M	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	140
N1	M	0,13	0,16	0,19	0,22	0,26	0,32	345
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	1125
N2	M	0,13	0,16	0,19	0,22	0,26	0,32	225
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	740
N3	M	0,13	0,16	0,19	0,22	0,26	0,32	150
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	490
N11	M	0,13	0,16	0,19	0,22	0,26	0,32	285
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	940
S1	M	0,040	0,048	0,055	0,065	0,075	0,095	39
	M	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	130
S2	M	0,040	0,048	0,055	0,065	0,075	0,095	28
	M	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S3	M	0,040	0,048	0,055	0,065	0,075	0,095	28
	M	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S11	M	0,070	0,085	0,095	0,11	0,12	0,14	70
	M	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	230
S12	M	0,070	0,085	0,095	0,11	0,12	0,14	55
	M	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	180
S13	M	0,065	0,075	0,085	0,095	0,10	0,12	43
	M	0.0026	0.0030	0.0034	0.0038	0.0040	0.0048	140

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

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

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

SMG		f						v <sub>c</sub>
		Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P11	M	0,16	0,18	0,20	0,22	0,24	0,24	150
	M	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	490
P12	M	0,16	0,18	0,20	0,22	0,24	0,24	90
	M	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	295
M1	M	0,22	0,25	0,28	0,30	0,30	0,32	110
	M	0.0085	0.010	0.011	0.012	0.012	0.013	360
M2	M	0,20	0,22	0,25	0,26	0,28	0,30	90
	M	0.0080	0.0085	0.010	0.010	0.011	0.012	295
M3	M	0,16	0,18	0,20	0,22	0,22	0,24	70
	M	0.0065	0.0070	0.0080	0.0085	0.0085	0.0095	230
M4	M	0,14	0,16	0,17	0,19	0,20	0,20	50
	M	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	165
M5	M	0,14	0,16	0,17	0,19	0,20	0,20	42
	M	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	140
N1	M	0,38	0,42	0,46	0,50	0,55	0,55	345
	M	0.015	0.017	0.018	0.020	0.022	0.022	1125
N2	M	0,38	0,42	0,46	0,50	0,55	0,55	225
	M	0.015	0.017	0.018	0.020	0.022	0.022	740
N3	M	0,38	0,42	0,46	0,50	0,55	0,55	150
	M	0.015	0.017	0.018	0.020	0.022	0.022	490
N11	M	0,38	0,42	0,46	0,50	0,55	0,55	285
	M	0.015	0.017	0.018	0.020	0.022	0.022	940
S1	M	0,11	0,13	0,15	0,16	0,17	0,19	39
	M	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	130
S2	M	0,11	0,13	0,15	0,16	0,17	0,19	28
	M	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S3	M	0,11	0,13	0,15	0,16	0,17	0,19	28
	M	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S11	M	0,17	0,19	0,22	0,24	0,25	0,26	70
	M	0.0065	0.0075	0.0085	0.0095	0.010	0.010	230
S12	M	0,17	0,19	0,22	0,24	0,25	0,26	55
	M	0.0065	0.0075	0.0085	0.0095	0.010	0.010	180
S13	M	0,15	0,17	0,19	0,20	0,22	0,22	43
	M	0.0060	0.0065	0.0075	0.0080	0.0085	0.0085	140

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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

SD205A – Ø 2-8 mm / 0.079-0.315 inci

SMG		f						V <sub>c</sub>
		Ø2,00 Ø 0.079	Ø3,00 Ø 0.118	Ø4,00 Ø 0.157	Ø5,00 Ø 0.197	Ø6,00 Ø 0.236	Ø8,00 Ø 0.315	
P11	M	0,060	0,075	0,085	0,10	0,11	0,14	150
	M	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	490
P12	M	0,060	0,075	0,085	0,10	0,11	0,14	90
	M	0.0024	0.0030	0.0034	0.0040	0.0044	0.0055	295
M1	M	0,075	0,095	0,11	0,13	0,15	0,19	110
	M	0.0030	0.0038	0.0044	0.0050	0.0060	0.0075	360
M2	M	0,065	0,085	0,10	0,12	0,14	0,17	90
	M	0.0026	0.0034	0.0040	0.0048	0.0055	0.0065	295
M3	M	0,055	0,065	0,080	0,095	0,11	0,14	70
	M	0.0022	0.0026	0.0032	0.0038	0.0044	0.0055	230
M4	M	0,048	0,060	0,070	0,085	0,095	0,12	50
	M	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	165
M5	M	0,048	0,060	0,070	0,085	0,095	0,12	42
	M	0.0019	0.0024	0.0028	0.0034	0.0038	0.0048	140
N1	M	0,13	0,16	0,19	0,22	0,26	0,32	345
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	1125
N2	M	0,13	0,16	0,19	0,22	0,26	0,32	225
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	740
N3	M	0,13	0,16	0,19	0,22	0,26	0,32	150
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	490
N11	M	0,13	0,16	0,19	0,22	0,26	0,32	285
	M	0.0050	0.0065	0.0075	0.0085	0.010	0.013	940
S1	M	0,040	0,048	0,055	0,065	0,075	0,095	39
	M	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	130
S2	M	0,040	0,048	0,055	0,065	0,075	0,095	28
	M	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S3	M	0,040	0,048	0,055	0,065	0,075	0,095	28
	M	0.0016	0.0019	0.0022	0.0026	0.0030	0.0038	90
S11	M	0,070	0,085	0,095	0,11	0,12	0,14	70
	M	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	230
S12	M	0,070	0,085	0,095	0,11	0,12	0,14	55
	M	0.0028	0.0034	0.0038	0.0044	0.0048	0.0055	180
S13	M	0,065	0,075	0,085	0,095	0,10	0,12	43
	M	0.0026	0.0030	0.0034	0.0038	0.0040	0.0048	140

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

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

Introducere

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Anexă

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

SMG		f						v <sub>c</sub>
		Ø10,00 Ø 0.394	Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P11	M	0,16	0,18	0,20	0,22	0,24	0,24	150
	M	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	490
P12	M	0,16	0,18	0,20	0,22	0,24	0,24	90
	M	0.0065	0.0070	0.0080	0.0085	0.0095	0.0095	295
M1	M	0,22	0,25	0,28	0,30	0,30	0,32	110
	M	0.0085	0.010	0.011	0.012	0.012	0.013	360
M2	M	0,20	0,22	0,25	0,26	0,28	0,30	90
	M	0.0080	0.0085	0.010	0.010	0.011	0.012	295
M3	M	0,16	0,18	0,20	0,22	0,22	0,24	70
	M	0.0065	0.0070	0.0080	0.0085	0.0085	0.0095	230
M4	M	0,14	0,16	0,17	0,19	0,20	0,20	50
	M	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	165
M5	M	0,14	0,16	0,17	0,19	0,20	0,20	42
	M	0.0055	0.0065	0.0065	0.0075	0.0080	0.0080	140
N1	M	0,38	0,42	0,46	0,50	0,55	0,55	345
	M	0.015	0.017	0.018	0.020	0.022	0.022	1125
N2	M	0,38	0,42	0,46	0,50	0,55	0,55	225
	M	0.015	0.017	0.018	0.020	0.022	0.022	740
N3	M	0,38	0,42	0,46	0,50	0,55	0,55	150
	M	0.015	0.017	0.018	0.020	0.022	0.022	490
N11	M	0,38	0,42	0,46	0,50	0,55	0,55	285
	M	0.015	0.017	0.018	0.020	0.022	0.022	940
S1	M	0,11	0,13	0,15	0,16	0,17	0,19	39
	M	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	130
S2	M	0,11	0,13	0,15	0,16	0,17	0,19	28
	M	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S3	M	0,11	0,13	0,15	0,16	0,17	0,19	28
	M	0.0044	0.0050	0.0060	0.0065	0.0065	0.0075	90
S11	M	0,17	0,19	0,22	0,24	0,25	0,26	70
	M	0.0065	0.0075	0.0085	0.0095	0.010	0.010	230
S12	M	0,17	0,19	0,22	0,24	0,25	0,26	55
	M	0.0065	0.0075	0.0085	0.0095	0.010	0.010	180
S13	M	0,15	0,17	0,19	0,20	0,22	0,22	43
	M	0.0060	0.0065	0.0075	0.0080	0.0085	0.0085	140

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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

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

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

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

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

SMG = Grupa de material Seco

f = mm/rev

v<sub>c</sub> = m/min

Toate regimurile de aşchiere sunt valori de pornire

Parametrii de aşchiere depinde de materialul de la finalul găurii. Se vor utiliza la materialele suprapuse N1-N3 și S11-S13

N1-N3 = Alu

S11-S13 = Ti

TS/TP = Composite



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

SMG		f				v <sub>c</sub>
		Ø3,00 Ø 0.118	Ø5,00 Ø 0.197	Ø7,00 Ø 0.276	Ø9,00 Ø 0.354	
TS2	CX1	0,075	0,085	0,090	0,10	150
	CX1	0,0030	0,0034	0,0036	0,0040	490
TS3	CX1	0,075	0,085	0,090	0,10	120
	CX1	0,0030	0,0034	0,0036	0,0040	395
TP2	CX1	0,075	0,085	0,090	0,10	150
	CX1	0,0030	0,0034	0,0036	0,0040	490
TP3	CX1	0,075	0,085	0,090	0,10	120
	CX1	0,0030	0,0034	0,0036	0,0040	395

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

SMG		f				v <sub>c</sub>
		Ø3,00 Ø 0.118	Ø5,00 Ø 0.197	Ø7,00 Ø 0.276	Ø9,00 Ø 0.354	
N1	CX2	0,048	0,050	0,055	0,060	185
	CX2	0,0019	0,0020	0,0022	0,0024	610
N2	CX2	0,048	0,050	0,055	0,060	120
	CX2	0,0019	0,0020	0,0022	0,0024	395
N3	CX2	0,048	0,050	0,055	0,060	80
	CX2	0,0019	0,0020	0,0022	0,0024	260
S11	CX2	0,019	0,020	0,024	0,025	16
	CX2	0,00075	0,00080	0,00095	0,0010	50
S12	CX2	0,019	0,020	0,024	0,025	12
	CX2	0,00075	0,00080	0,00095	0,0010	39
S13	CX2	0,017	0,018	0,020	0,022	9
	CX2	0,00065	0,00070	0,00080	0,00085	30

SMG = Grupa de material Seco

f = mm/rev

v<sub>c</sub> = m/min

Toate regimurile de aşchiere sunt valori de pornire

Parametrii de aşchiere depinde de materialul de la finalul găurii. Se vor utiliza la materialele suprapuse N1-N3 și S11-S13

N1-N3 = Alu

S11-S13 = Ti

TS/TP = Composite

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

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

SMG = Grupa de material Seco

f = mm/rev

v<sub>c</sub> = m/min

Toate regimurile de aşchiere sunt valori de pornire

Parametrii de aşchiere depinde de materialul de la finalul găurii. Se vor utiliza la materialele suprapuse N1-N3 și S11-S13

N1-N3 = Alu

S11-S13 = Ti

TS/TP = Composite

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

## SD22 &amp; SD26 – Ø 0,6-0,8 mm / 0.0236-0.0315 inci

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) v<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pomire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire



## Seco Crownloc®

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

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



## Prezentare generală

Crownloc®	Ø Gamă	Adâncimea de găurire	Toleranța Ø burghiului	Toleranța găurii (1)	Finisarea suprafeței (2)
<b>SD101</b>  Pag. 178-179	12,00-25,99 mm (0.472-1.023")	~ 1,5 x D	k7	IT 10	Ra 1-3 µm (Ra 39-118 µin)
<b>SD103</b>  Pag. 180-181	9,52-25,99 mm (0.375-1.023")	~ 3 x D	k7	IT 10	Ra 1-3 µm (Ra 39-118 µin)
<b>SD105</b>  Pag. 182-183	10,00-25,99 mm (0.394-1.023")	~ 5 x D	k7	IT 10	Ra 1-3 µm (Ra 39-118 µin)
<b>SD107</b>  Pag. 184-185	12,00-25,99 mm (0.472-1.023")	~ 7 x D	k7	IT 10	Ra 1-4 µm (Ra 39-157 µin)
<b>Chamfer module</b>  Pag. 193	12,00-19,99 mm (0.472-0.787")	-	-	-	-

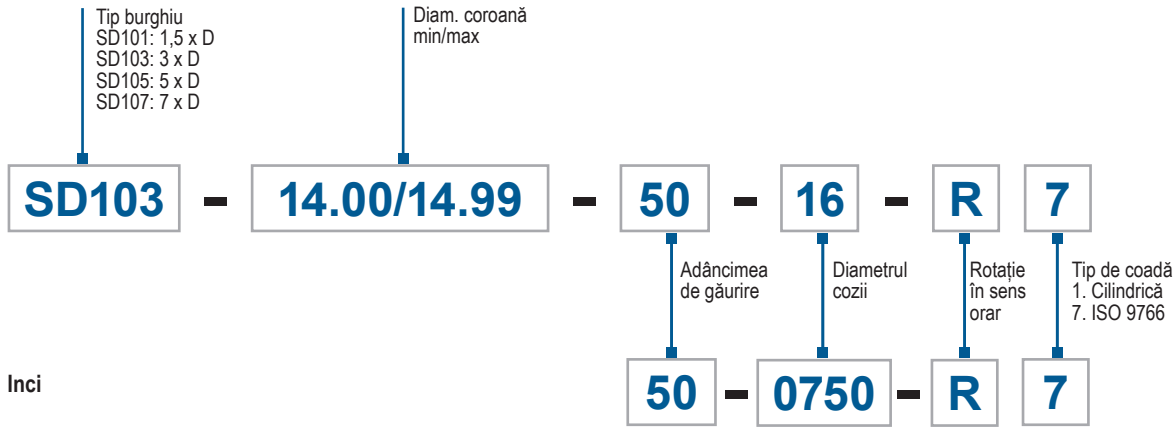
1) Pot apărea variații în funcție de material și de parametri de așchiere utilizați.

2) Adâncimea alezajului, parametrii de așchiere, presiunea lichidului de răcire și tipul de material pot influența negativ calitatea suprafeței.

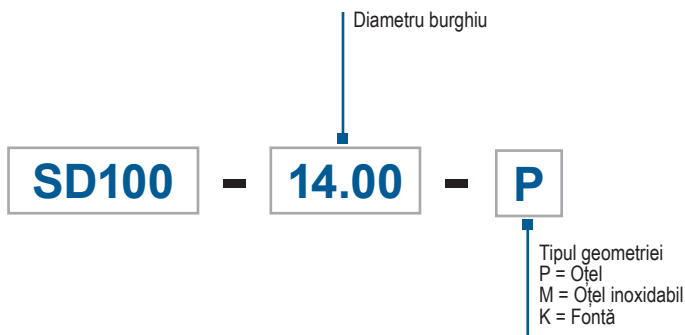
## Codificări

### Codificare corpuri de burghiu

#### Metric



### Codificare coroane



### Geometrii

**Geometria P**  
– Geometrie universală, prima alegere pentru găurirea în oțel



**Geometrie M**  
– Pentru oțel inox și aliaje rezistente la temperaturi înalte



**Geometrie K**  
– Prima alegere pentru găurire în fontă



## Instrucțiuni de montare

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

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

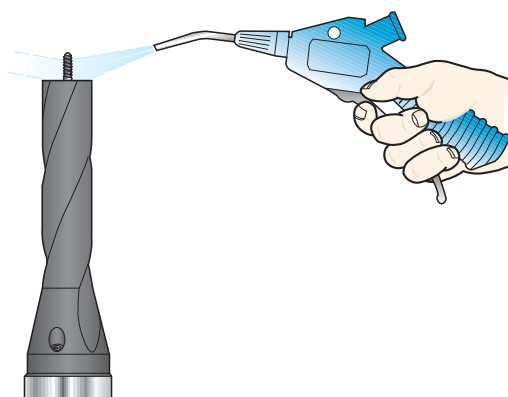
### Stabilitate

Stabilitatea aplicației este importantă pentru a obține cea mai bună durată de viață a sculei și precizie a găurii. Verifică starea arborelui mașinii, fixarea și prinderea componentelor pentru a asigura un maxim de stabilitate și rigiditate. Condițiile instabile pot duce la distrugerea sculei.

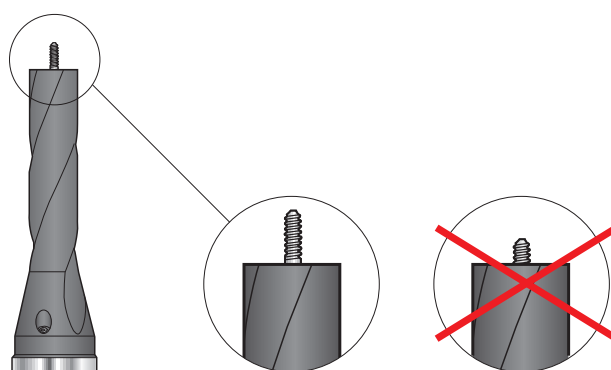
### Rotative

Bătaia radială indicată totală (TIR) nu trebuie să depășească 0,06 mm (0,002") la o aplicație rotativă. Măsoară bătaia când burghiul este montat în arborele mașinii.

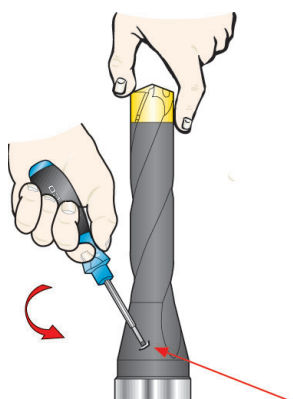
1.



2.

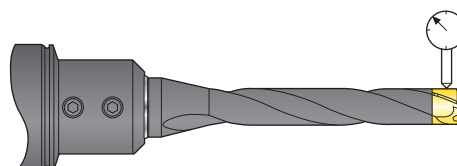


3.



### Staționare

Distanța dintre vârful burghiului și centrul rotativ al piesei de prelucrat nu trebuie să depășească 0,03 mm (0,001") radial la o aplicație staționară.



### Port-scule recomandate

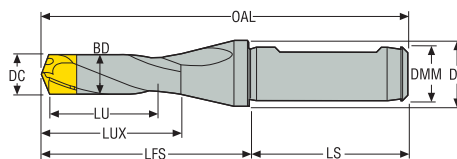
Pentru cele mai bune rezultate, utilizați port-scule tip DIN 1835 B/DIN 6535 HB (Weldon). Pentru informații suplimentare, consultați catalogul de scule.



Burghiu Ø DC mm	M <sub>c</sub> Nm	Burghiu Ø DC inci	M <sub>c</sub> in/lbs
10,00-13,99	0,8-1,0	0.394-0.551	7-9
14,00-16,99	1,8-2,2	0.551-0.669	16-19.5
17,00-25,99	2,5-3,0	0.669-1.023	22-26

## SD101

Adâncimea de găuire ~ 1,5 x D



- SD101 coadă -R7
- Răcire interioară
- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Pentru regimurile de aşchiere vezi pag. 196

Reper Nr.	Număr reper	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD101-12.00/12.49-20-16R7	02445790	12,0-12,49	20,0	96,0	32,0	11,5	48,0	48,0	16,0	20,0
SD101-12.50/12.99-20-16R7	02445791	12,5-12,99	20,0	96,4	32,4	12,0	48,4	48,0	16,0	20,0
SD101-13.00/13.99-20-16R7	02445792	13,0-13,99	20,0	96,8	32,8	12,5	48,8	48,0	16,0	20,0
SD101-14.00/14.99-25-16R7	02445793	14,0-14,99	25,0	102,4	38,4	13,5	54,4	48,0	16,0	20,0
SD101-15.00/15.99-25-16R7	02445794	15,0-15,99	25,0	103,3	39,3	14,5	55,3	48,0	16,0	20,0
SD101-16.00/16.99-25-16R7	02445795	16,0-16,99	25,0	104,0	40,0	15,5	56,0	48,0	16,0	20,0
SD101-17.00/17.99-30-20R7	02445796	17,0-17,99	30,0	110,7	44,7	16,5	60,7	50,0	20,0	25,0
SD101-18.00/18.99-30-20R7	02445797	18,0-18,99	30,0	111,7	45,7	17,5	61,7	50,0	20,0	25,0
SD101-19.00/19.99-30-20R7	02445798	19,0-19,99	30,0	112,5	46,5	18,5	62,5	50,0	20,0	25,0
SD101-20.00/21.99-40-25R7	02462832	20,0-21,99	40,0	129,5	53,5	19,5	73,5	56,0	25,0	31,0
SD101-22.00/23.99-40-25R7	02462833	22,0-23,99	40,0	129,5	53,5	21,5	73,5	56,0	25,0	31,0
SD101-24.00/25.99-40-25R7	02462834	24,0-25,99	40,0	129,5	53,5	23,5	73,5	56,0	25,0	31,0

### Piese de schimb

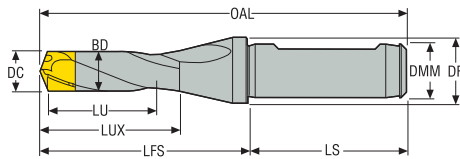
Pentru burghiu dia (mm)	Cheie de blocare	Şurub de blocare	Set piese de schimb
12,00-13,99	H1.5-2D	MP6SS3X12	SD101-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD101-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD101-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD101-SP-8.0

### Accesorii

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

## SD101 -R7 shank

Adâncimea de găurire ~ 1,5 x D – Inch shank



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 196

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

### Piese de schimb

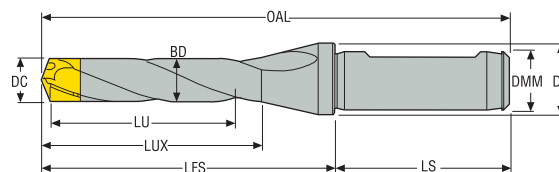
Pentru burghiu dia (inch)	Cheie de blocare	Şurub de blocare	Set piese de schimb
0.472-0.551	H1.5-2D	MP6SS3X12	SD101-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD101-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD101-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD101-SP-8.0

### Accesorii

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

## SD103

Adâncimea de găurire ~ 3 x D – Metric shank



- SD103 coadă -R7
- Răcire interioară
- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Pentru regimurile de aşchiere vezi pag. 197

Reper Nr.	Număr reper	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD103-10.00/10.49-30-16R7	02462815	10,0-10,49	30,0	101,0	38,0	9,5	53,0	48,0	16,0	20,0
SD103-10.50/10.99-30-16R7	02462818	10,5-10,99	30,0	101,0	38,0	10,0	53,0	48,0	16,0	20,0
SD103-11.00/11.49-30-16R7	02462819	11,0-11,49	30,0	101,0	38,0	10,5	53,0	48,0	16,0	20,0
SD103-11.50/11.99-30-16R7	02462820	11,5-11,99	30,0	101,0	38,0	11,0	53,0	48,0	16,0	20,0
SD103-12.00/12.49-40-16R7	02445799	12,0-12,49	40,0	116,0	48,0	11,5	68,0	48,0	16,0	20,0
SD103-12.50/12.99-40-16R7	02445800	12,5-12,99	40,0	116,4	48,4	12,0	68,4	48,0	16,0	20,0
SD103-13.00/13.99-40-16R7	02445801	13,0-13,99	40,0	116,8	48,8	12,5	68,8	48,0	16,0	20,0
SD103-14.00/14.99-50-16R7	02445802	14,0-14,99	50,0	127,4	59,4	13,5	79,4	48,0	16,0	20,0
SD103-15.00/15.99-50-16R7	02445803	15,0-15,99	50,0	128,3	60,3	14,5	80,3	48,0	16,0	20,0
SD103-16.00/16.99-50-16R7	02445804	16,0-16,99	50,0	129,0	61,0	15,5	81,0	48,0	16,0	20,0
SD103-17.00/17.99-60-20R7	02445805	17,0-17,99	60,0	140,7	67,7	16,5	90,7	50,0	20,0	25,0
SD103-18.00/18.99-60-20R7	02445806	18,0-18,99	60,0	141,7	68,7	17,5	91,7	50,0	20,0	25,0
SD103-19.00/19.99-60-20R7	02445807	19,0-19,99	60,0	142,5	69,5	18,5	92,7	50,0	20,0	25,0
SD103-20.00/21.99-75-25R7	02462836	20,0-21,99	75,0	164,5	88,5	19,5	108,5	56,0	25,0	31,0
SD103-22.00/23.99-75-25R7	02462838	22,0-23,99	75,0	164,5	88,5	21,5	108,5	56,0	25,0	31,0
SD103-24.00/25.99-75-25R7	02462841	24,0-25,99	75,0	164,5	88,5	23,5	108,5	56,0	25,0	31,0

### Piese de schimb

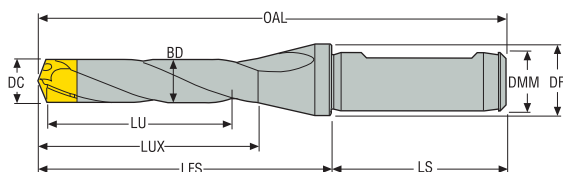
Pentru burghiu dia (mm)	Cheie de blocare	Şurub de blocare	Set piese de schimb
10,00-11,99	H1.5-2D	MP6SS3X12	SD103-SP-4.0
12,00-13,99	H1.5-2D	MP6SS3X12	SD103-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD103-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD103-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD103-SP-8.0

### Accesorii

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

## SD103 -R7 shank

Adâncimea de găurire ~ 3 x D – Inch shank



- Portsule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 197

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

### Piese de schimb

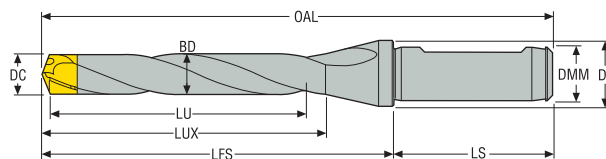
Pentru burghiu dia (inch)	Cheie de blocare	Şurub de blocare	Set piese de schimb
0.374-0.393	H1.5-2D	MP6SS3X12	-
0.394-0.472	H1.5-2D	MP6SS3X12	SD103-SP-4.0
0.472-0.551	H1.5-2D	MP6SS3X12	SD103-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD103-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD103-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD103-SP-8.0

### Accesorii

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

## SD105

Adâncimea de găurire ~ 5 x D – Metric shank



- SD105 coadă -R7
- Răcire interioară
- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Pentru regimurile de aşchiere vezi pag. 198

Reper Nr.	Număr reper	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD105-10.00/10.49-50-16R7	02462822	10,0-10,49	50,0	120,1	57,3	9,5	72,1	48,0	16,0	20,0
SD105-10.50/10.99-50-16R7	02462824	10,5-10,99	50,0	120,6	57,3	10,0	72,6	48,0	16,0	20,0
SD105-11.00/11.49-50-16R7	02462828	11,0-11,49	50,0	120,9	57,3	10,5	72,9	48,0	16,0	20,0
SD105-11.50/11.99-50-16R7	02462830	11,5-11,99	50,0	121,3	58,3	11,0	73,3	48,0	16,0	20,0
SD105-12.00/12.49-65-16R7	02445808	12,0-12,49	65,0	141,0	73,0	11,5	93,0	48,0	16,0	20,0
SD105-12.50/12.99-65-16R7	02445809	12,5-12,99	65,0	141,4	73,4	12,0	93,4	48,0	16,0	20,0
SD105-13.00/13.99-65-16R7	02445810	13,0-13,99	65,0	141,8	73,8	12,5	93,8	48,0	16,0	20,0
SD105-14.00/14.99-80-16R7	02445811	14,0-14,99	80,0	157,4	89,4	13,5	109,4	48,0	16,0	20,0
SD105-15.00/15.99-80-16R7	02445812	15,0-15,99	80,0	158,3	90,3	14,5	110,3	48,0	16,0	20,0
SD105-16.00/16.99-80-16R7	02445813	16,0-16,99	80,0	159,0	91,0	15,5	111,0	48,0	16,0	20,0
SD105-17.00/17.99-95-20R7	02445814	17,0-17,99	95,0	176,7	107,7	16,5	126,7	50,0	20,0	25,0
SD105-18.00/18.99-95-20R7	02445815	18,0-18,99	95,0	177,7	108,7	17,5	127,7	50,0	20,0	25,0
SD105-19.00/19.99-95-20R7	02445816	19,0-19,99	95,0	178,5	109,5	18,5	128,5	50,0	20,0	25,0
SD105-20.00/21.99-125-25R7	02462843	20,0-21,99	125,0	214,5	138,5	19,5	158,5	56,0	25,0	31,0
SD105-22.00/23.99-125-25R7	02462848	22,0-23,99	125,0	214,5	138,5	21,5	158,5	56,0	25,0	31,0
SD105-24.00/25.99-125-25R7	02462850	24,0-25,99	125,0	214,5	138,5	23,5	158,5	56,0	25,0	31,0

### Piese de schimb

Pentru burghiu dia (mm)	Cheie de blocare	Şurub de blocare	Set piese de schimb
10,00-11,99	H1.5-2D	MP6SS3X12	SD105-SP-4.0
12,00-13,99	H1.5-2D	MP6SS3X12	SD105-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD105-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD105-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD105-SP-8.0

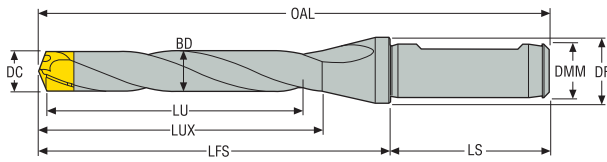
### Accesorii

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



## SD105 -R7 shank

Adâncimea de găurire ~ 5 x D – Inch shank



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 198

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

### Piese de schimb

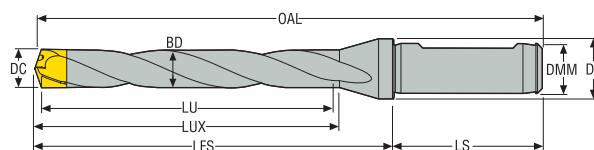
Pentru burghiu dia (inch)	Cheie de blocare	Şurub de blocare	Set piese de schimb
0.394-0.472	H1.5-2D	MP6SS3X12	SD105-SP-4.0
0.472-0.551	H1.5-2D	MP6SS3X12	SD105-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD105-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD105-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD105-SP-8.0

### Accesorii

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

## SD107

Adâncimea de găuire ~ 7 x D – Metric shank



- SD107 coadă -R7
- Răcire interioară
- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Pentru regimurile de aşchiere vezi pag. 199

Reper Nr.	Număr reper	DC	LU	OAL	LUX	BD	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm	mm
SD107-12.00/12.49-90-16R7	02427470	12,0-12,49	90,0	166,5	100,5	11,5	118,5	48,0	16,0	20,0
SD107-12.50/12.99-90-16R7	02427472	12,5-12,99	90,0	167,0	101,0	12,0	119,0	48,0	16,0	20,0
SD107-13.00/13.99-90-16R7	02427473	13,0-13,99	90,0	167,5	101,5	12,5	119,5	48,0	16,0	20,0
SD107-14.00/14.99-110-16R7	02427474	14,0-14,99	110,0	188,0	122,0	13,5	140,0	48,0	16,0	20,0
SD107-15.00/15.99-110-16R7	02427476	15,0-15,99	110,0	189,0	123,0	14,5	141,0	48,0	16,0	20,0
SD107-16.00/16.99-110-16R7	02427443	16,0-16,99	110,0	189,5	123,5	15,5	141,5	48,0	16,0	20,0
SD107-17.00/17.99-130-20R7	02427478	17,0-17,99	130,0	212,5	144,5	16,5	162,5	50,0	20,0	25,0
SD107-18.00/18.99-130-20R7	02427479	18,0-18,99	130,0	213,5	145,5	17,5	163,5	50,0	20,0	25,0
SD107-19.00/19.99-130-20R7	02427480	19,0-19,99	130,0	214,5	146,5	18,5	164,5	50,0	20,0	25,0
SD107-20.00/21.99-175-25R7	02530422	20,0-21,99	175,0	264,5	188,5	19,5	208,5	56,0	25,0	31,0
SD107-22.00/23.99-175-25R7	02530423	22,0-23,99	175,0	264,5	188,5	21,5	208,5	56,0	25,0	31,0
SD107-24.00/25.99-175-25R7	02517867	24,0-25,99	175,0	264,5	188,5	23,5	208,5	56,0	25,0	31,0

### Piese de schimb

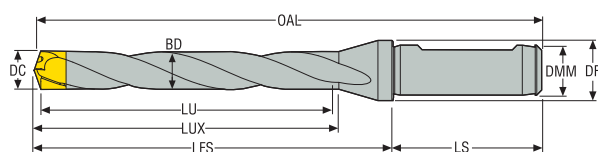
Pentru burghiu dia (mm)	Cheie de blocare	Şurub de blocare	Set piese de schimb
12,00-13,99	H1.5-2D	MP6SS3X12	SD107-SP-5.0
14,00-16,99	H2.0-2D	MP6SS4X12	SD107-SP-6.0
17,00-19,99	H2.5-2D	MP6SS5X16	SD107-SP-7.0
20,00-25,99	H2.5-2D	MP6SS5X16	SD107-SP-8.0

### Accesorii

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

## SD107 -R7 shank

Adâncimea de găurire ~ 7 x D – Inch shank



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 199

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

### Piese de schimb

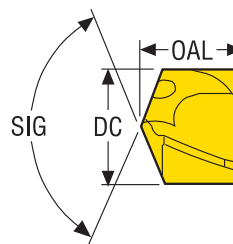
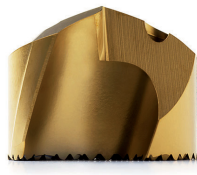
Pentru burghiu dia (inch)	Cheie de blocare	Şurub de blocare	Set piese de schimb
0.472-0.551	H1.5-2D	MP6SS3X12	SD107-SP-5.0
0.551-0.669	H2.0-2D	MP6SS4X12	SD107-SP-6.0
0.669-0.787	H2.5-2D	MP6SS5X16	SD107-SP-7.0
0.787-1.023	H2.5-2D	MP6SS5X16	SD107-SP-8.0

### Accesorii

Pentru burghiu dia (inch)	Lamă interschimbabilă	Cheie dinamometrică
0.472-0.551	H00-1.5	H00-1509
0.551-0.669	H00-2.0	H00-2020
0.669-0.787	H00-2.5	H00-2530
0.787-1.023	H00-2.5	H00-2535

## Coroane - Geometrie -P, -M și -K

Unghiul la vârf: 140°



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

Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	inci	mm	inci
SD100-12.00-P	00090314	■	-	-	12,0	0.472	9,6	0.378
SD100-12.10-P	00039002	■	-	-	12,1	0.476	9,6	0.378
SD100-12.20-P	00048248	■	-	-	12,2	0.480	9,6	0.378
SD100-12.30-M	00071559	-	■	-	12,3	0.484	9,6	0.378
SD100-12.30-P	00071546	■	-	-	12,3	0.484	9,6	0.378
SD100-12.41-M	00059768	-	■	-	12,41	0.489	9,6	0.378
SD100-12.41-P	00059767	■	-	-	12,41	0.489	9,6	0.378
SD100-12.50-K	00090319	-	-	■	12,5	0.492	10,0	0.394
SD100-12.50-M	00090318	-	■	-	12,5	0.492	10,0	0.394
SD100-12.50-P	00090317	■	-	-	12,5	0.492	10,0	0.394
SD100-12.60-P	02207212	■	-	-	12,6	0.496	10,0	0.394
SD100-12.70-K	00059633	-	-	■	12,7	0.500	10,0	0.394
SD100-12.70-M	00059632	-	■	-	12,7	0.500	10,0	0.394
SD100-12.70-P	00059631	■	-	-	12,7	0.500	10,0	0.394
SD100-12.80-K	00059636	-	-	■	12,8	0.504	10,0	0.394
SD100-12.80-M	00059635	-	■	-	12,8	0.504	10,0	0.394
SD100-12.80-P	00059634	■	-	-	12,8	0.504	10,0	0.394
SD100-12.90-M	02503935	-	■	-	12,9	0.508	10,0	0.394
SD100-12.90-P	00030891	■	-	-	12,9	0.508	10,0	0.394
SD100-13.00-K	00098529	-	-	■	13,0	0.512	10,4	0.409
SD100-13.00-M	00098528	-	■	-	13,0	0.512	10,4	0.409
SD100-13.00-P	00098527	■	-	-	13,0	0.512	10,4	0.409
SD100-13.10-K	00059639	-	-	■	13,1	0.516	10,4	0.409
SD100-13.10-M	00059638	-	■	-	13,1	0.516	10,4	0.409
SD100-13.10-P	00059637	■	-	-	13,1	0.516	10,4	0.409
SD100-13.20-P	00030894	■	-	-	13,2	0.520	10,4	0.409
SD100-13.30-M	00059641	-	■	-	13,3	0.524	10,4	0.409
SD100-13.30-P	00059640	■	-	-	13,3	0.524	10,4	0.409
SD100-13.50-K	00098532	-	-	■	13,5	0.531	10,4	0.409
SD100-13.50-M	00098531	-	■	-	13,5	0.531	10,4	0.409
SD100-13.50-P	00098530	■	-	-	13,5	0.531	10,4	0.409
SD100-13.70-M	00059644	-	■	-	13,7	0.539	10,4	0.409
SD100-13.70-P	00059643	■	-	-	13,7	0.539	10,4	0.409
SD100-13.80-K	00059648	-	-	■	13,8	0.543	10,4	0.409
SD100-13.80-M	00059647	-	■	-	13,8	0.543	10,4	0.409
SD100-13.80-P	00059646	■	-	-	13,8	0.543	10,4	0.409
SD100-13.89-M	00059771	-	■	-	13,89	0.547	10,4	0.409
SD100-13.89-P	00059770	■	-	-	13,89	0.547	10,4	0.409
SD100-14.00-K	00090322	-	-	■	14,0	0.551	11,0	0.433
SD100-14.00-M	00090321	-	■	-	14,0	0.551	11,0	0.433
SD100-14.00-P	00090320	■	-	-	14,0	0.551	11,0	0.433
SD100-14.10-P	00082712	■	-	-	14,1	0.555	11,0	0.433
SD100-14.20-K	00071549	-	-	■	14,2	0.559	11,0	0.433
SD100-14.20-M	00071561	-	■	-	14,2	0.559	11,0	0.433
SD100-14.20-P	00071548	■	-	-	14,2	0.559	11,0	0.433
SD100-14.29-K	00059675	-	-	■	14,29	0.563	11,0	0.433
SD100-14.29-M	00059674	-	■	-	14,29	0.563	11,0	0.433
SD100-14.29-P	00059673	■	-	-	14,29	0.563	11,0	0.433
SD100-14.40-P	02207869	■	-	-	14,4	0.567	11,0	0.433
SD100-14.50-K	00090325	-	-	■	14,5	0.571	11,0	0.433

Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	inci	mm	inci
SD100-14.50-M	00090324	-	■	-	14,5	0.571	11,0	0.433
SD100-14.50-P	00090323	■	-	-	14,5	0.571	11,0	0.433
SD100-14.68-K	00059775	-	-	■	14,68	0.578	11,0	0.433
SD100-14.68-M	00059774	-	■	-	14,68	0.578	11,0	0.433
SD100-14.68-P	00059773	■	-	-	14,68	0.578	11,0	0.433
SD100-14.70-M	00059650	-	■	-	14,7	0.579	11,0	0.433
SD100-14.70-P	00059649	■	-	-	14,7	0.579	11,0	0.433
SD100-14.80-M	00059653	-	■	-	14,8	0.583	11,0	0.433
SD100-14.80-P	00059652	■	-	-	14,8	0.583	11,0	0.433
SD100-14.90-M	02592745	-	■	-	14,9	0.587	11,0	0.433
SD100-14.90-P	00030895	■	-	-	14,9	0.587	11,0	0.433
SD100-15.00-K	00090328	-	-	■	15,0	0.591	11,9	0.469
SD100-15.00-M	00090327	-	■	-	15,0	0.591	11,9	0.469
SD100-15.00-P	00090326	■	-	-	15,0	0.591	11,9	0.469
SD100-15.08-M	00059777	-	■	-	15,08	0.594	11,9	0.469
SD100-15.08-P	00059776	■	-	-	15,08	0.594	11,9	0.469
SD100-15.10-P	00079342	■	-	-	15,1	0.594	11,9	0.469
SD100-15.20-P	00030896	■	-	-	15,2	0.598	11,9	0.469
SD100-15.25-K	00071551	-	-	■	15,25	0.600	11,9	0.469
SD100-15.25-M	00071562	-	■	-	15,25	0.600	11,9	0.469
SD100-15.25-P	00071550	■	-	-	15,25	0.600	11,9	0.469
SD100-15.48-K	00022926	-	-	■	15,48	0.609	11,9	0.469
SD100-15.48-M	00059780	-	■	-	15,48	0.609	11,9	0.469
SD100-15.48-P	00059779	■	-	-	15,48	0.609	11,9	0.469
SD100-15.50-K	00098535	-	-	■	15,5	0.610	11,9	0.469
SD100-15.50-M	00098534	-	■	-	15,5	0.610	11,9	0.469
SD100-15.50-P	00098533	■	-	-	15,5	0.610	11,9	0.469
SD100-15.70-M	00059656	-	■	-	15,7	0.618	11,9	0.469
SD100-15.70-P	00059655	■	-	-	15,7	0.618	11,9	0.469
SD100-15.80-K	00059660	-	-	■	15,8	0.622	11,9	0.469
SD100-15.80-M	00059659	-	■	-	15,8	0.622	11,9	0.469
SD100-15.80-P	00059658	■	-	-	15,8	0.622	11,9	0.469
SD100-15.88-K	00059678	-	-	■	15,88	0.625	11,9	0.469
SD100-15.88-M	00059677	-	■	-	15,88	0.625	11,9	0.469
SD100-15.88-P	00059676	■	-	-	15,88	0.625	11,9	0.469
SD100-16.00-K	00098538	-	-	■	16,0	0.630	12,6	0.496
SD100-16.00-M	00098537	-	■	-	16,0	0.630	12,6	0.496
SD100-16.00-P	00098536	■	-	-	16,0	0.630	12,6	0.496
SD100-16.10-P	00077964	■	-	-	16,1	0.634	12,6	0.496
SD100-16.20-P	00047365	■	-	-	16,2	0.638	12,6	0.496
SD100-16.25-P	00034081	■	-	-	16,25	0.640	12,6	0.496
SD100-16.27-K	00022929	-	-	■	16,27	0.641	12,6	0.496
SD100-16.27-M	00022928	-	■	-	16,27	0.641	12,6	0.496
SD100-16.27-P	00022927	■	-	-	16,27	0.641	12,6	0.496
SD100-16.40-P	02301114	■	-	-	16,4	0.646	12,6	0.496
SD100-16.50-K	00098541	-	-	■	16,5	0.650	12,6	0.496
SD100-16.50-M	00098540	-	■	-	16,5	0.650	12,6	0.496
SD100-16.50-P	00098539	■	-	-	16,5	0.650	12,6	0.496
SD100-16.67-K	00059681	-	-	■	16,67	0.656	12,6	0.496
SD100-16.67-M	00059680	-	■	-	16,67	0.656	12,6	0.496

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Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	inci	mm	inci
SD100-16.67-P	00059679	■	-	-	16,67	0.656	12,6	0.496
SD100-16.70-K	00059663	-	-	■	16,7	0.657	12,6	0.496
SD100-16.70-M	00059662	-	■	-	16,7	0.657	12,6	0.496
SD100-16.70-P	00059661	■	-	-	16,7	0.657	12,6	0.496
SD100-16.80-K	00059666	-	-	■	16,8	0.661	12,6	0.496
SD100-16.80-M	00059665	-	■	-	16,8	0.661	12,6	0.496
SD100-16.80-P	00059664	■	-	-	16,8	0.661	12,6	0.496
SD100-16.90-M	02593463	-	■	-	16,9	0.665	12,6	0.496
SD100-16.90-P	00030898	■	-	-	16,9	0.665	12,6	0.496
SD100-17.00-K	00090331	-	-	■	17,0	0.669	13,3	0.524
SD100-17.00-M	00090330	-	■	-	17,0	0.669	13,3	0.524
SD100-17.00-P	00090329	■	-	-	17,0	0.669	13,3	0.524
SD100-17.07-K	00022933	-	-	■	17,07	0.672	13,3	0.524
SD100-17.07-M	00022932	-	■	-	17,07	0.672	13,3	0.524
SD100-17.07-P	00022931	■	-	-	17,07	0.672	13,3	0.524
SD100-17.10-P	00034083	■	-	-	17,1	0.673	13,3	0.524
SD100-17.20-K	02515762	-	-	■	17,2	0.677	13,3	0.524
SD100-17.20-P	00047714	■	-	-	17,2	0.677	13,3	0.524
SD100-17.30-K	02203711	-	-	■	17,3	0.681	13,3	0.524
SD100-17.46-M	00059683	-	■	-	17,46	0.687	13,3	0.524
SD100-17.46-P	00059682	■	-	-	17,46	0.687	13,3	0.524
SD100-17.50-K	00090334	-	-	■	17,5	0.689	13,3	0.524
SD100-17.50-M	00090333	-	■	-	17,5	0.689	13,3	0.524
SD100-17.50-P	00090332	■	-	-	17,5	0.689	13,3	0.524
SD100-17.70-K	00059669	-	-	■	17,7	0.697	13,3	0.524
SD100-17.70-M	00059668	-	■	-	17,7	0.697	13,3	0.524
SD100-17.70-P	00059667	■	-	-	17,7	0.697	13,3	0.524
SD100-17.80-K	00059672	-	-	■	17,8	0.701	13,3	0.524
SD100-17.80-M	00059671	-	■	-	17,8	0.701	13,3	0.524
SD100-17.80-P	00059670	■	-	-	17,8	0.701	13,3	0.524
SD100-17.86-K	00022936	-	-	■	17,86	0.703	13,3	0.524
SD100-17.86-M	00022935	-	■	-	17,86	0.703	13,3	0.524
SD100-17.86-P	00022934	■	-	-	17,86	0.703	13,3	0.524
SD100-17.90-M	02442098	-	■	-	17,9	0.705	13,3	0.524
SD100-17.90-P	00047693	■	-	-	17,9	0.705	13,3	0.524
SD100-18.00-K	00090337	-	-	■	18,0	0.709	14,4	0.567
SD100-18.00-M	00090336	-	■	-	18,0	0.709	14,4	0.567
SD100-18.00-P	00090335	■	-	-	18,0	0.709	14,4	0.567
SD100-18.10-P	00030900	■	-	-	18,1	0.713	14,4	0.567
SD100-18.20-P	00038469	■	-	-	18,2	0.717	14,4	0.567
SD100-18.26-K	00035196	-	-	■	18,26	0.719	14,4	0.567
SD100-18.26-M	00022938	-	■	-	18,26	0.719	14,4	0.567
SD100-18.26-P	00022937	■	-	-	18,26	0.719	14,4	0.567
SD100-18.50-K	00059687	-	-	■	18,5	0.728	14,4	0.567
SD100-18.50-M	00059686	-	■	-	18,5	0.728	14,4	0.567
SD100-18.50-P	00059685	■	-	-	18,5	0.728	14,4	0.567
SD100-18.65-M	00035198	-	■	-	18,65	0.734	14,4	0.567
SD100-18.65-P	00035197	■	-	-	18,65	0.734	14,4	0.567
SD100-18.70-M	00059689	-	■	-	18,7	0.736	14,4	0.567
SD100-18.70-P	00059688	■	-	-	18,7	0.736	14,4	0.567

Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	inci	mm	inci
SD100-18.80-K	00059693	-	-	■	18,8	0.740	14,4	0.567
SD100-18.80-M	00059692	-	■	-	18,8	0.740	14,4	0.567
SD100-18.80-P	00059691	■	-	-	18,0	0.709	14,4	0.567
SD100-18.90-M	02592746	-	■	-	18,9	0.744	14,4	0.567
SD100-18.90-P	00030901	■	-	-	18,9	0.744	14,4	0.567
SD100-19.00-K	00059696	-	-	■	19,0	0.748	15,2	0.598
SD100-19.00-M	00059695	-	■	-	19,0	0.748	15,2	0.598
SD100-19.00-P	00059694	■	-	-	19,0	0.748	15,2	0.598
SD100-19.05-K	00059699	-	-	■	19,05	0.750	15,2	0.598
SD100-19.05-M	00059698	-	■	-	19,05	0.750	15,2	0.598
SD100-19.05-P	00059697	■	-	-	19,05	0.750	15,2	0.598
SD100-19.10-P	00030902	■	-	-	19,1	0.752	15,2	0.598
SD100-19.20-K	00071566	-	-	■	19,2	0.756	15,2	0.598
SD100-19.20-M	00071564	-	■	-	19,2	0.756	15,2	0.598
SD100-19.20-P	00071563	■	-	-	19,2	0.756	15,2	0.598
SD100-19.25-P	00048318	■	-	-	19,25	0.758	15,2	0.598
SD100-19.45-K	00035202	-	-	■	19,45	0.766	15,2	0.598
SD100-19.45-M	00035201	-	■	-	19,45	0.766	15,2	0.598
SD100-19.45-P	00035200	■	-	-	19,45	0.766	15,2	0.598
SD100-19.50-K	00059702	-	-	■	19,5	0.768	15,2	0.598
SD100-19.50-M	00059701	-	■	-	19,5	0.768	15,2	0.598
SD100-19.50-P	00059700	■	-	-	19,5	0.768	15,2	0.598
SD100-19.70-K	00059705	-	-	■	19,7	0.776	15,2	0.598
SD100-19.70-M	00059704	-	■	-	19,7	0.776	15,2	0.598
SD100-19.70-P	00059703	■	-	-	19,7	0.776	15,2	0.598
SD100-19.80-K	00059708	-	-	■	19,8	0.780	15,2	0.598
SD100-19.80-M	00059707	-	■	-	19,8	0.780	15,2	0.598
SD100-19.80-P	00059706	■	-	-	19,8	0.780	15,2	0.598
SD100-19.84-M	00035204	-	■	-	19,84	0.781	15,2	0.598
SD100-19.84-P	00035203	■	-	-	19,84	0.781	15,2	0.598
SD100-19.90-M	02592747	-	■	-	19,9	0.783	15,2	0.598
SD100-19.90-P	00010065	■	-	-	19,9	0.783	15,2	0.598
SD100-19.99-P	00081744	■	-	-	19,99	0.787	15,2	0.598
SD100-20.00-K	02433368	-	-	■	20,0	0.787	15,2	0.598
SD100-20.00-M	02469176	-	■	-	20,0	0.787	15,2	0.598
SD100-20.00-P	02469095	■	-	-	20,0	0.787	15,2	0.598
SD100-20.241-P	02469096	■	-	-	20,241	0.797	15,2	0.598
SD100-20.50-K	02569177	-	-	■	20,5	0.807	15,2	0.598
SD100-20.50-M	02469178	-	■	-	20,5	0.807	15,2	0.598
SD100-20.50-P	02469098	■	-	-	20,5	0.807	15,2	0.598
SD100-20.638-M	02469179	-	■	-	20,638	0.813	15,2	0.598
SD100-20.638-P	02469100	■	-	-	20,638	0.813	15,2	0.598
SD100-20.80-P	02508750	■	-	-	20,8	0.819	15,2	0.598
SD100-20.90-P	02586615	■	-	-	20,9	0.823	15,2	0.598
SD100-21.00-K	02523183	-	-	■	21,0	0.827	15,2	0.598
SD100-21.00-M	02469180	-	■	-	21,0	0.827	15,2	0.598
SD100-21.00-P	02469118	■	-	-	21,0	0.827	15,2	0.598
SD100-21.034-P	02469120	■	-	-	21,034	0.828	15,2	0.598
SD100-21.20-P	02469121	■	-	-	21,2	0.835	15,2	0.598
SD100-21.30-P	02521624	■	-	-	21,3	0.839	15,2	0.598

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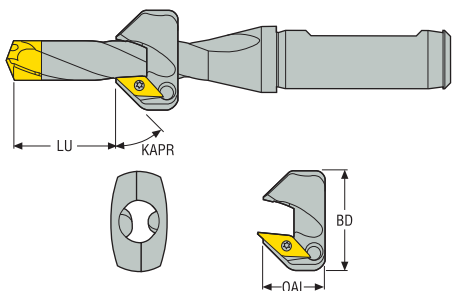


Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	inci	mm	inci
SD100-21.430-M	02469182	-	■	-	21,43	0.844	15,2	0.598
SD100-21.430-P	02469122	■	-	-	21,43	0.844	15,2	0.598
SD100-21.50-K	02521338	-	-	■	21,5	0.846	15,2	0.598
SD100-21.50-M	02469183	-	■	-	21,5	0.846	15,2	0.598
SD100-21.50-P	02469124	■	-	-	21,5	0.846	15,2	0.598
SD100-21.80-K	02592763	-	-	■	21,8	0.858	15,2	0.598
SD100-21.80-M	02555978	-	■	-	21,8	0.858	15,2	0.598
SD100-21.80-P	02592735	■	-	-	21,8	0.858	15,2	0.598
SD100-21.829-P	02469125	■	-	-	21,829	0.859	15,2	0.598
SD100-21.90-M	02592752	-	■	-	21,9	0.862	15,2	0.598
SD100-21.90-P	02592736	■	-	-	21,9	0.862	15,2	0.598
SD100-22.00-K	02511599	-	-	■	22,0	0.866	15,2	0.598
SD100-22.00-M	02469185	-	■	-	22,0	0.866	15,2	0.598
SD100-22.00-P	02469128	■	-	-	22,0	0.866	15,2	0.598
SD100-22.225-M	02469186	-	■	-	22,225	0.875	15,2	0.598
SD100-22.225-P	02469129	■	-	-	22,225	0.875	15,2	0.598
SD100-22.50-K	02569178	-	-	■	22,5	0.886	15,2	0.598
SD100-22.50-M	02469188	-	■	-	22,5	0.886	15,2	0.598
SD100-22.50-P	02469132	■	-	-	22,5	0.886	15,2	0.598
SD100-22.621-P	02469133	■	-	-	22,621	0.891	15,2	0.598
SD100-22.80-M	02592754	-	■	-	22,8	0.898	15,2	0.598
SD100-22.80-P	02539323	■	-	-	22,8	0.898	15,2	0.598
SD100-22.90-P	02592738	■	-	-	22,9	0.902	15,2	0.598
SD100-23.00-K	02515181	-	-	■	23,0	0.906	15,2	0.598
SD100-23.00-M	02469189	-	■	-	23,0	0.906	15,2	0.598
SD100-23.00-P	02469134	■	-	-	23,0	0.906	15,2	0.598
SD100-23.416-P	02469136	■	-	-	23,416	0.922	15,2	0.598
SD100-23.50-K	02551252	-	-	■	23,5	0.925	15,2	0.598
SD100-23.50-M	02469190	-	■	-	23,5	0.925	15,2	0.598
SD100-23.50-P	02469138	■	-	-	23,5	0.925	15,2	0.598
SD100-23.813-K	02592766	-	-	■	23,813	0.938	15,2	0.598
SD100-23.813-M	02554971	-	■	-	23,813	0.938	15,2	0.598
SD100-23.813-P	02469140	■	-	-	23,813	0.938	15,2	0.598
SD100-23.90-M	02592756	-	■	-	23,9	0.941	15,2	0.598
SD100-23.90-P	02592739	■	-	-	23,9	0.941	15,2	0.598
SD100-24.00-K	02569179	-	-	■	24,0	0.945	15,2	0.598
SD100-24.00-M	02469191	-	■	-	24,0	0.945	15,2	0.598
SD100-24.00-P	02469141	■	-	-	24,0	0.945	15,2	0.598
SD100-24.209-P	02469142	■	-	-	24,209	0.953	15,2	0.598
SD100-24.50-K	02569180	-	-	■	24,5	0.965	15,2	0.598
SD100-24.50-M	02469192	-	■	-	24,5	0.965	15,2	0.598
SD100-24.50-P	02469144	■	-	-	24,5	0.965	15,2	0.598
SD100-24.605-P	02469145	■	-	-	24,605	0.969	15,2	0.598
SD100-24.80-K	02592767	-	-	■	24,8	0.976	15,2	0.598
SD100-24.80-M	02508165	-	■	-	24,8	0.976	15,2	0.598
SD100-24.80-P	02529665	■	-	-	24,8	0.976	15,2	0.598
SD100-24.90-M	02592757	-	■	-	24,9	0.980	15,2	0.598
SD100-24.90-P	02592740	■	-	-	24,9	0.980	15,2	0.598
SD100-25.00-K	02524629	-	-	■	25,0	0.984	15,2	0.598
SD100-25.00-M	02469193	-	■	-	25,0	0.984	15,2	0.598

Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	Geometrie -K	DC		OAL	
					mm	inci	mm	inci
SD100-25.00-P	02469146	■	-	-	25,0	0.984	15,2	0.598
SD100-25.40-K	02569181	-	-	■	25,4	1.000	15,2	0.598
SD100-25.400-M	02469194	-	■	-	25,4	1.000	15,2	0.598
SD100-25.400-P	02469147	■	-	-	25,4	1.000	15,2	0.598
SD100-25.50-P	02536609	■	-	-	25,5	1.004	15,2	0.598
SD100-25.60-P	02519477	■	-	-	25,6	1.008	15,2	0.598
SD100-25.80-M	02592758	-	■	-	25,8	1.016	15,2	0.598
SD100-25.80-P	02581593	■	-	-	25,8	1.016	15,2	0.598
SD100-25.90-M	02592759	-	■	-	25,9	1.020	15,2	0.598
SD100-25.90-P	02592741	■	-	-	25,9	1.020	15,2	0.598
SD100-25.99-K	02516403	-	-	■	25,99	1.023	15,2	0.598
SD100-25.99-P	02516402	■	-	-	25,99	1.023	15,2	0.598

■ Stoc standard.

## Modul pentru șanfrenat



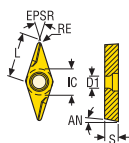
Reper Nr.	Număr reper	Pentru corpul burghiului	Adâncimea de găurire LU								Adâncime max. șanfren	OAL	BD
			SD101 (min-max)		SD103 (min-max)		SD105 (min-max)		SD107 (min-max)				
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
SD100-C45-12.00/12.49	00014922	SD10x-12.00/12.49	12,0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

### Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță		Cheie de blocare	
	Plăcuță amovibilă	Modul	Plăcuță amovibilă	Modul		
SD100-12.00-16.99	C02205-T07P	C04011-T15P	T07P-2	T15P-2		
SD100-17.00-19.99	C02205-T07P	C05012-T15P	T07P-2	T15P-2		

### Plăcuță amovibilă

Toleranța: mm/inci	Mărimea	IC mm/inci	L mm/inci	S mm/inci	D1 mm/inci	RE mm/inci
	09	5,556/0.2187"	9,0/0.2187"	2,5/0.0984"	2,9/0.1141"	0,2/0.0078"
	Calitate: T400D					
	Reper Nr.: VCGX090202-D1					
	Număr reper: 00014948					



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

## Modul pentru șanfrenat – Instrucțiuni de montare/schimbare a modulului

Introducere

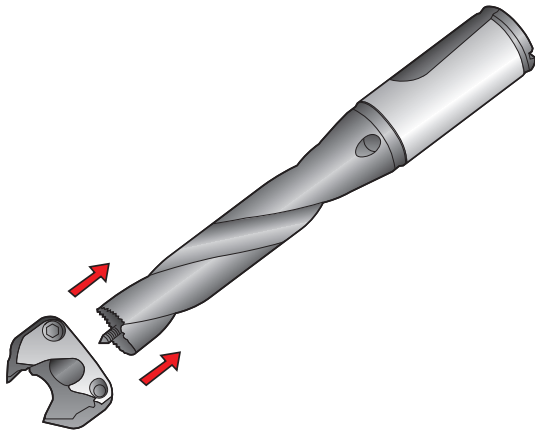
Găurire

Alezare

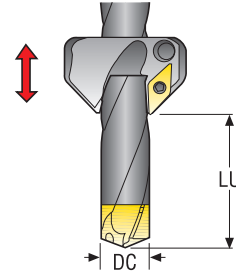
Alezare adâncă

Anexă

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

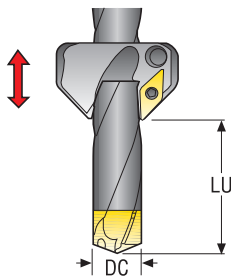


**2.1** Dacă este posibil, montează modulul cât mai aproape de coadă.



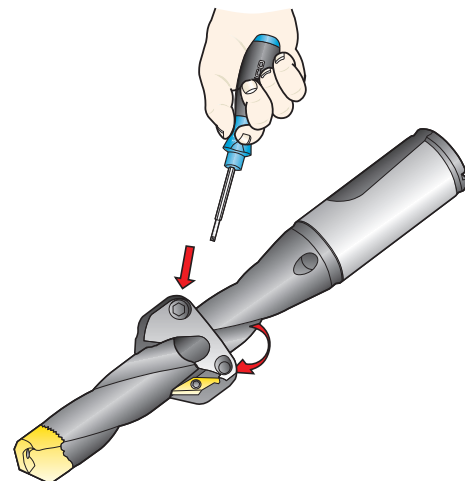
DC		LU Adâncimea de găurire (min-max)			
mm	inci	SD101		SD103	
mm	inci	mm	inci	mm	inci
12	.472	12-13	.472-.512	12-28	.472-1.102
12,5	.492	12-14	.472-.551	12-29	.472-1.142
13	.512	13-14	.512-.551	13-29	.512-1.142
14	.551	14-20	.551-.787	14-40	.551-1.575
15	.591	14-21	.551-.827	14-41	.551-1.614
16	.630	15-22	.591-.866	15-42	.591-1.654
17	.669	16-25	.630-.984	16-51	.630-2.008
18	.709	17-26	.669-1.024	17-52	.669-2.047
19	.748	18-27	.709-1.063	18-53	.709-2.087

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



DC		LU Adâncimea de găurire (min-max)			
mm	inci	SD105		SD107	
mm	inci	mm	inci	mm	inci
12	.472	28-53	1.102-2.087	53-78	2.087-3.071
12,5	.492	29-54	1.142-2.126	54-79	2.126-3.110
13	.512	29-54	1.142-2.126	54-79	2.126-3.110
14	.551	40-70	1.575-2.756	70-100	2.756-3.937
15	.591	41-71	1.614-2.785	71-101	2.795-3.976
16	.630	42-72	1.654-2.835	72-102	2.835-4.016
17	.669	51-87	2.008-3.425	87-123	3.425-4.843
18	.709	52-88	2.047-3.465	88-124	3.465-4.882
19	.748	53-89	2.087-3.504	89-125	3.504-4.921

**4.** Strângeți ambele șuruburi conform tabelului de mai jos.



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

## Modul pentru șanfrenat

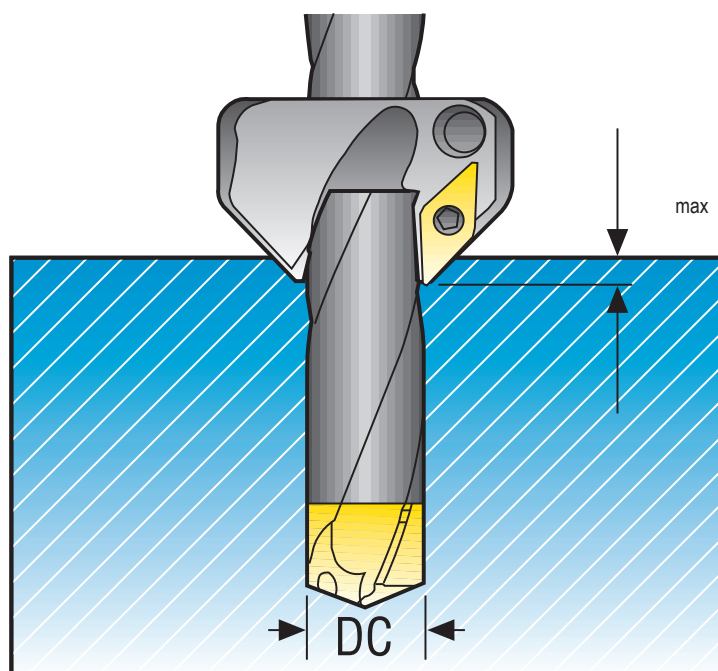
Vitezele de așchiere și avansurile recomandate pentru Crownloc® de la paginile 196-199 se pot utiliza și în cazul operațiilor de șanfrenare.

### Depanare

Vibrații în timpul șanfrenării

- Micșorează viteza de așchiere
- Dacă este posibil, montează modulul mai aproape de coada burghiului
- Dacă este posibil, utilizează un burghiu mai scurt

### Adâncimea maximă a șanfrenului



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

Regimuri de aşchiere – SD101 – Ø10-26

SMG		f									v <sub>c</sub>
		Ø10.00	Ø12.00	Ø14.00	Ø16.00	Ø18.00	Ø20.00	Ø22.00	Ø24.00	Ø26.00	
		Ø 0.394	Ø 0.472	Ø 0.551	Ø 0.630	Ø 0.709	Ø 0.787	Ø 0.866	Ø 0.945	Ø 1.024	
P1	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	125
	P	0.0080	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	410
P2	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	120
	P	0.0080	0.0095	0.010	0.011	0.012	0.013	0.013	0.014	0.014	395
P3	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	105
	P	0.0075	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	345
P4	P	0,19	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	95
	P	0.0075	0.0085	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	310
P5	P	0,19	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	90
	P	0.0075	0.0085	0.0095	0.010	0.011	0.012	0.012	0.013	0.013	295
P6	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	100
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	330
P7	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	95
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	310
P8	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	90
	P	0.0075	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	295
P11	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	90
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	295
P12	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	55
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	180
M1	M	0,14	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	85
	M	0.0055	0.0060	0.0060	0.0065	0.0065	0.0065	0.0065	0.0065	0.0065	280
M2	M	0,13	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	70
	M	0.0050	0.0050	0.0055	0.0055	0.0060	0.0060	0.0060	0.0065	0.0065	230
M3	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	50
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	165
M4	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	39
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	130
M5	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	33
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	110
K1	K	0,28	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	100
	K	0.011	0.013	0.013	0.014	0.015	0.016	0.017	0.017	0.017	330
K2	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	85
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	280
K3	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	70
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	230
K4	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	70
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	230
K5	K	0,24	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	41
	K	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	0.014	135
N1	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	335
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	1100
N2	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	215
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	710
N3	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	145
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	475
N11	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	170
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	560
S1	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	34
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	110
S2	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	25
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	80
S3	M	0,085	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	25
	M	0.0034	0.0034	0.0036	0.0038	0.0038	0.0038	0.0040	0.0040	0.0040	80
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	65
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	215
S12	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	49
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	160
S13	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	38
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	125
H3	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	27
	P	0.0034	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	90
H5	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	50
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	165
H7	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	27
	P	0.0034	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	90
H8	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	50
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	165
H11	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	65
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	215
H12	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	32
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	105
H21	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	50
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	165

SMG = Grupa de material Seco  
f = mm/rev  
v<sub>c</sub> = m/min  
Toate regimurile de aşchiere sunt valori de pomire

SMG		f									V <sub>c</sub>
		Ø10.00	Ø12.00	Ø14.00	Ø16.00	Ø18.00	Ø20.00	Ø22.00	Ø24.00	Ø26.00	
		Ø 0.394	Ø 0.472	Ø 0.551	Ø 0.630	Ø 0.709	Ø 0.787	Ø 0.866	Ø 0.945	Ø 1.024	
P1	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	120
	P	0.0080	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	395
P2	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	115
	P	0.0080	0.0095	0.010	0.011	0.012	0.013	0.013	0.014	0.014	375
P3	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	100
	P	0.0075	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	330
P4	P	0,19	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	85
	P	0.0075	0.0085	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	280
P5	P	0,19	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	85
	P	0.0075	0.0085	0.0095	0.010	0.011	0.012	0.012	0.013	0.013	280
P6	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	95
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	310
P7	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	90
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	295
P8	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	85
	P	0.0075	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	280
P11	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	85
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	280
P12	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	50
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	165
M1	M	0,14	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	80
	M	0.0055	0.0060	0.0060	0.0065	0.0065	0.0065	0.0065	0.0065	0.0065	260
M2	M	0,13	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	65
	M	0.0050	0.0050	0.0055	0.0055	0.0060	0.0060	0.0060	0.0065	0.0065	215
M3	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	49
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	160
M4	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	37
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	120
M5	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	31
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	100
K1	K	0,28	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	90
	K	0.011	0.013	0.013	0.014	0.015	0.016	0.017	0.017	0.017	295
K2	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	80
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	260
K3	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	65
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	215
K4	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	65
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	215
K5	K	0,24	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	38
	K	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	0.014	125
N1	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	315
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	1025
N2	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	200
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	660
N3	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	135
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	445
N11	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	160
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	520
S1	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	32
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	105
S2	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	23
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	75
S3	M	0,085	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	23
	M	0.0034	0.0034	0.0036	0.0038	0.0038	0.0038	0.0040	0.0040	0.0040	75
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	60
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	195
S12	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	46
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	150
S13	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	36
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	120
H3	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	25
	P	0.0034	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	80
H5	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	46
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	150
H7	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	25
	P	0.0034	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	80
H8	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	46
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	150
H11	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	60
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	195
H12	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	30
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	100
H21	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	46
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	150

 SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

SD105 – Ø 10-26 mm / 0.394-1.024 inci

SMG		f									V <sub>c</sub>
		Ø10.00 Ø 0.394	Ø12.00 Ø 0.472	Ø14.00 Ø 0.551	Ø16.00 Ø 0.630	Ø18.00 Ø 0.709	Ø20.00 Ø 0.787	Ø22.00 Ø 0.866	Ø24.00 Ø 0.945	Ø26.00 Ø 1.024	
P1	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	110
	P	0.0080	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	
P2	P	0,20	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	110
	P	0.0080	0.0095	0.010	0.011	0.012	0.013	0.013	0.014	0.014	
P3	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	95
	P	0.0075	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	
P4	P	0,19	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	85
	P	0.0075	0.0085	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	
P5	P	0,19	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	80
	P	0.0075	0.0085	0.0095	0.010	0.011	0.012	0.012	0.013	0.013	
P6	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	90
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	
P7	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	85
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	
P8	P	0,19	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	80
	P	0.0075	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	
P11	P	0,18	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	80
	P	0.0070	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	
P12	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	48
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	
M1	M	0,14	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	75
	M	0.0055	0.0060	0.0060	0.0065	0.0065	0.0065	0.0065	0.0065	0.0065	
M2	M	0,13	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	60
	M	0.0050	0.0050	0.0055	0.0055	0.0060	0.0060	0.0060	0.0065	0.0065	
M3	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	46
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	
M4	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	35
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	
M5	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	29
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	
K1	K	0,28	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	90
	K	0.011	0.013	0.013	0.014	0.015	0.016	0.017	0.017	0.017	
K2	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	75
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	
K3	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	65
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	
K4	K	0,26	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	60
	K	0.010	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	
K5	K	0,24	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	36
	K	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	0.014	
N1	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	300
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	
N2	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	190
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	
N3	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	130
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	
N11	M	0,18	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	150
	M	0.0070	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	
S1	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	30
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	
S2	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	22
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	
S3	M	0,085	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	22
	M	0.0034	0.0034	0.0036	0.0038	0.0038	0.0038	0.0040	0.0040	0.0040	
S11	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	55
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	
S12	M	0,10	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	44
	M	0.0040	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	
S13	M	0,090	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	34
	M	0.0036	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	
H3	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	24
	P	0.0034	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	
H5	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	44
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	
H7	P	0,085	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	24
	P	0.0034	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	
H8	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	44
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	
H11	P	0,13	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	55
	P	0.0050	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	
H12	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	29
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	
H21	P	0,095	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	44
	P	0.0038	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire

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SMG		f								V <sub>c</sub>
		Ø12.00 Ø 0.472	Ø14.00 Ø 0.551	Ø16.00 Ø 0.630	Ø18.00 Ø 0.709	Ø20.00 Ø 0.787	Ø22.00 Ø 0.866	Ø24.00 Ø 0.945	Ø26.00 Ø 1.024	
P1	P	0,24	0,26	0,28	0,30	0,32	0,34	0,34	0,36	110
	P	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	0.014	360
P2	P	0,24	0,26	0,28	0,30	0,32	0,34	0,36	0,36	105
	P	0.0095	0.010	0.011	0.012	0.013	0.013	0.014	0.014	345
P3	P	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	90
	P	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	295
P4	P	0,22	0,24	0,26	0,28	0,30	0,32	0,32	0,34	80
	P	0.0085	0.0095	0.010	0.011	0.012	0.013	0.013	0.013	260
P5	P	0,22	0,24	0,26	0,28	0,30	0,30	0,32	0,34	75
	P	0.0085	0.0095	0.010	0.011	0.012	0.012	0.013	0.013	245
P6	P	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	85
	P	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	280
P7	P	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	80
	P	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	260
P8	P	0,22	0,25	0,26	0,28	0,30	0,32	0,34	0,34	75
	P	0.0085	0.010	0.010	0.011	0.012	0.013	0.013	0.013	245
P11	P	0,22	0,24	0,26	0,28	0,28	0,30	0,32	0,32	80
	P	0.0085	0.0095	0.010	0.011	0.011	0.012	0.013	0.013	260
P12	P	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	47
	P	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	155
M1	M	0,15	0,15	0,16	0,16	0,16	0,17	0,17	0,17	75
	M	0.0060	0.0060	0.0065	0.0065	0.0065	0.0065	0.0065	0.0065	245
M2	M	0,13	0,14	0,14	0,15	0,15	0,15	0,16	0,16	60
	M	0.0050	0.0055	0.0055	0.0060	0.0060	0.0060	0.0065	0.0065	195
M3	M	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	45
	M	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	150
M4	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	34
	M	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	110
M5	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	28
	M	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	90
K1	K	0,32	0,34	0,36	0,38	0,40	0,42	0,42	0,44	85
	K	0.013	0.013	0.014	0.015	0.016	0.017	0.017	0.017	280
K2	K	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	75
	K	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	245
K3	K	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	60
	K	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	195
K4	K	0,28	0,30	0,32	0,34	0,36	0,38	0,38	0,40	60
	K	0.011	0.012	0.013	0.013	0.014	0.015	0.015	0.016	195
K5	K	0,26	0,28	0,30	0,32	0,32	0,34	0,36	0,36	35
	K	0.010	0.011	0.012	0.013	0.013	0.013	0.014	0.014	115
N1	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	290
	M	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	950
N2	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	185
	M	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	610
N3	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	125
	M	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	410
N11	M	0,19	0,19	0,20	0,20	0,20	0,22	0,22	0,22	145
	M	0.0075	0.0075	0.0080	0.0080	0.0080	0.0085	0.0085	0.0085	475
S1	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	29
	M	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	95
S2	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	21
	M	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	70
S3	M	0,085	0,090	0,095	0,095	0,095	0,10	0,10	0,10	21
	M	0.0034	0.0036	0.0038	0.0038	0.0038	0.0040	0.0040	0.0040	70
S11	M	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	55
	M	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	180
S12	M	0,11	0,11	0,11	0,12	0,12	0,12	0,12	0,13	42
	M	0.0044	0.0044	0.0044	0.0048	0.0048	0.0048	0.0048	0.0050	140
S13	M	0,095	0,095	0,10	0,10	0,10	0,11	0,11	0,11	33
	M	0.0038	0.0038	0.0040	0.0040	0.0040	0.0044	0.0044	0.0044	110
H3	P	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	23
	P	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	75
H5	P	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	43
	P	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	140
H7	P	0,095	0,11	0,12	0,12	0,13	0,14	0,14	0,15	23
	P	0.0038	0.0044	0.0048	0.0048	0.0050	0.0055	0.0055	0.0060	75
H8	P	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	43
	P	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	140
H11	P	0,15	0,16	0,18	0,19	0,20	0,20	0,22	0,22	55
	P	0.0060	0.0065	0.0070	0.0075	0.0080	0.0080	0.0085	0.0085	180
H12	P	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	28
	P	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	90
H21	P	0,11	0,12	0,13	0,14	0,15	0,16	0,17	0,17	43
	P	0.0044	0.0048	0.0050	0.0055	0.0060	0.0065	0.0065	0.0065	140

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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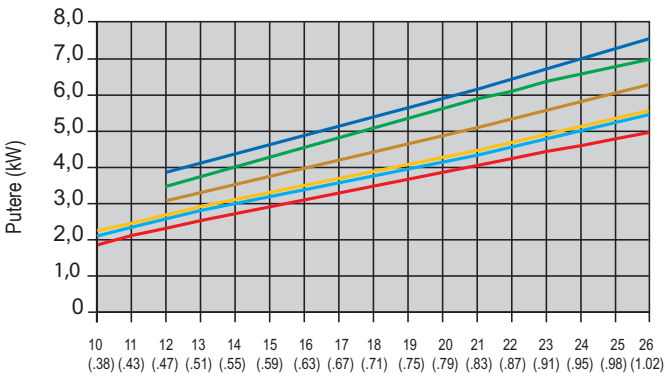
Alezare adâncă

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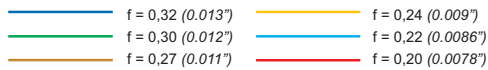
## Parametri de prelucrare

Valorile din grafic pot varia în funcție de ex. regimurile de așchiere, materialul, eficiența mașinii și uzura sculei.  
Graficele de mai jos sunt valabile pentru Grupa de materiale Seco (SMG) P5-P6 și viteza de așchiere de 90 m/min (295 SFM).

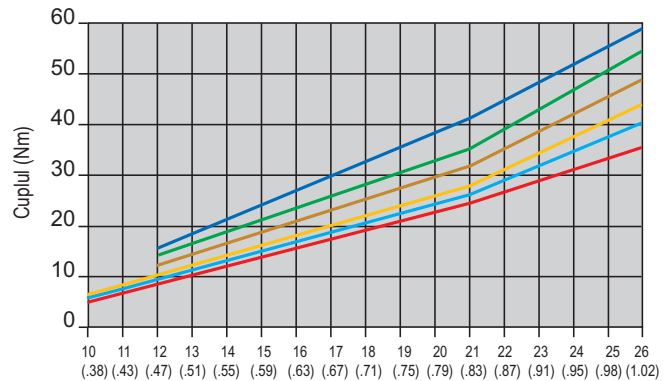
### Consumul net de putere



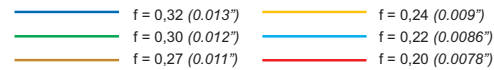
Diametru burghiu mm/(inci)



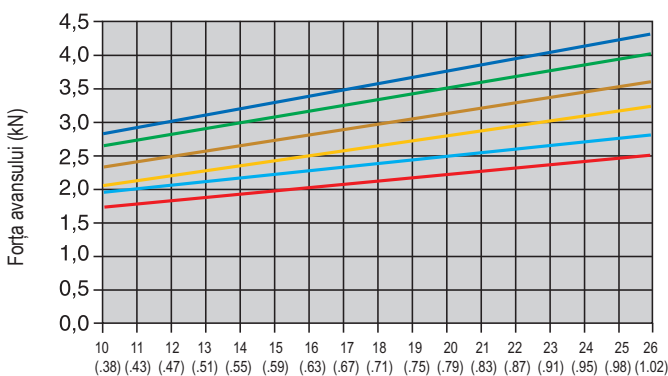
### Cuplul la găurire



Diametru burghiu mm/(inci)



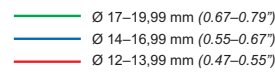
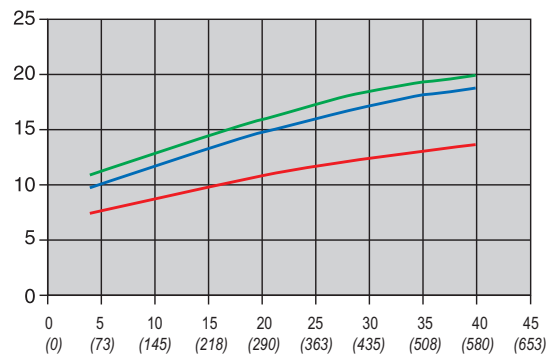
### Forța avansului



Diametru burghiu mm/(inci)



### Debitul lichidului de răcire la diferite presiuni



Debit de lichid de răcire recomandat Dx1 l/min

Debit de lichid de răcire minim D/2 l/min

D = diametrul burghiului

Presiune minimă recomandată a lichidului de răcire 10 bari (145 PSI) cu < 3 x D

Presiune minimă recomandată a lichidului de răcire 20 bari (290 PSI) cu > 3 x D

Presiune minimă recomandată a lichidului de răcire 40 bari (580 PSI) cu > 5 x D

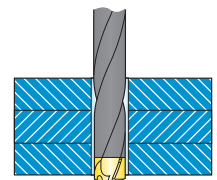
### Amestec de lichid de răcire

Amestec emulsie recomandat 6-8%.

Când se găurește în oțel inox, superaliaje și oțeluri de înaltă rezistență se recomandă un amestec de 10%.

### Recomandări de prelucrare

Este posibil să găuriți materiale suprapuse, cât timp piesele sunt bine fixate împreună, astfel încât să nu existe goluri de aer între ele. Golurile de aer pot influența evacuarea așchiilor, și pot duce chiar la distrugerea burghiului.



### Toleranța găurii/Finisarea suprafeței

SD101, SD103, SD105 și SD107 IT9-10 / R <sub>a</sub> 1-4*, Ra 39-157 μm*					
Burghiu Ø DC (mm)	Toleranța IT9 (μm)	Toleranța IT10 (μm)	Burghiu Ø DC (inci)	Toleranța IT9 (inci)	Toleranța IT10 (inci)
0 – +10-18	0 – +43	0 – +70	0 – +0.394-0.709	0 – +0.0017	0 – +0.0028
0 – +18-30	0 – +52	0 – +84	0 – +0.709-1.181	0 – +0.0020	0 – +0.0033

\*Deteriorarea finisării suprafeței și a toleranței găurii pot apărea când găuriți în oțel cu conținut redus de carbon sau în oțel inox. Utilizați cel mai scurt burghiu posibil pentru a obține o calitate maximă a găurii.

## Depanare - Condiții inițiale:

- Stabilitatea prinderii
- Starea arborelui mașinii
- Starea port-sculei
- Prinderea sculei:
  - Bătaie radială max. 0,06 TIR
- Îndepărtarea așchiilor:
  - regimuri de frezare
- Lichid de răcire:
  - Presiune
  - Debit
  - Concentrație

<p><b>Muchiile așchietoare sunt ciupite</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rot</li> <li>• Dacă burghiul vibrează, reduceți viteza de așchiere și măriți avansul</li> <li>• La găurirea unor suprafețe dure și neregulate, reduceți avansul cu 30%-50% la intrare și la ieșire</li> </ul>	<p><b>Toleranța diametrului nesatisfăcătoare</b></p> <ul style="list-style-type: none"> <li>• Măriți avansul/rotația</li> <li>• Utilizați un burghiu din carbură solidă Seco Feedmax, consultați paginile 15-18</li> <li>• Utilizați o operație de alezare, consultați paginile 328</li> <li>• Utilizați o operație de alezare adâncă, consultați paginile 492-493</li> </ul>
<p><b>Uzură rapidă a flancurilor</b></p> <ul style="list-style-type: none"> <li>• Verifică dacă se utilizează geometria corectă</li> <li>• Reduceți viteza de așchiere</li> </ul>	<p><b>Finisare slabă a suprafeței</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotație</li> <li>• Măriți viteza de așchiere</li> <li>• Verificați dacă se utilizează geometria corectă</li> <li>• Utilizați un burghiu din carbură solidă Feedmax, consultați paginile 15-18</li> <li>• Utilizați o operație de alezare, consultați paginile 328</li> </ul>
<p><b>Uzura canelurii</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rot</li> <li>• Reduceți viteza de așchiere</li> <li>• Măriți concentrația lichidului de răcire</li> </ul>	<p><b>Poziționarea găurii nesatisfăcătoare</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotație</li> <li>• La găurirea prin suprafețe neregulate, tari și înclinate – reduceți avansul cu 30-50% la intrare și la ieșire</li> <li>• Pregăurire cu un burghiu cu unghi la vârf de 140°</li> <li>• Utilizați un burghiu din carbură solidă Feedmax, consultați paginile despre Feedmax 15-18</li> <li>• Utilizați o operație de alezare adâncă, consultați paginile 492-493</li> </ul>
<p><b>Uzură a marginilor laterale periferice</b></p> <ul style="list-style-type: none"> <li>• Verificați dacă se utilizează geometria corectă</li> <li>• Reduceți viteza de așchiere</li> <li>• Măriți concentrația lichidului de răcire</li> <li>• La găurirea prin suprafețe neregulate, tari sau înclinate, reduceți rata de avans cu 30-50% la intrare și la ieșire</li> </ul>	<p><b>Probleme cu blocarea așchiilor din cauza așchiilor lungi</b></p> <ul style="list-style-type: none"> <li>• Măriți avansul</li> <li>• La materiale care produc așchii lungi SMG P1-P4, SMG M1-M2:                     <ul style="list-style-type: none"> <li>- Măriți viteza de așchiere și reduceți avansul/rotație</li> <li>- Utilizați geometria L (model personalizat)</li> </ul> </li> </ul>
<p><b>Spargere la ieșirea din material</b></p> <ul style="list-style-type: none"> <li>• Dacă conexiunea coroanei se rupe atunci când coroana este pe cale să iasă din material. Defectul este cauzat de:                     <ul style="list-style-type: none"> <li>- Interfața nu a fost curățată temeinic și există murdărie sau așchii rămase între coroană și corpul de burghiu</li> <li>- Coroana nu a fost bine prinsă. Utilizați cheia dinamometrică</li> <li>- Coroana este fixată cu prea puțin filet</li> </ul> </li> </ul>	<p><b>Ciupituri ale suprafeței de așezare</b></p> <ul style="list-style-type: none"> <li>• Ciupiturile minore nu sunt periculoase pentru sistemul de prindere. Nu vor afecta rezultatul găuririi</li> <li>• Dacă apar ciupituri majore la utilizarea unui avans mare sau când se găurește printr-o suprafață înclinată - reduceți rata avansului</li> </ul>



## Crownloc® Plus

Seco Crownloc® Plus este o nouă generație de burghie Seco cu coroane interschimbabile. Disponând de o nouă interfață de blocare, Crownloc Plus îmbunătățește îndepărtarea așchiilor și rezistența la uzură pentru o varietate de materiale.

- Un model de corp de burghiu robust, interfață de blocare de mare putere cu caneluri adânci și late și corp lustruit.
- Alegerea numărului unu pentru aplicații generale, geometria P reprezintă o soluție robustă și versatilă.
- Geometria M oferă performanțe excelente în aliaje de temperatură ridicată, titan, aliaje de titan și oțel inox

## Prezentare generală

Crownloc® Plus	Ø Gamă	Adâncimea de găurire	Toleranța Ø burghiului	Toleranța găurii (1)	Finisarea suprafeței (2)
 SD403 Pag. 206-209	12,00-19,99 mm (0.472-0.787")	~ 3 x D	k7	IT 9-10	Ra 1-3 µm (Ra 39-118 µin)
 SD405 Pag. 210-213	12,00-19,99 mm (0.472-0.787")	~ 5 x D	k7	IT 10	Ra 1-3 µm (Ra 39-118 µin)
 SD408 Pag. 214-217	12,00-19,99 mm (0.472-0.787")	~ 8 x D	k7	IT 10	Ra 1-3 µm (Ra 39-118 µin)

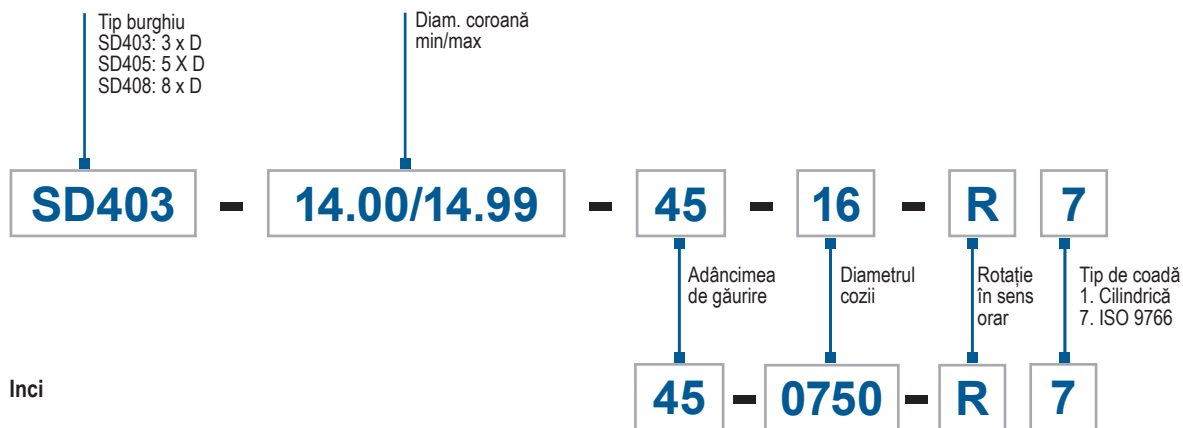
1) Pot apărea variații în funcție de material și de parametri de aşchiere utilizați.

2) Adâncimea alezajului, parametri de aşchiere, presiunea lichidului de răcire și tipul de material pot influența negativ calitatea suprafeței.

## Codificări

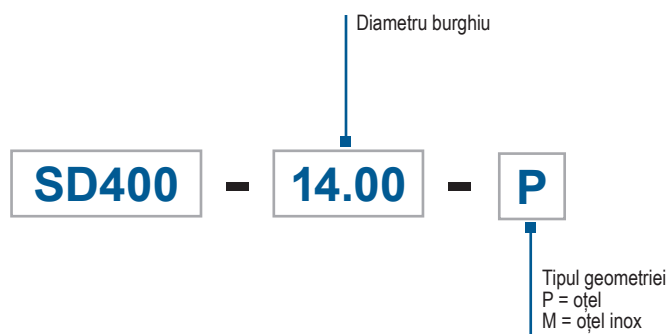
### Corpuri de burghiu Crownloc® Plus

#### Metric



#### Inci

### Codificare coroane



### Geometrii

**Geometria P**  
– Geometrie universală, prima alegere pentru  
găurirea în oțel



**Geometrie M**  
– Pentru oțel inox și aliaje rezistente la temperaturi  
înalte



## Instrucțiuni de montare

**1. Stabilitate**

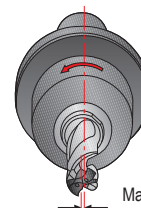
Stabilitatea aplicației este importantă pentru a obține cea mai bună durată de viață a sculei și toleranța găurii. Verifică starea arborelui mașinii, fixarea și prinderea componentelor pentru a asigura un maxim de stabilitate și rigiditate.

Condițiile instabile pot duce la distrugerea sculei.

**2. Aplicații dinamice**

Bătaia radială indicată totală (TIR) nu trebuie să depășească 0,06 mm (0,002") la o aplicație rotativă.

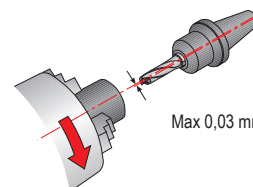
Măsoară bătaia burghiului la rotirea cu 360° în arborele mașinii.



Max 0,06 mm (0,002")

**3. Staționare**

Distanța dintre vârful burghiului și centrul rotativ al piesei de prelucrat nu trebuie să depășească 0,03 mm (0,001") radial la o aplicație staționară.



Max 0,03 mm (0,001")

**4. Port-scule recomandate**

Seco Tools oferă o gamă largă de port-scule (mandrine cu pensete, port-scule Shrinkfit, mandrine hidraulice Weldon etc.), disponibile pentru o varietate de tipuri de capete de alezare. Pentru cele mai bune rezultate, utilizați port-scule de tip BT JIS B 6339-ADB, tip ERHP 5672, mandrină de înaltă precizie. Pentru informații suplimentare, consultați catalogul de port-scule.



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



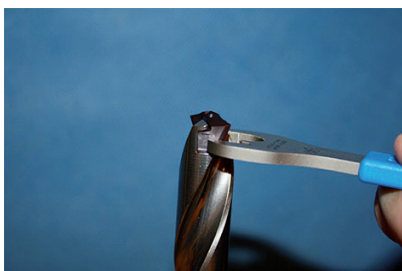
Prindere hidraulică  
(Doar pentru coadă cilindrică, -R1)



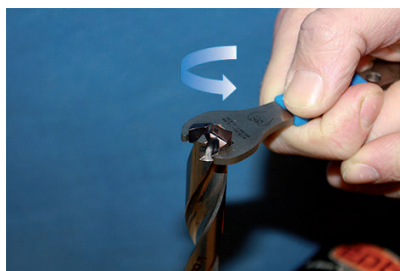
Weldon

**1.**

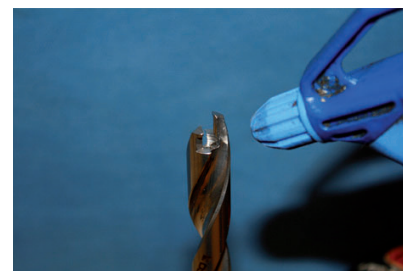
Pentru desfacerea coroanei, găsește cele două aplatizări de pe Coroană pentru cheie.

**2.**

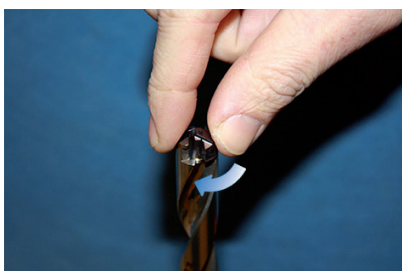
Rotește cheia în sens antiorar pentru a debloca coroana cu un sfert de tură.

**3.**

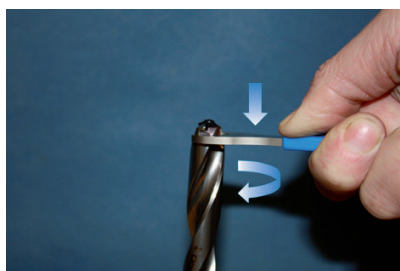
Curăță conexiunea înainte de montarea coroanei.

**4.**

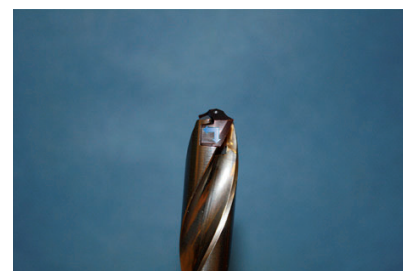
Strânge coroana la mână înainte de a utiliza cheia de strângere.

**5.**

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

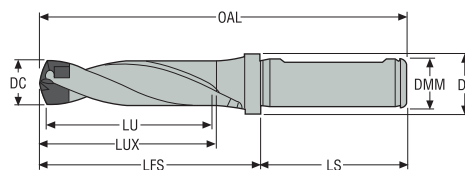
**6.**

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



## SD403 – R7

Adâncimea de găurire ~ 3 x D – Metric Coadă



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 222

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD403-12.00/12.49-38-16R7	02622894	12,0-12,49	38,0	106,2	46,2	58,2	48,0	16,0	20,0
SD403-12.50/12.99-39-16R7	02622895	12,5-12,99	39,0	108,0	47,5	60,0	48,0	16,0	20,0
SD403-13.00/13.99-42-16R7	02622896	13,0-13,99	42,0	111,9	50,9	63,9	48,0	16,0	20,0
SD403-14.00/14.99-45-16R7	02622898	14,0-14,99	45,0	116,5	54,5	68,5	48,0	16,0	20,0
SD403-15.00/15.99-48-16R7	02622899	15,0-15,99	48,0	121,2	58,2	73,2	48,0	16,0	20,0
SD403-16.00/16.99-51-20R7	02622900	16,0-16,99	51,0	127,9	61,9	77,9	50,0	20,0	24,0
SD403-17.00/17.99-54-20R7	02622902	17,0-17,99	54,0	132,6	65,6	82,6	50,0	20,0	24,0
SD403-18.00/18.99-57-20R7	02622903	18,0-18,99	57,0	137,3	69,3	87,3	50,0	20,0	24,0
SD403-19.00/19.99-60-20R7	02622905	19,0-19,99	60,0	142,0	73,0	92,0	50,0	20,0	24,0

### Accesorii

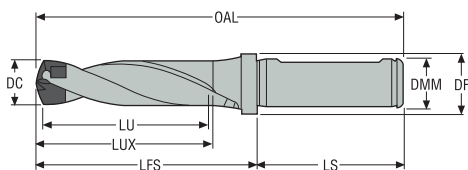
Pentru burghiu dia (mm)	Cheie
12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09





## SD403 – R7

Adâncimea de găurire ~ 3 x D – inci Coadă



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 222

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

### Piese de schimb

Pentru burghiu dia (inch)

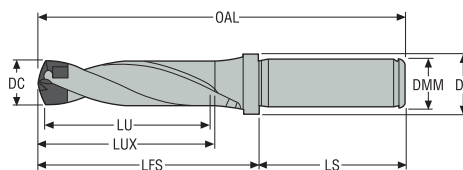
Cheie



0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

## SD403 – R1

Adâncimea de găurire ~ 3 x D – Metric Coadă



- Coadă cilindrică (R1) se potrivește în portsculele: 5834 și 5672
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 222

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD403-12.00/12.49-38-16R1	02622920	12,0-12,49	38,0	106,2	46,2	58,2	48,0	16,0	20,0
SD403-12.50/12.99-39-16R1	02622921	12,5-12,99	39,0	108,0	47,5	60,0	48,0	16,0	20,0
SD403-13.00/13.99-42-16R1	02622922	13,0-13,99	42,0	111,9	50,9	63,9	48,0	16,0	20,0
SD403-14.00/14.99-45-16R1	02622923	14,0-14,99	45,0	116,5	54,5	68,5	48,0	16,0	20,0
SD403-15.00/15.99-48-16R1	02622924	15,0-15,99	48,0	121,2	58,2	73,2	48,0	16,0	20,0
SD403-16.00/16.99-51-20R1	02622927	16,0-16,99	51,0	127,9	61,9	77,9	50,0	20,0	24,0
SD403-17.00/17.99-54-20R1	02622928	17,0-17,99	54,0	132,6	65,6	82,6	50,0	20,0	24,0
SD403-18.00/18.99-57-20R1	02622930	18,0-18,99	57,0	137,3	69,3	87,3	50,0	20,0	24,0
SD403-19.00/19.99-60-20R1	02622931	19,0-19,99	60,0	142,0	73,0	92,0	50,0	20,0	24,0

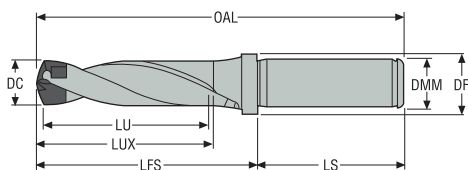
### Accesorii

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



## SD403 – R1

Adâncimea de găurire ~ 3 x D – inci Coadă



- Coadă cilindrică (R1) se potrivește în portsculele: 5834 și 5672
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 222

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

## Piese de schimb

Pentru burghiu dia  
(inch)

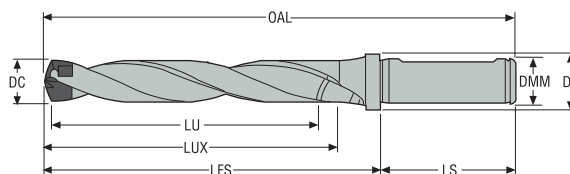
Cheie



0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

## SD405 – R7

Adâncimea de găurire ~ 5 x D – Metric Coadă



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 223

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD405-12.00/12.49-63-16R7	02623554	12,0-12,49	63,0	131,2	71,2	83,2	48,0	16,0	20,0
SD405-12.50/12.99-65-16R7	02623555	12,5-12,99	65,0	134,0	73,5	86,0	48,0	16,0	20,0
SD405-13.00/13.99-70-16R7	02623556	13,0-13,99	70,0	139,9	78,9	91,9	48,0	16,0	20,0
SD405-14.00/14.99-75-16R7	02623557	14,0-14,99	75,0	146,5	84,5	98,5	48,0	16,0	20,0
SD405-15.00/15.99-80-16R7	02623558	15,0-15,99	80,0	153,2	90,2	105,2	48,0	16,0	20,0
SD405-16.00/16.99-85-20R7	02623559	16,0-16,99	85,0	161,9	95,9	111,9	50,0	20,0	24,0
SD405-17.00/17.99-90-20R7	02623560	17,0-17,99	90,0	168,6	101,6	118,6	50,0	20,0	24,0
SD405-18.00/18.99-95-20R7	02623561	18,0-18,99	95,0	175,3	107,3	125,3	50,0	20,0	24,0
SD405-19.00/19.99-100-20R7	02623562	19,0-19,99	100,0	182,0	113,0	132,0	50,0	20,0	24,0

### Accesorii

Pentru burghiu dia  
(mm)

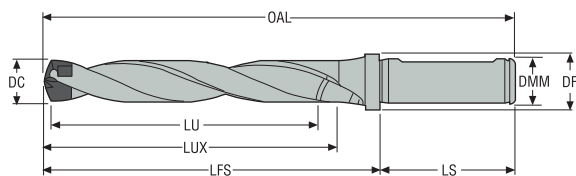
Cheie



12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

## SD405 – R7

Adâncimea de găurire ~ 5 x D – inci Coadă



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 223

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

### Piese de schimb

Pentru burghiu dia (inch)

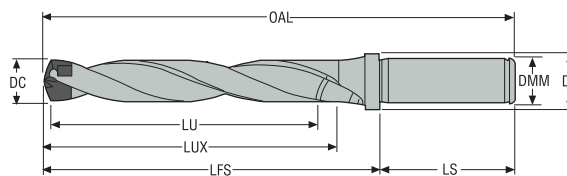
Cheie



0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

## SD405 – R1

Adâncimea de găurire ~ 5 x D – Metric Coadă



- Coadă cilindrică (R1) se potrivește în portsculele: 5834 și 5672
- Răcire interioară
- Pentru regimurile de așchiere vezi pag. 223

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD405-12.00/12.49-63-16R1	02623570	12,0-12,49	63,0	131,2	71,2	83,2	48,0	16,0	20,0
SD405-12.50/12.99-65-16R1	02623571	12,5-12,99	65,0	134,0	73,5	86,0	48,0	16,0	20,0
SD405-13.00/13.99-70-16R1	02623572	13,0-13,99	70,0	139,9	78,9	91,9	48,0	16,0	20,0
SD405-14.00/14.99-75-16R1	02623573	14,0-14,99	75,0	146,5	84,5	98,5	48,0	16,0	20,0
SD405-15.00/15.99-80-16R1	02623574	15,0-15,99	80,0	153,2	90,2	105,2	48,0	16,0	20,0
SD405-16.00/16.99-85-20R1	02623575	16,0-16,99	85,0	161,9	95,9	111,9	50,0	20,0	24,0
SD405-17.00/17.99-90-20R1	02623576	17,0-17,99	90,0	168,6	101,6	118,6	50,0	20,0	24,0
SD405-18.00/18.99-95-20R1	02623577	18,0-18,99	95,0	175,3	107,3	125,3	50,0	20,0	24,0
SD405-19.00/19.99-100-20R1	02623578	19,0-19,99	100,0	182,0	113,0	132,0	50,0	20,0	24,0

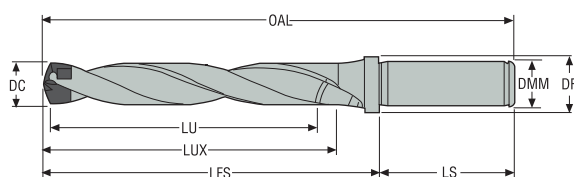
### Accesorii

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



## SD405 – R1

Adâncimea de găurire ~ 5 x D – inci Coadă



- Coadă cilindrică (R1) se potrivește în portsculele: 5834 și 5672
- Răcire interioară
- Pentru regimurile de așchiere vezi pag. 223

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

## Piese de schimb

Pentru burghiu dia  
(inch)

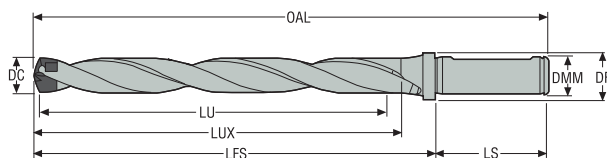
Cheie



0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

## SD408 – R7

Adâncimea de găurire ~ 8 x D – Metric Coadă



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 224

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD408-12.00/12.49-100-16R7	02623615	12,0-12,49	100,0	168,2	108,2	120,2	48,0	16,0	20,0
SD408-12.50/12.99-104-16R7	02623616	12,5-12,99	104,0	173,0	112,5	125,0	48,0	16,0	20,0
SD408-13.00/13.99-112-16R7	02623617	13,0-13,99	112,0	181,9	120,9	133,9	48,0	16,0	20,0
SD408-14.00/14.99-120-16R7	02623618	14,0-14,99	120,0	191,5	129,5	143,5	48,0	16,0	20,0
SD408-15.00/15.99-128-16R7	02623619	15,0-15,99	128,0	201,2	138,2	153,2	48,0	16,0	20,0
SD408-16.00/16.99-136-20R7	02623620	16,0-16,99	136,0	212,9	146,9	162,9	50,0	20,0	24,0
SD408-17.00/17.99-144-20R7	02623621	17,0-17,99	144,0	222,6	155,6	172,6	50,0	20,0	24,0
SD408-18.00/18.99-152-20R7	02623622	18,0-18,99	152,0	232,3	164,3	182,3	50,0	20,0	24,0
SD408-19.00/19.99-160-20R7	02623623	19,0-19,99	160,0	242,0	173,0	192,0	50,0	20,0	24,0

### Accesorii

Pentru burghiu dia  
(mm)

Cheie

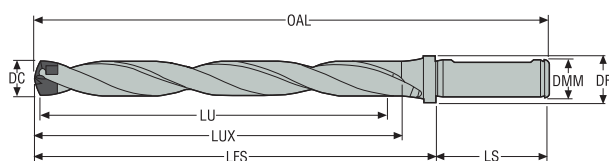


12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09



## SD408 – R7

Adâncimea de găurire ~ 8 x D – inci Coadă



- Portscule ISO9766: Weldon 1835B, ISO 5414, DIN 60880
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 224

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

## Piese de schimb

Pentru burghiu dia  
(inch)

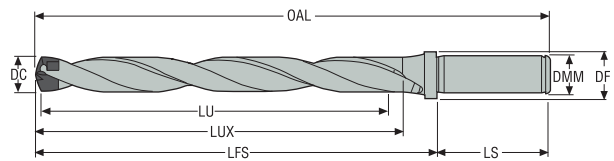
Cheie



0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09

## SD408 – R1

Adâncimea de găurire ~ 8 x D – Metric Coadă



- Coadă cilindrică (R1) se potrivește în portsculele: 5834 și 5672
- Răcire interioară
- Pentru regimurile de aşchiere vezi pag. 224

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF
		mm	mm	mm	mm	mm	mm	mm	mm
SD408-12.00/12.49-100-16R1	02623627	12,0-12,49	100,0	168,2	108,2	120,2	48,0	16,0	20,0
SD408-12.50/12.99-104-16R1	02623628	12,5-12,99	104,0	173,0	112,5	125,0	48,0	16,0	20,0
SD408-13.00/13.99-112-16R1	02623629	13,0-13,99	112,0	181,9	120,9	133,9	48,0	16,0	20,0
SD408-14.00/14.99-120-16R1	02623630	14,0-14,99	120,0	191,5	129,5	143,5	48,0	16,0	20,0
SD408-15.00/15.99-128-16R1	02623631	15,0-15,99	128,0	201,2	138,2	153,2	48,0	16,0	20,0
SD408-16.00/16.99-136-20R1	02623632	16,0-16,99	136,0	212,9	146,9	162,9	50,0	20,0	24,0
SD408-17.00/17.99-144-20R1	02623633	17,0-17,99	144,0	222,6	155,6	172,6	50,0	20,0	24,0
SD408-18.00/18.99-152-20R1	02623634	18,0-18,99	152,0	232,3	164,3	182,3	50,0	20,0	24,0
SD408-19.00/19.99-160-20R1	02623635	19,0-19,99	160,0	242,0	173,0	192,0	50,0	20,0	24,0

### Accesorii

Pentru burghiu dia  
(mm)

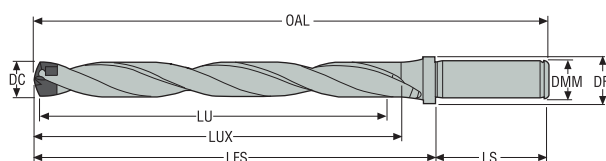
Cheie



12,00-12,99	SD400-K05
13,00-14,99	SD400-K06
15,00-16,99	SD400-K07
17,00-18,99	SD400-K08
19,00-19,99	SD400-K09

## SD408 – R1

Adâncimea de găurire ~ 8 x D – inci Coadă



- Coadă cilindrică (R1) se potrivește în portsculele: 5834 și 5672
- Răcire interioară
- Pentru regimurile de așchiere vezi pag. 224

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

### Piese de schimb

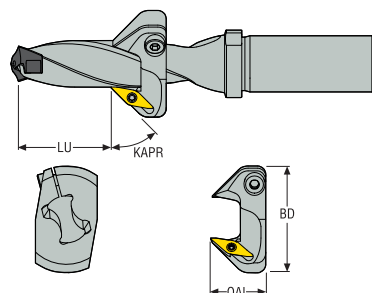
Pentru burghiu dia (inch)

Cheie



0.472-0.511	SD400-K05
0.512-0.590	SD400-K06
0.591-0.669	SD400-K07
0.669-0.748	SD400-K08
0.748-0.787	SD400-K09







## Modul pentru șanfenat



Adâncimea de găurire LU

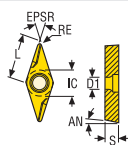
Reper Nr.	Număr reper	Pentru corpul burghiului	SD403 (min-max)		SD405 (min-max)		SD408 (min-max)		Adâncime max. șanfen	OAL	BD	KAPR°
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				
SD400-C45-12.00/12.49	02846075	SD40x-12.00/12.49	6,0 0.236	22,0 0.866	6,0 0.236	47,0 1.850	47,0 1.850	84,0 3.307	1,5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

### Piese de schimb

Pentru burghiu dia (mm)	Cheie plăcuță	Șurub plăcuță	Cheie de blocare	Cheie de blocare	Șurub de blocare 1	Șurub de blocare 2
SD400-C45...	 T07P-2	 C02505-T07P	 2SMS795	 3SMS795	 MC6S4X8	 P6SS4X8

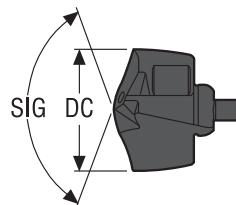
### Plăcuță amovibilă

Toleranța: mm/inci	Mărimea	IC mm/inci	L mm/inci	S mm/inci	D1 mm/inci	RE mm/inci
IC = ±0,025/0.000984" S = ±0,07/0.0027559" RE = ±0,10/0.0039370"	09	5,556/0.2187"	9,0/0.2187"	2,5/0.0984"	2,9/0.1141"	0,2/0.0078"
	Calitate: T400D					
	Reper Nr.: VCGX090202-D1					
	Număr reper: 00014948					



## Coroane - Geometrie -P și M

Unghiul la vârf: 140°



Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	DC	
				mm	inci
SD400-12.00-M	02826210	-	■	12,0	0.472
SD400-12.00-P	02630908	■	-	12,0	0.472
SD400-12.10-P	02630910	■	-	12,1	0.476
SD400-12.20-P	02630911	■	-	12,2	0.480
SD400-12.30-M	02826211	-	■	12,3	0.484
SD400-12.30-P	02630912	■	-	12,3	0.484
SD400-12.41-M	02826212	-	■	12,41	0.489
SD400-12.41-P	02630913	■	-	12,41	0.489
SD400-12.50-M	02826213	-	■	12,5	0.492
SD400-12.50-P	02630915	■	-	12,5	0.492
SD400-12.60-P	02630916	■	-	12,6	0.496
SD400-12.70-M	02826214	-	■	12,7	0.500
SD400-12.70-P	02630917	■	-	12,7	0.500
SD400-12.80-M	02826215	-	■	12,8	0.504
SD400-12.80-P	02630918	■	-	12,8	0.504
SD400-12.90-M	02826216	-	■	12,9	0.508
SD400-12.90-P	02630919	■	-	12,9	0.508
SD400-13.00-M	02826217	-	■	13,0	0.512
SD400-13.00-P	02634577	■	-	13,0	0.512
SD400-13.10-M	02826218	-	■	13,1	0.516
SD400-13.10-P	02634578	■	-	13,1	0.516
SD400-13.20-P	02634579	■	-	13,2	0.520
SD400-13.30-M	02826219	-	■	13,3	0.524
SD400-13.30-P	02634580	■	-	13,3	0.524
SD400-13.50-M	02826220	-	■	13,5	0.531
SD400-13.50-P	02634581	■	-	13,5	0.531
SD400-13.70-M	02826221	-	■	13,7	0.539
SD400-13.70-P	02634582	■	-	13,7	0.539
SD400-13.80-M	02826222	-	■	13,8	0.543
SD400-13.80-P	02634583	■	-	13,8	0.543
SD400-13.89-M	02826223	-	■	13,89	0.547
SD400-13.89-P	02634584	■	-	13,89	0.547
SD400-14.00-M	02826224	-	■	14,0	0.551
SD400-14.00-P	02634589	■	-	14,0	0.551
SD400-14.10-P	02634590	■	-	14,1	0.555
SD400-14.20-M	02826225	-	■	14,2	0.559
SD400-14.20-P	02634591	■	-	14,2	0.559
SD400-14.288-M	02826226	-	■	14,288	0.563
SD400-14.288-P	02634592	■	-	14,288	0.563

Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	DC	
				mm	inci
SD400-14.40-P	02634593	■	-	14,4	0.567
SD400-14.50-M	02826227	-	■	14,5	0.571
SD400-14.50-P	02634594	■	-	14,5	0.571
SD400-14.68-M	02826228	-	■	14,68	0.578
SD400-14.68-P	02634595	■	-	14,68	0.578
SD400-14.70-M	02826229	-	■	14,7	0.579
SD400-14.70-P	02634596	■	-	14,7	0.579
SD400-14.80-M	02826230	-	■	14,8	0.583
SD400-14.80-P	02634597	■	-	14,8	0.583
SD400-14.90-M	02826231	-	■	14,9	0.587
SD400-14.90-P	02634598	■	-	14,9	0.587
SD400-15.00-M	02826232	-	■	15,0	0.591
SD400-15.00-P	02634599	■	-	15,0	0.591
SD400-15.08-M	02826233	-	■	15,08	0.594
SD400-15.08-P	02634600	■	-	15,08	0.594
SD400-15.10-P	02634601	■	-	15,1	0.594
SD400-15.20-P	02634602	■	-	15,2	0.598
SD400-15.25-M	02826234	-	■	15,25	0.600
SD400-15.25-P	02634603	■	-	15,25	0.600
SD400-15.478-M	02826235	-	■	15,48	0.609
SD400-15.478-P	02634604	■	-	15,478	0.609
SD400-15.50-M	02826236	-	■	15,5	0.610
SD400-15.50-P	02634605	■	-	15,5	0.610
SD400-15.70-M	02826237	-	■	15,7	0.618
SD400-15.70-P	02634607	■	-	15,7	0.618
SD400-15.80-M	02826238	-	■	15,8	0.622
SD400-15.80-P	02634608	■	-	15,8	0.622
SD400-15.875-M	02826239	-	■	15,88	0.625
SD400-15.875-P	02634609	■	-	15,875	0.625
SD400-16.00-M	02826240	-	■	16,0	0.630
SD400-16.00-P	02635956	■	-	16,0	0.630
SD400-16.10-P	02635957	■	-	16,1	0.634
SD400-16.20-P	02635958	■	-	16,2	0.638
SD400-16.25-P	02635959	■	-	16,25	0.640
SD400-16.27-M	02826241	-	■	16,27	0.641
SD400-16.27-P	02635960	■	-	16,27	0.641
SD400-16.40-P	02635962	■	-	16,4	0.646
SD400-16.50-M	02826242	-	■	16,5	0.650
SD400-16.50-P	02635963	■	-	16,5	0.650
SD400-16.669-M	02826243	-	■	16,67	0.656
SD400-16.669-P	02635964	■	-	16,669	0.656
SD400-16.70-M	02826244	-	■	16,7	0.657
SD400-16.70-P	02635966	■	-	16,7	0.657
SD400-16.80-M	02826245	-	■	16,8	0.661
SD400-16.80-P	02635968	■	-	16,8	0.661
SD400-16.90-P	02635969	■	-	16,9	0.665
SD400-17.00-M	02826246	-	■	17,0	0.669
SD400-17.00-P	02635970	■	-	17,0	0.669
SD400-17.065-M	02826247	-	■	17,07	0.672
SD400-17.065-P	02635972	■	-	17,065	0.672
SD400-17.10-P	02635973	■	-	17,1	0.673

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Reper Nr.	Număr reper	Geometrie -P	Geometrie -M	DC	
				mm	inci
SD400-17.20-P	02635974	■	-	17,2	0.677
SD400-17.35-P	02888828	■	-	17,35	0.683
SD400-17.463-M	02826248	-	■	17,46	0.687
SD400-17.463-P	02635975	■	-	17,463	0.688
SD400-17.50-M	02826249	-	■	17,5	0.689
SD400-17.50-P	02635976	■	-	17,5	0.689
SD400-17.70-M	02826250	-	■	17,7	0.697
SD400-17.70-P	02635977	■	-	17,7	0.697
SD400-17.80-M	02826251	-	■	17,8	0.701
SD400-17.80-P	02635978	■	-	17,8	0.701
SD400-17.859-M	02826252	-	■	17,86	0.703
SD400-17.859-P	02635979	■	-	17,859	0.703
SD400-17.90-M	02826253	-	■	17,9	0.705
SD400-17.90-P	02635980	■	-	17,9	0.705
SD400-18.00-M	02826254	-	■	18,0	0.709
SD400-18.00-P	02635981	■	-	18,0	0.709
SD400-18.10-P	02635982	■	-	18,1	0.713
SD400-18.20-P	02635983	■	-	18,2	0.717
SD400-18.256-M	02826255	-	■	18,26	0.719
SD400-18.256-P	02635984	■	-	18,256	0.719
SD400-18.50-M	02826256	-	■	18,5	0.728
SD400-18.50-P	02635985	■	-	18,5	0.728
SD400-18.653-M	02826257	-	■	18,65	0.734
SD400-18.653-P	02635986	■	-	18,653	0.734
SD400-18.70-M	02826258	-	■	18,7	0.736
SD400-18.70-P	02635987	■	-	18,7	0.736
SD400-18.80-M	02826259	-	■	18,8	0.740
SD400-18.80-P	02635988	■	-	18,8	0.740
SD400-18.90-M	02826260	-	■	18,9	0.744
SD400-18.90-P	02635989	■	-	18,9	0.744
SD400-19.00-M	02826261	-	■	19,0	0.748
SD400-19.00-P	02635991	■	-	19,0	0.748
SD400-19.05-M	02826262	-	■	19,05	0.750
SD400-19.05-P	02635992	■	-	19,05	0.750
SD400-19.10-P	02635993	■	-	19,1	0.752
SD400-19.20-M	02826263	-	■	19,2	0.756
SD400-19.20-P	02635995	■	-	19,2	0.756
SD400-19.25-M	02925410	-	■	19,25	0.758
SD400-19.447-M	02826264	-	■	19,45	0.766
SD400-19.447-P	02635997	■	-	19,447	0.766
SD400-19.50-M	02826265	-	■	19,5	0.768
SD400-19.50-P	02635998	■	-	19,5	0.768
SD400-19.70-M	02826266	-	■	19,7	0.776
SD400-19.70-P	02635999	■	-	19,7	0.776
SD400-19.80-M	02826267	-	■	19,8	0.780
SD400-19.80-P	02636000	■	-	19,8	0.780
SD400-19.844-M	02826268	-	■	19,84	0.781
SD400-19.844-P	02636001	■	-	19,844	0.781
SD400-19.90-M	02826269	-	■	19,9	0.783
SD400-19.90-P	02636002	■	-	19,9	0.783

■ Stoc standard.

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Anexă

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire



SD405 – Ø 12-20 mm / 0.472-0.787 inci

SMG		f					V <sub>c</sub>
		Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P1	P	0,30	0,32	0,34	0,36	0,36	125
	P	0,012	0,013	0,013	0,014	0,014	410
P2	P	0,30	0,32	0,34	0,36	0,38	120
	P	0,012	0,013	0,013	0,014	0,015	395
P3	P	0,28	0,30	0,32	0,34	0,36	105
	P	0,011	0,012	0,013	0,013	0,014	345
P4	P	0,28	0,30	0,32	0,34	0,34	95
	P	0,011	0,012	0,013	0,013	0,013	310
P5	P	0,28	0,30	0,32	0,32	0,34	90
	P	0,011	0,012	0,013	0,013	0,013	295
P6	P	0,28	0,30	0,30	0,32	0,34	100
	P	0,011	0,012	0,012	0,013	0,013	330
P7	P	0,28	0,30	0,30	0,32	0,34	95
	P	0,011	0,012	0,012	0,013	0,013	310
P8	P	0,28	0,30	0,32	0,34	0,36	90
	P	0,011	0,012	0,013	0,013	0,014	295
P11	P	0,28	0,30	0,30	0,32	0,34	90
	P	0,011	0,012	0,012	0,013	0,013	295
P12	P	0,19	0,20	0,22	0,22	0,24	55
	P	0,0075	0,0080	0,0085	0,0085	0,0095	180
M1	M	0,17	0,19	0,20	0,22	0,22	80
	M	0,0065	0,0075	0,0080	0,0085	0,0085	260
M2	M	0,16	0,17	0,18	0,19	0,20	65
	M	0,0065	0,0065	0,0070	0,0075	0,0080	215
M3	M	0,13	0,14	0,14	0,15	0,16	49
	M	0,0050	0,0055	0,0055	0,0060	0,0065	160
M4	M	0,11	0,12	0,13	0,13	0,14	37
	M	0,0044	0,0048	0,0050	0,0050	0,0055	120
M5	M	0,11	0,12	0,13	0,13	0,14	31
	M	0,0044	0,0048	0,0050	0,0050	0,0055	100
K1	P	0,28	0,30	0,32	0,34	0,36	90
	P	0,011	0,012	0,013	0,013	0,014	295
K2	P	0,26	0,28	0,30	0,32	0,32	75
	P	0,010	0,011	0,012	0,013	0,013	245
K3	P	0,26	0,28	0,30	0,32	0,32	65
	P	0,010	0,011	0,012	0,013	0,013	215
K4	P	0,26	0,28	0,30	0,32	0,32	60
	P	0,010	0,011	0,012	0,013	0,013	195
K5	P	0,24	0,25	0,26	0,28	0,30	37
	P	0,0095	0,010	0,010	0,011	0,012	120
N2	M	0,26	0,28	0,30	0,32	0,34	175
	M	0,010	0,011	0,012	0,013	0,013	570
N3	M	0,26	0,28	0,30	0,32	0,34	120
	M	0,010	0,011	0,012	0,013	0,013	395
N11	M	0,26	0,28	0,30	0,32	0,34	140
	M	0,010	0,011	0,012	0,013	0,013	460
S1	M	0,095	0,11	0,12	0,13	0,13	28
	M	0,0038	0,0044	0,0048	0,0050	0,0050	90
S2	M	0,095	0,11	0,12	0,13	0,13	20
	M	0,0038	0,0044	0,0048	0,0050	0,0050	65
S3	M	0,095	0,11	0,12	0,13	0,13	20
	M	0,0038	0,0044	0,0048	0,0050	0,0050	65
S11	M	0,16	0,17	0,19	0,20	0,22	50
	M	0,0065	0,0065	0,0075	0,0080	0,0085	165
S12	M	0,16	0,17	0,19	0,20	0,22	40
	M	0,0065	0,0065	0,0075	0,0080	0,0085	130
S13	M	0,14	0,15	0,17	0,18	0,19	31
	M	0,0055	0,0060	0,0065	0,0070	0,0075	100
H3	P	0,12	0,13	0,14	0,15	0,15	26
	P	0,0048	0,0050	0,0055	0,0060	0,0060	85
H5	P	0,19	0,20	0,22	0,22	0,24	49
	P	0,0075	0,0080	0,0085	0,0085	0,0095	160
H7	P	0,12	0,13	0,14	0,15	0,15	26
	P	0,0048	0,0050	0,0055	0,0060	0,0060	85
H8	P	0,14	0,15	0,16	0,17	0,18	49
	P	0,0055	0,0060	0,0065	0,0065	0,0070	160
H11	P	0,19	0,20	0,22	0,22	0,24	60
	P	0,0075	0,0080	0,0085	0,0085	0,0095	195
H12	P	0,14	0,15	0,16	0,17	0,18	32
	P	0,0055	0,0060	0,0065	0,0065	0,0070	105
H21	P	0,14	0,15	0,16	0,17	0,18	49
	P	0,0055	0,0060	0,0065	0,0065	0,0070	160

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

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

SMG		f					V <sub>c</sub>
		Ø12,00 Ø 0.472	Ø14,00 Ø 0.551	Ø16,00 Ø 0.630	Ø18,00 Ø 0.709	Ø20,00 Ø 0.787	
P1	P	0,30	0,32	0,34	0,36	0,36	100
	P	0.012	0.013	0.013	0.014	0.014	330
P2	P	0,30	0,32	0,34	0,36	0,38	100
	P	0.012	0.013	0.013	0.014	0.015	330
P3	P	0,28	0,30	0,32	0,34	0,36	85
	P	0.011	0.012	0.013	0.013	0.014	280
P4	P	0,28	0,30	0,32	0,34	0,34	75
	P	0.011	0.012	0.013	0.013	0.013	245
P5	P	0,28	0,30	0,32	0,32	0,34	70
	P	0.011	0.012	0.013	0.013	0.013	230
P6	P	0,28	0,30	0,30	0,32	0,34	80
	P	0.011	0.012	0.012	0.013	0.013	260
P7	P	0,28	0,30	0,30	0,32	0,34	75
	P	0.011	0.012	0.012	0.013	0.013	245
P8	P	0,28	0,30	0,32	0,34	0,36	70
	P	0.011	0.012	0.013	0.013	0.014	230
P11	P	0,28	0,30	0,30	0,32	0,34	75
	P	0.011	0.012	0.012	0.013	0.013	245
P12	P	0,19	0,20	0,22	0,22	0,24	43
	P	0.0075	0.0080	0.0085	0.0085	0.0095	140
M1	M	0,17	0,19	0,20	0,22	0,22	65
	M	0.0065	0.0075	0.0080	0.0085	0.0085	215
M2	M	0,16	0,17	0,18	0,19	0,20	50
	M	0.0065	0.0065	0.0070	0.0075	0.0080	165
M3	M	0,13	0,14	0,14	0,15	0,16	39
	M	0.0050	0.0055	0.0055	0.0060	0.0065	130
M4	M	0,11	0,12	0,13	0,13	0,14	29
	M	0.0044	0.0048	0.0050	0.0050	0.0055	95
M5	M	0,11	0,12	0,13	0,13	0,14	24
	M	0.0044	0.0048	0.0050	0.0050	0.0055	80
K1	P	0,28	0,30	0,32	0,34	0,36	70
	P	0.011	0.012	0.013	0.013	0.014	230
K2	P	0,26	0,28	0,30	0,32	0,32	60
	P	0.010	0.011	0.012	0.013	0.013	195
K3	P	0,26	0,28	0,30	0,32	0,32	50
	P	0.010	0.011	0.012	0.013	0.013	165
K4	P	0,26	0,28	0,30	0,32	0,32	49
	P	0.010	0.011	0.012	0.013	0.013	160
K5	P	0,24	0,25	0,26	0,28	0,30	29
	P	0.0095	0.010	0.010	0.011	0.012	95
N2	M	0,26	0,28	0,30	0,32	0,34	140
	M	0.010	0.011	0.012	0.013	0.013	460
N3	M	0,26	0,28	0,30	0,32	0,34	95
	M	0.010	0.011	0.012	0.013	0.013	310
N11	M	0,26	0,28	0,30	0,32	0,34	110
	M	0.010	0.011	0.012	0.013	0.013	360
S1	M	0,095	0,11	0,12	0,13	0,13	22
	M	0.0038	0.0044	0.0048	0.0050	0.0050	70
S2	M	0,095	0,11	0,12	0,13	0,13	16
	M	0.0038	0.0044	0.0048	0.0050	0.0050	50
S3	M	0,095	0,11	0,12	0,13	0,13	16
	M	0.0038	0.0044	0.0048	0.0050	0.0050	50
S11	M	0,16	0,17	0,19	0,20	0,22	42
	M	0.0065	0.0065	0.0075	0.0080	0.0085	140
S12	M	0,16	0,17	0,19	0,20	0,22	32
	M	0.0065	0.0065	0.0075	0.0080	0.0085	105
S13	M	0,14	0,15	0,17	0,18	0,19	25
	M	0.0055	0.0060	0.0065	0.0070	0.0075	80
H3	P	0,12	0,13	0,14	0,15	0,15	21
	P	0.0048	0.0050	0.0055	0.0060	0.0060	70
H5	P	0,19	0,20	0,22	0,22	0,24	39
	P	0.0075	0.0080	0.0085	0.0085	0.0095	130
H7	P	0,12	0,13	0,14	0,15	0,15	21
	P	0.0048	0.0050	0.0055	0.0060	0.0060	70
H8	P	0,14	0,15	0,16	0,17	0,18	39
	P	0.0055	0.0060	0.0065	0.0065	0.0070	130
H11	P	0,19	0,20	0,22	0,22	0,24	49
	P	0.0075	0.0080	0.0085	0.0085	0.0095	160
H12	P	0,14	0,15	0,16	0,17	0,18	26
	P	0.0055	0.0060	0.0065	0.0065	0.0070	85
H21	P	0,14	0,15	0,16	0,17	0,18	39
	P	0.0055	0.0060	0.0065	0.0065	0.0070	130

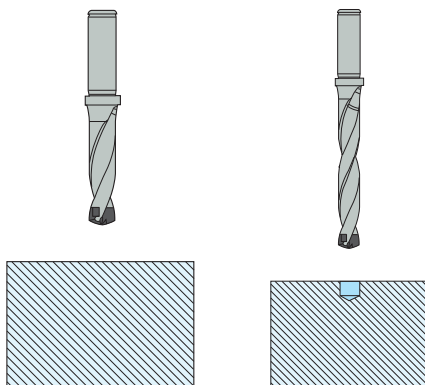
SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

## Informații despre aplicație

### Informații despre aplicație

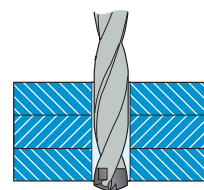
#### Suprafața prelucrată

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



#### Materiale suprapuse

Este posibil să găuriți materiale suprapuse, cât timp piesele sunt bine fixate împreună, astfel încât să nu existe goluri de aer între ele. Golurile de aer pot influența evacuarea așchilor, și pot duce chiar la distrugerea burghiului.



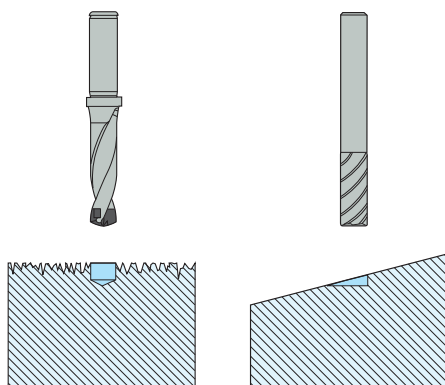
### Intrare neregulată/inclinată în gaură

La intrarea în gaură neregulată sau înclinată utilizați operații pregătitoare corespunzătoare. La utilizarea de burghie >3 x D se recomandă să executați o pre-găurire cu o sculă standard, de ex. SD403

#### Operație alternativă de pre-găurire

Prelucrați o suprafață plană cu o freză din gama Seco.

Intrarea neregulată în gaură



Intrarea înclinată în gaură

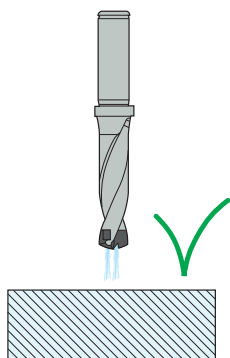
### Recomandări de lichid de răcire

#### Presiune lichid de răcire

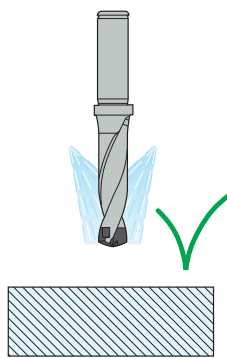
Presiunea minimă recomandată a lichidului de răcire 10 bari (145 PSI) cu  $\leq 3 \times D$   
Presiunea minimă recomandată a lichidului de răcire 30 bari (435 PSI) cu  $> 3 \times D$

#### Concentrația emulsiei

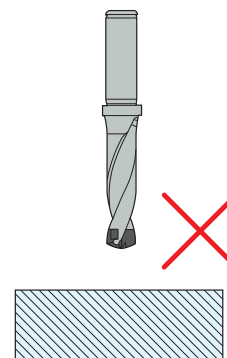
Amestec emulsie recomandat 6-8%. Când se găurește în oțel inox, superaliaje și oțeluri de înaltă rezistență se recomandă un amestec de 10%



Prima alegere



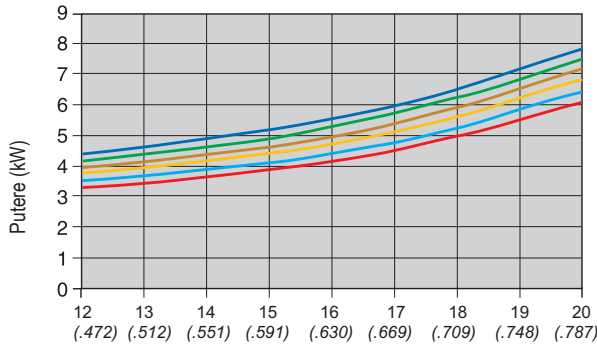
< 3 x D



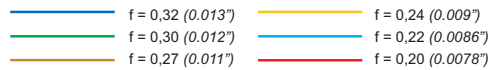
## Parametri de prelucrare

Valorile din grafic pot varia în funcție de ex. regimurile de aşchiere, materialul, eficiența mașinii și uzura sculei.  
Graficele de mai jos sunt valabile pentru Grupa de materiale Seco (SMG) P5-P6 și viteza de aşchiere de 90 m/min (295 SFM).

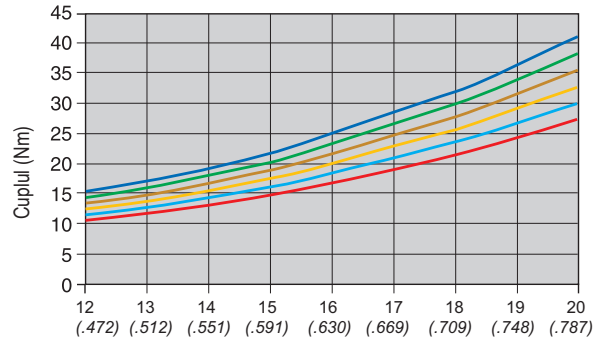
Consumul net de putere



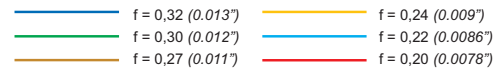
Diametru burghiu mm/(inci)



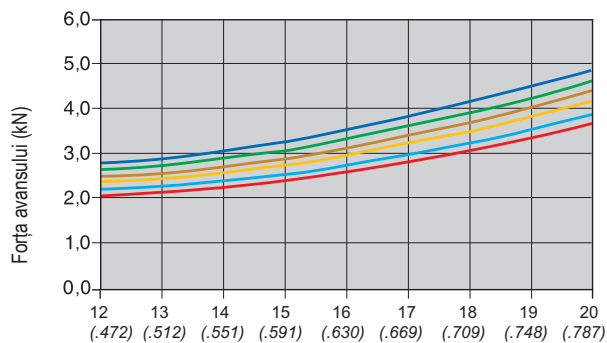
Cuplul la găurire



Diametru burghiu mm/(inci)



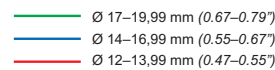
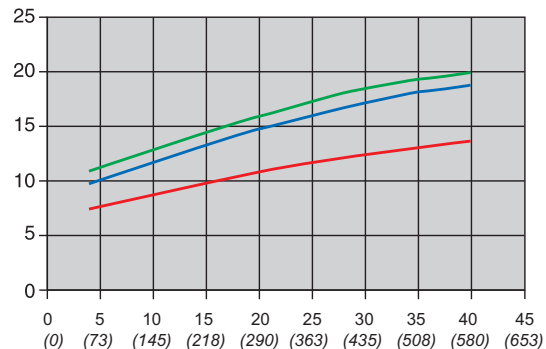
Forța avansului



Diametru burghiu mm/(inci)



Debitul lichidului de răcire la diferite presiuni



Debit de lichid de răcire recomandat Dx1 l/min  
Debit de lichid de răcire minim D/2 l/min  
D = diametrul burghiuului

Presiune minimă recomandată a lichidului de răcire 10 bari (145 PSI) cu  $\leq 3 \times D$   
Presiune minimă recomandată a lichidului de răcire 20 bari (290 PSI) cu  $\leq 5 \times D$   
Presiune minimă recomandată a lichidului de răcire 40 bari (580 PSI) cu  $> 5 \times D$

### Amestec de lichid de răcire

Amestec emulsie recomandat 6-8%.  
Când se găurește în oțel inox, superaliaje și oțeluri de înaltă rezistență se recomandă un amestec de 10%.

### Toleranța găurii/Finisarea suprafeței

SD403, SD405 și SD408 IT9-10 / R <sub>a</sub> 1-4*, Ra 39-157 μin*					
Burghiu Ø DC (mm)	Toleranța IT9 (μm)	Toleranța IT10 (μm)	Burghiu Ø DC (inci)	Toleranța IT9 (inci)	Toleranța IT10 (inci)
10-18	0 - +43	0 - +70	0 - +0.394-0.709	0 - +0.0017	0 - +0.0028
18-30	0 - +52	0 - +84	0 - +0.709-1.181	0 - +0.0020	0 - +0.0033

\*Deteriorarea finisării suprafeței și a toleranței găurii pot apărea când găuriți în oțel cu conținut redus de carbon sau în oțel inox. Utilizați cel mai scurt burghiu posibil pentru a obține o calitate maximă a găurii.

## Depanare - Condiții inițiale:

- Stabilitatea prinderii
- Starea arborelui mașinii
- Starea port-sculei
- Prinderea sculei:
  - Bătaie radială max. 0,06 TIR
- Îndepărtarea așchiilor:
  - regimuri de frezare
- Lichid de răcire:
  - Presiune
  - Debit
  - Concentrație

<p><b>Muchiile aşchiatoare sunt ciupite</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rot</li> <li>• Dacă burghiul vibrează, reduceți viteza de aşchiere și măriți avansul</li> <li>• La găurirea unor suprafețe dure și neregulate, reduceți avansul cu 30%-50% la intrare și la ieșire</li> </ul>	<p><b>Toleranța diametrului nesatisfăcătoare</b></p> <ul style="list-style-type: none"> <li>• Măriți avansul/rotația</li> <li>• Utilizați un burghiu din carbură solidă Seco Feedmax, consultați paginile 15-18</li> <li>• Utilizați o operație de alezare, consultați paginile 328</li> <li>• Utilizați o operație de alezare adâncă, consultați paginile 492-493</li> </ul>
<p><b>Uzură rapidă a flancurilor</b></p> <ul style="list-style-type: none"> <li>• Verifică dacă se utilizează geometria corectă</li> <li>• Reduceți viteza de aşchiere</li> </ul>	<p><b>Finisare slabă a suprafeței</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotație</li> <li>• Măriți viteza de aşchiere</li> <li>• Verificați dacă se utilizează geometria corectă</li> <li>• Utilizați un burghiu din carbură solidă Feedmax, consultați paginile 15-18</li> <li>• Utilizați o operație de alezare, consultați paginile 328</li> </ul>
<p><b>Uzura canelurii</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rot</li> <li>• Reduceți viteza de aşchiere</li> <li>• Măriți concentrația lichidului de răcire</li> </ul>	<p><b>Poziționarea găurii nesatisfăcătoare</b></p> <ul style="list-style-type: none"> <li>• Reduceți avansul/rotație</li> <li>• La găurirea prin suprafețe neregulate, tari și înclinate – reduceți avansul cu 30-50% la intrare și la ieșire</li> <li>• Pregăurire cu un burghiu cu unghi la vârf de 140°</li> <li>• Utilizați un burghiu din carbură solidă Feedmax, consultați paginile despre Feedmax 15-18</li> <li>• Utilizați o operație de alezare adâncă, consultați paginile 492-493</li> </ul>
<p><b>Uzură a marginilor laterale periferice</b></p> <ul style="list-style-type: none"> <li>• Verificați dacă se utilizează geometria corectă</li> <li>• Reduceți viteza de aşchiere</li> <li>• Măriți concentrația lichidului de răcire</li> <li>• La găurirea prin suprafețe neregulate, tari sau înclinate, reduceți rata de avans cu 30-50% la intrare și la ieșire</li> </ul>	<p><b>Probleme cu blocarea așchiilor din cauza așchiilor lungi</b></p> <ul style="list-style-type: none"> <li>• Măriți avansul</li> <li>• La materiale care produc așchii lungi SMG P1-P4, SMG M1-M2:                     <ul style="list-style-type: none"> <li>- Măriți viteza de aşchiere și reduceți avansul/rotație</li> <li>- Utilizați geometria L</li> </ul> </li> </ul>



## Perfomax®



Perfomax® este o gamă de tradiție, dovedită de burghie cu plăcuțe amovibile care oferă o soluție economică atunci când vine vorba de găurirea productivă a găurilor.

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

## Prezentare generală

Perfomax®	Ø Gamă	Adâncimea de găuire	Toleranța Ø burghiului	Toleranța găurii
<p><b>SD522</b></p>  <p>Pag. 242, 243, 244-242, 243, 244</p>	<p>15-59 mm (0.594-2.375")</p>	~ 2 x D	<p>+/- 0,1 mm (+/- 0.004")</p>	<p>+0/+ 0,2 mm (+ 0/+ 0.008")</p>
<p><b>SD523</b></p>  <p>Pag. 245, 246, 247, 248-261, 262, 263</p>	<p>15-59 mm (0.594-2.375")</p>	~ 3 x D	<p>+/- 0,1 mm (+/- 0.004")</p>	<p>+0/+ 0,3 mm (+ 0/+ 0.012")</p>
<p><b>SD524</b></p>  <p>Pag. 264, 265, 266-276, 277</p>	<p>17-59 mm (0.594-2.375")</p>	~ 4 x D	<p>+/- 0,1 mm (+/- 0.004")</p>	<p>+ 0,4 mm (+ 0/+ 0.016")</p>
<p><b>SD525</b></p>  <p>Pag. 278, 279-280</p>	<p>19-45 mm (0,750-2.000")</p>	~ 5 x D	<p>+/- 0,1 mm (+/- 0.004")</p>	<p>+0/+ 0,5 mm (+ 0/+ 0.020")</p>
<p><b>SD542</b></p>  <p>Pag. 281-282</p>	<p>60-85 mm (2.250-3.500")</p>	~ 2,5 x D	<p>+/- 0,1 mm (+/- 0.004")</p>	<p>+0/+ 0,2 mm (+ 0/+ 0.008")</p>

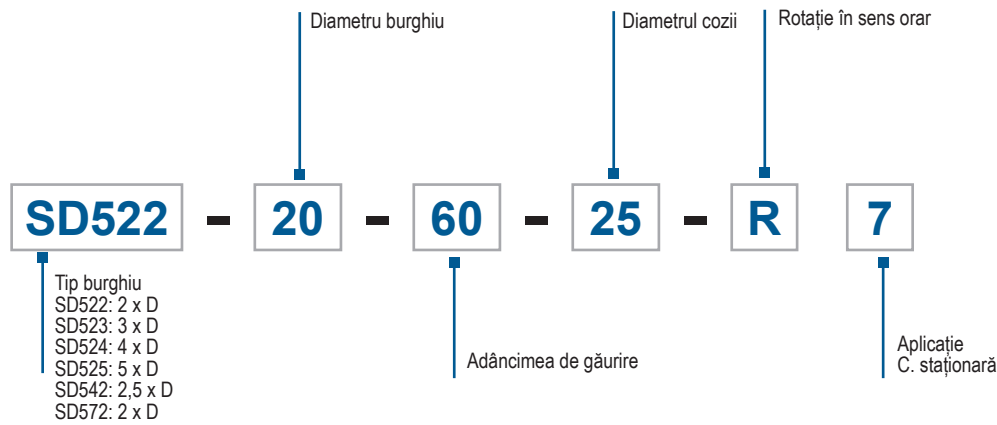
## Prezentare generală

Perfomax®	Ø Gamă	Adâncimea de găurire	Toleranța Ø burghiului	Toleranța găurii
<p><b>SD572</b></p>  <p>Pag. 283, 284-283, 284</p>	<p>15-47 mm (0.591"-1.850")</p>	<p>~ 2 x D</p>	<p>+/- 0,1 mm (+/- 0.004")</p>	<p>+0/+ 0,2 mm (+ 0/+ 0.008")</p>
<p><b>SD602</b></p>  <p>Pag. 287-291</p>	<p>60-160 mm (2.5"-4.000")</p>	<p>~ 1-10 x D</p>	<p>+/- 0,2 mm (+/- 0.008")</p>	<p>-</p>

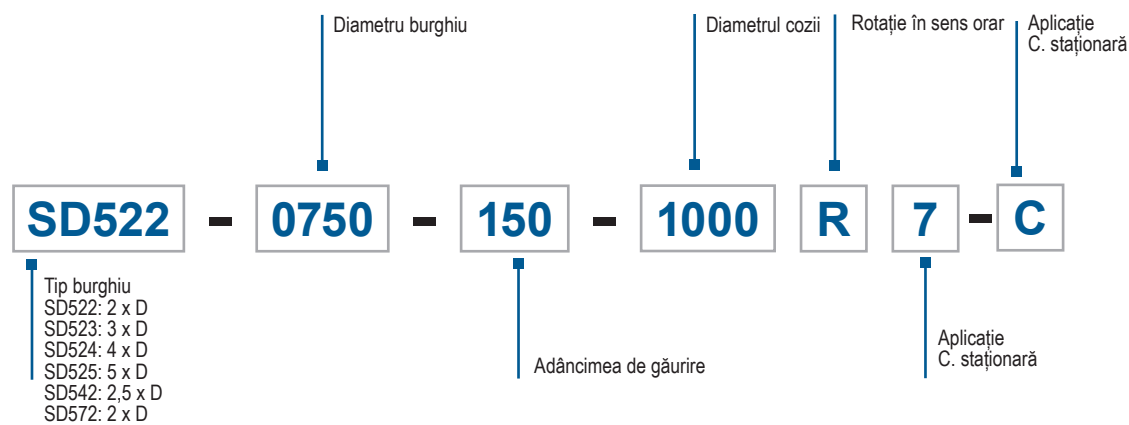


## Codificare – burghiu cu plăcuțe amovibile

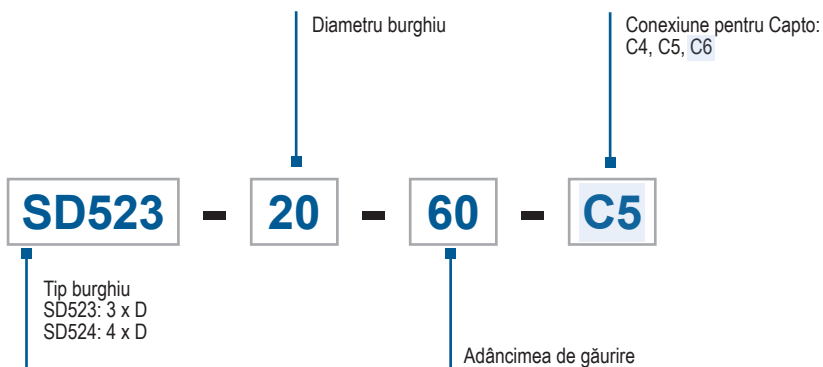
### Metric



### Inci



### Capto™



## Cozi prindere

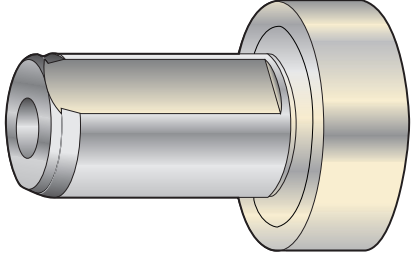
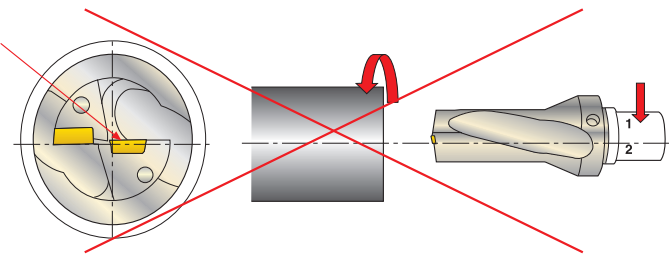
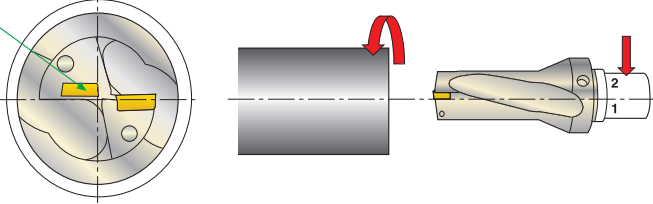
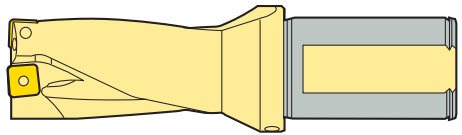
Introducere

Găurire

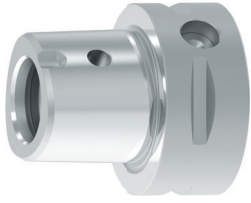
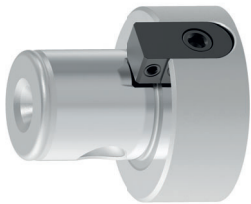

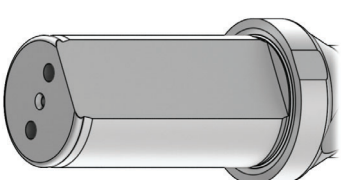
Alezare

Alezare adâncă

Anexă

Cozi prindere	
<p>-R7</p> 	<p><b>ISO 9766</b> Opțiunea Universal se potrivește în majoritatea port-sculelor de pe piață, cum ar fi:</p> <ul style="list-style-type: none"> <li>• Weldon 1835B</li> <li>• ISO 5414</li> <li>• DIN 69880</li> </ul> <p>Cu răcire interioară și la partea din spate a burghiului.</p>
<p>R7 și R7-C</p> 	<p><b>Cozi cu două sau patru aplazări</b> Muchia așchietoare a plăcuței centrale deasupra axei centrale a piesei de prelucrat.</p> <p><b>Pentru aplicații statice:</b></p> <ul style="list-style-type: none"> <li>• Este adăugată o aplatare suplimentară la coadă pentru mărirea stabilității la aplicațiile pe strung.</li> <li>• În cazul acestor aplicații axa centrală a piesei de prelucrat trebuie aliniată cu axa centrală a burghiului.</li> <li>• În caz contrar, plăcuța centrală ar putea fi poziționată deasupra axei centrale a piesei de prelucrat, ceea ce va duce la performanțe slabe ale burghiului.</li> </ul>
 <p>Prin rotirea burghiului cu 180 grade, a doua aplatare oferă posibilitatea de a compensa această nealiniere printr-o metodă rapidă și simplă.</p>	<p><b>Cozi cu patru aplazări</b> Muchia așchietoare a plăcuței centrale deasupra axei centrale a piesei de prelucrat.</p>
	<p><b>NOTĂ!</b></p> <ul style="list-style-type: none"> <li>• Dacă un burghiu cu coadă -7 este utilizat într-o aplicație rotativă împreună cu port-scula noastră reglabilă, trebuie utilizată aplatarea de pe aceeași parte cu plăcuța centrală.</li> <li>• În caz contrar diametrul găurii va fi poziționat greșit.</li> </ul>

## Cozi prindere

Seco Capto	
	<p><b>Seco-Capto C4, C5, C6</b></p> <ul style="list-style-type: none"> <li>• Flexibilitate - Aceeași port-sculă poate fi utilizată la diferite mașini.</li> <li>• Modular – Posibilitatea de a alcătui scule cu ajutorul adaptoarelor de extensie.</li> <li>• Transmiterea cuplului maxim - Cuplul este distribuit simetric.</li> <li>• Rigiditate mare - Prinderile strânse garantează lipsa jocului în cuplaj.</li> <li>• Acuratețe - Cupla conico-polygonală asigură o articulație auto-centrată în plaja a 2 microni.</li> </ul>
Graflex	
	<p><b>- G</b></p> <ul style="list-style-type: none"> <li>• Se fixează direct în port-sculele Graflex și se blochează cu două șuruburi de blocare cu cap sferic poziționate la 120°.</li> <li>• Ansambluri modulare care oferă rigiditate și bătaie radială bună.</li> <li>• Conectare cilindrică/frontală – precizie excelentă.</li> <li>• Asamblare/dezasamblare rapidă și ușoară a modulelor, pentru flexibilitate ridicată.</li> <li>• Cu răcire interioară și la partea din spate a burghiului.</li> </ul>
ABS 50(compatibil)	
	<p><b>- 2</b></p> <ul style="list-style-type: none"> <li>• O coadă compatibilă ABS 50.</li> <li>• Se fixează direct în port-scula ABS 50 cu un șurub de blocare.</li> <li>• Cu răcire interioară și la partea din spate a burghiului.</li> </ul>
VDI 30 și VDI 40 (compatibil)	
	<p><b>- 8</b></p> <ul style="list-style-type: none"> <li>• Coadă compatibilă VDI.</li> <li>• Se fixează direct în port-sculă pentru: <ul style="list-style-type: none"> <li>– VDI 3425 bl.2</li> <li>– DIN 69880</li> </ul> </li> </ul> <p><b>NOTĂ!</b> Garnitura pentru lichidul de răcire trebuie comandată separat.</p>

## Cozi – garnitură de lichid de răcire

Adâncimea de găurire	VDI 30		Accesorii Inel lichid răcire
	mm	inci	



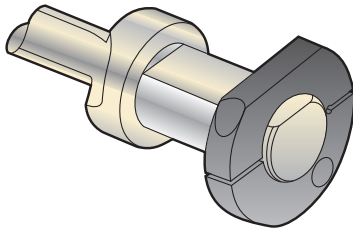
2 x D	15-31	0,591-1,220	SDA5-30R8
3 x D	15-31	0,591-1,220	SDA5-30R8
4 x D	17-31	0,669-1,220	SDA5-30R8
5 x D	19-31	0,748-1,220	SDA5-30R8

Adâncimea de găurire	VDI 40		Dop	Șurub de blocare	Accesorii Inel lichid răcire
	mm	inci			

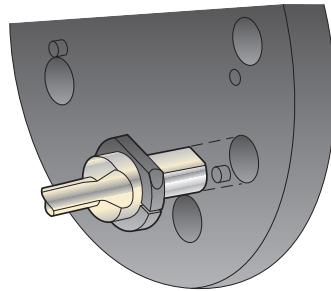


2 x D	15-31	0,591-1,220			SDA5-40R8
3 x D	15-31	0,591-1,220			SDA5-40R8
4 x D	17-31	0,669-1,220			SDA5-40R8
5 x D	19-31	0,748-1,220			SDA5-40R8
2 x D	41-59	1,614-2,323	R1/4"	P6SS8x8	SDA5-40R8
3 x D	41-59	1,614-2,323	R1/4"	P6SS8x8	SDA5-40R8

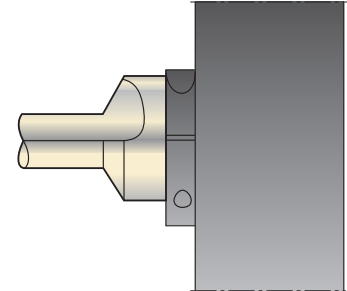
1. Potrivii garnitura în jurul burghiului dar nu strângeți șurubul de blocare.



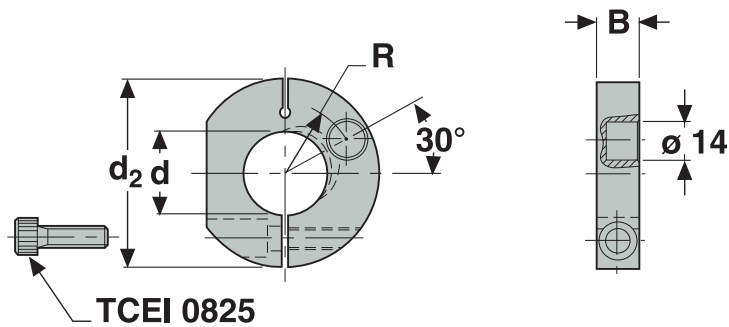
2. Blocați burghiul în pensetă.



3. Strângeți șurubul de blocare în inel lichidului de răcire.

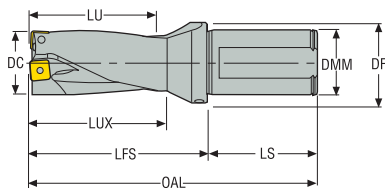


### Inel lichid răcire



SD522

Adâncimea de găuire ~ 2 x D – Metric



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 304, 305
- Pentru diametre intermediare vezi programul MyDesign.

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

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Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică	mm - Inci -
SD522-22-44-25R7	03080777	22,0 0.866	44,0 1.732	130,0 5.118	49,0 1.929	74,0 2.913	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX060204	0,44 0.017	0,46 0.018
SD522-23-46-25R7	03080781	23,0 0.906	46,0 1.811	132,0 5.197	51,0 2.008	76,0 2.992	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,33 0.013	0,5 0.020
SD522-23.5-47-25R7	03192517	23,5 0.925	47,0 1.850	133,0 5.236	52,0 2.047	77,0 3.031	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,23 0.009	0,5 0.020
SD522-24-48-25R7	03080785	24,0 0.945	48,0 1.890	134,0 5.276	53,0 2.087	78,0 3.071	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,11 0.004	0,5 0.020
SD522-25-50-32R7	03080788	25,0 0.984	50,0 1.969	140,0 5.512	55,0 2.165	80,0 3.150	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0703	SCGX070308	0,11 0.004	0,5 0.020
SD522-26-52-32R7	03080790	26,0 1.024	52,0 2.047	142,0 5.591	57,0 2.244	82,0 3.228	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,5 0.020	0,11 0.004
SD522-27-54-32R7	03080792	27,0 1.063	54,0 2.126	144,0 5.669	59,0 2.323	84,0 3.307	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,5 0.020	0,26 0.010
SD522-28-56-32R7	03080795	28,0 1.102	56,0 2.205	146,0 5.748	61,0 2.402	86,0 3.386	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,28 0.011	0,5 0.020
SD522-29-58-32R7	03080796	29,0 1.142	58,0 2.283	148,0 5.827	63,0 2.480	88,0 3.465	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,18 0.007	0,5 0.020
SD522-30-60-32R7	03080798	30,0 1.181	60,0 2.362	150,0 5.906	65,0 2.559	90,0 3.543	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,12 0.005	0,5 0.020
SD522-31-62-32R7	03080801	31,0 1.220	62,0 2.441	152,0 5.984	67,0 2.638	92,0 3.622	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,12 0.005	0,5 0.020
SD522-32-64-32R7	03080802	32,0 1.260	64,0 2.520	154,0 6.063	69,0 2.717	94,0 3.701	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,5 0.020	0,31 0.012
SD522-32-64-40R7	03080803	32,0 1.260	64,0 2.520	162,0 6.378	69,0 2.717	94,0 3.701	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX09T308	0,5 0.020	0,31 0.012
SD522-33-66-32R7	03080805	33,0 1.299	66,0 2.598	156,0 6.142	71,0 2.795	96,0 3.780	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,5 0.020	0,46 0.018
SD522-33-66-40R7	03080806	33,0 1.299	66,0 2.598	164,0 6.457	71,0 2.795	96,0 3.780	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX09T308	0,5 0.020	0,46 0.018
SD522-34-68-32R7	03080808	34,0 1.339	68,0 2.677	158,0 6.220	73,0 2.874	98,0 3.858	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,22 0.009	0,5 0.020
SD522-34-68-40R7	03080809	34,0 1.339	68,0 2.677	166,0 6.535	73,0 2.874	98,0 3.858	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX09T308	0,22 0.009	0,5 0.020
SD522-35-70-32R7	03080810	35,0 1.378	70,0 2.756	160,0 6.299	75,0 2.953	100,0 3.937	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX11T308	0,22 0.009	0,5 0.020
SD522-35-70-40R7	03080811	35,0 1.378	70,0 2.756	168,0 6.614	75,0 2.953	100,0 3.937	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,22 0.009	0,5 0.020
SD522-36-72-32R7	03080813	36,0 1.417	72,0 2.835	162,0 6.378	77,0 3.031	102,0 4.016	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD522-36-72-40R7	03080814	36,0 1.417	72,0 2.835	170,0 6.693	77,0 3.031	102,0 4.016	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD522-37-74-32R7	03080816	37,0 1.457	74,0 2.913	164,0 6.457	79,0 3.110	104,0 4.094	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD522-37-74-40R7	03080817	37,0 1.457	74,0 2.913	172,0 6.772	79,0 3.110	104,0 4.094	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD522-38-76-32R7	03080818	38,0 1.496	76,0 2.992	166,0 6.535	81,0 3.189	106,0 4.173	60,0 2.362	32,0 1.260	42,0 1.654	SPGX12T3	SCGX11T308	0,5 0.020	0,5 0.020
SD522-38-76-40R7	03080819	38,0 1.496	76,0 2.992	174,0 6.850	81,0 3.189	106,0 4.173	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX11T308	0,5 0.020	0,5 0.020
SD522-39-78-32R7	03080821	39,0 1.535	78,0 3.071	168,0 6.614	83,0 3.268	108,0 4.252	60,0 2.362	32,0 1.260	42,0 1.654	SPGX12T3	SCGX11T308	0,39 0.015	0,5 0.020
SD522-39-78-40R7	03080822	39,0 1.535	78,0 3.071	176,0 6.929	83,0 3.268	108,0 4.252	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX11T308	0,39 0.015	0,5 0.020
SD522-40-80-32R7	03080823	40,0 1.575	80,0 3.150	170,0 6.693	85,0 3.346	110,0 4.331	60,0 2.362	32,0 1.260	50,0 1.969	SPGX12T3	SCGX11T308	0,19 0.007	0,5 0.020
SD522-40-80-40R7	03080824	40,0 1.575	80,0 3.150	178,0 7.008	85,0 3.346	110,0 4.331	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX11T308	0,19 0.007	0,5 0.020
SD522-41-82-40R7	03080826	41,0 1.614	82,0 3.228	180,0 7.087	87,0 3.425	112,0 4.409	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408	0,19 0.007	0,5 0.020
SD522-42-84-40R7	03080828	42,0 1.654	84,0 3.307	182,0 7.165	89,0 3.504	114,0 4.488	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408	0,19 0.007	0,5 0.020

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

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
			
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

Accesorii

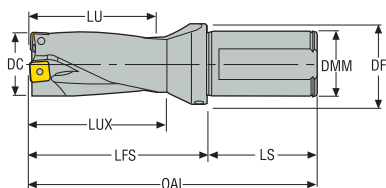
Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	 T00-07P09	 T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama



# SD522



Adâncimea de găurire ~ 2 x D – inci






- Coadă ISO 9766, R7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 304, 305
- Pentru diametre intermediare vezi programul MyDesign.

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plcuța centrală	Plăcuța periferică	Inci -	Inci +
SD522-0594-119-1000R7	03080704	0.594	1.190	4.621	1.387	2.371	2.250	1.000	1.378	SPGX0502	SCGX050204	0.008	0.013
SD522-0625-125-1000R7	03080705	0.625	1.250	4.681	1.447	2.431	2.250	1.000	1.378	SPGX0502	SCGX050204	0.005	0.015
SD522-0656-131-1000R7	03080707	0.656	1.310	4.741	1.507	2.491	2.250	1.000	1.378	SPGX0502	SCGX050204	0.002	0.019
SD522-0687-137-1000R7	03080709	0.687	1.370	4.801	1.567	2.551	2.250	1.000	1.378	SPGX0502	SCGX050204	0	0.020
SD522-0709-142-1000R7	03080710	0.709	1.420	4.851	1.617	2.601	2.250	1.000	1.378	SPGX0602	SCGX050204	0.013	0.008
SD522-0750-150-1000R7	03080712	0.750	1.500	4.931	1.697	2.681	2.250	1.000	1.378	SPGX0602	SCGX050204	0.004	0.017
SD522-0766-153-1000R7	03080713	0.766	1.530	4.961	1.727	2.711	2.250	1.000	1.378	SPGX0602	SCGX050204	0.001	0.020
SD522-0787-157-1000R7	03080714	0.787	1.570	5.001	1.767	2.751	2.250	1.000	1.378	SPGX0602	SCGX060204	0.003	0.018
SD522-0812-162-1000R7	03080715	0.812	1.620	5.051	1.817	2.801	2.250	1.000	1.378	SPGX0602	SCGX060204	0.001	0.020
SD522-0827-165-1000R7	03080717	0.827	1.650	5.081	1.847	2.831	2.250	1.000	1.378	SPGX0602	SCGX060204	0	0.020
SD522-0875-175-1000R7	03080718	0.875	1.750	5.181	1.947	2.931	2.250	1.000	1.378	SPGX0703	SCGX060204	0.015	0.020
SD522-0906-181-1000R7	03080720	0.906	1.810	5.241	2.007	2.991	2.250	1.000	1.378	SPGX0703	SCGX070308	0.013	0.020
SD522-0922-184-1000R7	03080721	0.922	1.840	5.271	2.037	3.021	2.250	1.000	1.378	SPGX0703	SCGX070308	0.010	0.020
SD522-0937-187-1000R7	03080722	0.937	1.870	5.301	2.067	3.051	2.250	1.000	1.378	SPGX0703	SCGX070308	0.004	0.020
SD522-0984-197-1250R7	03080724	0.984	1.970	5.526	2.167	3.151	2.375	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD522-1000-200-1250R7	03080725	1.000	2.000	5.556	2.197	3.181	2.375	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD522-1032-206-1250R7	03080727	1.032	2.060	5.616	2.257	3.241	2.375	1.250	1.654	SPGX0903	SCGX070308	0.020	0.004
SD522-1062-212-1250R7	03080728	1.062	2.120	5.676	2.317	3.301	2.375	1.250	1.654	SPGX0903	SCGX070308	0.020	0.010
SD522-1125-225-1250R7	03080730	1.125	2.250	5.806	2.447	3.431	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.008	0.020
SD522-1187-237-1250R7	03080732	1.187	2.370	5.926	2.567	3.551	2.375	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD522-1250-250-1500R7	03080735	1.250	2.500	6.306	2.697	3.681	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.011
SD522-1312-262-1500R7	03080736	1.312	2.620	6.426	2.817	3.801	2.625	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.020
SD522-1375-275-1500R7	03080737	1.375	2.750	6.556	2.947	3.931	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.009	0.020
SD522-1437-287-1500R7	03080739	1.437	2.870	6.676	3.067	4.051	2.625	1.500	1.969	SPGX11T3	SCGX11T308	0.004	0.020
SD522-1500-300-1500R7	03080743	1.500	3.000	6.806	3.197	4.181	2.625	1.500	1.969	SPGX12T3	SCGX11T308	0.020	0.020
SD522-1625-325-1500R7	03080748	1.625	3.250	7.056	3.447	4.431	2.625	1.500	1.969	SPGX12T3	SCGX120408	0.007	0.020
SD522-1750-350-1500R7	03080756	1.750	3.500	7.306	3.697	4.681	2.625	1.500	1.969	SPGX1504	SCGX120408	0.020	0.016
SD522-1875-375-1500R7	03080763	1.875	3.750	7.556	3.947	4.931	2.625	1.500	1.969	SPGX1504	SCGX150512	0.020	0.020
SD522-2000-400-1500R7	03080769	2.000	4.000	7.806	4.197	5.181	2.625	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD522-2125-425-1500R7	03080773	2.125	4.250	8.056	4.447	5.431	2.625	1.500	2.337	SPGX1904	SCGX150512	0.020	0.020
SD522-2250-450-1500R7	03080779	2.250	4.500	8.306	4.697	5.681	2.625	1.500	2.337	SPGX1904	SCGX150512	0.013	0.020
SD522-2375-475-1500R7	03080783	2.375	4.750	8.556	4.947	5.931	2.625	1.500	2.480	SPGX1904	SCGX150512	0.004	0.020

Piese de schimb

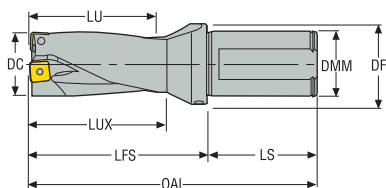
Pentru burghiu dia (inch)	Șurubul plăcuței		Cheie plăcuță
			
	Plăcuța centrală	Plăcuța periferică	
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787	C02205-T07P	C02205-T07P	T07P-2
0.812-0.827	C02205-T07P	C02205-T07P	T07P-2
0.875	C02506-T08P	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.062	C03007-T09P	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D
1.625	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

Accesorii

Pentru burghiu dia (inch)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
0.594-0.687	T00-07P09	T00-07P	8 in/lbs
0.709-0.766	T00-07P09	T00-07P	8 in/lbs
0.787	T00-07P09	T00-07P	8 in/lbs
0.812-0.827	T00-07P09	T00-07P	8 in/lbs
0.875	T00-08P12	T00-08P	10.6 in/lbs
0.906-1.000	T00-08P12	T00-08P	10.6 in/lbs
1.032-1.062	T00-09P20	T00-09P	17.7 in/lbs
1.125-1.187	T00-09P20	T00-09P	17.7 in/lbs
1.250-1.500	T00-15P30	T00-15P	26.6 in/lbs
1.625	T00-15P30	T00-15P	26.6 in/lbs
1.750-2.375	T00-15P30	T00-15P	26.6 in/lbs

# SD522

Adâncimea de găurire ~ 2 x D – inci



- Coadă ISO 9766, R7-C
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 304-305
- Pentru diametre intermediare vezi programul MyDesign.
- For stationary applications

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plăcuța centrală	Plăcuța periferică	Inci -
SD522-0625-125-1000R7-C	03080706	0.625	1.250	5.378	1.447	2.628	2.750	1.000	1.378	SPGX0502	SCGX050204	0.005	0.015
SD522-0687-137-1000R7-C	03080708	0.687	1.370	5.498	1.567	2.748	2.750	1.000	1.378	SPGX0502	SCGX050204	0	0.020
SD522-0750-150-1000R7-C	03080711	0.750	1.500	5.628	1.697	2.878	2.750	1.000	1.378	SPGX0602	SCGX050204	0.004	0.017
SD522-0812-162-1000R7-C	03080716	0.812	1.620	5.748	1.817	2.998	2.750	1.000	1.378	SPGX0602	SCGX060204	0.001	0.020
SD522-0875-175-1000R7-C	03080719	0.875	1.750	5.878	1.947	3.128	2.750	1.000	1.378	SPGX0703	SCGX060204	0.015	0.020
SD522-0937-187-1000R7-C	03080723	0.937	1.870	5.998	2.067	3.248	2.750	1.000	1.378	SPGX0703	SCGX070308	0.004	0.020
SD522-1000-200-1250R7-C	03080726	1.000	2.000	6.128	2.197	3.378	2.750	1.250	1.654	SPGX0703	SCGX070308	0.004	0.020
SD522-1062-212-1250R7-C	03080729	1.062	2.120	6.248	2.317	3.498	2.750	1.250	1.654	SPGX0903	SCGX070308	0.020	0.010
SD522-1125-225-1250R7-C	03080731	1.125	2.250	6.378	2.447	3.628	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.008	0.020
SD522-1187-237-1250R7-C	03080733	1.187	2.370	6.498	2.567	3.748	2.750	1.250	1.654	SPGX0903	SCGX09T308	0.005	0.020
SD522-1250-250-1500R7-C	03080734	1.250	2.500	6.628	2.697	3.878	2.750	1.500	1.969	SPGX11T3	SCGX09T308	0.020	0.011
SD522-1375-275-1500R7-C	03080738	1.375	2.750	6.878	2.947	4.128	2.750	1.500	1.969	SPGX11T3	SCGX11T308	0.009	0.020
SD522-1500-300-1500R7-C	03080742	1.500	3.000	7.128	3.197	4.378	2.750	1.500	1.969	SPGX12T3	SCGX11T308	0.020	0.020
SD522-1750-350-1500R7-C	03080757	1.750	3.500	7.628	3.697	4.878	2.750	1.500	1.969	SPGX1504	SCGX120408	0.020	0.016
SD522-2000-400-1500R7-C	03080770	2.000	4.000	8.128	4.197	5.378	2.750	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD522-2125-425-1500R7-C	03080774	2.125	4.250	8.378	4.447	5.628	2.750	1.500	2.337	SPGX1904	SCGX150512	0.020	0.020
SD522-2250-450-1500R7-C	03080780	2.250	4.500	8.628	4.697	5.878	2.750	1.500	2.337	SPGX1904	SCGX150512	0.013	0.020
SD522-2375-475-1500R7-C	03080784	2.375	4.750	8.878	4.947	6.128	2.750	1.500	2.480	SPGX1904	SCGX150512	0.004	0.020

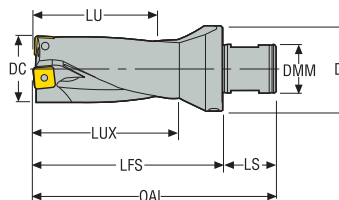
## Piese de schimb

## Accesorii

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

## SD522

Adâncimea de găurire ~ 2 x D – Metric





- O coadă compatibilă ABS 50, R2
- Răcire interioară
- Pentru informații depre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 304, 305
- Pentru diametre intermediare vezi programul MyDesign.

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

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

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
			
	Plăcuța centrală	Plăcuța periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

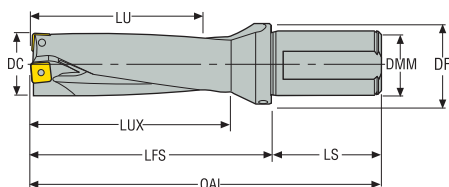
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

# SD523

Adâncimea de găurire ~ 3 x D – Metric



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.

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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică	mm - Inci -
SD523-20.5-62-25R7	03080586	20,5 0.807	62,0 2.441	148,0 5.827	67,0 2.638	92,0 3.622	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0602	SCGX060204	0,04 0.002	0,49 0.019
SD523-21-63-25R7	03080599	21,0 0.827	63,0 2.480	149,0 5.866	68,0 2.677	93,0 3.661	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0602	SCGX060204	0,01 0	0,5 0.020
SD523-21.5-65-25R7	03080595	21,5 0.846	65,0 2.559	151,0 5.945	70,0 2.756	95,0 3.740	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX060204	0,5 0.020	0,36 0.014
SD523-22-66-25R7	03080605	22,0 0.866	66,0 2.598	152,0 5.984	71,0 2.795	96,0 3.780	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX060204	0,44 0.017	0,46 0.018
SD523-22.5-68-25R7	03080602	22,5 0.886	68,0 2.677	154,0 6.063	73,0 2.874	98,0 3.858	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,42 0.017	0,47 0.019
SD523-23-69-25R7	03080608	23,0 0.906	69,0 2.717	155,0 6.102	74,0 2.913	99,0 3.898	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,33 0.013	0,5 0.020
SD523-23.5-71-25R7	03080607	23,5 0.925	71,0 2.795	157,0 6.181	76,0 2.992	101,0 3.976	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,23 0.009	0,5 0.020
SD523-24-72-25R7	03080612	24,0 0.945	72,0 2.835	158,0 6.220	77,0 3.031	102,0 4.016	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,11 0.004	0,5 0.020
SD523-24.5-74-25R7	03080611	24,5 0.965	74,0 2.913	160,0 6.299	79,0 3.110	104,0 4.094	56,0 2.205	25,0 0.984	35,0 1.378	SPGX0703	SCGX070308	0,11 0.004	0,5 0.020
SD523-25-75-32R7	03080616	25,0 0.984	75,0 2.953	165,0 6.496	80,0 3.150	105,0 4.134	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0703	SCGX070308	0,11 0.004	0,5 0.020
SD523-25.5-77-32R7	03080615	25,5 1.004	77,0 3.031	167,0 6.575	82,0 3.228	107,0 4.213	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,5 0.020	0,11 0.004
SD523-26-78-32R7	03080619	26,0 1.024	78,0 3.071	168,0 6.614	83,0 3.268	108,0 4.252	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,5 0.020	0,11 0.004
SD523-26.5-80-32R7	03080618	26,5 1.043	80,0 3.150	170,0 6.693	85,0 3.346	110,0 4.331	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,5 0.020	0,19 0.007
SD523-27-81-32R7	03080622	27,0 1.063	81,0 3.189	171,0 6.732	86,0 3.386	111,0 4.370	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,5 0.020	0,26 0.010
SD523-27.5-83-32R7	03080621	27,5 1.083	83,0 3.268	173,0 6.811	88,0 3.465	113,0 4.449	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,46 0.018	0,44 0.017
SD523-28-84-32R7	03080626	28,0 1.102	84,0 3.307	174,0 6.850	89,0 3.504	114,0 4.488	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX070308	0,28 0.011	0,5 0.020
SD523-28.5-86-32R7	03080624	28,5 1.122	86,0 3.386	176,0 6.929	91,0 3.583	116,0 4.567	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,21 0.008	0,5 0.020
SD523-29-87-32R7	03080629	29,0 1.142	87,0 3.425	177,0 6.969	92,0 3.622	117,0 4.606	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,18 0.007	0,5 0.020
SD523-29.5-89-32R7	03080628	29,5 1.161	89,0 3.504	179,0 7.047	94,0 3.701	119,0 4.685	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,15 0.006	0,5 0.020
SD523-30-90-32R7	03080632	30,0 1.181	90,0 3.543	180,0 7.087	95,0 3.740	120,0 4.724	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,12 0.005	0,5 0.020
SD523-30.5-92-32R7	03080631	30,5 1.201	92,0 3.622	182,0 7.165	97,0 3.819	122,0 4.803	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,12 0.005	0,5 0.020
SD523-31-93-32R7	03080636	31,0 1.220	93,0 3.661	183,0 7.205	98,0 3.858	123,0 4.843	60,0 2.362	32,0 1.260	42,0 1.654	SPGX0903	SCGX09T308	0,12 0.005	0,5 0.020
SD523-31.5-95-32R7	03080634	31,5 1.240	95,0 3.740	185,0 7.283	100,0 3.937	125,0 4.921	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,5 0.020	0,24 0.009
SD523-32-96-32R7	03080638	32,0 1.260	96,0 3.780	186,0 7.323	101,0 3.976	126,0 4.961	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,5 0.020	0,31 0.012
SD523-32-96-40R7	03080639	32,0 1.260	96,0 3.780	194,0 7.638	101,0 3.976	126,0 4.961	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX09T308	0,5 0.020	0,31 0.012
SD523-33-99-32R7	03080641	33,0 1.299	99,0 3.898	189,0 7.441	104,0 4.094	129,0 5.079	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,5 0.020	0,46 0.018
SD523-33-99-40R7	03080642	33,0 1.299	99,0 3.898	197,0 7.756	104,0 4.094	129,0 5.079	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX09T308	0,5 0.020	0,46 0.018
SD523-34-102-32R7	03080644	34,0 1.339	102,0 4.016	192,0 7.559	107,0 4.213	132,0 5.197	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX09T308	0,22 0.009	0,5 0.020
SD523-34-102-40R7	03080645	34,0 1.339	102,0 4.016	200,0 7.874	107,0 4.213	132,0 5.197	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX09T308	0,22 0.009	0,5 0.020
SD523-35-105-32R7	03080648	35,0 1.378	105,0 4.134	195,0 7.677	110,0 4.331	135,0 5.315	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX11T308	0,22 0.009	0,5 0.020
SD523-35-105-40R7	03080649	35,0 1.378	105,0 4.134	203,0 7.992	110,0 4.331	135,0 5.315	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,22 0.009	0,5 0.020



Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică	mm - Inci -
SD523-35.5-107-40R7	03080647	35,5 1.398	107,0 4.213	205,0 8.071	112,0 4.409	137,0 5.394	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD523-36-108-32R7	03080651	36,0 1.417	108,0 4.252	198,0 7.795	113,0 4.449	138,0 5.433	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD523-36-108-40R7	03080652	36,0 1.417	108,0 4.252	206,0 8.110	113,0 4.449	138,0 5.433	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD523-37-111-32R7	03080653	37,0 1.457	111,0 4.370	201,0 7.913	116,0 4.567	141,0 5.551	60,0 2.362	32,0 1.260	42,0 1.654	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD523-37-111-40R7	03080654	37,0 1.457	111,0 4.370	209,0 8.228	116,0 4.567	141,0 5.551	68,0 2.677	40,0 1.575	50,0 1.969	SPGX11T3	SCGX11T308	0,09 0.004	0,5 0.020
SD523-38-114-32R7	03080655	38,0 1.496	114,0 4.488	204,0 8.031	119,0 4.685	144,0 5.669	60,0 2.362	32,0 1.260	42,0 1.654	SPGX12T3	SCGX11T308	0,5 0.020	0,5 0.020
SD523-38-114-40R7	03080656	38,0 1.496	114,0 4.488	212,0 8.346	119,0 4.685	144,0 5.669	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX11T308	0,5 0.020	0,5 0.020
SD523-39-117-32R7	03080658	39,0 1.535	117,0 4.606	207,0 8.150	122,0 4.803	147,0 5.787	60,0 2.362	32,0 1.260	42,0 1.654	SPGX12T3	SCGX11T308	0,39 0.015	0,5 0.020
SD523-39-117-40R7	03080659	39,0 1.535	117,0 4.606	215,0 8.465	122,0 4.803	147,0 5.787	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX11T308	0,39 0.015	0,5 0.020
SD523-40-120-32R7	03080661	40,0 1.575	120,0 4.724	210,0 8.268	125,0 4.921	150,0 5.906	60,0 2.362	32,0 1.260	50,0 1.969	SPGX12T3	SCGX11T308	0,19 0.007	0,5 0.020
SD523-40-120-40R7	03080662	40,0 1.575	120,0 4.724	218,0 8.583	125,0 4.921	150,0 5.906	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX11T308	0,19 0.007	0,5 0.020
SD523-41-123-40R7	03080665	41,0 1.614	123,0 4.843	221,0 8.701	128,0 5.039	153,0 6.024	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408	0,19 0.007	0,5 0.020
SD523-41.5-125-40R7	03080663	41,5 1.634	125,0 4.921	223,0 8.780	130,0 5.118	155,0 6.102	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408	0,19 0.007	0,5 0.020
SD523-42-126-40R7	03080666	42,0 1.654	126,0 4.961	224,0 8.819	131,0 5.157	156,0 6.142	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408	0,19 0.007	0,5 0.020
SD523-43-129-40R7	03080667	43,0 1.693	129,0 5.079	227,0 8.937	134,0 5.276	159,0 6.260	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408	0,05 0.002	0,5 0.020
SD523-44-132-40R7	03080670	44,0 1.732	132,0 5.197	230,0 9.055	137,0 5.394	162,0 6.378	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX120408	0,5 0.020	0,41 0.016
SD523-44.5-134-40R7	03080669	44,5 1.752	134,0 5.276	232,0 9.134	139,0 5.472	164,0 6.457	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX150512	0,5 0.020	0,41 0.016
SD523-45-135-40R7	03080672	45,0 1.772	135,0 5.315	233,0 9.173	140,0 5.512	165,0 6.496	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX150512	0,5 0.020	0,41 0.016
SD523-46-138-40R7	03080673	46,0 1.811	138,0 5.433	236,0 9.291	143,0 5.630	168,0 6.614	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX150512	0,5 0.020	0,5 0.020
SD523-47-141-40R7	03080675	47,0 1.850	141,0 5.551	239,0 9.409	146,0 5.748	171,0 6.732	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX150512	0,5 0.020	0,5 0.020
SD523-47.5-143-40R7	03080674	47,5 1.870	143,0 5.630	241,0 9.488	148,0 5.827	173,0 6.811	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX150512	0,5 0.020	0,5 0.020
SD523-48-144-40R7	03080676	48,0 1.890	144,0 5.669	242,0 9.528	149,0 5.866	174,0 6.850	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1504	SCGX150512	0,45 0.018	0,5 0.020
SD523-49-147-40R7	03080677	49,0 1.929	147,0 5.787	245,0 9.646	152,0 5.984	177,0 6.969	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1504	SCGX150512	0,2 0.008	0,5 0.020
SD523-50-150-40R7	03080678	50,0 1.969	150,0 5.906	248,0 9.764	155,0 6.102	180,0 7.087	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1504	SCGX150512	0,2 0.008	0,5 0.020
SD523-51-153-40R7	03080679	51,0 2.008	153,0 6.024	251,0 9.882	158,0 6.220	183,0 7.205	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1504	SCGX150512	0,2 0.008	0,5 0.020
SD523-52-156-40R7	03080680	52,0 2.047	156,0 6.142	254,0 10.000	161,0 6.339	186,0 7.323	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1904	SCGX150512	0,5 0.020	0,42 0.017
SD523-53-159-40R7	03080681	53,0 2.087	159,0 6.260	257,0 10.118	164,0 6.457	189,0 7.441	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1904	SCGX150512	0,5 0.020	0,42 0.017
SD523-54-162-40R7	03080682	54,0 2.126	162,0 6.378	260,0 10.236	167,0 6.575	192,0 7.559	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1904	SCGX150512	0,5 0.020	0,5 0.020
SD523-55-165-40R7	03080683	55,0 2.165	165,0 6.496	263,0 10.354	170,0 6.693	195,0 7.677	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1904	SCGX150512	0,5 0.020	0,5 0.020
SD523-56-168-40R7	03080684	56,0 2.205	168,0 6.614	266,0 10.472	173,0 6.811	198,0 7.795	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1904	SCGX150512	0,5 0.020	0,5 0.020
SD523-57-171-40R7	03080685	57,0 2.244	171,0 6.732	269,0 10.591	176,0 6.929	201,0 7.913	68,0 2.677	40,0 1.575	59,35 2.337	SPGX1904	SCGX150512	0,39 0.015	0,5 0.020

Introducere

Găuire

Alegere

Alegere adâncă

Anexă

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică	mm - Inci -
SD523-58-174-40R7	03080686	58,0 2.283	174,0 6.850	272,0 10.709	179,0 7.047	204,0 8.031	68,0 2.677	40,0 1.575	63,0 2.480	SPGX1904	SCGX150512	0,09 0.004	0,5 0.020
SD523-59-177-40R7	03080687	59,0 2.323	177,0 6.969	275,0 10.827	182,0 7.165	207,0 8.150	68,0 2.677	40,0 1.575	63,0 2.480	SPGX1904	SCGX150512	0,09 0.004	0,5 0.020

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

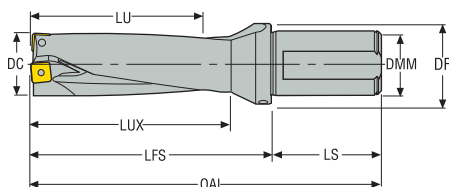
## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

# SD523

Adâncimea de găurire ~ 3 x D – inci



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.

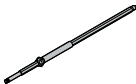

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
										Plcuța centrală	Plăcuța periferică	Inci -	Inci +
SD523-0562-169-1000R7	03080485	0.562	1.686	5.117	1.883	2.867	2.250	1.000	1.378	SPGX0502	SCGX050204	0.011	0.009
SD523-0594-178-1000R7	03080486	0.594	1.780	5.211	1.977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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		Inci	Inci	inci	Inci	Inci	Inci	Inci	Inci	Inci	Plcuța centrală	Plăcuța periferică	Inci -
SD523-1937-581-1500R7	03080581	1.937	5.810	9.616	6.007	6.991	2.625	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD523-2000-600-1500R7	03080588	2.000	6.000	9.806	6.197	7.181	2.625	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD523-2062-619-1500R7	03080593	2.062	6.190	9.996	6.387	7.371	2.625	1.500	2.337	SPGX1904	SCGX150512	0.020	0.017
SD523-2125-638-1500R7	03080596	2.125	6.380	10.186	6.577	7.561	2.625	1.500	2.337	SPGX1904	SCGX150512	0.020	0.020
SD523-2250-675-1500R7	03080603	2.250	6.750	10.556	6.947	7.931	2.625	1.500	2.337	SPGX1904	SCGX150512	0.013	0.020
SD523-2375-713-1500R7	03080609	2.375	7.130	10.936	7.327	8.311	2.625	1.500	2.480	SPGX1904	SCGX150512	0.004	0.020

## Piese de schimb

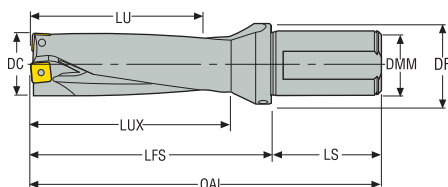
Pentru burghiu dia (inch)	urub plăcuță centru	urub plăcuță periferie	Cheie
0.562-0.687	 C02245-T07P	 C02245-T07P	 T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787-0.827	C02205-T07P	C02205-T07P	T07P-2
0.875	C02506-T08P	C02506-T08P	T08P-2
0.906	C02507-T08P	C03007-T08P	T08P-2
0.922	C02506-T08P	C03007-T08P	T08P-2
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.109	C03007-T09P	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.562	C03508-T15P	C03508-T15P	T15P-2D
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

## Accesorii

Pentru burghiu dia (inch)	Lamă interschimbabilă	Cheie dinamometrică
0.562-0.687	 T00-07P	 T00-07P09
0.709-0.766	-	T00-07P09
0.787-0.827	-	T00-07P09
0.875	-	T00-08P12
0.906	-	T00-08P12
0.922	-	T00-08P12
0.937-1.000	-	T00-08P12
1.032-1.109	-	T00-09P20
1.125-1.187	-	T00-09P20
1.250-1.562	-	T00-15P30
1.625-1.687	-	T00-15P30
1.750-2.375	-	T00-15P35

SD523

Adâncimea de găurire ~ 3 x D – inci








- Coadă ISO 9766, R7-C
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.
- For stationary applications


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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă		Intern	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plcuța centrală	Plăcuța periferică	Inci -
SD523-1937-581-1500R7-C	03080582	1.937	5.810	9.938	6.007	7.188	2.750	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD523-2000-600-1500R7-C	03080589	2.000	6.000	10.128	6.197	7.378	2.750	1.500	2.337	SPGX1504	SCGX150512	0.008	0.020
SD523-2125-638-1500R7-C	03080598	2.125	6.380	10.508	6.577	7.758	2.750	1.500	2.337	SPGX1904	SCGX150512	0.020	0.020
SD523-2250-675-1500R7-C	03080604	2.250	6.750	10.878	6.947	8.128	2.750	1.500	2.337	SPGX1904	SCGX150512	0.013	0.020
SD523-2375-713-1500R7-C	03080610	2.375	7.130	11.258	7.327	8.508	2.750	1.500	2.480	SPGX1904	SCGX150512	0.004	0.020

## Piese de schimb

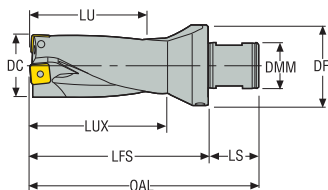
Pentru burghiu dia (inch)	Adaptor furtun	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie	Dop
0.594-0.687	 1310	 C02245-T07P	 C02245-T07P	 T07P-2	 R1/4
0.709-0.766	1310	C02205-T07P	C02245-T07P	T07P-2	R1/4
0.787-0.827	1310	C02205-T07P	C02205-T07P	T07P-2	R1/4
0.875	1310	C02506-T08P	C02506-T08P	T08P-2	R1/4
0.906-0.922	1310	C02506-T08P	C03007-T08P	T08P-2	R1/4
0.937-1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4
1.032-1.109	1310	C03007-T09P	C03007-T09P	T09P-2	R1/4
1.125-1.187	1310	C03007-T09P	C03009-T09P	T09P-2	R1/4
1.250-1.562	1310	C03508-T15P	C03508-T15P	T15P-2D	R1/4
1.625-1.687	1310	C03508-T15P	C05012-T15P	T15P-2D	R1/4
1.750-2.375	1310	C04011-T15P	C05012-T15P	T15P-2D	R1/4

## Accesorii

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

# SD523

Adâncimea de găurire ~ 3 x D – Metric



- O coadă compatibilă ABS 50, -2
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.

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

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Anexă



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

Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Chieie plăcuță
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D



## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

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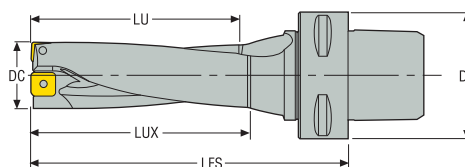
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## SD523

Adâncimea de găurire ~ 3 x D – Metric



- Seco-Capto™ coadă C4
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.

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

Reper Nr.	Număr reper	DC	LU	LUX	LFS	DF	Plăcuță amovibilă		Intern	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică	mm - Inci -	mm + Inci +
SD523-29-87-C4	03080939	29,0 1.142	87,0 3.425	92,0 3.622	132,0 5.197	40,0 1.575	SPGX0903	SCGX09T308	0,18 0.007	0,5 0.020
SD523-30-90-C4	03080940	30,0 1.181	90,0 3.543	95,0 3.740	135,0 5.315	40,0 1.575	SPGX0903	SCGX09T308	0,12 0.005	0,5 0.020

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

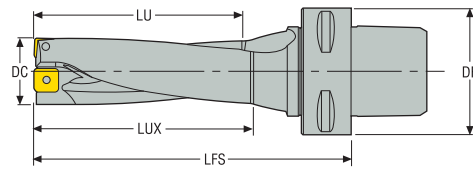
## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

## SD523

Adâncimea de găuire ~ 3 x D – Metric






- Seco-Capto™ coadă C5
- Răcire interioară
- Pentru informații depre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.



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

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

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
			
	Plăcuța centrală	Plăcuța periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

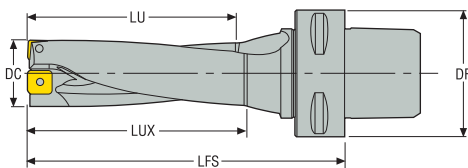
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	 T00-07P09	 T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

# SD523

Adâncimea de găuire ~ 3 x D – Metric



- Seco-Capto™ coadă C6
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.

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



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

### Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuța centrală	Plăcuța periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D



## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

Introducere

Găurire

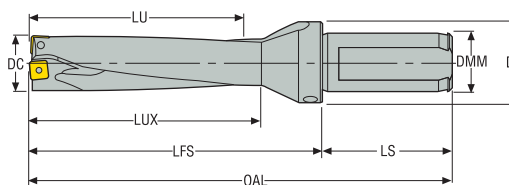
Alezare

Alezare adâncă

Anexă

## SD524

Adâncimea de găuire ~ 4 x D – Metric






- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.



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

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

Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
			
	Plăcuța centrală	Plăcuța periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

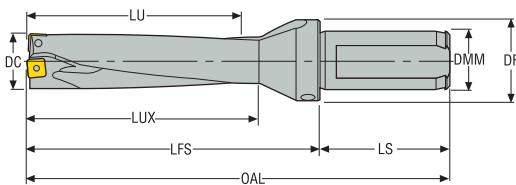
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

# SD524

Adâncimea de găurire ~ 4 x D – inci






- Coadă ISO 9766, R7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.


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

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă	
		<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	Plicuța centrală	Plăcuța periferică
SD524-2062-825-1500R7	03080339	2.062	8.250	12.056	8.447	9.431	2.625	1.500	2.337	SPGX1904	SCGX150512
SD524-2125-850-1500R7	03080342	2.125	8.500	12.306	8.697	9.681	2.625	1.500	2.337	SPGX1904	SCGX150512
SD524-2250-900-1500R7	03080346	2.250	9.000	12.806	9.197	10.181	2.625	1.500	2.337	SPGX1904	SCGX150512
SD524-2375-950-1500R7	03080349	2.375	9.500	13.306	9.697	10.681	2.625	1.500	2.480	SPGX1904	SCGX150512

### Piese de schimb

Pentru burghiu dia (inch)	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie
			
0.594-0.687	C02245-T07P	C02245-T07P	T07P-2
0.709-0.766	C02205-T07P	C02245-T07P	T07P-2
0.787-0.827	C02205-T07P	C02205-T07P	T07P-2
0.875-0.905	C02506-T08P	C02506-T08P	T08P-2
0.906-1.000	C02507-T08P	C03007-T08P	T08P-2
1.032-1.109	C03007-T09P	C03007-T09P	T09P-2
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2
1.250-1.562	C03508-T15P	C03508-T15P	T15P-2D
1.625-1.687	C03508-T15P	C05012-T15P	T15P-2D
1.750-2.375	C04011-T15P	C05012-T15P	T15P-2D

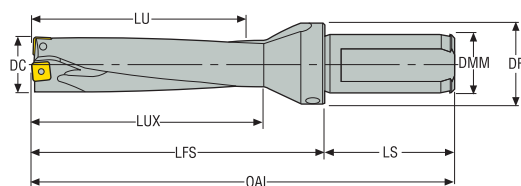
### Accesorii

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

Torque wrench including blade.

# SD524

Adâncimea de găurire ~ 4 x D – inci



- Coadă ISO 9766, R7-C
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.
- For stationary applications

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plcuța centrală	Plăcuța periferică
SD524-0625-250-1000R7-C	03080282	0.625	2.500	6.628	2.697	3.878	2.750	1.000	1.378	SPGX0502	SCGX050204
SD524-0687-275-1000R7-C	03080284	0.687	2.750	6.878	2.947	4.128	2.750	1.000	1.378	SCGX0502	SCGX050204
SD524-0750-300-1000R7-C	03080287	0.750	3.000	7.128	3.197	4.378	2.750	1.000	1.378	SPGX0602	SCGX050204
SD524-0812-325-1000R7-C	03080293	0.812	3.250	7.378	3.447	4.628	2.750	1.000	1.378	SPGX0602	SCGX060204
SD524-0875-350-1000R7-C	03080296	0.875	3.500	7.628	3.697	4.878	2.750	1.000	1.378	SPGX0703	SCGX060204
SD524-0937-375-1000R7-C	03080300	0.937	3.750	7.878	3.947	5.128	2.750	1.000	1.378	SPGX0703	SCGX070308
SD524-1000-400-1250R7-C	03080303	1.000	4.000	8.128	4.197	5.378	2.750	1.250	1.654	SPGX0703	SCGX070308
SD524-1062-425-1250R7-C	03080306	1.062	4.250	8.378	4.447	5.628	2.750	1.250	1.654	SPGX0903	SCGX070308
SD524-1125-450-1250R7-C	03080309	1.125	4.500	8.628	4.697	5.878	2.750	1.250	1.654	SPGX0903	SCGX09T308
SD524-1187-475-1250R7-C	03080312	1.187	4.750	8.878	4.947	6.128	2.750	1.250	1.654	SPGX0903	SCGX09T308
SD524-1250-500-1500R7-C	03080313	1.250	5.000	9.128	5.197	6.378	2.750	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1312-525-1500R7-C	03080316	1.312	5.250	9.378	5.447	6.628	2.750	1.500	1.969	SPGX11T3	SCGX09T308
SD524-1375-550-1500R7-C	03080319	1.375	5.500	9.628	5.697	6.878	2.750	1.500	1.969	SPGX11T3	SCGX11T308
SD524-1500-600-1500R7-C	03080321	1.500	6.000	10.128	6.197	7.378	2.750	1.500	1.969	SPGX12T3	SCGX11T308
SD524-1750-700-1500R7-C	03080329	1.750	7.000	11.128	7.197	8.378	2.750	1.500	1.969	SPGX1504	SCGX120408
SD524-2000-800-1500R7-C	03080338	2.000	8.000	12.128	8.197	9.378	2.750	1.500	2.337	SPGX1504	SCGX150512
SD524-2125-850-1500R7-C	03080343	2.125	8.500	12.628	8.697	9.878	2.750	1.500	2.337	SPGX1904	SCGX150512
SD524-2250-900-1500R7-C	03080347	2.250	9.000	13.128	9.197	10.378	2.750	1.500	2.337	SPGX1904	SCGX150512
SD524-2375-950-1500R7-C	03080350	2.375	9.500	13.628	9.697	10.878	2.750	1.500	2.480	SPGX1904	SCGX150512

## Piese de schimb

## Accesorii

Pentru burghiu dia (inch)	Adaptor furtun	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie	Dop	Cheie dinamometrică
0.625-0.687	1310	C02245-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.750	1310	C02205-T07P	C02245-T07P	T07P-2	R1/4	T00-07P09
0.812	1310	C02205-T07P	C02205-T07P	T07P-2	R1/4	T00-07P09
0.875	1310	C02506-T08P	C02506-T08P	T08P-2	R1/4	T00-08P12
0.937-1.000	1310	C02507-T08P	C03007-T08P	T08P-2	R1/4	T00-08P12
1.062	1310	C03007-T09P	C03007-T09P	T09P-2	R1/4	T00-09P20
1.125-1.187	1310	C03007-T09P	C03009-T09P	T09P-2	R1/4	T00-09P20
1.250-1.375	1310	C03508-T15P	C03508-T15P	T15P-2D	R1/4	T00-15P30
1.750-2.375	1310	C04011-T15P	C05012-T15P	T15P-2D	R1/4	T00-15P35

Introducere

Găurire

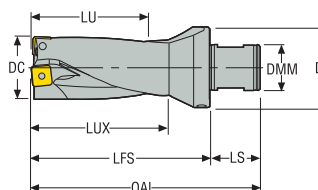
Alezare

Alezare adâncă

Anexă

## SD524

Adâncimea de găuire ~ 4 x D – Metric



- O coadă compatibilă ABS 50, -2
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă	
										Plcuța centrală	Plăcuța periferică
SD524-17-68-50R2	03080208	17,0 0.669	68,0 2.677	129,0 5.079	73,0 2.874	98,0 3.858	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0502	SCGX050204
SD524-17.5-70-50R2	03080327	17,5 0.689	70,0 2.756	131,0 5.157	75,0 2.953	100,0 3.937	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX050204
SD524-18-72-50R2	03080209	18,0 0.709	72,0 2.835	133,0 5.236	77,0 3.031	102,0 4.016	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX050204
SD524-18.5-74-50R2	03080210	18,5 0.728	74,0 2.913	135,0 5.315	79,0 3.110	104,0 4.094	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX050204
SD524-19-76-50R2	03080422	19,0 0.748	76,0 2.992	137,0 5.394	81,0 3.189	106,0 4.173	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX050204
SD524-20-80-50R2	03080341	20,0 0.787	80,0 3.150	141,0 5.551	85,0 3.346	110,0 4.331	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX060204
SD524-20.62-83-50R2	03080215	20,62 0.812	83,0 3.268	144,0 5.669	88,0 3.465	113,0 4.449	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX060204
SD524-21-84-50R2	03080345	21,0 0.827	84,0 3.307	145,0 5.709	89,0 3.504	114,0 4.488	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0602	SCGX060204
SD524-22-88-50R2	03080193	22,0 0.866	88,0 3.465	149,0 5.866	93,0 3.661	118,0 4.646	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0703	SCGX060204
SD524-22.23-89-50R2	03080216	22,23 0.875	89,0 3.504	150,0 5.906	94,0 3.701	119,0 4.685	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0703	SCGX060204
SD524-23-92-50R2	03080194	23,0 0.906	92,0 3.622	153,0 6.024	97,0 3.819	122,0 4.803	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0703	SCGX070308
SD524-24-96-50R2	03080195	24,0 0.945	96,0 3.780	157,0 6.181	101,0 3.976	126,0 4.961	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0703	SCGX070308
SD524-25-100-50R2	03080196	25,0 0.984	100,0 3.937	161,0 6.339	105,0 4.134	130,0 5.118	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0703	SCGX070308
SD524-25.4-102-50R2	03080217	25,4 1.000	102,0 4.016	163,0 6.417	107,0 4.213	132,0 5.197	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0703	SCGX070308
SD524-26-104-50R2	03080423	26,0 1.024	104,0 4.094	165,0 6.496	109,0 4.291	134,0 5.276	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX070308
SD524-27-108-50R2	03080197	27,0 1.063	108,0 4.252	169,0 6.654	113,0 4.449	138,0 5.433	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX070308
SD524-28-112-50R2	03080424	28,0 1.102	112,0 4.409	173,0 6.811	117,0 4.606	142,0 5.591	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX070308
SD524-28.59-115-50R2	03080218	28,59 1.126	115,0 4.528	176,0 6.929	120,0 4.724	145,0 5.709	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX070308
SD524-29-116-50R2	03080198	29,0 1.142	116,0 4.567	177,0 6.969	121,0 4.764	146,0 5.748	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX09T308
SD524-30-120-50R2	03080199	30,0 1.181	120,0 4.724	181,0 7.126	125,0 4.921	150,0 5.906	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX09T308
SD524-31-124-50R2	03080200	31,0 1.220	124,0 4.882	185,0 7.283	129,0 5.079	154,0 6.063	31,0 1.220	28,0 1.102	50,0 1.969	SPGX0903	SCGX09T308
SD524-31.75-127-50R2	03080359	31,75 1.250	127,0 5.000	188,0 7.402	132,0 5.197	157,0 6.181	31,0 1.220	50,0 1.969	50,0 1.969	SPGX11T3	SCGX09T308



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

## Piese de schimb

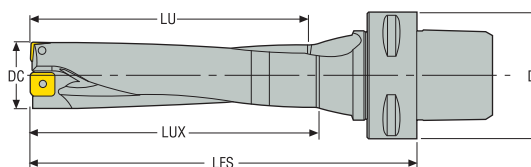
Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

## SD524




Adâncimea de găuire ~ 4 x D – Metric





- Seco-Capto™ coadă C4
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.

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

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
			
	Plăcuța centrală	Plăcuța periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

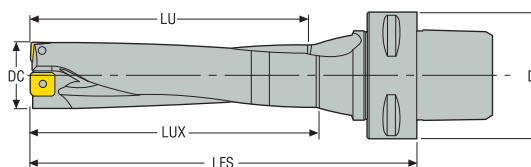
## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

## SD524

Adâncimea de găurire ~ 4 x D – Metric



- Seco-Capto™ coadă C5
- Răcire interioară
- Pentru informații depre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.

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

Reper Nr.	Număr reper	DC	LU	LUX	LFS	DF	Plăcuță amovibilă	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică
SD524-32-128-C5	03080253	32,0 1.260	128,0 5.039	133,0 5.236	174,0 6.850	50,0 1.969	SPGX11T3	SCGX09T308
SD524-33-132-C5	03080254	33,0 1.299	132,0 5.197	137,0 5.394	178,0 7.008	50,0 1.969	SPGX11T3	SCGX09T308
SD524-34-136-C5	03080255	34,0 1.339	136,0 5.354	141,0 5.551	182,0 7.165	50,0 1.969	SPGX11T3	SCGX09T308
SD524-35-140-C5	03080256	35,0 1.378	140,0 5.512	145,0 5.709	186,0 7.323	50,0 1.969	SPGX11T3	SCGX11T308
SD524-36-144-C5	03080257	36,0 1.417	144,0 5.669	149,0 5.866	190,0 7.480	50,0 1.969	SPGX11T3	SCGX11T308
SD524-37-148-C5	03080258	37,0 1.457	148,0 5.827	153,0 6.024	194,0 7.638	50,0 1.969	SPGX11T3	SCGX11T308
SD524-38-152-C5	03080259	38,0 1.496	152,0 5.984	157,0 6.181	198,0 7.795	50,0 1.969	SPGX12T3	SCGX11T308
SD524-39-156-C5	03080260	39,0 1.535	156,0 6.142	161,0 6.339	202,0 7.953	50,0 1.969	SPGX12T3	SCGX11T308
SD524-40-160-C5	03080261	40,0 1.575	160,0 6.299	165,0 6.496	206,0 8.110	50,0 1.969	SPGX12T3	SCGX11T308

## Piese de schimb

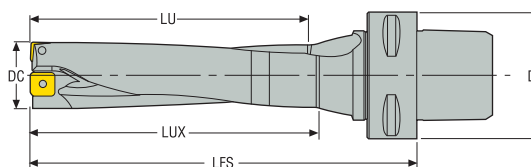
Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

## SD524

Adâncimea de găuire ~ 4 x D – Metric



- Seco-Capto™ coadă C6
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 308, 309
- Pentru diametre intermediare vezi programul MyDesign.

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

Reper Nr.	Număr reper	DC	LU	LUX	LFS	DF	Plăcuță amovibilă	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală	Plăcuță periferică
SD524-32-128-C6	03080399	32,0 1.260	128,0 5.039	133,0 5.236	176,0 6.929	63,0 2.480	SPGX11T3	SCGX09T308
SD524-33-132-C6	03080400	33,0 1.299	132,0 5.197	137,0 5.394	180,0 7.087	63,0 2.480	SPGX11T3	SCGX09T308
SD524-34-136-C6	03080401	34,0 1.339	136,0 5.354	141,0 5.551	184,0 7.244	63,0 2.480	SPGX11T3	SCGX09T308
SD524-35-140-C6	03080402	35,0 1.378	140,0 5.512	145,0 5.709	188,0 7.402	63,0 2.480	SPGX11T3	SCGX11T308
SD524-36-144-C6	03080403	36,0 1.417	144,0 5.669	149,0 5.866	192,0 7.559	63,0 2.480	SPGX11T3	SCGX11T308
SD524-37-148-C6	03080404	37,0 1.457	148,0 5.827	153,0 6.024	196,0 7.717	63,0 2.480	SPGX11T3	SCGX11T308
SD524-38-152-C6	03080405	38,0 1.496	152,0 5.984	157,0 6.181	200,0 7.874	63,0 2.480	SPGX12T3	SCGX11T308
SD524-39-156-C6	03080406	39,0 1.535	156,0 6.142	161,0 6.339	204,0 8.031	63,0 2.480	SPGX12T3	SCGX11T308
SD524-40-160-C6	03080407	40,0 1.575	160,0 6.299	165,0 6.496	208,0 8.189	63,0 2.480	SPGX12T3	SCGX11T308

## Piese de schimb

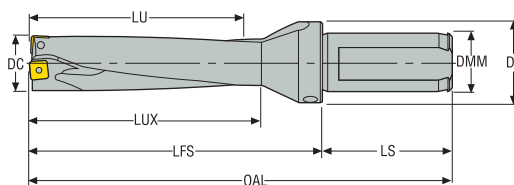
Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuța centrală	Plăcuța periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

## SD525

Adâncimea de găuire ~ 5 x D – Metric



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații depre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 310, 311
- Pentru diametre intermediare vezi programul MyDesign.

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



Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă	
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	Plăcuță centrală
SD525-41-205-40R7	03079604	41,0 1.614	205,0 8.071	303,0 11.929	210,0 8.268	235,0 9.252	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408
SD525-42-210-40R7	03079605	42,0 1.654	210,0 8.268	308,0 12.126	215,0 8.465	240,0 9.449	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408
SD525-43-215-40R7	03079606	43,0 1.693	215,0 8.465	313,0 12.323	220,0 8.661	245,0 9.646	68,0 2.677	40,0 1.575	50,0 1.969	SPGX12T3	SCGX120408
SD525-44-220-40R7	03079607	44,0 1.732	220,0 8.661	318,0 12.520	225,0 8.858	250,0 9.843	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX120408
SD525-45-225-40R7	03079608	45,0 1.772	225,0 8.858	323,0 12.717	230,0 9.055	255,0 10.039	68,0 2.677	40,0 1.575	50,0 1.969	SPGX1504	SCGX150512

## Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță
	Plăcuță centrală	Plăcuță periferică	
15,00-17,45	C02245-T07P	C02245-T07P	T07P-2
17,46-19,49	C02205-T07P	C02245-T07P	T07P-2
19,50-21,24	C02205-T07P	C02205-T07P	T07P-2
21,25-22,49	C02506-T08P	C02506-T08P	T08P-2
22,50-25,49	C02507-T08P	C03007-T08P	T08P-2
25,50-28,49	C03007-T09P	C03007-T09P	T09P-2
28,50-31,49	C03007-T09P	C03009-T09P	T09P-2
31,50-40,49	C03508-T15P	C03508-T15P	T15P-2D
40,50-43,24	C03508-T15P	C05012-T15P	T15P-2D
43,25-59,00	C04011-T15P	C05012-T15P	T15P-2D

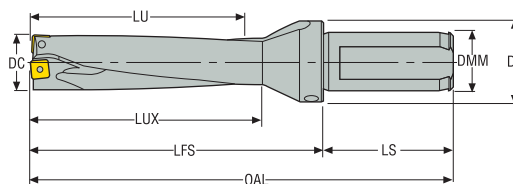
## Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-17,45	T00-07P09	T00-07P	0,9 Nm
17,46-19,49	T00-07P09	T00-07P	0,9 Nm
19,50-21,24	T00-07P09	T00-07P	0,9 Nm
21,25-22,49	T00-08P12	T00-08P	1,2 Nm
22,50-25,49	T00-08P12	T00-08P	1,2 Nm
25,50-28,49	T00-09P20	T00-09P	2,0 Nm
28,50-31,49	T00-09P20	T00-09P	2,0 Nm
31,50-40,49	T00-15P30	T00-15P	3,0 Nm
40,50-43,24	T00-15P30	T00-15P	3,0 Nm
43,25-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

## SD525

Adâncimea de găurire ~ 5 x D – inci



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 306-307
- Pentru diametre intermediare vezi programul MyDesign.

Reper Nr.	Număr reper	DC	LU	OAL	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plcuța centrală	Plăcuța periferică
SD525-0750-375-1000R7	03079565	0.750	3.750	7.181	3.947	4.931	2.250	1.000	1.378	SPGX0602	SCGX050204
SD525-0812-406-1000R7	03079566	0.812	4.060	7.491	4.257	5.241	2.250	1.000	1.378	SPGX0602	SCGX060204
SD525-0875-438-1000R7	03079567	0.875	4.380	7.811	4.577	5.561	2.250	1.000	1.378	SPGX0703	SCGX060204
SD525-0937-469-1000R7	03079568	0.937	4.690	8.121	4.887	5.871	2.250	1.000	1.378	SPGX0703	SCGX070308
SD525-1000-500-1250R7	03079569	1.000	5.000	8.556	5.197	6.181	2.375	1.250	1.654	SPGX0703	SCGX070308
SD525-1062-531-1250R7	03079570	1.062	5.310	8.866	5.507	6.491	2.375	1.250	1.654	SPGX0903	SCGX070308
SD525-1125-563-1250R7	03079571	1.125	5.630	9.186	5.827	6.811	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD525-1187-594-1250R7	03079572	1.187	5.940	9.496	6.137	7.121	2.375	1.250	1.654	SPGX0903	SCGX09T308
SD525-1250-625-1500R7	03079573	1.250	6.250	10.056	6.447	7.431	2.625	1.500	1.969	SPGX11T3	SCGX09T308
SD525-1375-687-1500R7	03079574	1.375	6.870	10.676	7.067	8.051	2.625	1.500	1.969	SPGX11T3	SCGX11T308
SD525-1500-750-1500R7	03079575	1.500	7.500	11.306	7.697	8.681	2.625	1.500	1.969	SPGX12T3	SCGX11T308
SD525-1625-812-1500R7	03079576	1.625	8.120	11.926	8.317	9.301	2.625	1.500	1.969	SPGX12T3	SCGX120408
SD525-1750-875-1500R7	03079577	1.750	8.750	12.556	8.947	9.931	2.625	1.500	1.969	SPGX1504	SCGX120408
SD525-1875-937-1500R7	03079578	1.875	9.370	13.176	9.567	10.551	2.625	1.500	1.969	SPGX1504	SCGX150512
SD525-1937-968-1500R7	03079579	1.937	9.680	13.486	9.877	10.861	2.625	1.500	2.337	SPGX1504	SCGX150512
SD525-2000-1000-1500R7	03079581	2.000	10.000	13.806	10.197	11.181	2.625	1.500	2.337	SPGX1504	SCGX150512

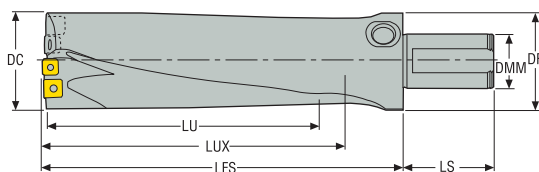
### Piese de schimb

### Accesorii

Pentru burghiu dia (inch)	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie	Cheie dinamometrică
0.750	C02205-T07P	C02245-T07P	T07P-2	T00-07P09
0.812	C02205-T07P	C02205-T07P	T07P-2	T00-07P09
0.875	C02506-T08P	C02506-T08P	T08P-2	T00-08P12
0.937-1.000	C02507-T08P	C03007-T08P	T08P-2	T00-08P12
1.062	C03007-T09P	C03007-T09P	T09P-2	T00-09P20
1.125-1.187	C03007-T09P	C03009-T09P	T09P-2	T00-09P20
1.250-1.500	C03508-T15P	C03508-T15P	T15P-2D	T00-15P30
1.625	C03508-T15P	C05012-T15P	T15P-2D	T00-15P30
1.750-2.000	C04011-T15P	C05012-T15P	T15P-2D	T00-15P35

## SD542






Adâncimea de găurire ~ 2,5 x D





- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 312, 313
- Pentru diametre intermediare vezi programul MyDesign.

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

### Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță	Dop	Adaptor furtun
					
	Plăcuța centrală	Plăcuța periferică			
60,00-64,99	C03007-T09P	C03009-T09P	T09P-2	R3/8	R3/8-HA
65,00-68,99	C03508-T15P	C03508-T15P	T15P-2D	R3/8	R3/8-HA
69,00-86,99	C03508-T15P	C05012-T15P	T15P-2D	R3/8	R3/8-HA

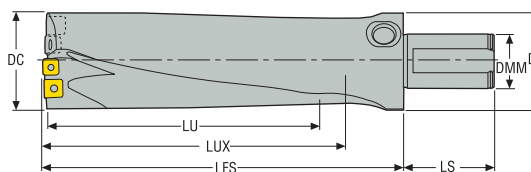
### Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
60,00-64,99	T00-09P20	T00-09P	3,0 Nm
65,00-68,99	T00-15P30	T00-15P	3,0 Nm
69,00-86,99	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

## SD542

Adâncimea de găurire ~ 2.5 X D – inci



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 312, 313
- Pentru diametre intermediare vezi programul MyDesign.

Reper Nr.	Număr reper	DC	LU	LUX	LFS	LS	DMM	DF	Plăcuță amovibilă	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Plăcuța centrală	Plăcuța periferică
SD542-2250-563-1500R7	02602085	2.250	5.630	5.800	7.000	4.500	1.500	3.110	SPGX 0903-C1	SCGX 09T308..
SD542-2500-625-1500R7	02602087	2.500	6.250	6.520	8.280	4.500	1.500	3.110	SPGX 0903-C1	SCGX 09T308..
SD542-2750-688-1500R7	02602088	2.750	6.880	7.190	8.900	4.500	1.500	3.110	SPGX 11T3-C1	SCGX 120408..
SD542-3000-750-2000R7	02602089	3.000	7.500	7.860	9.530	4.500	2.000	3.110	SPGX 11T3-C1	SCGX 120408..
SD542-3250-813-2500R7	02602090	3.250	8.130	8.460	10.150	4.500	2.500	3.500	SPGX 12T3-C1	SCGX 120408..
SD542-3500-875-2500R7	02602091	3.500	8.750	9.140	10.780	4.500	2.500	3.500	SPGX 1504-C1	SCGX 120408..

### Piese de schimb

Pentru burghiu dia (inch)	Șurubul plăcuței		Cheie plăcuță	Dop	Adaptor furtun
	Plăcuța centrală	Plăcuța periferică			
2.250-2.500	C03007-T09P	C03009-T09P	T09P-2	R3/8	R3/8-HA
2.750-3.000	C03508-T15P	C03508-T15P	T15P-2D	R3/8	R3/8-HA
3.250-3.500	C03508-T15P	C05012-T15P	T15P-2D	R3/8	R3/8-HA

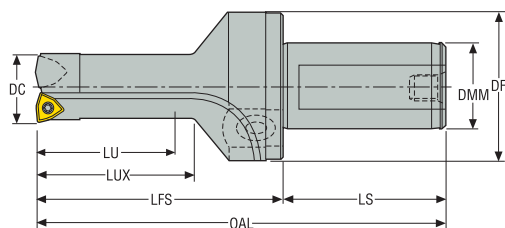
### Accesorii

Pentru burghiu dia (inch)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
2.250-2.500	T00-09P20	T00-09P	26.6 in/lbs
2.750-3.000	T00-15P30	T00-15P	26.6 in/lbs
3.250-3.500	T00-15P30	T00-15P	26.6 in/lbs

\*Inclusiv lama

## SD572






Adâncimea de găurire ~ 2 x D






- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de așchiere vezi pag. 314-315
- Pentru diametre intermediare vezi programul MyDesign.

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

### Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță	Dop	Adaptor furtun
					
	Plăcuța centrală	Plăcuța periferică			
15,00-20,50	C02205-T07P	C02205-T07P	T07P-2	R1/4	1310
20,51-24,50	C03007-T08P	C02506-T08P	T08P-2	R1/4	1310
24,51-32,50	C03508-T15P	C03007-T08P	T08P-2, T15P-2D	R1/4	1310
32,51-36,50	C03508-T15P	C03508-T15P	T15P-2D	R1/4	1310
36,51-59,00	C04011-T15P	C04011-T15P	T15P-2D	R1/4	1310

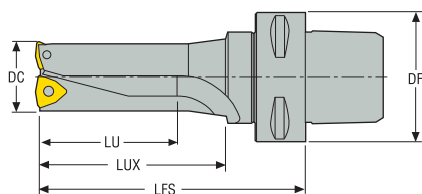
Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
			
15,00-20,50	T00-07P09	T00-07P	0,9 Nm
20,51-24,50	T00-08P12	T00-08P	1,2 Nm
24,51-32,50	T00-08P12	T00-08P	1,2 Nm
32,51-36,50	T00-15P30	T00-15P	3,0 Nm
36,51-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama

# SD572

Adâncimea de găurire ~ 2 x D – inci



- Coadă ISO 9766, -7
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 314-315
- Pentru diametre intermediare vezi programul MyDesign.

Reper Nr.	Număr reper	Hole dia min-max (inci)	DC	LU	LUX	LFS	DF	Plăcuță amovibilă	
								Plăcuța centrală	Plăcuța periferică
SD572-0591-118-1000R7	02602128	0.591-0.709	0.591	1.182	1.379	2.56	1.775	WCMX030208-86	WCMX 030208..
SD572-0669-134-1000R7	02602129	0.669-0.748	0.669	1.338	1.535	2.716	1.775	WCMX030208-86	WCMX 030208..
SD572-0748-150-1000R7	02602131	0.748-0.866	0.748	1.496	1.69	2.874	1.775	WCMX040208-86	WCMX 030208..
SD572-0866-173-1000R7	02602132	0.866-1.062	0.866	1.732	1.929	3.11	1.775	WCMX050308-86	WCMX 040208..
SD572-1062-212-1250R7	02602133	1.062-1.299	1.062	2.124	2.321	3.502	2.165	WCMX06T308-86	WCMX 050308..
SD572-1299-260-1500R7	02602134	1.299-1.614	1.299	2.598	2.795	3.976	2.303	WCMX080412-86	WCMX 06T308..
SD572-1614-322-1500R7	02602135	1.614-1.850	1.614	3.228	3.425	4.606	2.303	WCMX080412-86	WCMX 080412..
SD572-1850-370-1500R7	02602136	1.850-2.047	1.85	3.7	3.7	5.078	2.303	WCMX080412-86	WCMX 080412..

## Piese de schimb

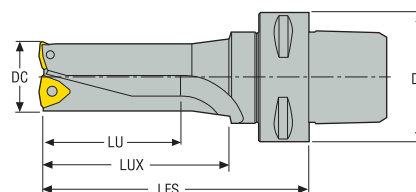
Pentru burghiu dia (inch)	Adaptor furtun	Cheie plăcuță	Șurub plăcuță centru	Șurub plăcuță periferie	Cheie (steag)	Șurub
0.591-0.748	1310	T07P-2	C02205-T07P	C02245-T07P	C02245-T07P	R1/4
0.866	1310	T08P-2	C02506-T08P	C03007-T08P	-	R1/4
1.062	1310	T08P-2	C03508-T15P	C03007-T08P	T15P-2D	R1/4
1.299	1310	T15P-2D	C03508-T15P	C02506-T08P	C02506-T08P	R1/4
1.614-1.850	1310	T15P-2D	C04011-T15P	C04011-T15P	-	R1/4

## Accesorii

Pentru burghiu dia (inch)	Lamă interschimbabilă	Cheie dinamometrică
0.591-0.748	-	T00-07P09
0.866	-	T00-08P12
1.062	T00-15P	T00-15P30
1.299	-	T00-15P30
1.614-1.850	-	T00-15P30

## SD572

Adâncimea de găurire ~ 2 x D – Metric



- Seco-Capto™ coadă C5
- Răcire interioară
- Pentru informații despre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 314-315
- Pentru diametre intermediare vezi programul MyDesign.

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

### Piese de schimb

Pentru burghiu dia (mm)	Șurubul plăcuței		Cheie plăcuță	Dop	Adaptor furtun
	Plăcuță centrală	Plăcuță periferică			
15,00-20,50	C02205-T07P	C02205-T07P	T07P-2	R1/4	1310
20,51-24,50	C03007-T08P	C02506-T08P	T08P-2	R1/4	1310
24,51-32,50	C03508-T15P	C03007-T08P	T08P-2, T15P-2D	R1/4	1310
32,51-36,50	C03508-T15P	C03508-T15P	T15P-2D	R1/4	1310
36,51-59,00	C04011-T15P	C04011-T15P	T15P-2D	R1/4	1310

### Accesorii

Pentru burghiu dia (mm)	Cheie dinamometrică*	Lamă de schimb	Valoare cuplu
15,00-20,50	T00-07P09	T00-07P	0,9 Nm
20,51-24,50	T00-08P12	T00-08P	1,2 Nm
24,51-32,50	T00-08P12	T00-08P	1,2 Nm
32,51-36,50	T00-15P30	T00-15P	3,0 Nm
36,51-59,00	T00-15P30	T00-15P	3,0 Nm

\*Inclusiv lama





## Perfomax® SD602

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

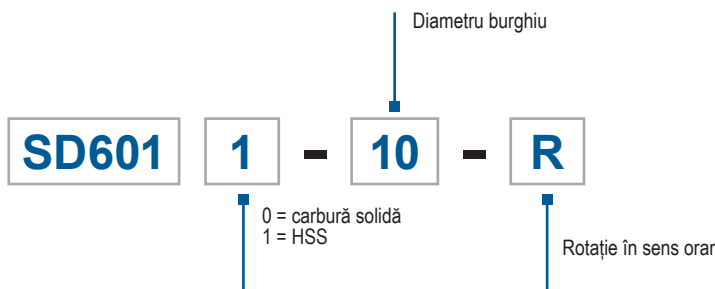
- Plăcuțele amovibile de clasă DP3000 asigură robustețea necesară pentru optimizarea Perfomax® SD602
- Clasa permite avansuri și turații mari
- Flexibilitate ridicată prin utilizarea extensiilor pentru a ajunge la adâncimea de găurire necesară

## Codificări

### Corpuri de burghiu

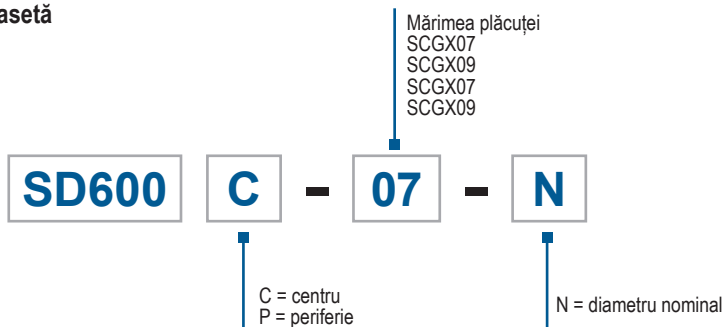


### Burghiu de ghidare



(Burghiul de ghidare trebuie achiziționat separat)

### Casetă

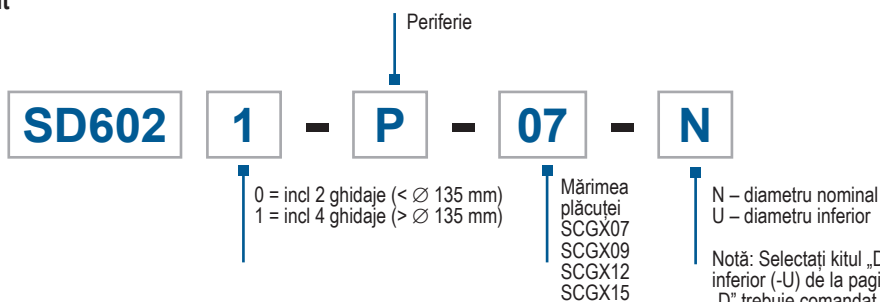


-N



-U

### Kit



-N



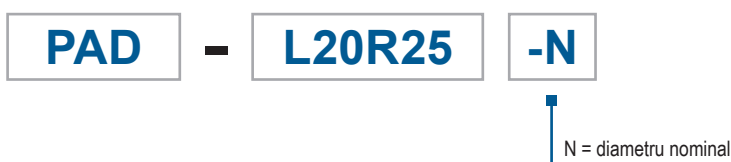
-U

Notă: Selectați kitul „D” de piese de schimb pentru diametru nominal (-N) sau inferior (-U) de la pagina 291 pentru a completa ansamblul corpului de burghiu. Kitul „D” trebuie comandat separat.

### Inci

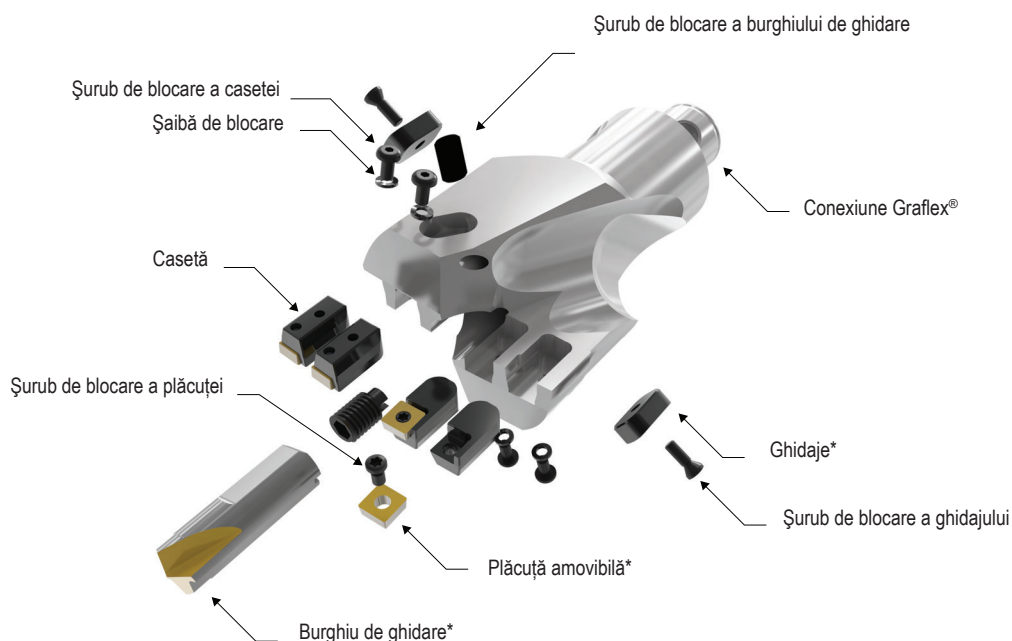


### Ghidaj



## Asamblare burghiu cu cap modular

SD602-59/60-40RG



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



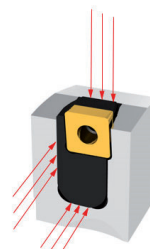
Exemplu: Diametru 60; SD602-60-40RG  
Utilizați kitul: SD6020-P07-N\*

### Instrucțiuni de montare

### Montarea cartușelor și a ghidajelor

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

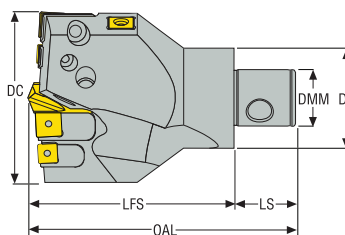
- Montează caseta
- Verifică să nu fie loc între casetă și pereți
- Strânge șurubul de blocare a casetei cu cheia dinamometrică:  
SD600-x-07: 3 Nm  
SD600-x-09: 3 Nm  
SD600-x-12: 8 Nm  
SD600-x-15: 8 Nm
- Montează ghidajele
- Strânge șurubul de blocare a ghidajului



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

## SD602

SD602 - Cap burghiu modular – Metric



- Răcire interioară
- Pentru informații depre plăcuțe vezi pag. 297-303
- Pentru regimurile de aşchiere vezi pag. 316-317
- Burghiu pilot cu lungime reglabilă

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

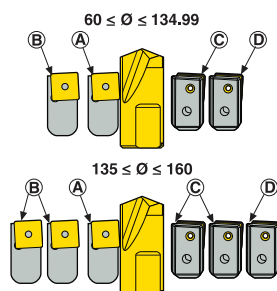
### Piese de schimb

Casetă	Casetă	Șurub casetă	Șaibă	Șurub plăcuță	Cheie plăcuță	Ghidaje*	Ghidaje*	Șurub ghidaj
SD600-C-07	SD600-P-07-N	K6S4x8	LW0408	C03007-T09P	T09P-2, T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-09	SD600-P-09-N	K6S4x8	LW0408	C03508-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-12	SD600-P-12-N	K6S6x10	LW0611	C05012-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P
SD600-C-15	SD600-P-15-N	K6S6x12	LW0611	C05012-T15P	T15P-2D	PAD-L20R25	PAD-L20R25-N	C04014-T15P

\*Nu este inclus în pachetul de livrare

# SD602

## SD602 - Cap burghiu modular



### Piese de schimb

Reper Nr.	Pentru burghiu dia (mm)	Pentru burghiu dia (inch)	Șurub pilot	Șurub reglaj	Casetă (A)	Casetă (B)	Casetă (C)	Kit periferic* (D)	Burghiu de ghidare* x=0 Carbură solidă x=1 HSS
SD602-59/60-40RG	59	2.323	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-U	SD601x-10-R
SD602-59/60-40RG	60	2.362	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-N	SD601x-10-R
SD602-2500-40RG	62,5	2.461	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-U	SD601x-10-R
SD602-2500-40RG	63,5	2.500	P6SS 8X8	19TLR0816	SD600-C-07	SD600-C-07	SD600-P-07	SD6020-P-07-N	SD601x-10-R
SD602-2750-40RG	68,85	2.711	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-07	SD600-P-07	SD6020-P-07-U	SD601x-10-R
SD602-2750-40RG	69,85	2.750	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-07	SD600-P-07	SD6020-P-07-N	SD601x-10-R
SD602-69/70-40RG	69	2.717	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-10-R
SD602-69/70-40RG	70	2.756	P6SS 8X8	19TLR0816	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-10-R
SD602-3000-40RG	75,2	2.961	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-15-R
SD602-3000-40RG	76,2	3.000	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-15-R
SD602-79/80-50RG	79	3.110	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-15-R
SD602-79/80-50RG	80	3.150	P6SS 10X10	19TLR1016	SD600-C-09	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-15-R
SD602-3250-50RG	81,55	3.211	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-09-U	SD601x-15-R
SD602-3250-50RG	82,55	3.250	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-09-N	SD601x-15-R
SD602-3500-50RG	87,9	3.461	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-U	SD601x-15-R
SD602-3500-50RG	88,9	3.500	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-N	SD601x-15-R
SD602-89/90-50RG	89	3.504	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-U	SD601x-15-R
SD602-89/90-50RG	90	3.543	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-09	SD600-P-09	SD6020-P-12-N	SD601x-15-R
SD602-99/100-63RG	99	3.898	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-U	SD601x-15-R
SD602-99/100-63RG	100	3.937	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-N	SD601x-15-R
SD602-4000-63RG	100,6	3.961	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-U	SD601x-15-R
SD602-4000-63RG	101,6	4.000	P6SS 10X10	19TLR1016	SD600-C-12	SD600-C-12	SD600-P-12	SD6020-P-12-N	SD601x-15-R
SD602-119/120-63RG	119	4.685	P6SS 10X10	19TLR1016	SD600-C-15	SD600-C-15	SD600-P-15	SD6020-P-15-U	SD601x-15-R
SD602-119/120-63RG	120	4.724	P6SS 10X10	19TLR1016	SD600-C-15	SD600-C-15	SD600-P-15	SD6020-P-15-N	SD601x-15-R
SD602-139/140-90RG	139	5.472	P6SS 12X12	19TLR1216	SD600-C-12	SD600-C-12	SD600-P-12	SD6021-P-12-U	SD601x-25-R
SD602-139/140-90RG	140	5.512	P6SS 12X12	19TLR1216	SD600-C-12	SD600-C-12	SD600-P-12	SD6021-P-12-N	SD601x-25-R
SD602-159/160-90RG	159	6.260	P6SS 12X12	19TLR1216	SD600-C-15	SD600-C-12	SD600-P-12	SD6021-P-15-U	SD601x-25-R
SD602-159/160-90RG	160	6.299	P6SS 12X12	19TLR1216	SD600-C-15	SD600-C-12	SD600-P-12	SD6021-P-15-N	SD601x-25-R

\*Nu este inclus în pachetul de livrare. Kit periferic, U-subdimensionat, N-nominal  
Pentru mărimea plăcuței vezi pag. 297-303

## Instrucțiuni de reascuțire pentru SD602

**Specificații:**

Specificațiile propuse pentru discul de diamant:

Ajustaj conic: Forma roții 12A2 Granulația D54 (fig.1).

Tăietura: Forma roții 1A1 sau 1V1 Granulația D64-D46 (fig. 2-3).

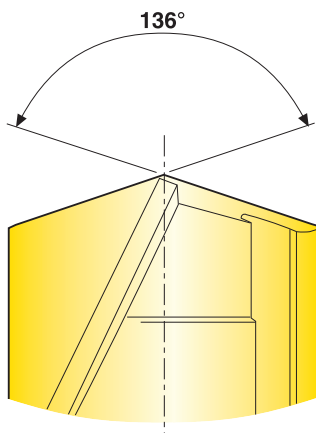
Șanfrenul la colț: Forma roții 1A1 sau 12A2 (fig. 1).

Tratamentul muchiei: ascuțire K-land sau rectificare (figura 2).

**Important:**

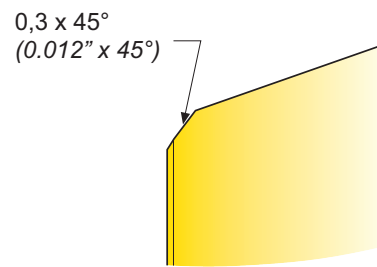
- Muchiile așchietoare trebuie să fie uniforme și să aibă pregătirea muchiei de aceeași mărime.
- Pregătirea muchiei trebuie efectuată pe toată lungimea muchiilor așchietoare.

**1. Flancul conic**

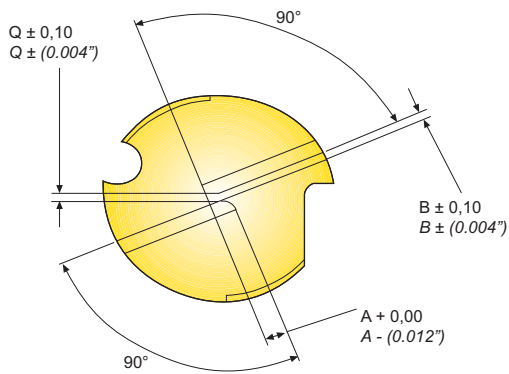


Pregătirea muchiei 0-0,1 mm (0-0,004") x 20°. Degajarea conică a vârfului burghiului 10°.

**2. Șanfrenul la colț**



**3.**

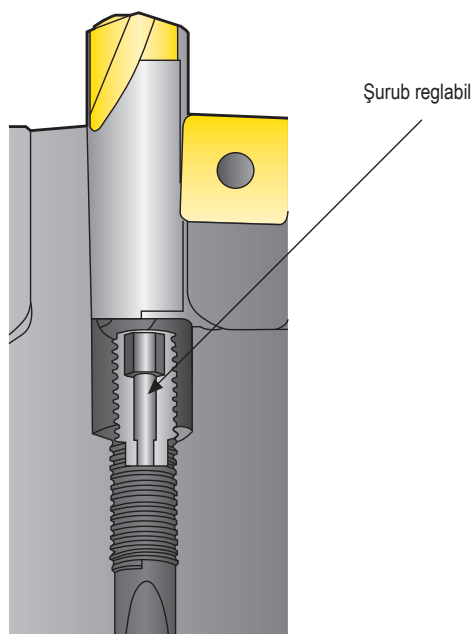


**4.**

Dimensiunile în mm (inc)				
Diametru	A	B	C	Minim lungime
10 mm	1,5 (0.059)	0,5 (0.020)	0,57 (0.022)	38 (1.496)
15 mm	1,5 (0.059)	0,6 (0.024)	0,68 (0.027)	45 (1.772)
25 mm	1,5 (0.059)	1,4 (0.055)	1,6 (0.063)	57 (2.244)

## Asamblare burghiu cu cap modular

## Caracteristici: Burghiu de ghidare reglabil

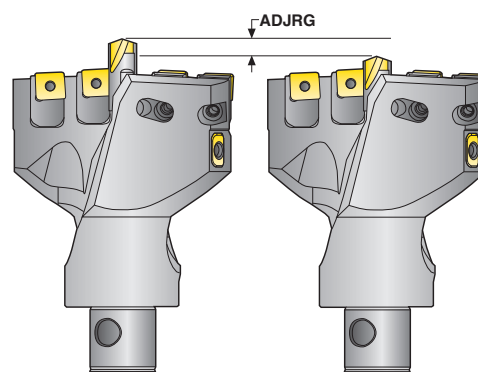


Burghiu	Lungime reglabilă ADJRG	
	mm	inci
SD602-59/60-40RG	3,0	0.118
SD602-69/70-40RG	3,0	0.118
SD602-79/80-50RG	5,0	0.197
SD602-89/90-50RG	5,0	0.197
SD602-99/100-63RG	5,0	0.197
SD602-119/120-63RG	5,0	0.197
SD602-139/140-90RG	5,0	0.197
SD602-159/160-90RG	5,0	0.197
SD602-2500-40RG	3,0	0.118
SD602-2750-40RG	3,0	0.118
SD602-3000-40RG	5,0	0.197
SD602-3250-50RG	5,0	0.197
SD602-3500-50RG	5,0	0.197
SD602-4000-63RG	5,0	0.197

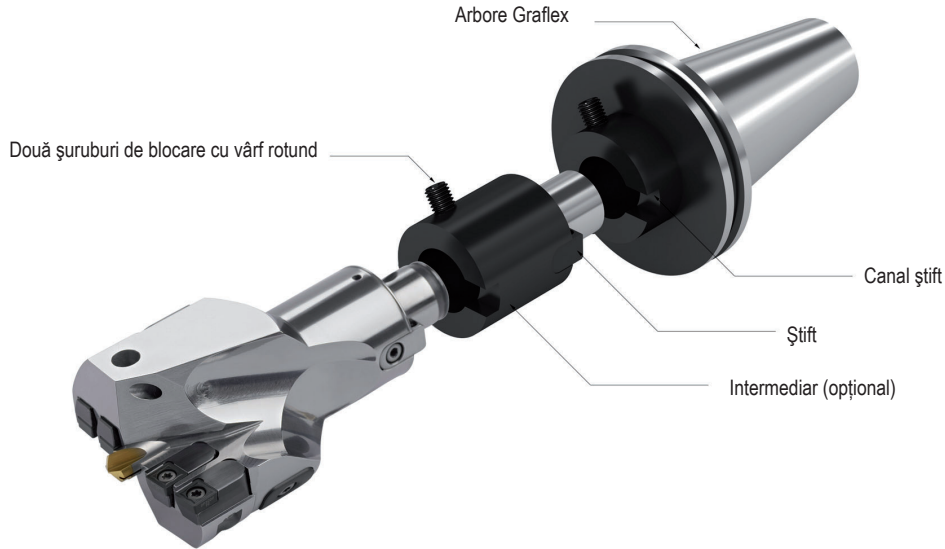
## Caracteristici: Lungime reglabilă

**Beneficii:** Aceeași lungime de reglare după reascuțirea unui burghiu pilot  
Posibilitatea de a regla lungimea în consolă a burghiului pilot  
Când adâncimea de găurire > 5 x D se recomandă reglarea burghiului cu 5 mm (0,197") în plus.

**Recomandare:** În cazul reintrării în gaură se recomandă reglarea burghiului de ghidare cu 3 mm (0,118") în plus față de poziția inițială pentru a asigura o mai bună centrare.

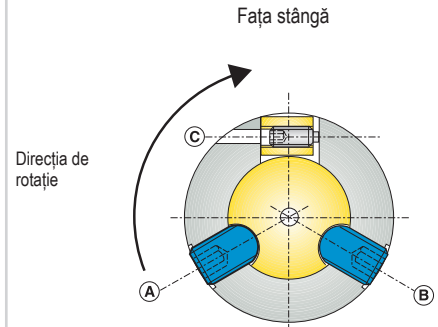
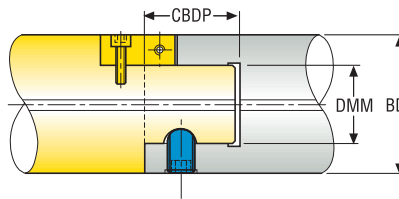


## Asamblare burghiu cu cap modular



### Instrucțiuni de montare

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



### Cuplul recomandat la prinderea Graflex

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



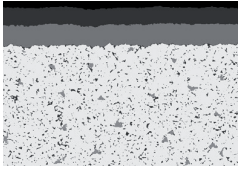
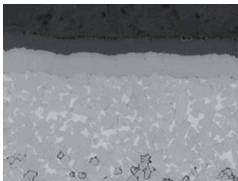
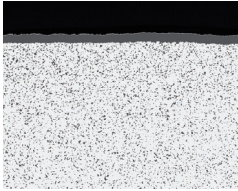
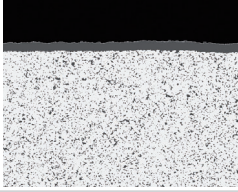
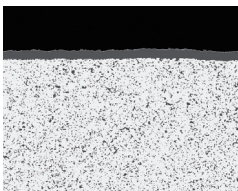
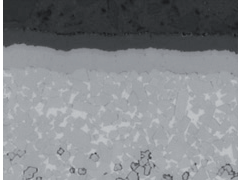
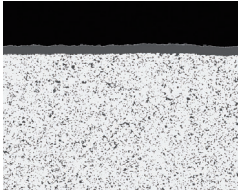
## Calitatea carbunii

### Caracteristici:

- 4 muchii de aşchiere pe plăcuță
- Plăcuțe pătrate solide

### Beneficii:

- Economie
- Siguranță
- Performanță
- Preț mic per gaură

Plăcuța periferică		
DP2000		Tehnologia de acoperire DURATOMIC® Optimizată pentru prelucrarea oțelului și a fontelor Pentru prelucrarea cu viteze foarte mari de aşchiere O combinație unică de rezistență superioară a muchiei și o acoperire subțire rezistentă la uzură Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC®
DP3000		Tehnologia de acoperire DURATOMIC® Calitate universală Rezistență mare la uzură și muchie rezistentă Calitate dură pentru maxim de securitate Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC® Microstructură stratificată
T250D		Potrivită pentru materialele dure Prima alegere pentru aluminiu Microstructura dură cu acoperire TiAlN asigură - O duritate extrem de mare - Rezistență extremă la coroziunea chimică și oxidare Acoperire PVD (Ti, Al)N + TiN
DS2050		Calitate optimizată pentru titan, superalaje și oțeluri inoxidabile dificile Acoperire PVD TiAlN + NbN
Centru		
T400D		Prima alegere Calitate rezilientă pentru plăcuța centrală, asigură o securitate maximă a aplicației Acoperire PVD (Ti, Al)N + TiN
DP3000		Tehnologia de acoperire DURATOMIC® Calitate universală Rezistență mare la uzură și muchie rezistentă Calitate dură pentru maxim de securitate Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC® Microstructură stratificată
DS4050		Calitate optimizată pentru titan, superalaje și oțeluri inoxidabile dificile Acoperire PVD TiAlN + NbN

## Geometrii



1. Formă plăcuțe amovibile			2. Unghiul de degajare laterală al plăcuței amovibile		4. Tip																																																																
					X=Special																																																																
3. Toleranțe			5. Lungimea muchiei așchietoare																																																																		
<table border="1"> <thead> <tr> <th rowspan="2">Clase de toleranțe</th> <th colspan="3">Toleranța +/- mm (inc)</th> <th colspan="8">Pentru dimensiunea IC în mm (inc)</th> </tr> <tr> <th>m</th> <th>S</th> <th>IC</th> <th>5,566 (0.2187)</th> <th>6,35 (0.2500)</th> <th>7,937 (0.3125)</th> <th>7,94 (0.3126)</th> <th>9,525 (0.3750)</th> <th>11,509 (0.4531)</th> <th>12,7 (0.5000)</th> <th>15,875 (0.6250)</th> <th>19,05 (0.7500)</th> </tr> </thead> <tbody> <tr> <td>G</td> <td>0,025 (0.001)</td> <td>0,13 (0.005)</td> <td>0,025 (0.001)</td> <td>•</td> <td>•</td> <td>•</td> <td>•</td> <td>•</td> <td>•</td> <td>•</td> <td>•</td> <td>•</td> </tr> <tr> <td>M</td> <td>0,013 (0.005)</td> <td>0,13 (0.005)</td> <td>0,05 (0.002)</td> <td>•</td> <td>•</td> <td></td> <td>•</td> <td>•</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>M</td> <td>0,013 (0.005)</td> <td>0,13 (0.005)</td> <td>0,08 (0.003)</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td>•</td> <td></td> <td></td> </tr> </tbody> </table>			Clase de toleranțe	Toleranța +/- mm (inc)			Pentru dimensiunea IC în mm (inc)								m	S	IC	5,566 (0.2187)	6,35 (0.2500)	7,937 (0.3125)	7,94 (0.3126)	9,525 (0.3750)	11,509 (0.4531)	12,7 (0.5000)	15,875 (0.6250)	19,05 (0.7500)	G	0,025 (0.001)	0,13 (0.005)	0,025 (0.001)	•	•	•	•	•	•	•	•	•	M	0,013 (0.005)	0,13 (0.005)	0,05 (0.002)	•	•		•	•					M	0,013 (0.005)	0,13 (0.005)	0,08 (0.003)							•						
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6. Grosimea			7. Plăcuță amovibilă cu colț șanfren/rază la colț		10. Descriere proprie:																																																																
<p>02 = 2,38 mm (0.094") 03 = 3,18 mm (0.125") T3 = 3,97 mm (0.156")</p> <p>04 = 4,76 mm (0.187") 05 = 5,56 mm (0.219")</p>			<p>04 = 0,4 mm (0.016") 08 = 0,8 mm (0.031") 12 = 1,2 mm (0.047") etc.</p> <p>rază la vârf</p>		<p>ex.: descrierea fragmentatorului</p> <p>P1 = xx P2 = xx 85 = xx 86 = xx</p>																																																																

Introducere

Găurire

Alezare

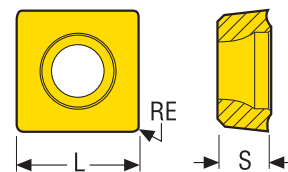
Alezare adâncă

Anexă

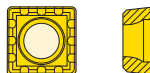
## Plăcuțe amovibile - Plăcuță periferică, tip P1\*

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

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



SCGX-P1

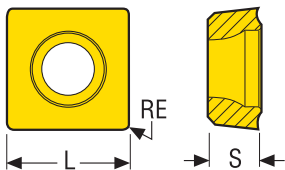


Reper Nr.	Plăcuțe amovibile	L		S		RE		Calități		
		mm	Inci	mm	Inci	mm	Inci	T250D	DP2000	DP3000
SCGX060204-P1	SCGX-P1	6,35	0.250	2,381	0.094	0,4	0.016	00059712	02590849	02807362
SCGX070308-P1	SCGX-P1	7,938	0.313	3,175	0.125	0,8	0.031	00059713	02590850	02807363
SCGX09T308-P1	SCGX-P1	9,525	0.375	3,969	0.156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

\*Fragmentator de așchii pentru avansuri mici și pentru o bună finisare a suprafeței în toate materialele

## Plăcuțe amovibile - Plăcuță periferică, tip P2\*

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



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

SCGX-P2



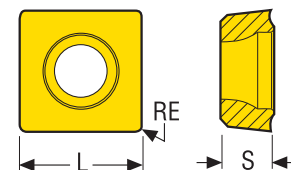
Reper Nr.	Plăcuțe amovibile	L		S		RE		Calități		
		mm	Inci	mm	Inci	mm	Inci	T250D	DP2000	DP3000
SCGX050204-P2	SCGX-P2	5,556	0.219	2,38	0.094	0,4	0.016	00059711	02590854	02807356
SCGX060204-P2	SCGX-P2	6,35	0.250	2,38	0.094	0,4	0.016	02526803	02590855	02807357
SCGX070308-P2	SCGX-P2	7,937	0.312	3,18	0.125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

\*\*Fragmentator pentru avansuri mari în oțel, oțel inoxidabil și fontă.

## Plăcuțe amovibile - Plăcuță periferică, pentru tip MP

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

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



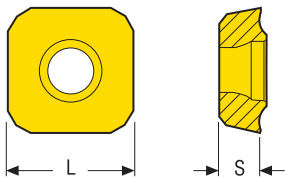
SCGX-MP



Reper Nr.	Plăcuțe amovibile	L	S	RE	Calități
		mm Inci	mm Inci	mm Inci	
SCGX050204-MP	SCGX-MP	5,56 0.219	2,38 0.094	0,4 0.016	DS2050 03134312
SCGX060204-MP	SCGX-MP	6,35 0.250	6,35 0.250	0,4 0.016	03134313
SCGX070308-MP	SCGX-MP	7,94 0.313	3,18 0.125	0,8 0.031	03134314
SCGX09T308-MP	SCGX-MP	9,525 0.375	3,97 0.156	0,8 0.031	03134315
SCGX11T308-MP	SCGX-MP	11,509 0.453	3,97 0.156	0,8 0.031	03134316
SCGX120408-MP	SCGX-MP	12,7 0.500	4,76 0.187	0,8 0.031	03134317
SCGX150512-MP	SCGX-MP	15,875 0.625	5,56 0.219	1,2 0.047	03134318

## Plăcuțe amovibile - Plăcuță centrală, tip C1

pentru SD522, SD523, SD524, SD525, SD542



**Toleranțe:**  
L =  $\pm 0,025$  (0.001 in)  
S =  $\pm 0,13$  (0.005 in)

SPGX-C1

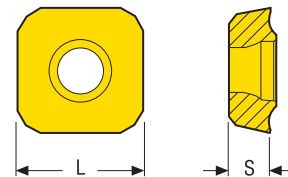


Reper Nr.	Plăcuțe amovibile	L		S		Calități	
		mm Inci	mm Inci	mm Inci	mm Inci	T400D	DP3000
SPGX0502-C1	SPGX-C1	5,556 0.219	2,38 0.094	74077370	02807367		
SPGX0602-C1	SPGX-C1	6,35 0.250	2,38 0.094	74077371	02807368		
SPGX0703-C1	SPGX-C1	7,937 0.312	3,18 0.125	74077372	02807369		
SPGX0903-C1	SPGX-C1	9,525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

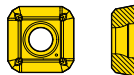
## Plăcuțe amovibile - Plăcuță centrală, tip MC

pentru SD522, SD523, SD524, SD525, SD542

Toleranțe:  
L =  $\pm 0,025$  (0.001 in)  
S =  $\pm 0,13$  (0.005 in)



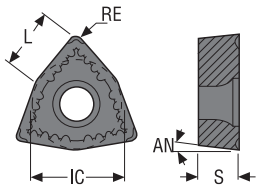
SPGX-MC



Reper Nr.	Plăcuțe amovibile	L		S		Calități
		mm	Inci	mm	Inci	
						DS4050
SPGX0502-MC	SPGX-MC	5,56	0.219	2,38	0.094	03134319
SPGX0602-MC	SPGX-MC	6,35	0.250	2,38	0.094	03134320
SPGX0703-MC	SPGX-MC	7,94	0.313	3,18	0.125	03134321
SPGX0903-MC	SPGX-MC	9,525	0.375	3,18	0.125	03134322
SPGX11T3-MC	SPGX-MC	11,509	0.453	3,97	0.156	03134323
SPGX12T3-MC	SPGX-MC	12,7	0.500	3,97	0.156	03134324
SPGX1504-MC	SPGX-MC	15,875	0.625	4,76	0.187	03134325
SPGX1904-MC	SPGX-MC	19,05	0.750	4,76	0.187	03134326

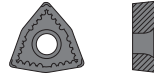
## Plăcuțe amovibile - Plăcuță periferică, tip 85\*

pentru SD572



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

WCMX-85



Reper Nr.	Plăcuțe amovibile	IC	L	S	RE	Calități
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	DP3000
WCMX040208-85	WCMX-85	6,35 0.250	3,99 0.157	2,38 0.094	0,8 0.031	02807375
WCMX050308-85	WCMX-85	7,94 0.313	5,07 0.200	3,18 0.125	0,8 0.031	02807376
WCMX06T308-85	WCMX-85	9,525 0.375	6,14 0.242	3,97 0.156	0,8 0.031	02807377
WCMX080412-85	WCMX-85	12,7 0.500	8,14 0.320	4,76 0.187	1,2 0.047	02807378

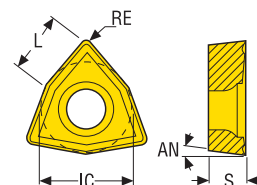
\* Fragmentator de așchii pentru avansuri mici și pentru o bună finisare a suprafeței în toate materialele



## Plăcuță centrală, Plăcuță periferică

pentru SD572

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



WCMX-86



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

\*\* Pentru avansuri mari în oțel, oțel inoxidabil și fontă.

SD522 Ø 15-60 mm / 0.590-2.375 inci

SMG		f							V <sub>c</sub>
		Ø 15,00-19,49 Ø 0.590-0.767	Ø 19,50-22,49 Ø 0.768-0.885	Ø 22,50-28,49 Ø 0.886-1.121	Ø 28,50-34,49 Ø 1.122-1.357	Ø 34,50-40,49 Ø 1.358-1.593	Ø 40,49-44,49 Ø 1.594-1.751	Ø 44,50-59,99 Ø 1.752-2.375	
P1	P1 DP2000	0,060	0,070	0,085	0,095	0,11	0,12	0,13	460
	P1 DP2000	0,0024	0,0028	0,0034	0,0038	0,0044	0,0048	0,0050	1500
P2	P1 DP2000	0,060	0,070	0,085	0,10	0,11	0,12	0,13	450
	P1 DP2000	0,0024	0,0028	0,0034	0,0040	0,0044	0,0048	0,0050	1475
P3	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	345
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0085	0,0085	0,010	1125
P4	P2 DP3000	0,12	0,13	0,16	0,19	0,22	0,22	0,25	220
	P2 DP3000	0,0048	0,0050	0,0065	0,0075	0,0085	0,0085	0,010	720
P5	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	210
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	690
P6	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	235
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	770
P7	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	225
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	740
P8	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	210
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0085	0,0085	0,010	690
P11	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	215
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	710
P12	P2 DP3000	0,075	0,090	0,11	0,12	0,14	0,15	0,17	130
	P2 DP3000	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	425
M1	P2 DP3000	0,085	0,10	0,12	0,14	0,16	0,17	0,19	260
	P2 DP3000	0,0034	0,0040	0,0048	0,0055	0,0065	0,0065	0,0075	850
M2	P2 DP3000	0,080	0,090	0,11	0,13	0,14	0,15	0,17	210
	P2 DP3000	0,0032	0,0036	0,0044	0,0050	0,0055	0,0060	0,0065	690
M3	MP DS2050	0,065	0,075	0,090	0,10	0,12	0,13	0,14	160
	MP DS2050	0,0026	0,0030	0,0036	0,0040	0,0048	0,0050	0,0055	520
M4	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	140
	MP DS2050	0,0022	0,0026	0,0032	0,0036	0,0040	0,0044	0,0048	460
M5	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	115
	MP DS2050	0,0022	0,0026	0,0032	0,0036	0,0040	0,0044	0,0048	375
K1	P2 DP2000	0,12	0,14	0,17	0,20	0,22	0,24	0,26	250
	P2 DP2000	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	820
K2	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	215
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	710
K3	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	185
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	610
K4	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	175
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	570
K5	P2 DP2000	0,10	0,11	0,14	0,16	0,18	0,19	0,22	105
	P2 DP2000	0,0040	0,0044	0,0055	0,0065	0,0070	0,0075	0,0085	345
N1	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	365
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	1200
N2	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	235
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	770
N3	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	155
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	510
N11	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	310
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	1025
S1	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	60
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	195
S2	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	48
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	155
S3	MP DS2050	0,085	0,10	0,12	0,14	0,16	0,17	0,19	41
	MP DS2050	0,0034	0,0040	0,0048	0,0055	0,0065	0,0065	0,0075	135
S11	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	85
	MP DS2050	0,0044	0,0048	0,0060	0,0065	0,0075	0,0080	0,0095	280
S12	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	65
	MP DS2050	0,0044	0,0048	0,0060	0,0065	0,0075	0,0080	0,0095	215
S13	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	50
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	165
H3	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	70
	P1 T250D	0,0020	0,0024	0,0028	0,0032	0,0038	0,0040	0,0044	230
H5	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	130
	P1 T250D	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	425
H7	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	70
	P1 T250D	0,0020	0,0024	0,0028	0,0032	0,0038	0,0040	0,0044	230
H8	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	130
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	425
H11	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	165
	P1 T250D	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	540
H12	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	150
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	490
H21	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	130
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	425

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire

## SD522 Viteza de aşchiere

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

SMG = Grupa de material Seco V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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SD523 Ø 15-60 mm / 0.590-2.375 inci

SMG		f							V <sub>c</sub>
		Ø 15,00-19,49 Ø 0.590-0.767	Ø 19,50-22,49 Ø 0.768-0.885	Ø 22,50-28,49 Ø 0.886-1.121	Ø 28,50-34,49 Ø 1.122-1.357	Ø 34,50-40,49 Ø 1.358-1.593	Ø 40,49-44,49 Ø 1.594-1.751	Ø 44,50-59,99 Ø 1.752-2.375	
P1	P1 DP2000	0,060	0,070	0,085	0,095	0,11	0,12	0,13	415
	P1 DP2000	0,0024	0,0028	0,0034	0,0038	0,0044	0,0048	0,0050	1350
P2	P1 DP2000	0,060	0,070	0,085	0,10	0,11	0,12	0,13	405
	P1 DP2000	0,0024	0,0028	0,0034	0,0040	0,0044	0,0048	0,0050	1325
P3	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	310
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0085	0,0085	0,010	1025
P4	P2 DP3000	0,12	0,13	0,16	0,19	0,22	0,22	0,25	190
	P2 DP3000	0,0048	0,0050	0,0065	0,0075	0,0085	0,0085	0,010	620
P5	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	180
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	590
P6	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	200
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	660
P7	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	190
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	620
P8	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	180
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0085	0,0085	0,010	590
P11	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	185
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	610
P12	P2 DP3000	0,075	0,090	0,11	0,12	0,14	0,15	0,17	110
	P2 DP3000	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	360
M1	P2 DP3000	0,085	0,10	0,12	0,14	0,16	0,17	0,19	245
	P2 DP3000	0,0034	0,0040	0,0048	0,0055	0,0065	0,0065	0,0075	800
M2	P2 DP3000	0,080	0,090	0,11	0,13	0,14	0,15	0,17	195
	P2 DP3000	0,0032	0,0036	0,0044	0,0050	0,0055	0,0060	0,0065	640
M3	MP DS2050	0,065	0,075	0,090	0,10	0,12	0,13	0,14	150
	MP DS2050	0,0026	0,0030	0,0036	0,0040	0,0048	0,0050	0,0055	490
M4	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	120
	MP DS2050	0,0022	0,0026	0,0032	0,0036	0,0040	0,0044	0,0048	395
M5	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	100
	MP DS2050	0,0022	0,0026	0,0032	0,0036	0,0040	0,0044	0,0048	330
K1	P2 DP2000	0,12	0,14	0,17	0,20	0,22	0,24	0,26	225
	P2 DP2000	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	740
K2	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	195
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	640
K3	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	165
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	540
K4	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	160
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	520
K5	P2 DP2000	0,10	0,11	0,14	0,16	0,18	0,19	0,22	95
	P2 DP2000	0,0040	0,0044	0,0055	0,0065	0,0070	0,0075	0,0085	310
N1	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	310
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	1025
N2	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	200
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	660
N3	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	135
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	445
N11	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	260
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	850
S1	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	55
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	180
S2	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	43
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	140
S3	MP DS2050	0,085	0,10	0,12	0,14	0,16	0,17	0,19	37
	MP DS2050	0,0034	0,0040	0,0048	0,0055	0,0065	0,0065	0,0075	120
S11	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	75
	MP DS2050	0,0044	0,0048	0,0060	0,0065	0,0075	0,0080	0,0095	245
S12	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	60
	MP DS2050	0,0044	0,0048	0,0060	0,0065	0,0075	0,0080	0,0095	195
S13	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	45
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	150
H3	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	60
	P1 T250D	0,0020	0,0024	0,0028	0,0032	0,0038	0,0040	0,0044	195
H5	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	110
	P1 T250D	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	360
H7	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	60
	P1 T250D	0,0020	0,0024	0,0028	0,0032	0,0038	0,0040	0,0044	195
H8	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	110
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	360
H11	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	140
	P1 T250D	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	460
H12	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	130
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	425
H21	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	110
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	360

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire

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SD523 Viteza de aşchiere

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

SMG = Grupa de material Seco V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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SD524 Ø 17-60 mm / 0.590-2.375 inci

SMG		f							V <sub>c</sub>
		Ø 15,00-19,49 Ø 0.590-0.767	Ø 19,50-22,49 Ø 0.768-0.885	Ø 22,50-28,49 Ø 0.886-1.121	Ø 28,50-34,49 Ø 1.122-1.357	Ø 34,50-40,49 Ø 1.358-1.593	Ø 40,49-44,49 Ø 1.594-1.751	Ø 44,50-59,99 Ø 1.752-2.375	
P1	P1 DP2000	0,060	0,070	0,085	0,095	0,11	0,12	0,13	380
	P1 DP2000	0,0024	0,0028	0,0034	0,0038	0,0044	0,0048	0,0050	1250
P2	P1 DP2000	0,060	0,070	0,085	0,10	0,11	0,12	0,13	370
	P1 DP2000	0,0024	0,0028	0,0034	0,0040	0,0044	0,0048	0,0050	1225
P3	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	285
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0085	0,0085	0,010	940
P4	P2 DP3000	0,12	0,13	0,16	0,19	0,22	0,22	0,25	165
	P2 DP3000	0,0048	0,0050	0,0065	0,0075	0,0085	0,0085	0,010	540
P5	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	160
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	520
P6	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	180
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	590
P7	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	170
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	560
P8	P2 DP3000	0,12	0,14	0,17	0,19	0,22	0,22	0,26	160
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0085	0,0085	0,010	520
P11	P2 DP3000	0,11	0,13	0,16	0,18	0,20	0,22	0,25	165
	P2 DP3000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,010	540
P12	P2 DP3000	0,075	0,090	0,11	0,12	0,14	0,15	0,17	95
	P2 DP3000	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	310
M1	P2 DP3000	0,085	0,10	0,12	0,14	0,16	0,17	0,19	235
	P2 DP3000	0,0034	0,0040	0,0048	0,0055	0,0065	0,0065	0,0075	770
M2	P2 DP3000	0,080	0,090	0,11	0,13	0,14	0,15	0,17	190
	P2 DP3000	0,0032	0,0036	0,0044	0,0050	0,0055	0,0060	0,0065	620
M3	MP DS2050	0,065	0,075	0,090	0,10	0,12	0,13	0,14	145
	MP DS2050	0,0026	0,0030	0,0036	0,0040	0,0048	0,0050	0,0055	475
M4	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	105
	MP DS2050	0,0022	0,0026	0,0032	0,0036	0,0040	0,0044	0,0048	345
M5	MP DS2050	0,055	0,065	0,080	0,090	0,10	0,11	0,12	90
	MP DS2050	0,0022	0,0026	0,0032	0,0036	0,0040	0,0044	0,0048	295
K1	P2 DP2000	0,12	0,14	0,17	0,20	0,22	0,24	0,26	210
	P2 DP2000	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	690
K2	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	180
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	590
K3	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	155
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	510
K4	P2 DP2000	0,11	0,13	0,16	0,18	0,20	0,22	0,24	145
	P2 DP2000	0,0044	0,0050	0,0065	0,0070	0,0080	0,0085	0,0095	475
K5	P2 DP2000	0,10	0,11	0,14	0,16	0,18	0,19	0,22	85
	P2 DP2000	0,0040	0,0044	0,0055	0,0065	0,0070	0,0075	0,0085	280
N1	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	270
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	890
N2	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	175
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	570
N3	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	115
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	375
N11	P1 T250D	0,12	0,14	0,17	0,20	0,22	0,24	0,26	230
	P1 T250D	0,0048	0,0055	0,0065	0,0080	0,0085	0,0095	0,010	750
S1	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	48
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	155
S2	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	39
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	130
S3	MP DS2050	0,085	0,10	0,12	0,14	0,16	0,17	0,19	33
	MP DS2050	0,0034	0,0040	0,0048	0,0055	0,0065	0,0065	0,0075	110
S11	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	70
	MP DS2050	0,0044	0,0048	0,0060	0,0065	0,0075	0,0080	0,0095	230
S12	MP DS2050	0,11	0,12	0,15	0,17	0,19	0,20	0,24	55
	MP DS2050	0,0044	0,0048	0,0060	0,0065	0,0075	0,0080	0,0095	180
S13	MP DS2050	0,090	0,11	0,13	0,15	0,17	0,18	0,20	41
	MP DS2050	0,0036	0,0044	0,0050	0,0060	0,0065	0,0070	0,0080	135
H3	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	50
	P1 T250D	0,0020	0,0024	0,0028	0,0032	0,0038	0,0040	0,0044	165
H5	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	95
	P1 T250D	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	310
H7	P1 T250D	0,050	0,060	0,070	0,080	0,095	0,10	0,11	50
	P1 T250D	0,0020	0,0024	0,0028	0,0032	0,0038	0,0040	0,0044	165
H8	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	95
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	310
H11	P1 T250D	0,075	0,090	0,11	0,12	0,14	0,15	0,17	125
	P1 T250D	0,0030	0,0036	0,0044	0,0048	0,0055	0,0060	0,0065	410
H12	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	110
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	360
H21	P1 T250D	0,060	0,070	0,085	0,095	0,11	0,11	0,13	95
	P1 T250D	0,0024	0,0028	0,0034	0,0038	0,0044	0,0044	0,0050	310

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire

SD524 Viteza de aşchiere

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

SMG = Grupa de material Seco V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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SD525 Ø 19-45 mm / 0.768-2.000 inci

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

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire



## SD525 Viteza de aşchiere

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

SMG = Grupa de material Seco V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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

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

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire

## SD542 Viteza de aşchiere

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

SMG = Grupa de material Seco V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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SD572 Ø 15-52 mm / 0.590-2.0472 inci

SMG	f							V <sub>c</sub>
	Ø15,00-17,00 Ø 0.590-0.669	Ø18,00-20,00 Ø 0.670-0.787	Ø21,00-24,00 Ø 0.788-0.944	Ø25,00-32,00 Ø 0.945-1.259	Ø33,00-36,00 Ø 1.260-1.417	Ø37,00-52,00 Ø 1.418-1.850		
P1	85 DP3000	0,042	0,042	0,048	0,060	0,070	0,085	310
	85 DP3000	0.0017	0.0017	0.0019	0.0024	0.0028	0.0034	1025
P2	85 DP3000	0,042	0,042	0,050	0,060	0,070	0,085	305
	85 DP3000	0.0017	0.0017	0.0020	0.0024	0.0028	0.0034	1000
P3	86 DP3000	0,12	0,12	0,13	0,17	0,19	0,22	260
	86 DP3000	0.0048	0.0048	0.0050	0.0065	0.0075	0.0085	850
P4	86 DP3000	0,11	0,11	0,13	0,16	0,19	0,22	230
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0075	0.0085	750
P5	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	220
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	720
P6	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	245
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	800
P7	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	235
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	770
P8	86 DP3000	0,12	0,12	0,13	0,17	0,19	0,22	220
	86 DP3000	0.0048	0.0048	0.0050	0.0065	0.0075	0.0085	720
P11	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	225
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	740
P12	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	135
	86 DP3000	0.0030	0.0030	0.0034	0.0044	0.0048	0.0060	445
M1	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	235
	86 DP3000	0.0030	0.0030	0.0034	0.0044	0.0048	0.0060	770
M2	86 DP3000	0,070	0,070	0,080	0,10	0,11	0,14	190
	86 DP3000	0.0028	0.0028	0.0032	0.0040	0.0044	0.0055	620
M3	85 DP3000	0,034	0,034	0,040	0,048	0,055	0,070	145
	85 DP3000	0.0013	0.0013	0.0016	0.0019	0.0022	0.0028	475
M4	85 DP3000	0,030	0,030	0,034	0,042	0,050	0,060	110
	85 DP3000	0.0012	0.0012	0.0013	0.0017	0.0020	0.0024	360
M5	85 DP3000	0,030	0,030	0,034	0,042	0,050	0,060	90
	85 DP3000	0.0012	0.0012	0.0013	0.0017	0.0020	0.0024	295
K1	86 DP3000	0,12	0,12	0,14	0,17	0,20	0,24	180
	86 DP3000	0.0048	0.0048	0.0055	0.0065	0.0080	0.0095	590
K2	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	155
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	510
K3	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	130
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	425
K4	86 DP3000	0,11	0,11	0,13	0,16	0,18	0,22	125
	86 DP3000	0.0044	0.0044	0.0050	0.0065	0.0070	0.0085	410
K5	86 DP3000	0,10	0,10	0,11	0,14	0,16	0,19	75
	86 DP3000	0.0040	0.0040	0.0044	0.0055	0.0065	0.0075	245
S1	85 DP3000	0,055	0,055	0,060	0,075	0,090	0,11	40
	85 DP3000	0.0022	0.0022	0.0024	0.0030	0.0036	0.0044	130
S2	85 DP3000	0,055	0,055	0,060	0,075	0,090	0,11	30
	85 DP3000	0.0022	0.0022	0.0024	0.0030	0.0036	0.0044	100
S3	85 DP3000	0,050	0,050	0,060	0,070	0,085	0,10	30
	85 DP3000	0.0020	0.0020	0.0024	0.0028	0.0034	0.0040	100
S11	85 DP3000	0,060	0,060	0,070	0,090	0,10	0,12	80
	85 DP3000	0.0024	0.0024	0.0028	0.0036	0.0040	0.0048	260
S12	85 DP3000	0,060	0,060	0,070	0,090	0,10	0,12	60
	85 DP3000	0.0024	0.0024	0.0028	0.0036	0.0040	0.0048	195
S13	85 DP3000	0,055	0,055	0,060	0,075	0,090	0,11	47
	85 DP3000	0.0022	0.0022	0.0024	0.0030	0.0036	0.0044	155
H3	86 DP3000	0,050	0,050	0,060	0,070	0,085	0,10	80
	86 DP3000	0.0020	0.0020	0.0024	0.0028	0.0034	0.0040	260
H5	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	150
	86 DP3000	0.0030	0.0030	0.0034	0.0044	0.0048	0.0060	490
H7	86 DP3000	0,050	0,050	0,060	0,070	0,085	0,10	80
	86 DP3000	0.0020	0.0020	0.0024	0.0028	0.0034	0.0040	260
H8	86 DP3000	0,060	0,060	0,065	0,085	0,095	0,11	150
	86 DP3000	0.0024	0.0024	0.0026	0.0034	0.0038	0.0044	490
H11	86 DP3000	0,075	0,075	0,085	0,11	0,12	0,15	195
	86 DP3000	0.0030	0.0030	0.0034	0.0044	0.0048	0.0060	640
H12	86 DP3000	0,060	0,060	0,065	0,085	0,095	0,11	80
	86 DP3000	0.0024	0.0024	0.0026	0.0034	0.0038	0.0044	260
H21	86 DP3000	0,060	0,060	0,065	0,085	0,095	0,11	150
	86 DP3000	0.0024	0.0024	0.0026	0.0034	0.0038	0.0044	490

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

## SD572 Viteza de aşchiere

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

SMG = Grupa de material Seco  $V_c = m/min$  (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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Anexă

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

SMG		f					V <sub>c</sub>
		Ø60,00-69,99 Ø 2.362-2.755	Ø70,00-91,99 Ø 2.756-3.621	Ø92,00-110,99 Ø 3.622-4.369	Ø111,00-134,99 Ø 4.370-4.314	Ø135,00-160,00 Ø 4.315-6.300	
P1	P2 DP3000	0,085	0,095	0,12	0,13	0,12	295
	P2 DP3000	0,0034	0,0038	0,0048	0,0050	0,0048	970
P2	P2 DP3000	0,085	0,10	0,12	0,13	0,12	285
	P2 DP3000	0,0034	0,0040	0,0048	0,0050	0,0048	940
P3	P2 DP3000	0,17	0,19	0,22	0,26	0,22	245
	P2 DP3000	0,0065	0,0075	0,0085	0,010	0,0085	800
P4	P2 DP3000	0,16	0,19	0,22	0,25	0,22	130
	P2 DP3000	0,0065	0,0075	0,0085	0,010	0,0085	425
P5	P2 DP3000	0,16	0,18	0,22	0,25	0,22	125
	P2 DP3000	0,0065	0,0070	0,0085	0,010	0,0085	410
P6	P2 DP3000	0,16	0,18	0,22	0,25	0,22	140
	P2 DP3000	0,0065	0,0070	0,0085	0,010	0,0085	460
P7	P2 DP3000	0,16	0,18	0,22	0,25	0,22	135
	P2 DP3000	0,0065	0,0070	0,0085	0,010	0,0085	445
P8	P2 DP3000	0,17	0,19	0,22	0,26	0,22	125
	P2 DP3000	0,0065	0,0075	0,0085	0,010	0,0085	410
P11	P2 DP3000	0,16	0,18	0,22	0,25	0,22	130
	P2 DP3000	0,0065	0,0070	0,0085	0,010	0,0085	425
P12	P2 DP3000	0,11	0,12	0,15	0,17	0,15	75
	P2 DP3000	0,0044	0,0048	0,0060	0,0065	0,0060	245
M1	P2 DP3000	0,12	0,14	0,17	0,19	0,17	215
	P2 DP3000	0,0048	0,0055	0,0065	0,0075	0,0065	710
M2	P2 DP3000	0,11	0,13	0,15	0,17	0,15	175
	P2 DP3000	0,0044	0,0050	0,0060	0,0065	0,0060	570
M3	P1 DP3000	0,090	0,10	0,12	0,14	0,12	135
	P1 DP3000	0,0036	0,0040	0,0048	0,0055	0,0048	445
M4	P1 DP3000	0,075	0,090	0,11	0,12	0,11	100
	P1 DP3000	0,0030	0,0036	0,0044	0,0048	0,0044	330
M5	P1 DP3000	0,075	0,090	0,11	0,12	0,11	85
	P1 DP3000	0,0030	0,0036	0,0044	0,0048	0,0044	280
K1	P2 DP3000	0,17	0,20	0,24	0,26	0,24	175
	P2 DP3000	0,0065	0,0080	0,0095	0,010	0,0095	570
K2	P2 DP3000	0,16	0,18	0,22	0,24	0,22	150
	P2 DP3000	0,0065	0,0070	0,0085	0,0095	0,0085	490
K3	P2 DP3000	0,16	0,18	0,22	0,24	0,22	130
	P2 DP3000	0,0065	0,0070	0,0085	0,0095	0,0085	425
K4	P2 DP3000	0,16	0,18	0,22	0,24	0,22	120
	P2 DP3000	0,0065	0,0070	0,0085	0,0095	0,0085	395
K5	P2 DP3000	0,14	0,16	0,19	0,22	0,19	75
	P2 DP3000	0,0055	0,0065	0,0075	0,0085	0,0075	245
H3	P2 DP3000	0,070	0,080	0,10	0,11	0,10	42
	P2 DP3000	0,0028	0,0032	0,0040	0,0044	0,0040	140
H5	P2 DP3000	0,11	0,12	0,15	0,17	0,15	80
	P2 DP3000	0,0044	0,0048	0,0060	0,0065	0,0060	260
H7	P2 DP3000	0,070	0,080	0,10	0,11	0,10	42
	P2 DP3000	0,0028	0,0032	0,0040	0,0044	0,0040	140
H8	P2 DP3000	0,085	0,095	0,11	0,13	0,11	80
	P2 DP3000	0,0034	0,0038	0,0044	0,0050	0,0044	260
H11	P2 DP3000	0,11	0,12	0,15	0,17	0,15	100
	P2 DP3000	0,0044	0,0048	0,0060	0,0065	0,0060	330
H12	P2 DP3000	0,085	0,095	0,11	0,13	0,11	45
	P2 DP3000	0,0034	0,0038	0,0044	0,0050	0,0044	150
H21	P2 DP3000	0,085	0,095	0,11	0,13	0,11	80
	P2 DP3000	0,0034	0,0038	0,0044	0,0050	0,0044	260

SMG = Grupa de material Seco f = mm/rev (IPR) V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pomire

SD602 Viteza de aşchiere

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

SMG = Grupa de material Seco v<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

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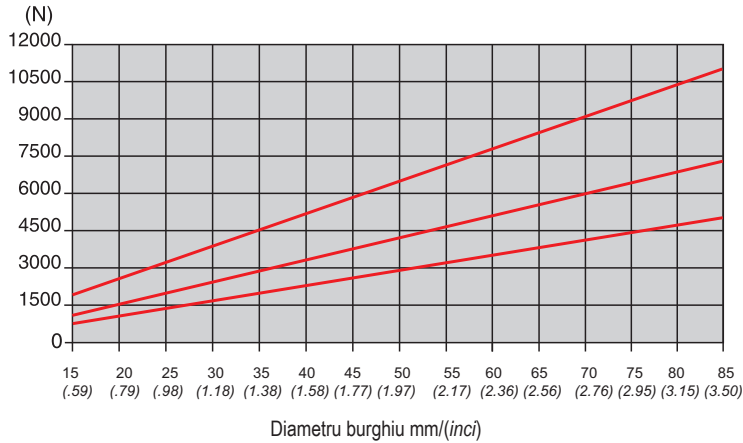
Anexă

## Parametri de prelucrare SD522, SD523, SD524, SD525, SD542 și SD572 – consum de putere, volum de lichid de răcire și grafice cu forțe

Valorile din grafic pot varia în funcție de ex. regimurile de așchiere, materialul, eficiența mașinii și uzura sculei.

Graficele de mai jos sunt valabile pentru Grupa de materiale Seco (SMG) P5-P6 și viteza de așchiere de 200 m/min (655 sf/m).

### Forța avansului

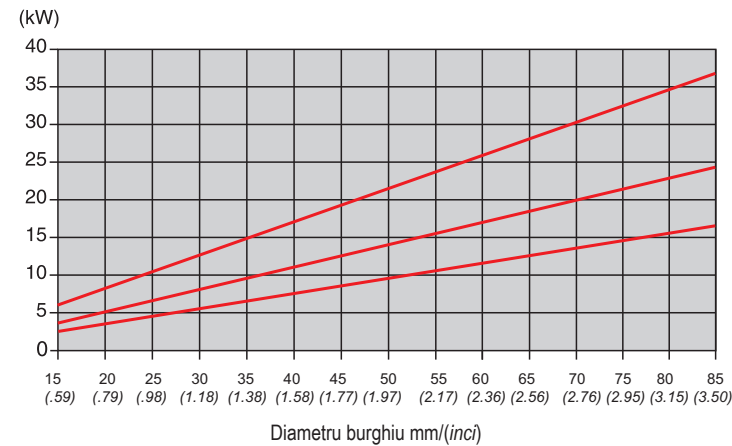


$f = 0,18$  mm/rot  
( $f = 0,007$  inci/rot)

$f = 0,12$  mm/rot  
( $f = 0,005$  inci/rot)

$f = 0,08$  mm/rot  
( $f = 0,003$  inci/rot)

### Consumul net de putere

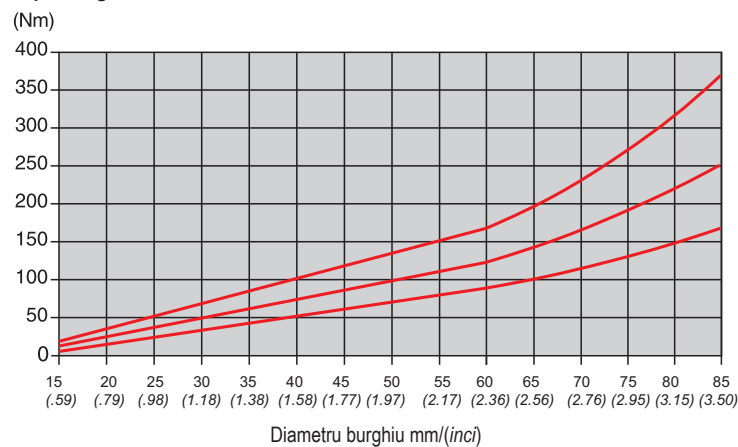


$f = 0,18$  mm/rot  
( $f = 0,007$  inci/rot)

$f = 0,12$  mm/rot  
( $f = 0,005$  inci/rot)

$f = 0,08$  mm/rot  
( $f = 0,003$  inci/rot)

### Cuplul la găurire



$f = 0,18$  mm/rot  
( $f = 0,007$  inci/rot)

$f = 0,12$  mm/rot  
( $f = 0,005$  inci/rot)

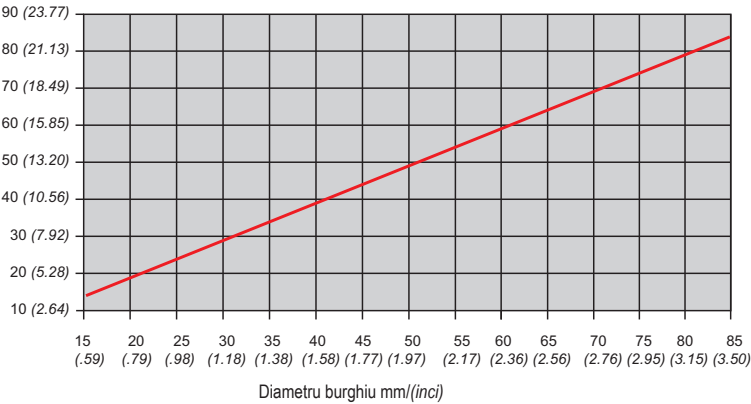
$f = 0,08$  mm/rot  
( $f = 0,003$  inci/rot)



## Parametri de prelucrare

### Necesitățile privind volumul lichidului de răcire

Litri/minut (galoane/minut)

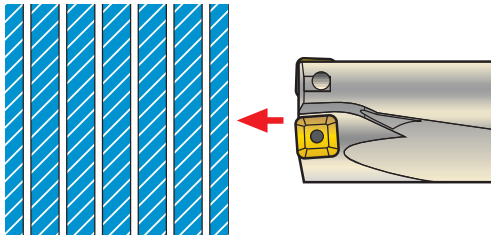


### Necesitățile privind presiunea lichidului de răcire

#### Presiune recomandată bari (PSI)

Adâncimea de găurire	Diametrul burghiului mm (inci)		
	15-25 (0,591-0,984)	> 25-40 > 0,984-1,575	> 40 > 1,575
< 3 x D	6 (87)	4,5 (65)	3 (44)
≥ 3 x D	12 (174)	9 (130)	6 (87)

### Găurirea materialelor suprapuse



Găurirea materialelor suprapuse fără goluri de aer între straturi, max. 0,2 mm (0,008”), poate fi executată cu burghiile SD522 2 x D, SD523 3 x D și SD542 2.5 x D și SD542 2.5 x D. Materialele trebuie să fie bine fixate și nu trebuie să apară încovoiere la străpungerea fiecărui strat.

### Recomandări pentru regimul de așchiere și plăcuțe la găurirea materialelor suprapuse.

Geometria plăcuțe amovibile:	Geometria plăcuțe	Calități de carbură:
Plăcuță centrală	SPGX-C1	T400D
Plăcuța periferică	SCGX-P2	DP3000

**Viteza de așchiere:** Consultați recomandările pentru calitatea carburii DP3000

**Avans/rotație:** Consultați recomandările pentru geometria P2

Dacă survin probleme la străpungerea fiecărui strat, reduceți avansul/rotația cu 30-50 %.

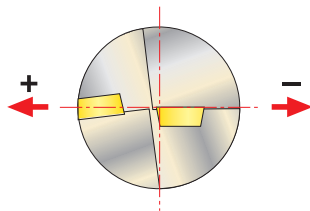
#### Atenție!

Discul produs la ieșirea burghiului poate fi aruncat cu viteză mare la utilizarea burghiului ca scula staționară, (rotirea semifabricatului).

Este foarte important să vă asigurați că mașina este bine protejată pentru a asigura siguranța operatorului.

### Configurare

**Reglarea diametrului găurii și recomandări de configurare** Burghiile cu plăcuțe pot fi montate excentric pentru a obține un diametru al găurii mai mic sau mai mare decât burghiul în sine. Pentru măsurători, consultați „Ajustare radială” în tabelul cu parametrii de sculă din paginile catalogului.



#### Rotativ

Port-scula reglabilă Seco este recomandată pentru setarea de precizie IT10 a diametrului găurii la utilizarea SD522 și SD523, 3 x D ca burghie rotative.

#### Staționară

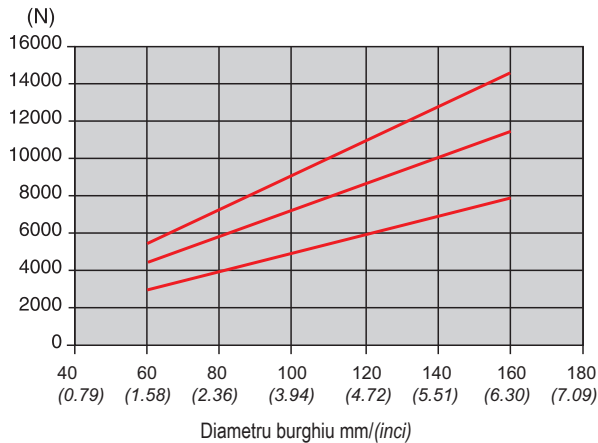
La montarea burghiului, asigurați-vă că muchiile așchietoare sunt paralele cu ghidajele saniei transversale și că axa centrală a burghiului și a piesei de prelucrat sunt aliniată. Pentru a obține un diametru mai mare al găurii, poziționați burghiul în așa fel încât plăcuța periferică să se îndepărteze de axa centrală a piesei de prelucrat.

## Parametri de aşchiere SD602 – Consum de putere, necesităţi de volum de lichid de răcire şi grafice cu forţe

Valorile din grafic pot varia, de ex. regimurile de aşchiere, materialul, cu eficienţa maşinii de 80%.

Graficele de mai jos sunt valabile pentru SMG P5-P6 şi viteza de aşchiere de 200 m/min (655 sf/min).

### Forţa avansului

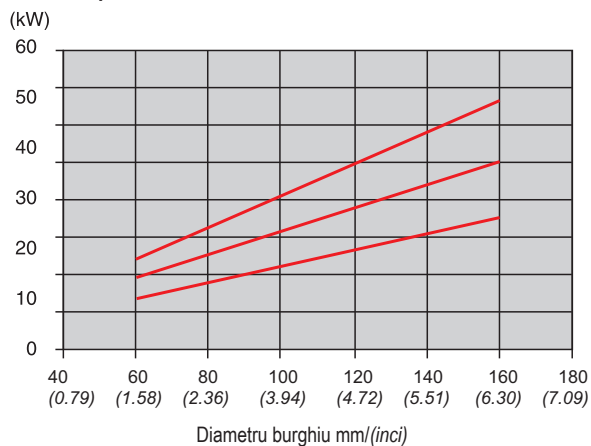


f = 0,18 mm/rot  
(f = 0,007 inci/rot)

f = 0,12 mm/rot  
(f = 0,005 inci/rot)

f = 0,08 mm/rot  
(f = 0,003 inci/rot)

### Consumul net de putere

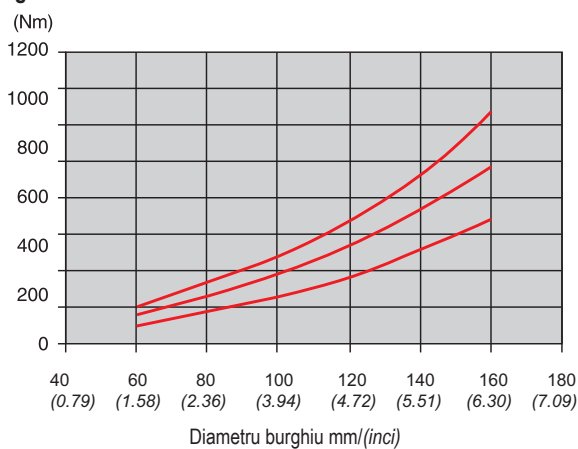


f = 0,18 mm/rot  
(f = 0,007 inci/rot)

f = 0,12 mm/rot  
(f = 0,005 inci/rot)

f = 0,08 mm/rot  
(f = 0,003 inci/rot)

### Cuplul la găurire



f = 0,18 mm/rot  
(f = 0,007 inci/rot)

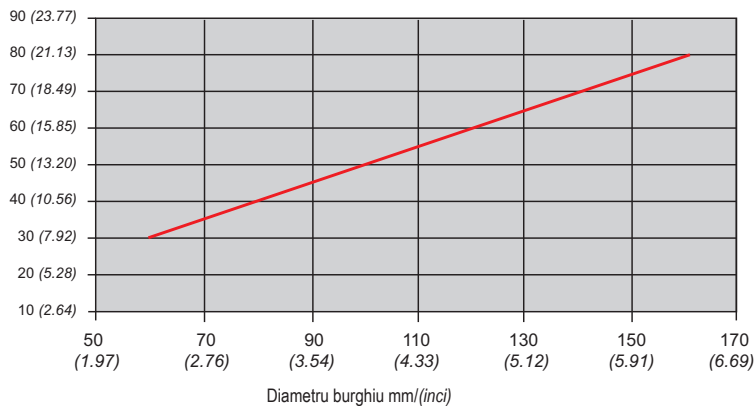
f = 0,12 mm/rot  
(f = 0,005 inci/rot)

f = 0,08 mm/rot  
(f = 0,003 inci/rot)

## Parametri de prelucrare SD602

### Necesitățile privind volumul lichidului de răcire

Litri/minut (galoane/minut)



### Metode

Nerecomandat	Soluție
	<p>1.  2. </p>
	<p>1.  2. </p>
	<p>1.  2. </p> <p>&gt; 5xD</p>

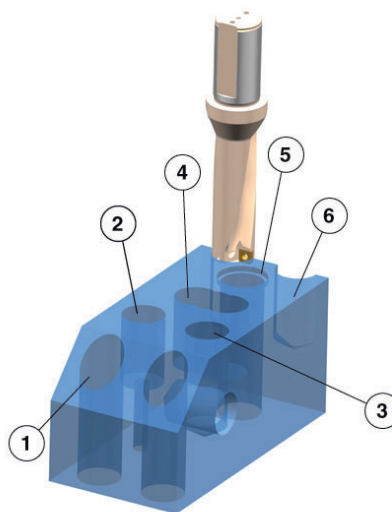
## Polivalență

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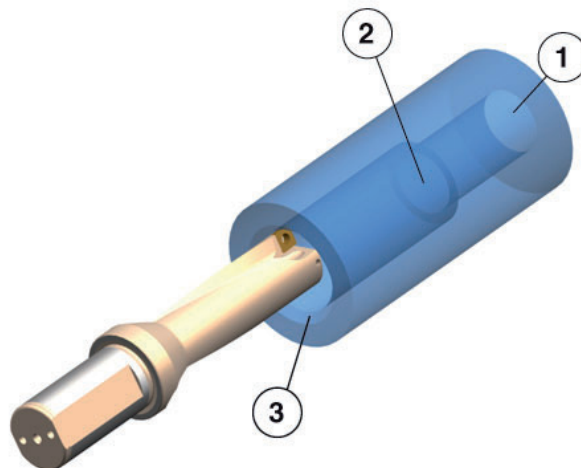
### Aplicații

1. Găuri cu intrare în unghi
2. Alezare adâncă
3. Găurire transversal cu o gaură existentă
4. Găurire și frezare axială
5. Găurire și frezare anti-orară cu interpolare circulară
6. Frezare axială



### Mai multe opțiuni pentru operații statice

1. Găurire
2. Alezare adâncă / Gaură conică
3. Șanfrezare



### Recomandări

- Burghie 2 x D și 3 x D (SD522, SD523)
- Reduceți avansul ~ 50% atunci când burghiul nu este complet antrenat
- Utilizați calitatea DP3000
- Utilizați fragmentatorul de așchii -P2

Alezare adâncă

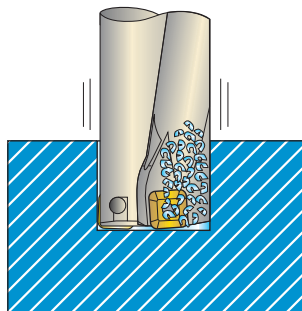
Anexă

## Depanare

### Vibrații

#### Aplicații

- Verifică prinderea burghiului
- Verifică fixarea piesei de prelucrat
- Mărește avansul. Dacă este un material foarte maleabil, reduceți avansul și creșteți viteza
- Mărește viteza de așchiere



#### Cuplu insuficient

- Reduceți avansul
- Alege o geometrie cu fragmentator puternic pentru avansuri mai mici.

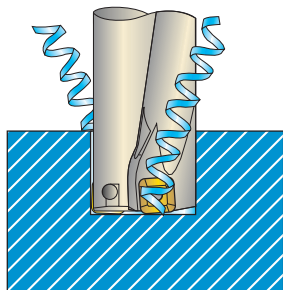
#### Putere insuficientă

- Reduceți viteza de așchiere
- Reduceți avansul
- Alegeți o geometrie cu un fragmentator de așchii mai puternic pentru avansuri mai mici (SCGX-P1)

### Probleme cu blocarea așchiilor

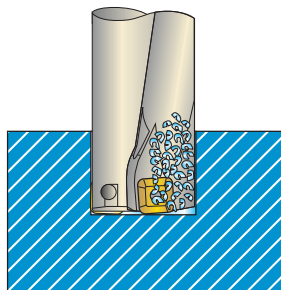
#### Probleme cu blocarea așchiilor din cauza așchiilor lungi

- Măriți avansul. Dacă este un material foarte moale, reduceți avansul și creșteți viteza
- Alegeți o geometrie cu fragmentator de așchii mai puternic pentru avansuri mai mici (SCGX-P1)



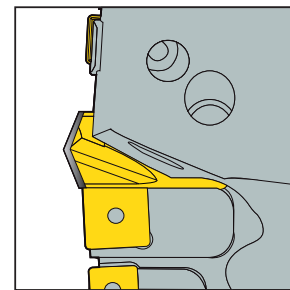
#### Probleme cu blocarea așchiilor în ciuda așchiilor scurte

- Măriți presiunea/volumul lichidului de răcire
- Reduceți viteza de așchiere



#### Uzura rapidă a flancului pe burghiul de centrare

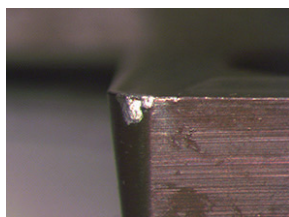
- Reduceți viteza de așchiere
- Mărește concentrația lichidului de răcire



### Probleme cu durata de viață a sculei

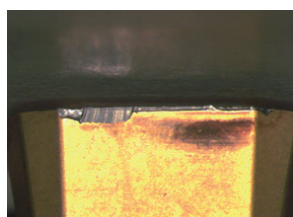
#### Ciobirea plăcuței periferice

- Reduceți avansul la intrare
- Alege o calitate mai dură
- Alege o geometrie cu un fragmentator pentru avansuri mari (SCGX-P2)
- Reduceți avansul
- Reduceți viteza de așchiere



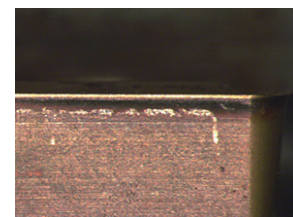
#### Ciobirea plăcuței centrale

- Verifică prinderea burghiului
- Verifică fixarea piesei de prelucrat
- Reduceți avansul la intrare
- Mărește avansul
- Reduceți viteza de așchiere



#### Uzură rapidă a flancului la plăcuța periferică

- Reduceți viteza de așchiere
- Mărește presiunea lichidului de răcire
- Alege o calitate mai rezistentă la uzură



## Port-scule ajustabile

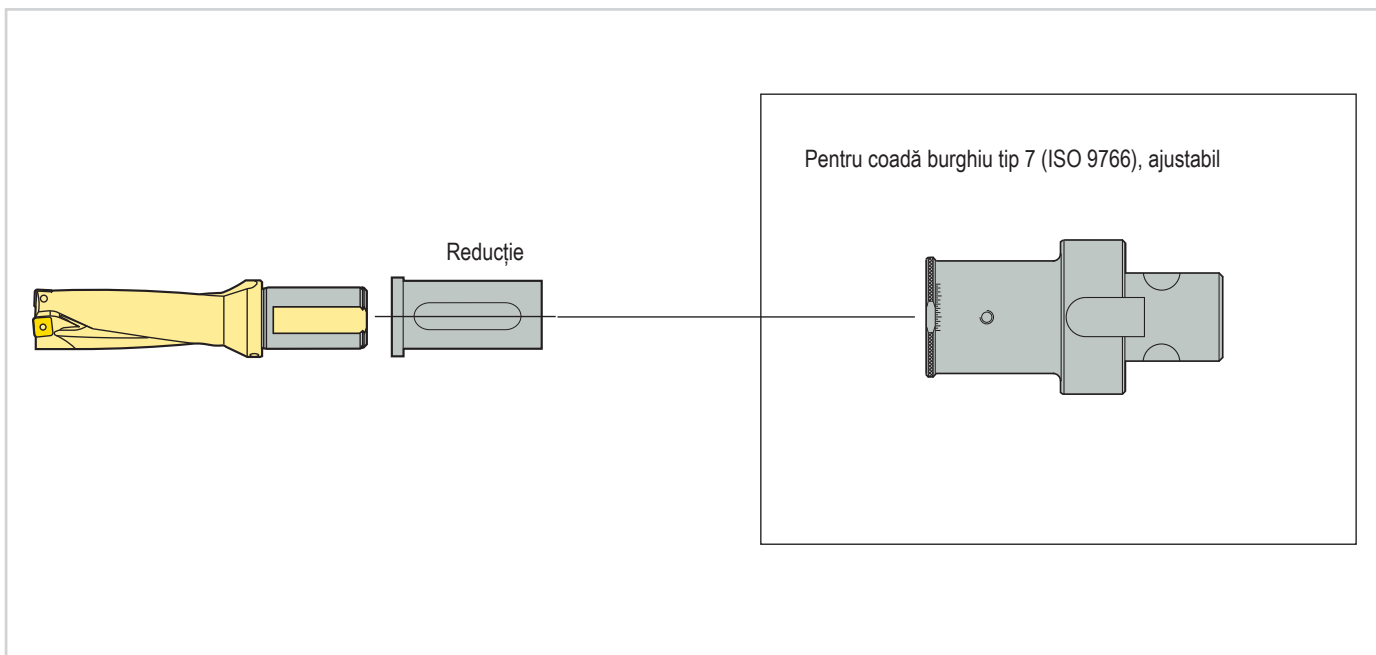
Introducere

Găurire

Alezare

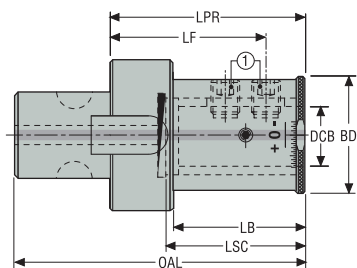
Alezare adâncă

Anexă



## Tip BM/6100-6101 - Port-sculă ajustabilă pentru burghiu, pentru cozi de burghiu tip 7

Graflex®



1. Șurub de blocare



- Pentru burghie Performax®
- Ajustabil de la -0,3 mm la +0,8 mm

Număr reper	Reper Nr.	Spre mașină Dimensiune coadă Graflex	Spre semifabricat Pentru burghiu tip coadă									Greutate kg lbs	Echili- brare
				DCB	OAL	LPR	BD	LF	LB	LSC			
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci		
02422113	BM061610025	G6	R7	25,0 0.984	110,0 4.331	70,0 2.756	49,0 1.929	55,0 2.165	54,0 2.126	54,0 2.126	1,12 2.470	PB	
02422116	BM061610125	G6	R7	25,4 1.000	110,0 4.331	70,0 2.756	49,0 1.929	55,0 2.165	54,0 2.126	54,5 2.146	1,11 2.450	PB	
02422114	BM061610032	G6	R7	32,0 1.260	125,0 4.921	85,0 3.346	71,0 2.795	70,0 2.756	66,0 2.598	60,5 2.382	2,09 4.610	PB	
02422118	BM061610138	G6	R7	38,1 1.500	125,0 4.921	85,0 3.346	81,0 3.189	70,0 2.756	66,0 2.598	60,5 2.382	2,45 5.400	PB	
02422115	BM061610040	G6	R7	40,0 1.575	125,0 4.921	85,0 3.346	81,0 3.189	70,0 2.756	66,0 2.598	60,5 2.382	2,38 5.250	PB	

### Piese de schimb

Pentru DCB	Șurub de blocare	Cep
25/0.984	950AF1210014	90M61
25,4/1.000	950AF1210014	90M61
32/1.260	950AF1210020	90M61
38,1/1.500	950AF1210020	90M61
40/1.575	950AF1210020	90M61

### Accesorii

Pentru DCB	Cheie (tip T)	Cheie	Man'on reducție	Man'on reducție 2
25/0.984	DOUBLE-T	H6B-H6.0L	-	-
25,4/1.000	DOUBLE-T	H6B-H6.0L	-	-
32/1.260	DOUBLE-T	H6B-H6.0L	05B61003225	-
38,1/1.500	-	H06-4	-	-
40/1.575	DOUBLE-T	H6B-H6.0L	05B61004025	05B61004032

PB=Pre-echilibrate din construcție (vezi Ghidul de echilibrare din catalogul Sisteme de Scule pentru mai multe informații)

# ALEZARE



## PRECIMASTER™ PLUS CAP DE ALEZARE INTERSCHIMBABIL, PENTRU MANIPULARE RAPIDĂ ȘI UȘOARĂ

Precimaster™ Plus este un sistem de alezor modular care crește viteza de alezare, stabilitatea și versatilitatea pentru realizare de găuri mai precisă și mai rentabilă. Dezvoltat pe baza succesului originalului Precimaster™, sistemul dispune de o conexiune inovatoare de înaltă precizie, capete de unică folosință din carbură solidă și port-scule comune pentru aplicații de gaură înfundată și străpunsă.

### TOLERANȚE

- Menține toleranțe între 15 și 25 micrometri și permite finisări de suprafețe de Ra 0,4 până la Ra 0,8  $\mu\text{m}$  (RMS 15 - 35 micro/inci)

### CARACTERISTICI

- Sistemul dispune de o conexiune inovatoare de înaltă precizie, capete de unică folosință din carbură solidă, precum și de port-scule comune pentru aplicații de gaură înfundată și străpunsă.

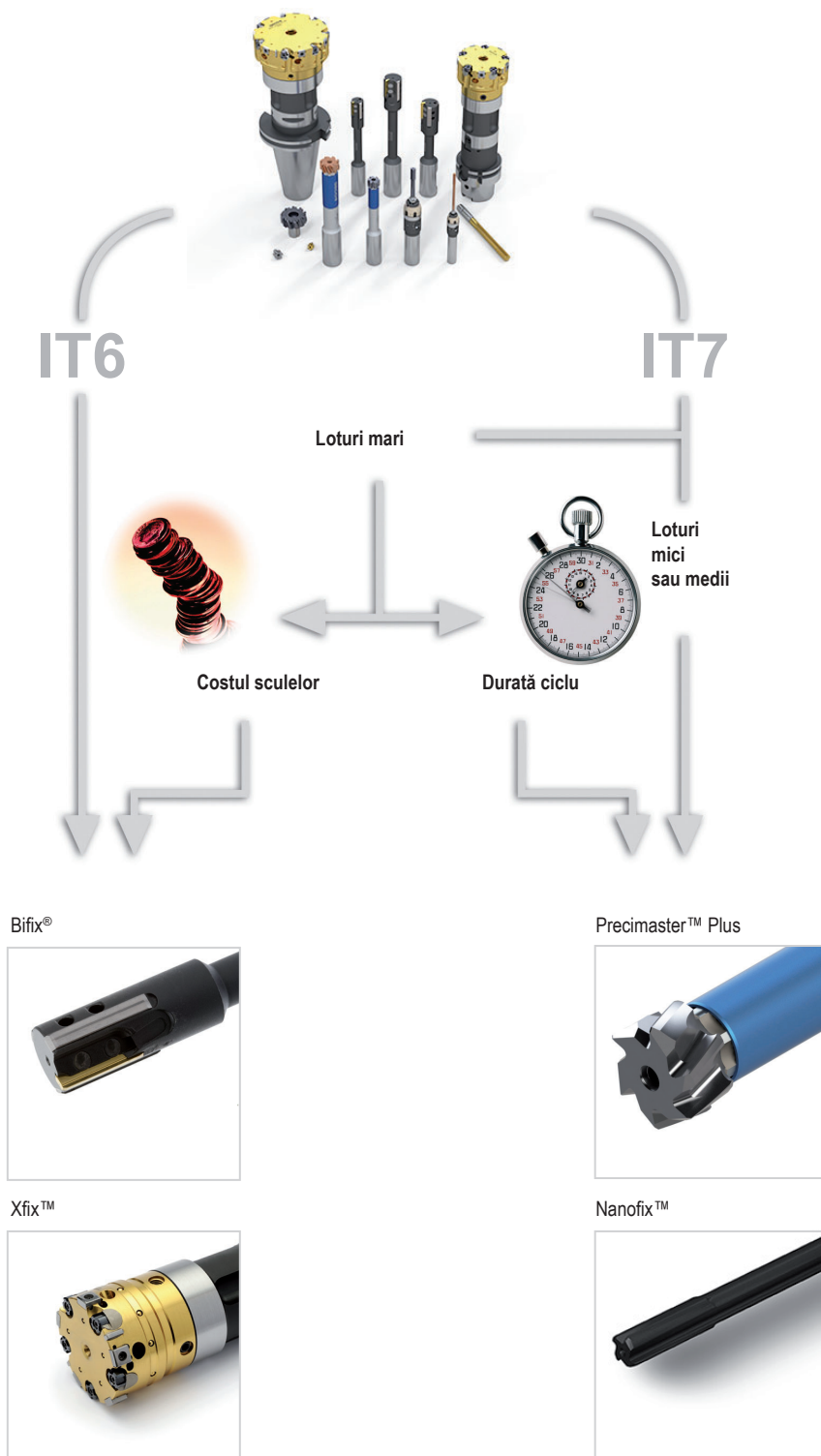




## Mai multe muchii sau plăcuțe amovibile - Alegerea celei mai bune soluții

Calitate, performanță și costul sculei, toate trei obiectivele pot fi atinse. Alegerea alezătorului depinde de toleranța găurii, cantitatea de producție și durata unui ciclu. Sistemele de prelucrare a alezajelor Seco pot atinge aceste cerințe. Cu alezătoarele Precimaster, Bifix, noile Xfix și Nanofix, Seco poate rezolva toate problemele legate de operațiile de alezare.

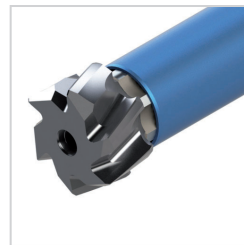
Tabelul de mai jos vă ajută să alegeți scula de alezare ideală.



Bifix®



Precimaster™ Plus



Xfix™



Nanofix™



## Prezentare generală

	Ø Gamă	Adâncimea de alezare	Toleranța Ø gaură	Diametre intermediare	Finisarea suprafeței
<b>Precimaster™ Plus</b>  Pag. 329-367	7,75-60,500 mm (0.3051-2.3818")	~ 2-10 x D	IT 6-7-8	Da, disponibil în Custom design	R <sub>a</sub> 0,2-1,2 μm (Ra 7.87-47.2 μin)
<b>Nanofix™</b>  Pag. 368-397	2,970-12,050 mm (0.1169-0.4744")	~ 5-12 x D	IT 7	Da, disponibil în Custom design	R <sub>a</sub> 0,2-1,2 μm (Ra 7.87-47.2 μin)
<b>Bifix®</b>  Pag. 398-424	5,900-60,500 mm (0.2323-2.3819")	~ 2-7 x D	IT 6-7	Da, disponibil în Custom design	R <sub>a</sub> 0,2-0,8 μm (Ra 7.87-31.5 μin)
<b>Xfix™</b>  Pag. 425-465	39,500-154,500 mm (1.5551-6.0827")	~ 2,5-6,5 x D	IT 6	Da, disponibil în Custom design	R <sub>a</sub> 0,8-1,6 μm (Ra 31-63 μin)



## Precimaster™ Plus

Precimaster™ Plus este un sistem de alezor modular care crește viteza de alezare, stabilitatea și versatilitatea pentru realizare de găuri mai precisă și mai rentabilă.

- Sistemul dispune de conexiune inovatoare de înaltă precizie, capete de unică folosință din carbură solidă, precum și port-scule comune pentru aplicații de găuri înfundate și străpunse
- Permite toleranțe între 15 și 25 micrometri și finisări de suprafețe de Ra 0,4 până la Ra 0,8  $\mu\text{m}$  (RMS 15 până la 35 micro/inci)

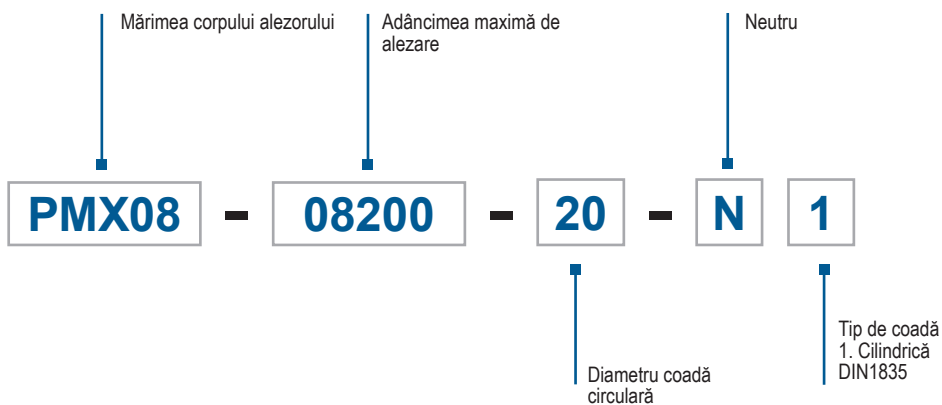
## Precimaster™ Plus – Prezentare generală

	Ø Gamă	Adâncimea de alezare	Toleranța Ø gaură	Diametre intermediare	Finisarea suprafeței
Introducere 	7,75-60 mm (0.3051-2.3622")	~ 2-3 x D	IT 6-7-8	Da, disponibil în Custom design	R <sub>a</sub> 0,4-0,8 μm (Ra 15.7-31.5 μin)
Găurire 	7,75-60 mm (0.3051-2.3622")	~ 4-5 x D	IT 6-7-8	Da, disponibil în Custom design	R <sub>a</sub> 0,4-0,8 μm (Ra 15.7-31.5 μin)
Alezare 	7,75-60 mm (0.3051-2.3622")	~ 8-10 x D	IT 6-7-8	Da, disponibil în Custom design	R <sub>a</sub> 0,4-0,8 μm (Ra 15.7-31.5 μin)

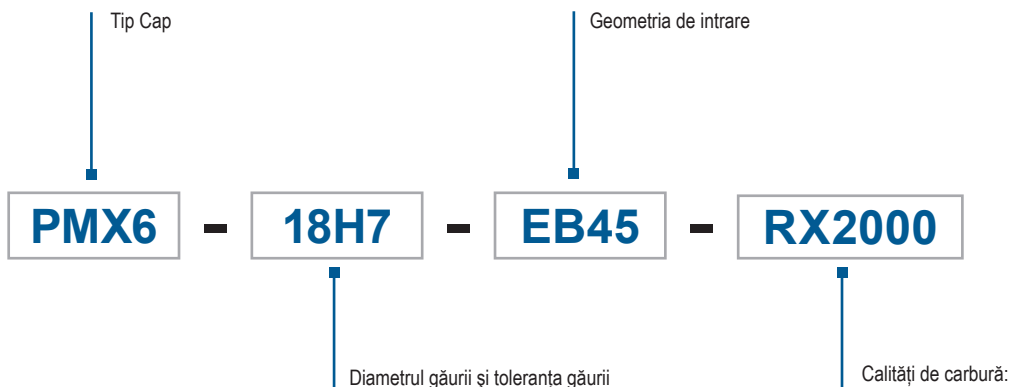
## Codificări

Cozile Precimaster Plus se pot folosi atât la găuri înfundate cât și la cele străpuse.

### Coadă sculei

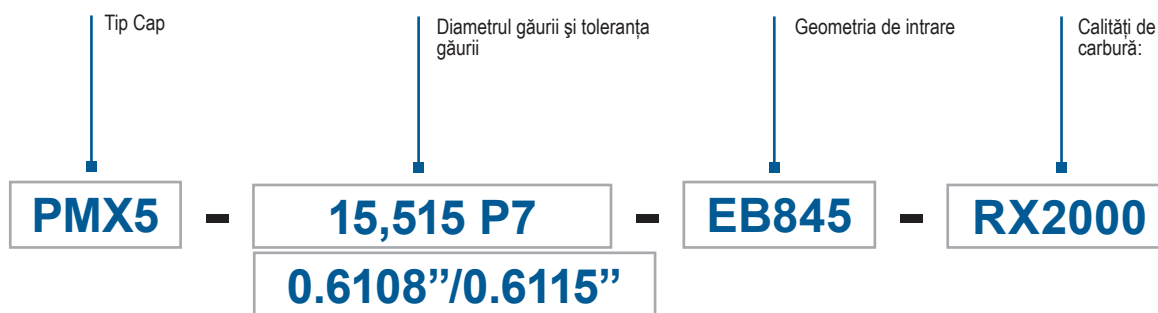


### Cap

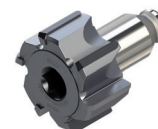


PMX6

### Diametru intermediar cap



PMX5

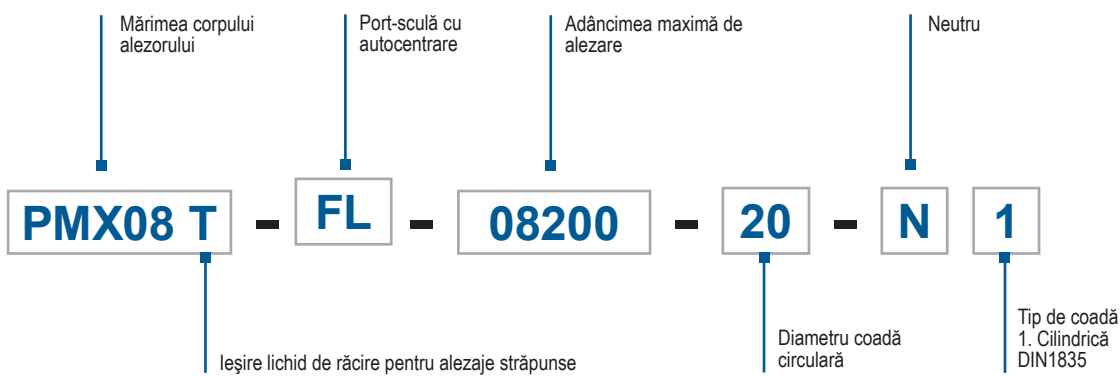
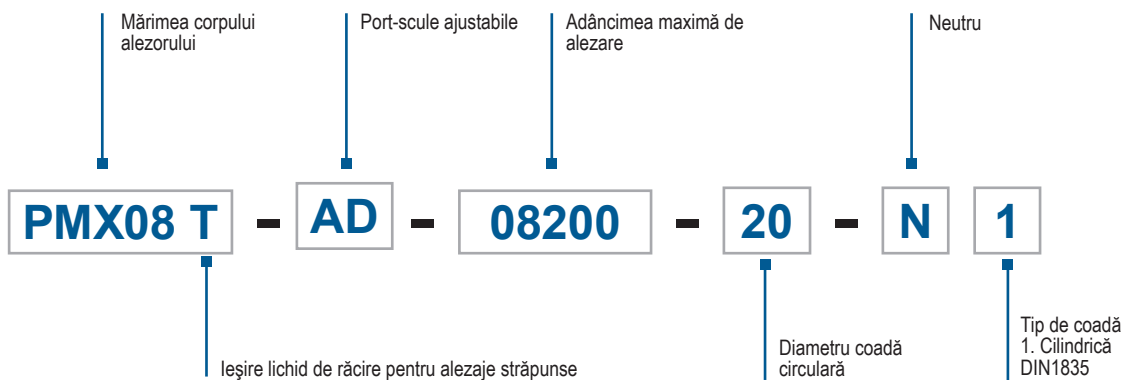
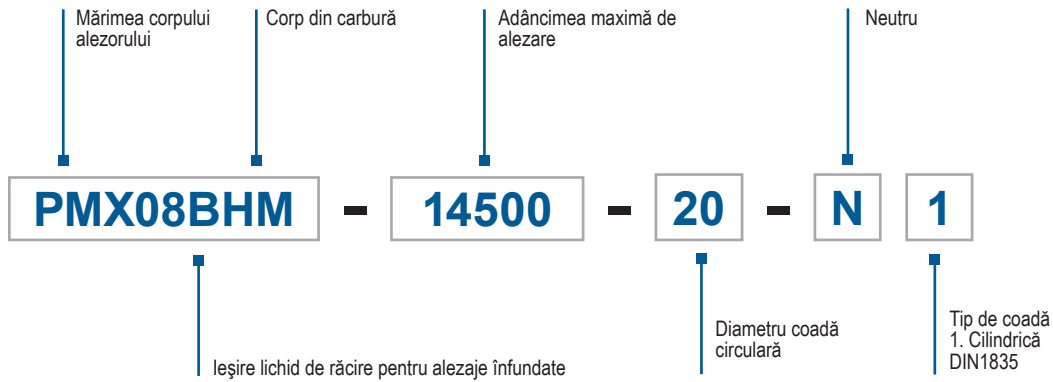


PMX8

PMX5 : Design cu caneluri drepte, pentru găuri înfundate sau străpuse.  
 PMX6 : Design cu caneluri elicoidale, doar pentru găuri străpuse.  
 PMX8 : Caneluri drepte, expandabil, pentru găuri înfundate sau străpuse.  
 Designul cu caneluri pe stânga asigură împingerea așchiilor spre înainte.  
 Consultați pagina cu opțiunile de cap Precimaster Plus 338.

## Codificări

Cozile Precimaster Plus se pot folosi atât la găuri înfundate cât și la cele străpunse.



## Reglarea lichidului de răcire

### Procedura de reglare a ieșirii lichidului de răcire: Descrierea pieselor de schimb

Manșon de răcire pentru ieșirea lichidului de răcire pentru găuri străpuse

Șurub pentru ieșirea lichidului de răcire pentru găuri străpuse

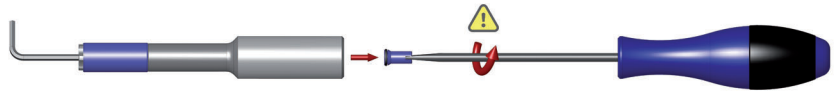
Cheie de prindere (inclusă în livrare)

Șurub pentru ieșirea lichidului de răcire pentru găuri înfundate (inclus în livrare)

### Procedura de reglare a ieșirii lichidului de răcire: Reglarea pentru găuri înfundate

1.

Scoateți șurubul pentru alezare străpunsă (albastru)  
**Notă:** șuruburile sunt șuruburi de stânga

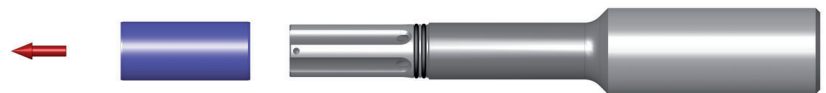


Folosiți o șurubelniță lată SAU o cheie Allen, recomandări de mărime conform tabelului

Mărimea corpului	Mărimea șurubelniței late mm	Mărimea șurubelniței late inci	Mărimea cheii Allen mm	Mărimea cheii Allen inci
PMX05	1,2 x 4 x 120	0,05 x 0,16 x 4,72	2 x 120	0,08 x 4,72
PMX06	1,0 x 5,5 x 150	0,04 x 0,22 x 5,9	2,5 x 150	0,10 x 5,9
PMX08	1,2 x 6,5 x 200	0,05 x 0,26 x 7,87	3 x 200	0,12 x 7,87
PMX12	1,2 x 8 x 200	0,05 x 0,31 x 6,89	5 x 200	0,2 x 6,89

2.

Scoateți manșonul de lichid de răcire



3.

Instalați șurubul pentru alezări înfundate (roșu)  
**Notă:** șuruburile sunt șuruburi de stânga



## Montarea capului

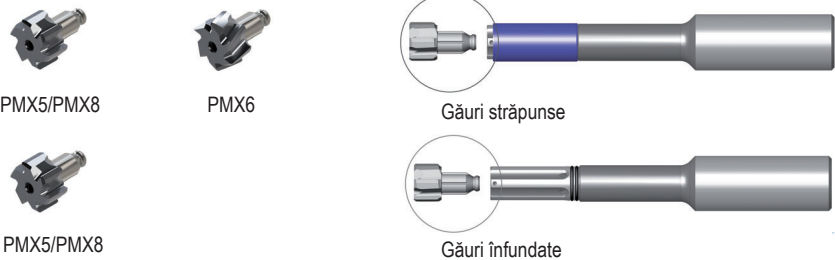
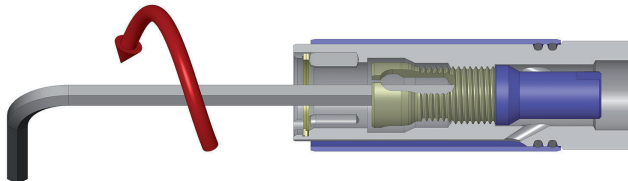
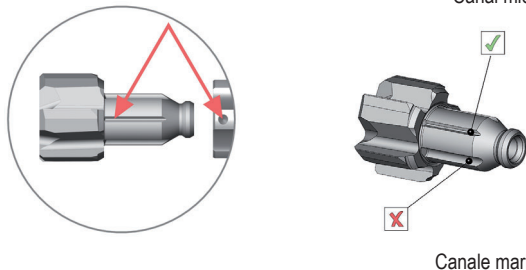
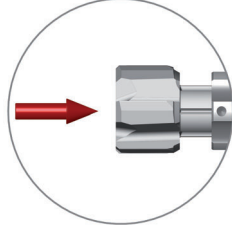
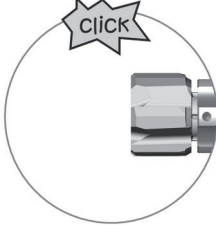
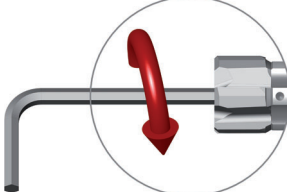
Introducere

Găurire

Alezare

Alezare adâncă

Anexă

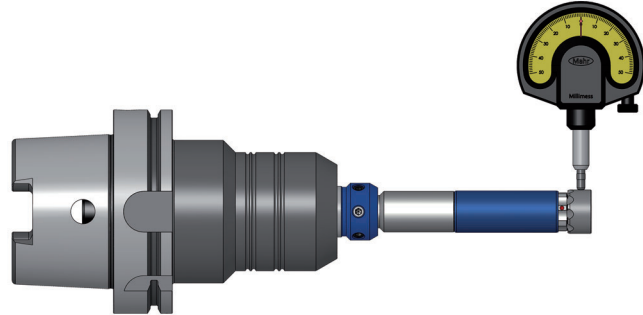
<p><b>1.</b> Asigurați-vă că geometria capului este adecvată pentru tipul de lichid de răcire</p>	 <p>PMX5/PMX8      PMX6</p> <p>PMX5/PMX8</p> <p>Găuri străpunse</p> <p>Găuri înfundate</p>												
<p><b>2.</b> Pozitionați clema înainte de montarea capului</p>													
<p><b>3.</b> Aliniați canalul de rotire cu punctul roșu de pe corp</p>	 <p>Canal mic</p> <p>Canale mari</p>												
<p><b>4.</b> Amplasați capul în corp</p>													
<p><b>5.</b> Apăsați capul în corp până se aude un „clic”</p>	 <p>click</p>												
<p><b>6.</b> Strângeți capul cu ajutorul cheii Allen</p>	 <table border="1" data-bbox="1029 1780 1412 1960"> <thead> <tr> <th>PMX Mărimea cozii</th> <th>Recommended clamping torque</th> </tr> </thead> <tbody> <tr> <td>PMX05</td> <td>0,5 Nm</td> </tr> <tr> <td>PMX06</td> <td>0,9 Nm</td> </tr> <tr> <td>PMX08</td> <td>1,2 Nm</td> </tr> <tr> <td>PMX12</td> <td>2,0 Nm</td> </tr> <tr> <td>PMX16</td> <td>5,0 Nm</td> </tr> </tbody> </table>	PMX Mărimea cozii	Recommended clamping torque	PMX05	0,5 Nm	PMX06	0,9 Nm	PMX08	1,2 Nm	PMX12	2,0 Nm	PMX16	5,0 Nm
PMX Mărimea cozii	Recommended clamping torque												
PMX05	0,5 Nm												
PMX06	0,9 Nm												
PMX08	1,2 Nm												
PMX12	2,0 Nm												
PMX16	5,0 Nm												



## Reglare - Bătaia radială

### Aplicații dinamice

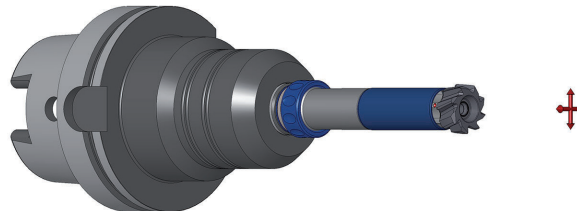
Bătaia radială maximă recomandată: 10-15  $\mu\text{m}$  (393,7008-590,5512  $\mu\text{in}$ ).  
Se recomandă prinderea în mandrină hidraulică, Shrinkfit, port-sculă sau mandrină cu pensete de precizie.  
Pentru un control cât mai bun al bătaii radiale, se recomandă utilizarea adaptoarelor reglabile Precimaster Plus PMX-AD, consultați paginile 351-352.



### Aplicații statice

Utilizați port-sculele flotante Precimaster Plus PMX - FL, consultați paginile 353-354.

Port-sculele cu autocentrare permit autocentrarea alezorului în gaura prelucrată.



### Cerințele lichidului de răcire

Pentru a obține o viață lungă a sculei și o calitate ridicată a găurii, trebuie ținut cont de următoarele caracteristici ale lichidului de răcire. Se recomandă răcirea interioară.

Se poate utiliza alimentare externă cu lichid de răcire pentru adâncime de alezare <math>< 2 \times D</math>.

Ulei solubil de calitate cu minim 40% ulei mineral.

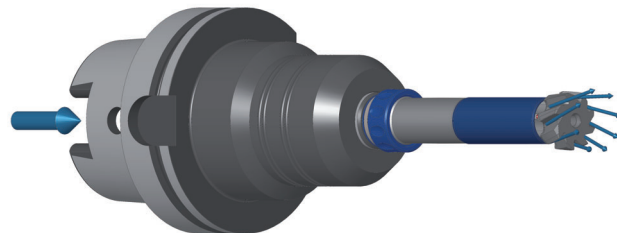
Se recomandă ulei curat pentru oțel inoxidabil.

Concentrația minimă 6-8 %.

Filtrare 30-50  $\mu\text{m}$  (1200-2000  $\mu\text{in}$ ).

Volum min. 0,5 l/min/mm (3,35 gal/min/inci) din diametrul sculei.

(Ex: Alezor  $\varnothing$  10, volum min. este 5 l/min (1,3 gal/min)).



### Măsurarea diametrului

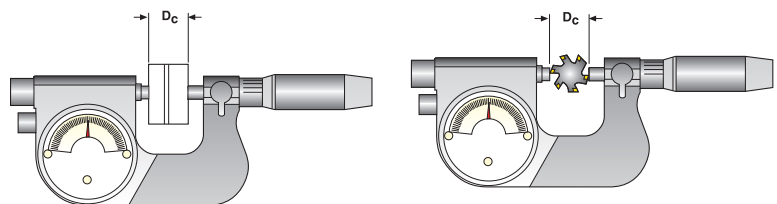
Calibrați ceasul micrometrului înainte de măsurătoare.

#### Important

Alezoarele Precimaster au pas diferențial al dinților.

La măsurarea diametrului se utilizează 2 dinți opuși la 180°.

La calibrare utilizați un comparator micrometric și o cală de calibrare.



## Reglarea configurării cozilor:

Introducere

Găurire

Alezare

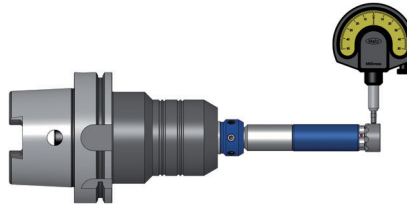
Alezare adâncă

Anexă

**1.**

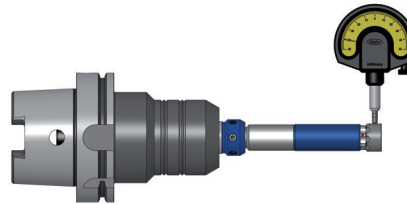
Instalați masterul de setare (furnizat cu port-sculă reglabilă).

Instalați scula în capul de alezare.



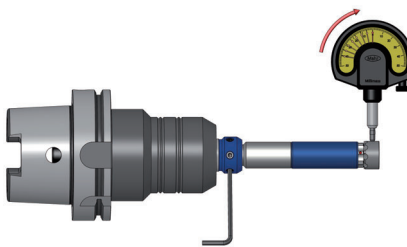
**2.**

Setați comparatorul după cum este indicat.



**3.**

Rotiți manual scula până se atinge punctul cel mai de jos.

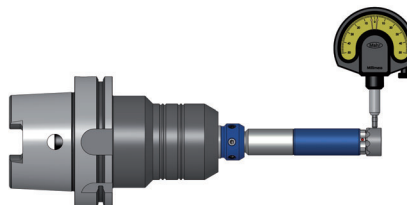


**4.**

Compensează bătaia radială folosind șuruburile de reglaj. Direcția așa cum este indicată prin săgeți.

**5.**

Verificați bătaia radială și repetați compensarea, dacă este necesar.



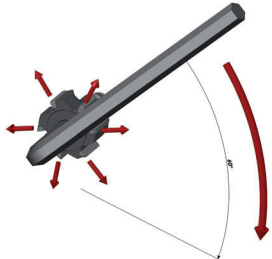
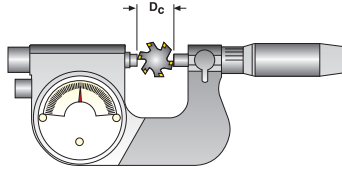
**6.**

Dacă bătaia radială este mai mică de  $5 \mu\text{m}$  ( $197 \mu\text{in}$ ), asigurați strângerea șuruburilor de reglare pentru a nu pierde reglarea

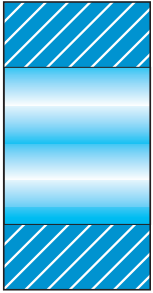


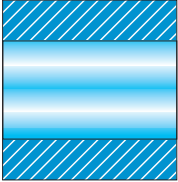

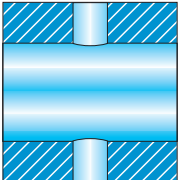
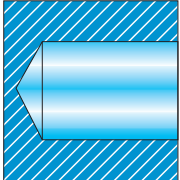
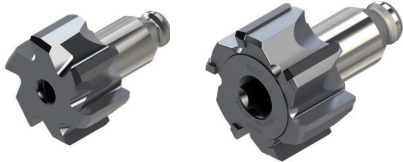

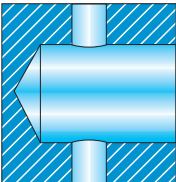
## Configurare cozi flotante:

<p><b>1.</b> Blocați complet coada flotantă prin rotirea în sensul acelor de ceasornic a inelului de reglare.</p>	
<p><b>2.</b> Deschideți coada flotantă 2 sau 3 clicuri rotind inelul de reglare în sens invers acelor de ceasornic.</p>	
<p><b>3.</b> Continuați cu reglarea suplimentară a valorii flotante, dacă este necesar. O valoarea flotantă prea mare poate crea condiții instabile la intrarea alezajului. O valoarea prea mică duce la apariția vibrațiilor și poate produce o gaură conică.</p>	

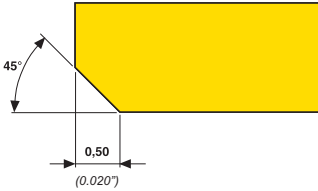
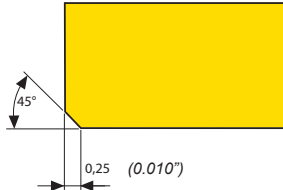
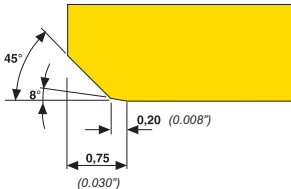
## Compensare uzură alezoz expandabil

<p><b>1.</b> Folosiți o cheie Allen hexagonală pentru a compensa uzura diametrului sculei (trepte de 60° = aproximativ 0,005 mm (0,0002") compensare a diametrului)</p>	
<p><b>2.</b> Verifică dimensiunea Ø după expansiune utilizând un comparator</p>	

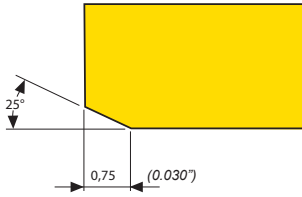
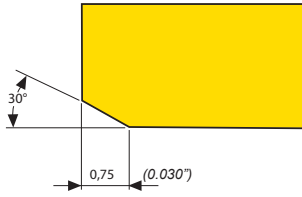
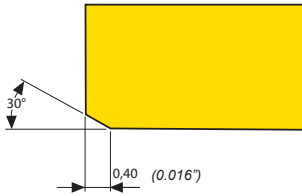
## Opțiune de cap

Piesă de prelucrat	Diametru de alezat $\varnothing$ 8-60 mm (0,3150-2,3622")	
<p>Găuri străpunse scurte &lt; 3 x D</p> 	<p><b>PMX5 / PMX8</b></p> 	
<p>Găuri străpunse lungi &gt; 3 x D</p> 	<p><b>PMX6</b> Pentru aplicații de alezaje străpunse, ieșirea lichidului de răcire al port-sucei trebuie setată pentru găuri străpunse: consultați paginile referitoare la configurarea agentului de răcire.</p> 	
<p>Găuri încrucișate</p> 		
<p>Găuri înfundate</p> 	<p><b>PMX5/PMX8</b> Pentru aplicații de alezaje străpunse, ieșirea lichidului de răcire al port-sucei trebuie setată pentru găuri străpunse: consultați paginile referitoare la configurarea agentului de răcire</p> 	
<p>Găuri înfundate și încrucișate</p> 		

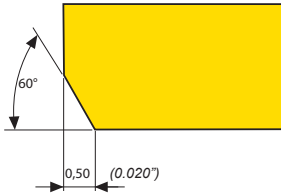
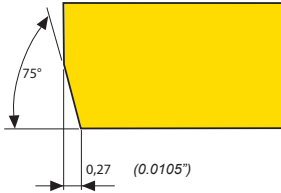
## Alegerea geometriei - Aplicații

Geometria vârfului - EB45	
<p>Controlul asupra formării așchiilor ++                      Finisarea suprafeței +++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math>                      (Finisarea suprafeței +++ <math>R_a</math> 31 - 47 <math>\mu\text{in}</math>)                      Versatil</p>	
Geometria vârfului - EBS45	
<p>Controlul asupra formării așchiilor +++                      Finisarea suprafeței + <math>R_a</math> 0,8- 1,2                      (Finisarea suprafeței + <math>R_a</math> 31- 47 <math>\mu\text{in}</math>)                      Scurt EB45</p>	
Geometria vârfului - EB845	
<p>Controlul asupra formării așchiilor ++                      Finisarea suprafeței +++ <math>R_a</math> 0,2 - 0,8 <math>\mu\text{m}</math>                      (Finisarea suprafeței +++ <math>R_a</math> 8 - 31 <math>\mu\text{in}</math>)</p>	

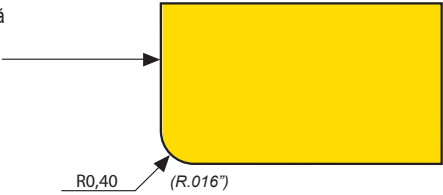
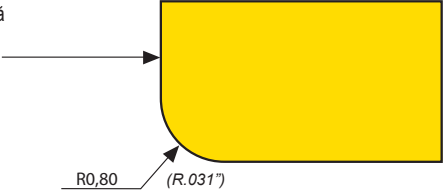
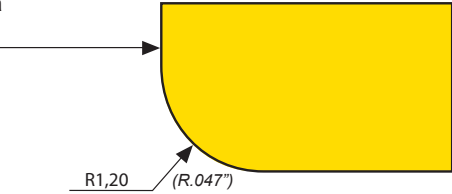
## Alegerea geometriei - Aplicații

<p><b>Geometria vârfului - EB25</b></p> <p>Performanța avansului +++ Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor +</p>	
<p><b>Geometria vârfului - EB30</b></p> <p>Performanța avansului +++ Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor +</p>	
<p><b>Geometria vârfului - EBS30</b></p> <p>Performanța avansului +++ Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor + Scurt EB30</p>	












## Alegerea geometriei - Aplicații

Geometria vârfului - EB60	
<p>Performanța avansului + Finisarea suprafeței ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 31 - 47 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor ++</p>	
Geometria vârfului - EB75	
<p>Performanța avansului + Finisarea suprafeței ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 31 - 47 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor ++</p>	

## Alegerea geometriei - Aplicații

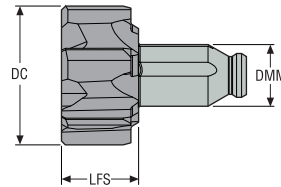
<b>Geometria vârfului - RE040</b>	
<p>Performanța avansului ++ Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor +</p>	<p>Fără așchiere finală</p> 
<b>Geometria vârfului - RE080</b>	
<p>Performanța avansului ++ Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor +</p>	<p>Fără așchiere finală</p> 
<b>Geometria vârfului - RE120</b>	
<p>Performanța avansului ++ Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor + Disponibil de la <math>\varnothing</math> 14 mm (0,551")</p>	<p>Fără așchiere finală</p> 



Calități		
	RX2000	<b>Coated</b> High performance coated grade suitable for all materials.
	CP20	<b>Acoperită</b> O calitate acoperită potrivită pentru majoritatea materialelor, cu excepția aluminiului. TiN
	H15	<b>Neacoperită</b> O calitate rezistentă a microstructurii pentru toate materialele. Potrivită pentru operațiuni de alezare fină datorită unei muchii foarte ascuțite.
	CF	<b>Cermet</b> O calitate rezistentă la uzură pentru performanțe optime în oțel.
	RX1500	<b>Cermet acoperit</b> O calitate acoperită rezistentă la uzură pentru optimizarea performanțelor în oțel și fontă.
	RN2010	<b>Neacoperită</b> Microstructură neacoperită cu geometrie pentru materiale N (neferoase).
	RM2020	<b>Acoperită</b> O calitate rezilientă acoperită potrivită pentru alezare de finisare cu o geometrie optimizată pentru materiale M.
	RM2090	<b>Acoperită</b> Calitate acoperită rezistentă la uzură cu geometrie specifică materialelor M. Optimizare în materiale M.
	RK2050	<b>Acoperită</b> A tough coated grade suitable for fine reaming operation with optimized geometries for K materials.
	RK1550	<b>Cermet acoperit</b> A wear resistant coated grade with specific geometries for K materials. Optimization in K materials.
	RS2090	<b>Acoperită</b> Calitate acoperită rezistentă la uzură cu geometrie specifică materialelor S. Optimizare în materiale S.

## Capete pentru găuri străpunse și înfundare

Ø 8-32 mm / 0.315-1.260"



- Pentru regimurile de așchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	Număr reper	DC	Mărimea burghiului*		LFS	DMM	Mărimea corpului	Geometrii			Calități				
			mm	mm					mm	mm	EB45	EB845	EB30	H15	CP20
PMX5-8H7-EB45	03123158	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	□	□
PMX5-9H7-EB45	03123159	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	□	□
PMX5-10H7-EB30	10020602	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-10H7-EB45	02965840	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-11H7-EB45	02925754	11,0	10,8/10,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-12H7-EB30	10019482	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-12H7-EB45	02925755	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-13H7-EB30	10019483	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-13H7-EB45	02925756	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-14H7-EB30	10019484	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	□	□	■	□	□	■	□	□
PMX5-14H7-EB45	02925757	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX5-15H7-EB30	10019485	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-15H7-EB45	02925758	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-16H7-EB30	10019486	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-16H7-EB45	02925759	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-17H7-EB30	10019487	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-17H7-EB45	02925760	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-18H7-EB30	10019488	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-18H7-EB45	02925761	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-19H7-EB30	10019489	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-19H7-EB45	02925762	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-20H7-EB30	10020603	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	□	□	■	□	□	■	□	□
PMX5-20H7-EB45	02925763	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-21H7-EB45	02925764	21,0	20,8/20,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX5-22H7-EB30	10020604	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-22H7-EB45	02925765	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-23H7-EB30	10019490	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-23H7-EB45	02925766	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-24H7-EB30	10019491	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-24H7-EB45	02925767	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-25H7-EB30	10019492	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-25H7-EB45	02925768	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-26H7-EB30	10019493	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-26H7-EB45	02925769	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-27H7-EB45	02925770	27,0	26,8/26,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-28H7-EB30	10019494	28,0	26,8/26,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□

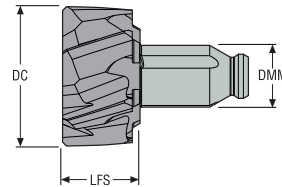
Reper Nr.	Număr reper	DC	Mărimea burghiului*		LFS	DMM	Mărimea corpului	Geometrii			Calități				
			mm	mm				EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX5-28H7-EB45	02925771	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-29H7-EB45	02925772	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-30H7-EB30	10019495	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-30H7-EB45	02925773	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-31H7-EB45	02925774	31,0	30,8/30,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX5-32H7-EB30	10019496	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	□	□	■	□	□	■	□	□
PMX5-32H7-EB45	02925775	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

\*Pentru mai multe informații despre ce alezor să folosiți și cum să-l folosiți vezi pag. 7

■ Stoc standard. □ Non stoc standard.

## Capete pentru găuri străpunse și înfundare

Ø 8-32 mm / 0.315-1.260"



- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

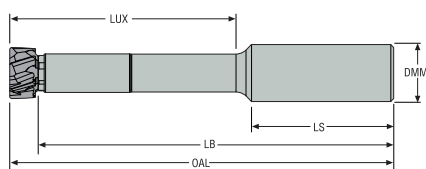
Reper Nr.	Număr reper	DC	Mărimea burghiului*		LFS	DMM	Mărimea corpului	Geometrii			Calități				
			mm	mm				EB45	EB845	EB30	H15	CP20	RX2000	CF	RX1500
PMX6-8H7-EB45	03123161	8,0	7,8/7,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	□	□
PMX6-9H7-EB45	03123162	9,0	8,8/8,9	6	6,0	4,5	PMX05-xx	■	□	□	□	□	■	□	□
PMX6-10H7-EB45	02965863	10,0	9,8/9,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-11H7-EB45	02925776	11,0	10,8/10,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-12H7-EB45	02925777	12,0	11,8/11,908	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-13H7-EB45	02925778	13,0	12,8/12,9	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-14H7-EB45	02925779	14,0	13,8/13,891	6	7,0	6,0	PMX06-xx	■	□	□	□	□	■	□	□
PMX6-15H7-EB45	02925780	15,0	14,8/14,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-16H7-EB45	02925781	16,0	15,8/15,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-17H7-EB45	02925782	17,0	16,8/16,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-18H7-EB45	02925783	18,0	17,8/17,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-19H7-EB45	02925784	19,0	18,8/18,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-20H7-EB45	02925785	20,0	19,8/19,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-21H7-EB45	02925786	21,0	20,8/20,9	6	10,0	8,0	PMX08-xx	■	□	□	□	□	■	□	□
PMX6-22H7-EB45	02925030	22,0	21,8/21,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-23H7-EB45	02925031	23,0	22,8/22,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-24H7-EB45	02925032	24,0	23,813/23,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-25H7-EB45	02925033	25,0	24,8/24,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-26H7-EB45	02925034	26,0	25,8/25,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-27H7-EB45	02925035	27,0	26,8/26,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-28H7-EB45	02925036	28,0	27,8/27,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-29H7-EB45	02925037	29,0	28,8/28,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-30H7-EB45	02925038	30,0	29,8/29,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-31H7-EB45	02925039	31,0	30,8/30,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□
PMX6-32H7-EB45	02925040	32,0	31,8/31,9	8	12,0	12,0	PMX12-xx	■	□	□	□	□	■	□	□

\*Pentru mai multe informații despre ce alezori să folosiți și cum să-i folosiți vezi pag. 7

■ Stoc standard. □ Non stoc standard.

## Cozi pentru găuri străpunse și înfundate

Ø 7,75-60,500 mm / 0.305-2.381"



- Pentru regimurile de așchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339



Reper Nr.	Număr reper	Materialul portsculei	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05-02800-10N1	03123012	Oțel	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05-04100-10N1	02929923	Oțel	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05-10000-10N1	03123013	Oțel	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06-03700-12N1	02925828	Oțel	9,901 - 14,499	84,0	77,0	45,0	37,0	12,0
PMX06-05700-12N1	02925829	Oțel	9,901 - 14,499	104,0	97,0	45,0	57,0	12,0
PMX06-12000-12N1	02925830	Oțel	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX06HM-12000-12N1	02925831	Carbură	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX08-04600-20N1	02925832	Oțel	14,5 - 21,499	99,0	89,0	50,0	46,0	20,0
PMX08-08200-20N1	02925833	Oțel	14,5 - 21,499	135,0	125,0	50,0	82,0	20,0
PMX08-14500-20N1	02925834	Oțel	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX08HM-14500-20N1	02925835	Carbură	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX12-06800-25N1	02925836	Oțel	21,5 - 32,499	127,0	115,0	56,0	68,0	25,0
PMX12-10400-25N1	02925837	Oțel	21,5 - 32,499	163,0	151,0	56,0	104,0	25,0
PMX12-17000-25N1	02925838	Oțel	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX12HM-17000-25N1	02925839	Carbură	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX16-06300-32N1	02925840	Oțel	32,5 - 60,5	124,0	110,0	61,0	63,0	32,0
PMX16-12700-32N1	02925841	Oțel	32,5 - 60,5	188,0	174,0	61,0	127,0	32,0
PMX16-17000-32N1	02925842	Oțel	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0
PMX16HM-17000-32N1	02925843	Carbură	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

## Piese de schimb

Pentru coadă	Pentru Ø (mm)	Cheie clemă	Set clemă	Set răcire	Șurub dop, gaură înfundată	Șurub dop, gaură străpunsă
PMX05	7,75-9,900	1.5SMS795	PMX05-CLKI	RT05-KI	SB05	ST05
PMX06	9,901-14,499	2SMS795	PMX06-CLKI	RT06-KI	SB06	ST06
PMX08	14,5-21,499	2.5SMS795	PMX08-CLKI	RT08-KI	SB08	ST08
PMX12	21,5-32,499	4SMS795	PMX12-CLKI	RT12-KI	SB12	ST12
PMX16	32,5-60	5SMS795	PMX16-CLKI	-	SB16	ST16

\* Piese de schimb doar pentru corpurile PMX16. Pentru PMX16, șuruburile dop sunt folosite și pentru prindere.

Accesorii

For dia. (mm)	Mărimea cozii	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Cheie dinamometrică	Nr. comandă și produs	Cheie dinamometrică	Valoare cuplu
7,750-9,900	PMX05	03178237		–	–	03178196		–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Introducere

Găurire

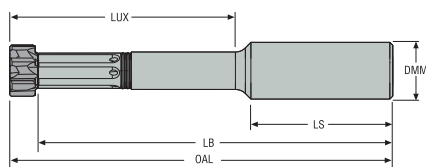
Alezare

Alezare adâncă

Anexă

## Cozi pentru găuri înfundate

Ø 7,75-60,500 mm / 0.305-2.381"



- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339



Reper Nr.	Număr reper	Materialul portsculei	DC	OAL	LB	LS	LUX	DMM
			mm	mm	mm	mm	mm	mm
PMX05B-02800-10N1	03144322	Oţel	7,75 - 9,9	69,0	63,0	40,0	28,0	10,0
PMX05B-04100-10N1	03144323	Oţel	7,75 - 9,9	84,0	78,0	40,0	41,0	10,0
PMX05B-10000-10N1	03144324	Oţel	7,75 - 9,9	143,0	137,0	40,0	100,0	10,0
PMX06B-03700-12N1	03075433	Oţel	9,901 - 14,499	84,0	77,0	45,0	37,0	12,0
PMX06B-05700-12N1	03075434	Oţel	9,901 - 14,499	104,0	97,0	45,0	57,0	12,0
PMX06B-12000-12N1	03075435	Oţel	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX06BHM-12000-12N1	03075436	Carbură	9,901 - 14,499	167,0	160,0	45,0	120,0	12,0
PMX08B-04600-20N1	03075437	Oţel	14,5 - 21,499	99,0	89,0	50,0	46,0	20,0
PMX08B-08200-20N1	03075438	Oţel	14,5 - 21,499	135,0	125,0	50,0	82,0	20,0
PMX08B-14500-20N1	03075439	Oţel	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX08BHM-14500-20N1	03075440	Carbură	14,5 - 21,499	198,0	188,0	50,0	145,0	20,0
PMX12B-06800-25N1	03075441	Oţel	21,5 - 32,499	127,0	115,0	56,0	68,0	25,0
PMX12B-10400-25N1	03075442	Oţel	21,5 - 32,499	163,0	151,0	56,0	104,0	25,0
PMX12B-17000-25N1	03075443	Oţel	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX12BHM-17000-25N1	03075444	Carbură	21,5 - 32,499	229,0	217,0	56,0	170,0	25,0
PMX16B-06300-32N1	03075445	Oţel	32,5 - 60,5	124,0	110,0	61,0	63,0	32,0
PMX16B-12700-32N1	03075446	Oţel	32,5 - 60,5	188,0	174,0	61,0	127,0	32,0
PMX16B-17000-32N1	03075447	Oţel	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0
PMX16BHM-17000-32N1	03075448	Carbură	32,5 - 60,5	231,0	217,0	61,0	170,0	32,0

## Piese de schimb

Pentru coadă	Pentru Ø (mm)	Cheie clemă	Set clemă	Şurub dop, gaură înfundată
PMX05B	7,75-9,900	1.5SMS795	PMX05-CLKI	SB05
PMX06B	9,901-14,499	2SMS795	PMX06-CLKI	SB06
PMX08B	14,500-21,499	2.5SMS795	PMX08-CLKI	SB08
PMX12B	21,500-32,499	4SMS795	PMX12-CLKI	SB12
PMX16B	32,500-60,000	5SMS795	PMX16-CLKI	SB16

\* Piese de schimb doar pentru corpurile PMX16. Pentru PMX16, şuruburile dop sunt folosite şi pentru prindere.

Accesorii

For dia. (mm)	Mărimea cozii	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Cheie dinamometrică	Nr. comandă și produs	Cheie dinamometrică	Valoare cuplu
7,750-9,900	PMX05	03178237		–	–	03178196		–	–	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	5,0 Nm

Introducere

Găurire

Alezare

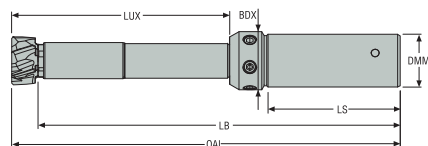
Alezare adâncă

Anexă



## Cozi reglabile pentru găuri străpuse

Ø 7,75-60,500 mm / 0.305-2.381"



- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	Număr reper	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05T-AD-04100-16N1	03271918	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06T-AD-05700-16N1	03002833	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08T-AD-08200-20N1	03002835	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12T-AD-10400-25N1	03002837	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16T-AD-12700-32N1	03002839	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

### Piese de schimb

Pentru coadă	Pentru Ø (mm)	Cheie clemă	Inel răcire	Cheie de reglare	Calibru de reglare
PMX05T	7,750-9,900	1.5SMS795	RT05-KI	2SMS795	PMX05-MSTR
PMX06T	9,901-14,499	2SMS795	RT06-KI	-	PMX06-MSTR
PMX08T	14,50-21,499	2.5SMS795	RT08-KI	-	PMX08-MSTR
PMX12T	21,50-32,499	4SMS795	RT12-KI	3SMS795	PMX12-MSTR
PMX16T	32,50-60,000	5SMS795	-	3SMS795	-

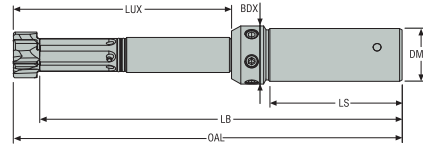
### Accesorii

For dia. (mm)	Mărimea cozii	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Cheie dinamometrică	Nr. comandă și produs	Cheie dinamometrică	Valoare cuplu
7,750-9,900	PMX05	03178237	H00-1.5-27	-	-	03178196	H00-1505-24	-	-	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	-	-	03178197	H00-2009-33	-	-	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	-	-	03178199	H00-2512-40	-	-	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	-	-	03178201	H00-4020-60	-	-	2,0 Nm
32,500-60,500	PMX16	-	-	02506761	H00T-5,0	-	-	03271887	H00T-5050	5,0 Nm

Note: Repair clamp kit PMxx-CLKI are not suitable for PMX FL & AD type

## Cozi reglabile pentru găuri înfundate




Ø 7,75-60,500 mm / 0.305-2.381"




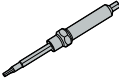

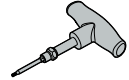
- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	Număr reper	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05B-AD-04100-16N1	03271919	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06B-AD-05700-16N1	03002834	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08B-AD-08200-20N1	03002836	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12B-AD-10400-25N1	03002838	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16B-AD-12700-32N1	03002840	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

### Piese de schimb

Pentru coadă	Pentru Ø (mm)	Cheie clemă	Cheie de reglare	Calibru de reglare
				
PMX05B	7,750-9,900	1.5SMS795	2SMS795	PMX05-MSTR
PMX06B	9,901-14,499	2SMS795	-	PMX06-MSTR
PMX08B	14,50-21,499	2.5SMS795	-	PMX08-MSTR
PMX12B	21,50-32,499	4SMS795	3SMS795	PMX12-MSTR
PMX16B	32,50-60,000	5SMS795	3SMS795	-

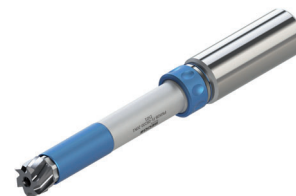
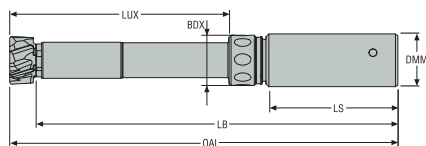
### Accesorii

For dia. (mm)	Mărimea cozii	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Cheie dinamometrică	Nr. comandă și produs	Cheie dinamometrică	Valoare cuplu
										
7,750-9,900	PMX05	03178237	H00-1.5-27	-	-	03178196	H00-1505-24	-	-	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	-	-	03178197	H00-2009-33	-	-	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	-	-	03178199	H00-2512-40	-	-	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	-	-	03178201	H00-4020-60	-	-	2,0 Nm
32,500-60,500	PMX16	-	-	02506761	H00T-5,0	-	-	03271887	H00T-5050	5,0 Nm

Note: Repair clamp kit PMxx-CLKI are not suitable for PMX FL & AD type

## Cozi cu autocentrare pentru găuri străpuse


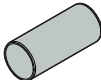
Ø 7,75-60,500 mm / 0.305-2.381"




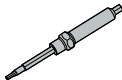

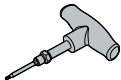
- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	Număr reper	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05T-FL-04100-16N1	03197751	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06T-FL-05700-16N1	03002825	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08T-FL-08200-20N1	03002827	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12T-FL-10400-25N1	03002829	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16T-FL-12700-32N1	03002831	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

### Piese de schimb

Pentru coadă	Pentru Ø (mm)	Cheie clemă	Inel răcire
			
PMX05T	7,750-9,900	1.5SMS795	RT05-KI
PMX06T	9,901-14,499	2SMS795	RT06-KI
PMX08T	14,50-21,499	2.5SMS795	RT08-KI
PMX12T	21,50-32,499	4SMS795	RT12-KI
PMX16T	32,50-60,000	5SMS795	-

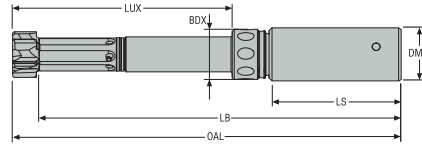
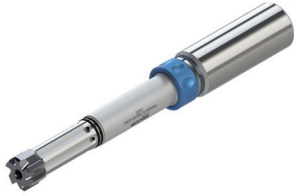
### Accesorii

For dia. (mm)	Mărima cozii	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Cheie dinamometrică	Nr. comandă și produs	Cheie dinamometrică	Valoare cuplu
										
7,750-9,900	PMX05	03178237	H00-1.5-27	-	-	03178196	H00-1505-24	-	-	0,5 Nm
9,901-14,499	PMX06	03178238	H00-2.0-33	-	-	03178197	H00-2009-33	-	-	0,9 Nm
14,500-21,499	PMX08	03178240	H00-2.5-40	-	-	03178199	H00-2512-40	-	-	1,2 Nm
21,500-32,499	PMX12	03178242	H00-4.0-60	-	-	03178201	H00-4020-60	-	-	2,0 Nm
32,500-60,500	PMX16	-	-	02506761	H00T-5,0	-	-	03271887	H00T-5050	5,0 Nm

Note: Repair clamp kit PMxx-CLKI are not suitable for PMX FL & AD type

## Cozi cu autocentrare pentru găuri înfundate

Ø 7,75-60,500 mm / 0.305-2.381"



- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	Număr reper	DC	OAL	LB	LS	LUX	DMM
		mm	mm	mm	mm	mm	mm
PMX05B-FL-04100-16N1	03271916	7,75 - 9,9	102,0	96,0	48,0	41,0	16,0
PMX06B-FL-05700-16N1	03002826	9,901 - 14,499	117,0	110,0	48,0	57,0	16,0
PMX08B-FL-08200-20N1	03002828	14,5 - 21,499	147,0	137,0	50,0	82,0	20,0
PMX12B-FL-10400-25N1	03002830	21,5 - 32,499	179,0	167,0	56,0	104,0	25,0
PMX16B-FL-12700-32N1	03002832	32,5 - 60,5	214,0	200,0	60,0	127,0	32,0

### Piese de schimb

Pentru coadă	Pentru Ø (mm)	Cheie clemă
PMX05B	7,750-9,900	1.5SMS795
PMX06B	9,901-14,499	2SMS795
PMX08B	14,50-21,499	2.5SMS795
PMX12B	21,50-32,499	4SMS795
PMX16B	32,50-60,500	5SMS795

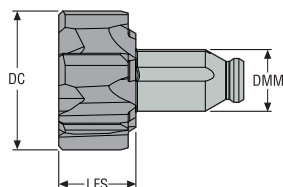
### Accesorii

For dia. (mm)	Mărimea cozii	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Lamă de schimb	Nr. comandă și produs	Cheie dinamometrică	Nr. comandă și produs	Cheie dinamometrică	Valoare cuplu	
7,750-9,900	PMX05	03178237		H00-1.5-27	–	–	03178196	H00-1505-24	–	–	0,5 Nm
9,901-14,499	PMX06	03178238		H00-2.0-33	–	–	03178197	H00-2009-33	–	–	0,9 Nm
14,500-21,499	PMX08	03178240		H00-2.5-40	–	–	03178199	H00-2512-40	–	–	1,2 Nm
21,500-32,499	PMX12	03178242		H00-4.0-60	–	–	03178201	H00-4020-60	–	–	2,0 Nm
32,500-60,500	PMX16	–	–	02506761	H00T-5,0	–	–	03271887	H00T-5050	–	5,0 Nm

Note: Repair clamp kit PMxx-CLKI are not suitable for PMx FL & AD type

## Capete pentru găuri străpunse și înfundare, Custom design

Ø 7,75-60,500 mm / 0.305-2.381"



- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	DCN	DCX	LFS	DMM	Mărimea corpului	Geometrii	Calități												
	mm Inci	mm Inci	mm Inci	mm Inci			H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090		
PMX5-7.75-XX-XXXX	7,75 0.305	9,999 0.394	6,0 0.236	4,5 0.177	6	PMX05-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX5-10.0-XX-XXXX	10,0 0.394	14,499 0.571	7,0 0.276	6,0 0.236	6	PMX06-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX5-14.5-XX-XXXX	14,5 0.571	21,499 0.846	10,0 0.394	8,0 0.315	6	PMX08-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX5-21.5-XX-XXXX	21,5 0.846	32,499 1.279	12,0 0.472	12,0 0.472	8	PMX12-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX5-32.5-XX-XXXX	32,5 1.280	60,5 2.382	14,0 0.551	16,0 0.630	10	PMX16-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

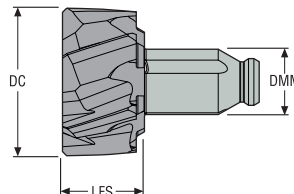
= Stoc non standard Stocul se poate modifica pe parcurs, consultați lista de stocuri și prețuri curentă.

Notă: La comandarea alezatoarelor Precimaster Plus pentru diametre intermediare, vă rugăm să precizați diametrul și toleranța găurii de alezat.

Exemplu de comandă: PMX5-16.515 P7-EB45 RM2020. PMX6-16.515 P7-EB45 RM2020.

## Capete pentru găuri străpunse, Custom design

Ø 7,75-60,500 mm / 0.305-2.381"



- Pentru regimurile de aşchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	DCN	DCX	LFS	DMM	Mărimea corpului	Geometrii	Calităţi											
	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX6-7.75-XX-XXXX	7,75 0.305	9,999 0.394	6,0 0.236	4,5 0.177	6	PMX05-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX6-10.0-XX-XXXX	10,0 0.394	14,499 0.571	7,0 0.276	6,0 0.236	6	PMX06-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX6-14.5-XX-XXXX	14,5 0.571	21,499 0.846	10,0 0.394	8,0 0.315	6	PMX08-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX6-21.5-XX-XXXX	21,5 0.846	32,499 1.279	12,0 0.472	12,0 0.472	8	PMX12-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX6-32.5-XX-XXXX	32,5 1.280	60,5 2.382	14,0 0.551	16,0 0.630	10	PMX16-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

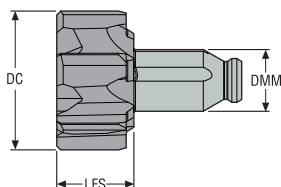
= Stoc non standard Stocul se poate modifica pe parcurs, consultați lista de stocuri și prețuri curentă.

Notă: La comandarea alezoarelor Precimaster Plus pentru diametre intermediare, vă rugăm să precizați diametrul și toleranța găurii de alezat.


Exemplu de comandă: PMX5-16.515 P7-EB45 RM2020. PMX6-16.515 P7-EB45 RM2020.

## Capete expandabile pentru găuri străpunse și găuri înfundate

Ø 10,00-32,500 mm / 0.393-1.279"



- Pentru regimurile de așchiere vezi pag. 360-367
- Pentru alegerea geometriei vârfului EB45, EB845 sau EB30 vezi pag. 339

Reper Nr.	DCN	DCX	LFS	DMM	Mărimea corpului	Geometrii	Calități											
	mm Inci	mm Inci	mm Inci	mm Inci				H15	CP20	RX2000	RK2050	RK1550	CF	RX1500	RN2010	RM2020	RM2090	RS2090
PMX8-10.0-XX-XXXX	10,0 0.394	14,499 0.571	7,0 0.276	6,0 0.236	6	PMX06-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX8-14.5-XX-XXXX	14,5 0.571	21,499 0.846	10,0 0.394	8,0 0.315	6	PMX08-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PMX8-21.5-XX-XXXX	21,5 0.846	32,499 1.279	12,0 0.472	12,0 0.472	8	PMX12-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

= Stoc non standard Stocul se poate modifica pe parcurs, consultați lista de stocuri și prețuri curentă.

Notă: La comandarea alezozelor Precimaster Plus pentru diametre intermediare, vă rugăm să precizați diametrul și toleranța găurii de alezat.

Exemplu de comandă: PMX8-16.515 P7-EB45 RM2020.

## Depanare

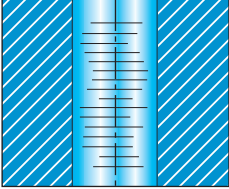
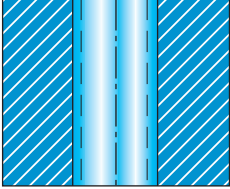
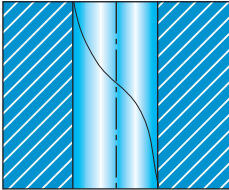
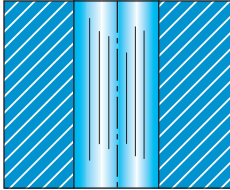
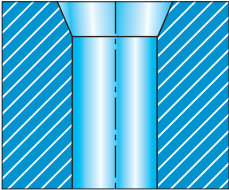
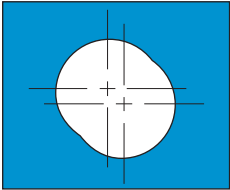
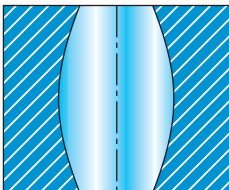
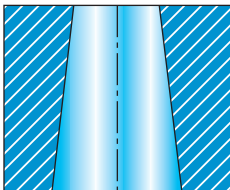
Introducere

Găurire

Alezare

Alezare adâncă

Anexă

<p><b>Finisare slabă a suprafeței</b></p> <ul style="list-style-type: none"> <li>• Verifică adaosul de material</li> <li>• Îmbunătățește condițiile de răcire (tipul difuzorului, presiunea, calitatea)</li> <li>• Reduceți avansul</li> </ul> 	<p><b>Diametru prea mare</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți centrarea (piesă/sculă)</li> </ul> 
<p><b>Urme de retragere</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți condițiile de răcire (tipul ieșirii, presiunea, calitatea)</li> <li>• Îmbunătățiți centrarea (piesă/sculă)</li> <li>• Reduceți viteza la retragere</li> </ul> 	<p><b>Fațete</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți centrarea (piesă/sculă)</li> <li>• Verificați toleranța materialului</li> </ul> 
<p><b>Intrare conică</b></p> <ul style="list-style-type: none"> <li>• Micșorează avansul</li> <li>• Îmbunătățește centrarea (piesă/sculă)</li> <li>• Micșorează bătaia radială</li> </ul> 	<p><b>Excentricitate/Ovalitate</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți prinderea (deformarea piesei de prelucrat)</li> <li>• Verificați toleranța materialului</li> <li>• Îmbunătățiți centrarea (piesă/sculă)</li> </ul> 
<p><b>Gaură deformată</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți prinderea (deformarea piesei de lucru)</li> </ul> 	<p><b>Gaură conică</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți centrarea (piesă/sculă)</li> </ul> 



## Instrucțiuni pentru reascuțire

### Specificații

Roată diamantată pentru ascuțire

Granulația:

**D6** – Pentru primul unghi de degajare ( $\beta_1$  -  $\beta_3$ )

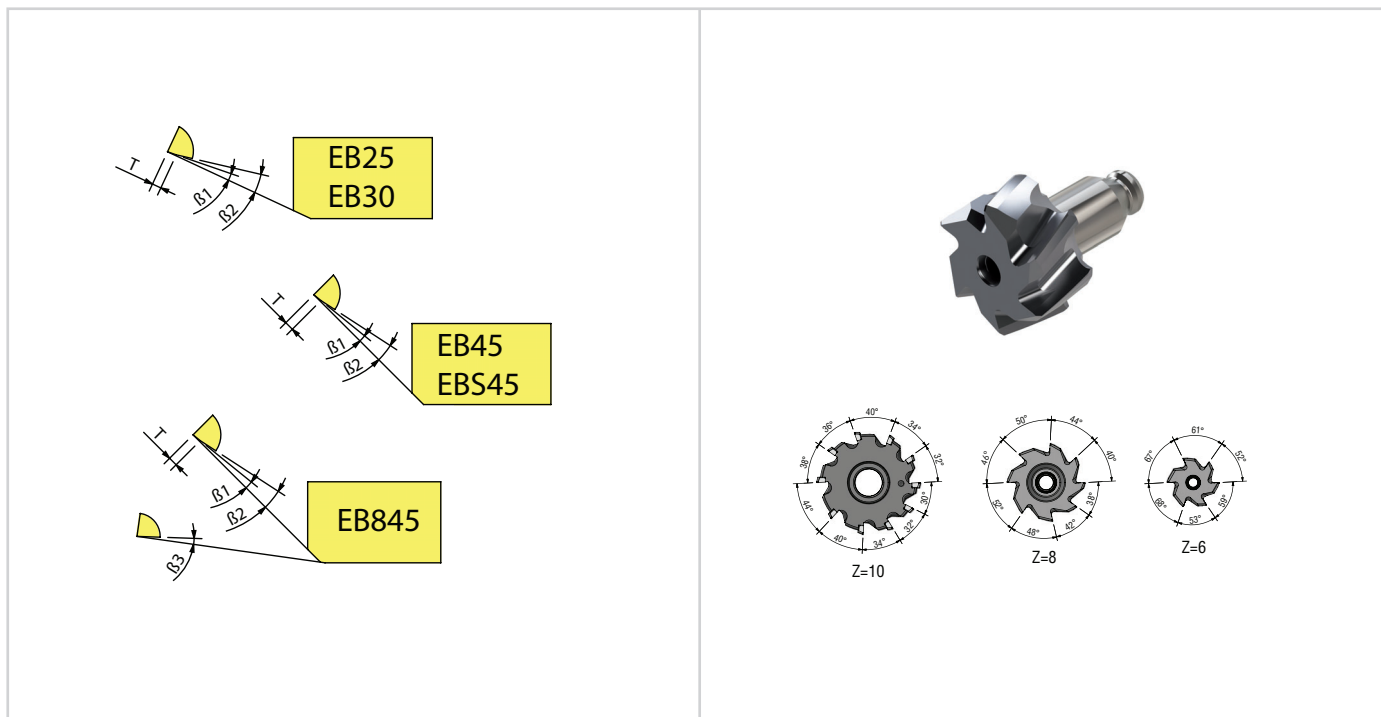
**D64** – Pentru al doilea unghi de degajare ( $\beta_2$ )

### Important:

Reascuțirea reduce diametrul alezului

Reacoperirea poate duce la mărirea diametrului

Bătaia radială max. pe șanfenări de intrare 10  $\mu\text{m}$  (394  $\mu\text{in}$ )



$\varnothing$ Precimaster Plus mm (inci)	$\beta_1$	$\beta_2$	$\beta_3$	T mm (inci)
7,75-9,999 (0,3151-0,3937)	8°	18°	8°	0,20 (0,008)
10,00-14,499 (0,3937-0,5708)	8°	18°	8°	0,20 (0,008)
14,500-21,499 (0,5709-0,8464)	8°	18°	8°	0,20 (0,008)
21,500-32,499 (0,8465-1,2795)	8°	18°	8°	0,25 (0,010)
32,500-60,499 (1,2795-2,3819)	8°	15°	8°	0,30 (0,012)

Regimuri de aşchiere – PM Plus... -EB45 metric

SMG		$a_p$ (°)		f			$v_c$										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
P1	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-	-	-	-	-
P2	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-	-	-	-	-
P3	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-	-	-	-	-
P4	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-	-
P5	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-	-
P6	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-	-
P7	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-	-
P8	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	-	80 (60-120)	120 (80-180)	-	-	-	-	-
P11	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	-	80 (60-120)	120 (80-180)	-	-	-	-	-
P12	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	12 (8-15)	25 (15-45)	30 (15-65)	-	65 (45-95)	95 (65-145)	-	-	-	-	-
M1	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	12 (9-15)	25 (15-45)	35 (20-70)	-	-	-	-	-	25 (15-40)	40 (25-80)	-
M2	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	25 (15-45)	35 (20-70)	-	-	-	-	-	25 (15-40)	40 (25-80)	-
M3	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	25 (15-45)	35 (20-70)	-	-	-	-	-	25 (15-40)	40 (25-80)	-
M4	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-30)	25 (15-50)	-	-	-	-	-	20 (10-30)	30 (20-60)	-
M5	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-30)	25 (15-50)	-	-	-	-	-	20 (10-30)	30 (20-60)	-
K1	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-	-
K2	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	25 (20-40)	40 (30-70)	45 (35-80)	-	80 (50-100)	90 (55-110)	-	-	-	-
K3	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-	-
K4	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	-	-	-	-
K5	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	-	-	-	-
K6	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-	-
K7	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-	-
N1	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	-	80 (30-150)	-	-	-	-	50 (30-100)	-	-	-
N2	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	-	80 (30-150)	-	-	-	-	50 (30-100)	-	-	-
N3	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	-	80 (30-150)	-	-	-	-	50 (30-100)	-	-	-
N11	PMX5...6..8-EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	50 (30-100)	-	80 (30-150)	-	-	-	-	50 (30-100)	-	-	-
S1	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-25)	20 (10-25)	-	-	-	-	-	-	-	-
S2	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-25)	20 (10-25)	-	-	-	-	-	-	-	-
S3	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-25)	20 (10-25)	-	-	-	-	-	-	-	-
S11	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	-	-	-	-	-
S12	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	-	-	-	-	-
S13	PMX5...6..8-EB45	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	-	-	-	-	-

The table continues on next page.

Regimuri de aşchiere – PM Plus... -EB45 metric

SMG		$a_p$ (°)		f			$v_c$										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
H3	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H5	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H7	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H8	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H11	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H12	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H21	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
H31	PMX5 .6 .8 -EB45	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-	-
PM1	PMX5 .6 .8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	50 (30-80)	70 (40-100)	-	-	-	-	-	-	-	-
PM2	PMX5 .6 .8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	50 (30-80)	70 (40-100)	-	-	-	-	-	-	-	-
PM3	PMX5 .6 .8 -EB45	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	50 (30-80)	70 (40-100)	-	-	-	-	-	-	-	-
TS1	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TS2	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TS3	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TS4	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TP1	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TP2	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TP3	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
TP4	PMX5 .6 .8 -EB45	0,10 -0,15	0,10 -0,20	0,30 -0,90	0,40 -1,20	0,50 -1,50	20 (15-25)	-	40 (20-60)	-	-	-	-	-	-	-	-
GR1	PMX5 .6 .8 -EB45	0,10 -0,30	0,10 -0,40	0,30 -0,90	0,40 -1,20	0,50 -1,50	40 (80-20)	-	60 (30-120)	-	-	-	-	-	-	-	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – PM Plus...-EB45 inci

SMG		a <sub>p</sub> (°)		f			v <sub>c</sub>										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
P1	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-	-	-	-	-
P2	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-	-	-	-	-
P3	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-	-	-	-	-
P4	PMX5...6...8-EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-	-
P5	PMX5...6...8-EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-	-
P6	PMX5...6...8-EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-	-
P7	PMX5...6...8-EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-	-
P8	PMX5...6...8-EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	-	260 (195-395)	395 (260-590)	-	-	-	-	-
P11	PMX5...6...8-EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	-	260 (195-395)	395 (260-590)	-	-	-	-	-
P12	PMX5...6...8-EB45	.004 -.008	.004 -.008	.008 -.028	.012 -.039	.016 -.047	40 (25-50)	80 (50-130)	100 (50-215)	-	215 (150-315)	315 (215-480)	-	-	-	-	-
M1	PMX5...6...8-EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	40 (30-50)	80 (50-130)	115 (65-230)	-	-	-	-	-	80 (50-130)	130 (80-260)	-
M2	PMX5...6...8-EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	80 (50-130)	115 (65-230)	-	-	-	-	-	80 (50-130)	130 (80-260)	-
M3	PMX5...6...8-EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	80 (50-130)	115 (65-230)	-	-	-	-	-	80 (50-130)	130 (80-260)	-
M4	PMX5...6...8-EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	65 (35-100)	80 (50-165)	-	-	-	-	-	65 (35-100)	100 (65-195)	-
M5	PMX5...6...8-EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	65 (35-100)	80 (50-165)	-	-	-	-	-	65 (35-100)	100 (65-195)	-
K1	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-	-
K2	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	-	80 (65-130)	130 (100-230)	145 (110-260)	-	260 (165-330)	290 (185-370)	-	-	-	-
K3	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-	-
K4	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	-	-	-	-
K5	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	-	-	-	-
K6	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	-	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-	-
K7	PMX5...6...8-EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	-	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-	-
N1	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	-	260 (100-490)	-	-	-	-	165 (100-330)	-	-	-
N2	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	-	260 (100-490)	-	-	-	-	165 (100-330)	-	-	-
N3	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	-	260 (100-490)	-	-	-	-	165 (100-330)	-	-	-
N11	PMX5...6...8-EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	165 (100-330)	-	260 (100-490)	-	-	-	-	165 (100-330)	-	-	-
S1	PMX5...6...8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	-	65 (35-80)	65 (35-80)	-	-	-	-	-	-	-	80 (40-100)
S2	PMX5...6...8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	-	65 (35-80)	65 (35-80)	-	-	-	-	-	-	-	80 (40-100)
S3	PMX5...6...8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	-	65 (35-80)	65 (35-80)	-	-	-	-	-	-	-	80 (40-100)
S11	PMX5...6...8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	-	-	-	-	165 (80-215)
S12	PMX5...6...8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	-	-	-	-	165 (80-215)
S13	PMX5...6...8-EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	-	-	-	-	165 (80-215)

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Introducere

Găurire

Alezare

Alezare adâncă

Anexă

Regimuri de aşchiere – PM Plus...-EB45 inci

SMG		a <sub>p</sub> (°)		f			v <sub>c</sub>										
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RN2010	RM2020	RM2090	RS2090
H5	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
H7	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
H8	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
H11	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
H12	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
H21	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
H31	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-	-
PM1	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	-	165 (100-260)	230 (130-330)	-	-	-	-	-	-	-	-
PM2	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	-	165 (100-260)	230 (130-330)	-	-	-	-	-	-	-	-
PM3	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	-	165 (100-260)	230 (130-330)	-	-	-	-	-	-	-	-
TS1	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TS2	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TS3	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TS4	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TP1	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TP2	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TP3	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
TP4	PMX5 ..6 ..8 -EB45	.004 -.006	.004 -.008	.012 -.035	.016 -.047	.020 -.059	65 (50-80)	-	130 (65-195)	-	-	-	-	-	-	-	-
GR1	PMX5 ..6 ..8 -EB45	.004 -.012	.004 -.016	.012 -.035	.016 -.047	.020 -.059	130 (260-65)	-	195 (100-395)	-	-	-	-	-	-	-	-

SMG = Grupa de material Seco

a<sub>p</sub> = inci

f = in/rev

v<sub>c</sub> = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – PM Plus...-EB845 metric

SMG		$a_p$ (°)		f			$v_c$									
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RM2020	RM2090	RS2090
P3	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-	-	-	-
P4	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-
P5	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-
P6	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-
P7	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-	-	-	-
P8	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	-	80 (60-120)	120 (80-180)	-	-	-	-
P11	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	15 (10-20)	35 (20-60)	40 (20-80)	-	80 (60-120)	120 (80-180)	-	-	-	-
P12	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,30	0,20 -0,70	0,30 -1,00	0,40 -1,20	12 (8-15)	25 (15-45)	30 (15-65)	-	65 (45-95)	95 (65-145)	-	-	-	-
M1	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	12 (9-15)	25 (15-45)	35 (20-70)	-	-	-	-	25 (15-40)	35 (20-70)	-
M2	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	25 (15-45)	35 (20-70)	-	-	-	-	25 (15-40)	35 (20-70)	-
M3	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	25 (15-45)	35 (20-70)	-	-	-	-	25 (15-40)	35 (20-70)	-
M4	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-30)	25 (15-50)	-	-	-	-	20 (10-30)	25 (15-50)	-
M5	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,20	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-30)	25 (15-50)	-	-	-	-	20 (10-30)	25 (15-50)	-
K1	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-
K2	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	25 (20-40)	40 (30-70)	45 (35-80)	-	80 (50-100)	90 (55-110)	-	-	-
K3	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-
K4	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	-	-	-
K5	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)	-	-	-
K6	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-
K7	PMX5..6..8-EB845	0,10 -0,20	0,10 -0,25	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)	-	-	-
S1	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-25)	20 (10-25)	-	-	-	-	-	-	25 (12-30)
S2	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-25)	20 (10-25)	-	-	-	-	-	-	25 (12-30)
S3	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	-	20 (10-25)	20 (10-25)	-	-	-	-	-	-	25 (12-30)
S11	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	-	-	-	50 (25-65)
S12	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	-	-	-	50 (25-65)
S13	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,60	0,30 -0,80	0,40 -1,00	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	-	-	-	50 (25-65)
H3	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H5	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H7	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H8	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H11	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H12	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H21	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
H31	PMX5..6..8-EB845	0,08 -0,15	0,10 -0,15	0,20 -0,40	0,30 -0,60	0,40 -0,75	-	-	10 (8-15)	-	-	-	-	-	-	-
PM1	PMX5..6..8-EB845	0,10 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	50 (30-80)	70 (40-100)	-	-	-	-	-	-	-
PM2	PMX5..6..8-EB845	0,10 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	50 (30-80)	70 (40-100)	-	-	-	-	-	-	-
PM3	PMX5..6..8-EB845	0,10 0,20	0,10 -0,30	0,30 -0,90	0,40 -1,20	0,50 -1,50	-	50 (30-80)	70 (40-100)	-	-	-	-	-	-	-

SMG = Grupa de material Seco  
 $a_p$  = mm  
 f = mm/rev  
 $v_c$  = m/min  
 Toate regimurile de aşchiere sunt valori de pornire

Introducere

Găurire

Alezare

Alezare adâncă

Anexă

Regimuri de aşchiere – PM Plus...-EB845 inci

SMG		a <sub>p</sub> (°)		f			v <sub>c</sub>									
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550	RM2020	RM2090	RS2090
P3	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-	-	-	-
P4	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-
P5	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-
P6	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-
P7	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-	-	-	-
P8	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	-	260 (195-395)	395 (260-590)	-	-	-	-
P11	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	50 (35-65)	115 (65-195)	130 (65-260)	-	260 (195-395)	395 (260-590)	-	-	-	-
P12	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.008 -.028	.012 -.039	.016 -.047	40 (25-50)	80 (50-130)	100 (50-215)	-	215 (150-315)	315 (215-480)	-	-	-	-
M1	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	40 (30-50)	80 (50-130)	115 (65-230)	-	-	-	-	80 (50-130)	115 (65-230)	-
M2	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	80 (50-130)	115 (65-230)	-	-	-	-	80 (50-130)	115 (65-230)	-
M3	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	80 (50-130)	115 (65-230)	-	-	-	-	80 (50-130)	115 (65-230)	-
M4	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	65 (35-100)	80 (50-165)	-	-	-	-	65 (35-100)	80 (50-165)	-
M5	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.008	.008 -.024	.012 -.031	.016 -.039	-	65 (35-100)	80 (50-165)	-	-	-	-	65 (35-100)	80 (50-165)	-
K1	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-
K2	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	-	80 (65-130)	130 (100-230)	145 (110-260)	-	260 (165-330)	290 (185-370)	-	-	-
K3	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-
K4	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	-	-	-
K5	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)	-	-	-
K6	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	-	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-
K7	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.010	.012 -.035	.016 -.047	.020 -.059	-	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)	-	-	-
S1	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	-	65 (35-80)	65 (35-80)	-	-	-	-	-	-	80 (40-100)
S2	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	-	65 (35-80)	65 (35-80)	-	-	-	-	-	-	80 (40-100)
S3	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	-	65 (35-80)	65 (35-80)	-	-	-	-	-	-	80 (40-100)
S11	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	-	-	-	165 (80-215)
S12	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	-	-	-	165 (80-215)
S13	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.024	.012 -.031	.016 -.039	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	-	-	-	165 (80-215)
H3	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H5	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H7	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H8	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H11	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H12	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H21	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
H31	PMX5 ..6 ..8 -EB45	.003 -.006	.004 -.006	.008 -.016	.012 -.024	.016 -.030	-	-	35 (25-50)	-	-	-	-	-	-	-
PM1	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	-	165 (100-260)	230 (130-330)	-	-	-	-	-	-	-
PM2	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	-	165 (100-260)	230 (130-330)	-	-	-	-	-	-	-
PM3	PMX5 ..6 ..8 -EB45	.004 -.008	.004 -.012	.012 -.035	.016 -.047	.020 -.059	-	165 (100-260)	230 (130-330)	-	-	-	-	-	-	-

SMG = Grupa de material Seco  
 a<sub>p</sub> = inci  
 f = in/rev  
 v<sub>c</sub> = sf/min  
 Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Plus... -EB25/EB30 metric

SMG		$a_p$ (°)		f			$v_c$						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-
P2	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-
P3	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	25 (15-30)	60 (30-100)	80 (30-150)	-	180 (90-200)	220 (120-300)	-
P4	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-
P5	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-
P6	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-
P7	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-1,80	1,00-2,40	1,20-3,00	20 (10-25)	50 (30-80)	60 (30-120)	-	120 (80-150)	180 (90-200)	-
M1	PMX5 ..6 ..8 -EB25/EB30	0,08-0,15	0,10-0,20	0,80-1,20	1,00-2,00	1,20-2,50	-	25 (15-40)	35 (20-70)	-	-	-	-
K1	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)
K2	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	-	25 (20-40)	40 (30-70)	45 (35-80)	-	80 (50-100)	90 (55-110)
K3	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)
K4	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)
K5	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-2,20	1,00-2,80	1,20-3,50	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	100 (70-150)	150 (80-200)	170 (90-225)
K6	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	-	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)
K7	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,25	0,80-1,80	1,00-2,40	1,20-3,00	-	60 (40-100)	80 (30-150)	90 (35-170)	-	220 (120-300)	245 (135-335)
N1	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	-	-	-	-	-	-
N2	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	-	-	-	-	-	-
N3	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	-	-	-	-	-	-
N11	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,80-2,20	1,00-2,80	1,20-3,50	50 (30-100)	-	-	-	-	-	-
PM1	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	-	50 (30-80)	70 (40-100)	-	-	-	-
PM2	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	-	50 (30-80)	70 (40-100)	-	-	-	-
PM3	PMX5 ..6 ..8 -EB25/EB30	0,10-0,20	0,10-0,30	0,50-1,80	0,80-2,00	1,00-2,50	-	50 (30-80)	70 (40-100)	-	-	-	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire



Regimuri de aşchiere – PM Plus... -EB25/EB30 inci

SMG		a <sub>p</sub> (Z)		f			v <sub>c</sub>						
		z=6	z=8 z=10	z=6	z=8	z=10	H15	CP20	RX2000	RK2050	CF	RX1500	RK1550
P1	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-
P2	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-
P3	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	80 (50-100)	195 (100-330)	260 (100-490)	-	590 (295-655)	720 (395-985)	-
P4	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-
P5	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-
P6	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-
P7	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.071	.039-.094	.047-.118	65 (35-80)	165 (100-260)	195 (100-395)	-	395 (260-490)	590 (295-655)	-
M1	PMX5..6..8-EB25/EB30	.003-.006	.004-.008	.031-.047	.039-.079	.039-.098	-	80 (50-130)	115 (65-230)	-	-	-	-
K1	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.087	.039-.110	.047-.138	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)
K2	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.071	.039-.094	.047-.118	-	80 (65-130)	130 (100-230)	145 (110-260)	-	260 (165-330)	290 (185-370)
K3	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.087	.039-.110	.047-.138	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)
K4	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.087	.039-.110	.047-.138	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)
K5	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.087	.039-.110	.047-.138	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)	330 (230-490)	490 (260-655)	550 (290-735)
K6	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.071	.039-.094	.047-.118	-	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)
K7	PMX5..6..8-EB25/EB30	.004-.008	.004-.010	.031-.071	.039-.094	.047-.118	-	195 (130-330)	260 (100-490)	290 (110-550)	-	720 (395-985)	805 (440-1105)
N1	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.087	.039-.110	.047-.138	165 (100-330)	-	-	-	-	-	-
N2	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.087	.039-.110	.047-.138	165 (100-330)	-	-	-	-	-	-
N3	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.087	.039-.110	.047-.138	165 (100-330)	-	-	-	-	-	-
N11	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.031-.087	.039-.110	.047-.138	165 (100-330)	-	-	-	-	-	-
PM1	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.020-.071	.031-.079	.039-.098	-	165 (100-260)	230 (130-330)	-	-	-	-
PM2	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.020-.071	.031-.079	.039-.098	-	165 (100-260)	230 (130-330)	-	-	-	-
PM3	PMX5..6..8-EB25/EB30	.004-.008	.004-.012	.020-.071	.031-.079	.039-.098	-	165 (100-260)	230 (130-330)	-	-	-	-

SMG = Grupa de material Seco

a<sub>p</sub> = inci

f = in/rev

v<sub>c</sub> = sf/min

Toate regimurile de aşchiere sunt valori de pornire




## Nanofix™

Alezoarele din carbură solidă Nanofix™ sunt concepute pentru diametre mici de la 2,97 până la 12,05 mm (0,117" - 0,474").

- Agent de răcire complet cu sistem reglabil simplu pentru ca stilul ieșirii să poate fi setat fie pentru alezare înfundată sau străpunsă, în funcție de aplicație
- Permite toleranțe între 10 și 15  $\mu\text{m}$  (0,0004-0,0006')
- Trei geometrii disponibile: EB45, EB845 și EB25

## Prezentare generală

	Ø Gamă	Adâncimea de alezare	Toleranța Ø burghiului	Diametre intermediare	Finisarea suprafeței
<b>Nanofix™</b> 	2,97-12,05 mm (0.1169-0.4744")	5-12 x D	IT 7	Da, disponibil în Custom design	R <sub>a</sub> 0,8-1,2 μm (R <sub>a</sub> 31-47 μin)

Nanofix™ este un alezor Seco din carbură solidă conceput pentru diametre mici Ø de la 2,97 la 12,05 mm (0.1169 to 0.4744").

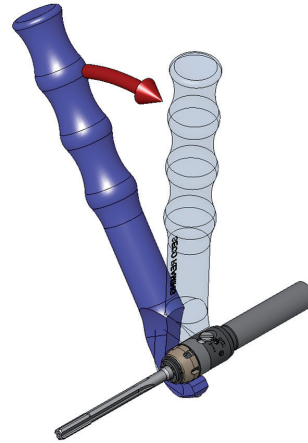
Designul include un sistem de prindere brevetat Quick-fit care permite prinderea întregii familii de alezoare în doar 2 portscule.

Portsculele au canale interioare pentru lichidul de răcire cu un sistem simplu de reglare care permite comutarea rapidă a tipului de ieșire a lichidului de răcire în funcție de aplicație - găuri străpunse sau găuri înfundate.

## Quick-fit

### Quick-fit

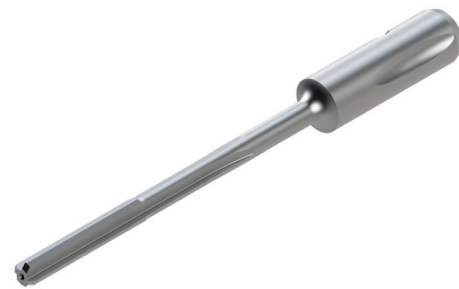
Schimbare rapidă și ușoară a sculei.  
Repoziționare precisă a lungimii și bătăii radiale



### 2 mărimi Quick-fit care acoperă complet gama de diametre

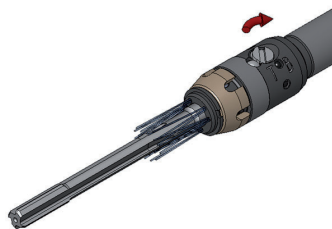


Quick-fit  $\varnothing$  10 mm pentru  
 $\varnothing$  6,051-12,050 mm  
( $\varnothing$  0,2382-0,4744")



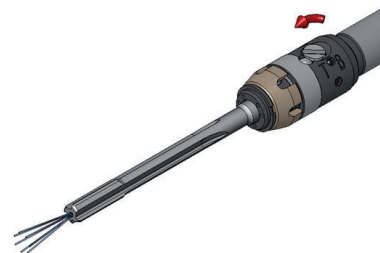
Quick-fit  $\varnothing$  6 mm pentru  
 $\varnothing$  2,97 -6,050 mm  
( $\varnothing$  0,1169-0,2382")

### Aceeași sculă pentru aplicații cu găuri înfundate sau străpuse



străpuns

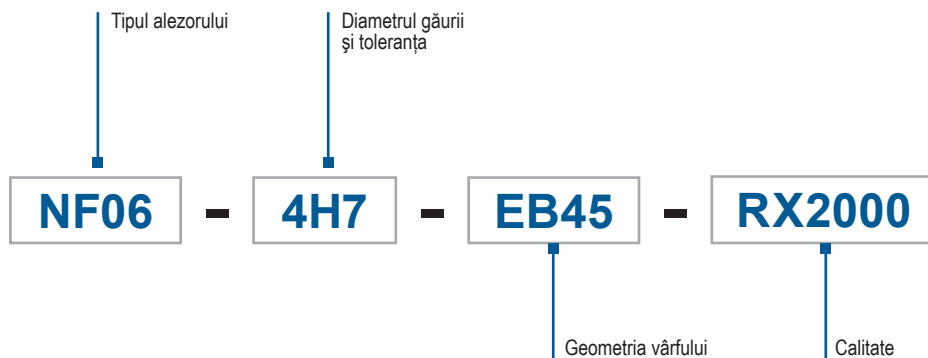
Rotește șurubul de reglaj pentru răcire cu 1/4 tură  
pentru a schimba evacuarea lichidului de răcire  
de la găuri străpuse la înfundate și vice-versa.



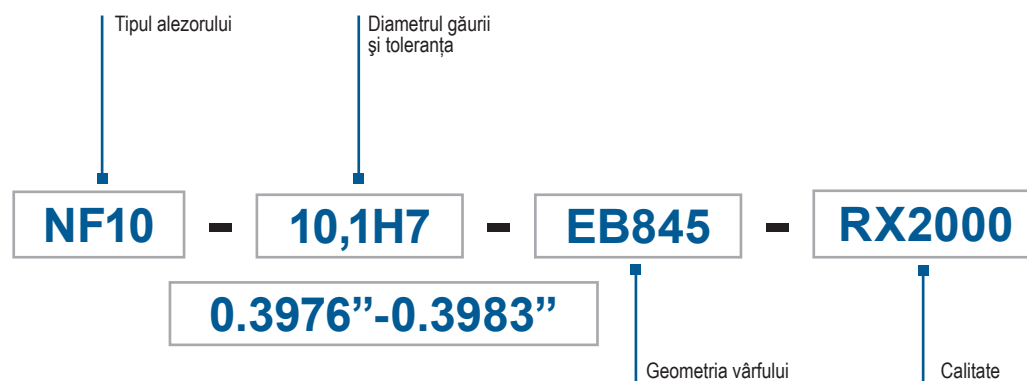
înfundat

## Codificări

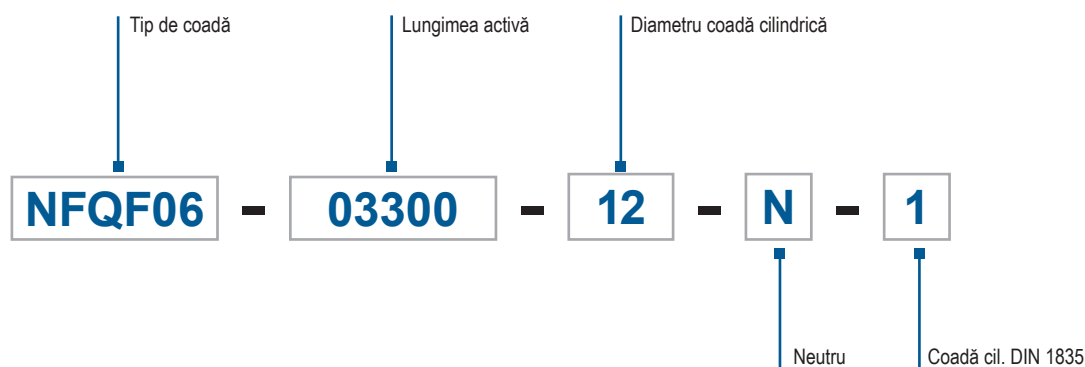
### Alezoare



### Diametru intermediar alezoare



### Cozi prindere

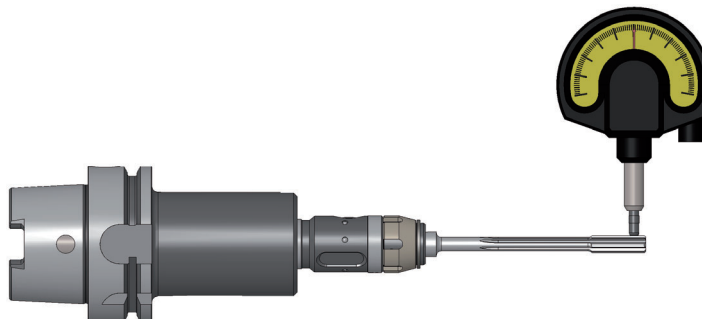


## Bătaia radială:

### Aplicații dinamice

Bătaia radială maximă recomandată: 5  $\mu\text{m}$  (197  $\mu\text{in}$ ).  
Se recomandă o portsculă de precizie: Mandrină hidraulică, mandrină cu pensețe tip D sau mandrină cu pensețe 5672.

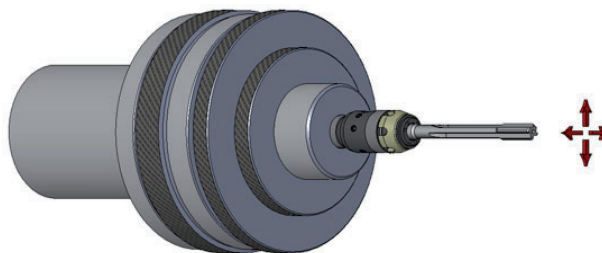
Notă: datorită inelului O de etanșare a racordului pentru lichidul de răcire, utilizarea port-sculei Shrinkfit nu este recomandată.



### Aplicații statice

Utilizați o port-sculă flotantă Seco, consultați pagina 480-484.

Port-sculele flotante permit autocentrarea la pregăuire.



### Cerințele lichidului de răcire

Pentru a obține o viață lungă a sculei și o calitate ridicată a găurii, trebuie ținut cont de următoarele caracteristici ale lichidului de răcire.

Se recomandă răcirea interioară.

Se poate utiliza răcire exterioară cu reducerea parametrilor de așchiere la 75%.

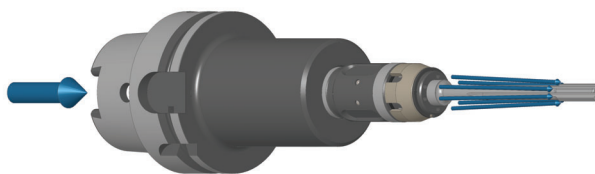
Ulei solubil cu minim 40% ulei mineral.

Se recomandă ulei curat pentru oțel inoxidabil.

Concentrația minimă 6-8%.

Filtrare 30–50  $\mu\text{m}$  (1181-1969  $\mu\text{in}$ ).

Volum min. 0,5 l/min/mm (0,13 gal/min/inci) din diametrul sculei (de ex: Alezor  $\varnothing$  10, volum min. este 5 l/min (1,3 gal/min)).



### Măsurarea diametrului

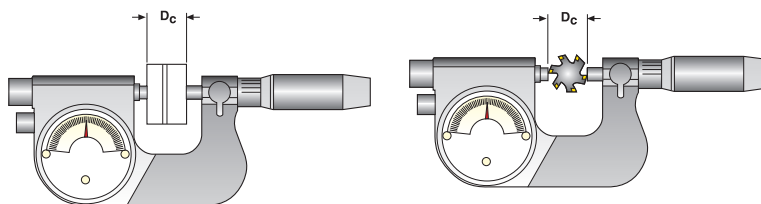
Calibrați ceasul micrometrului înainte de măsurătoare.

#### Important!

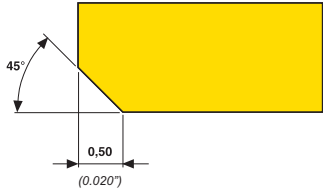
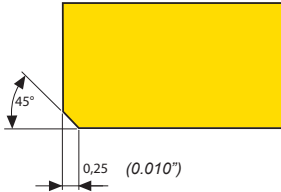
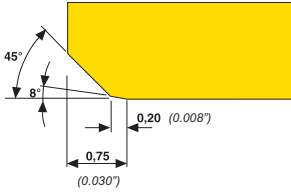
Alezoarele Nanofix au pas diferențial al dinților.

La măsurarea diametrului se utilizează 2 dinți opuși la 180°.

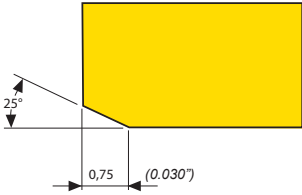
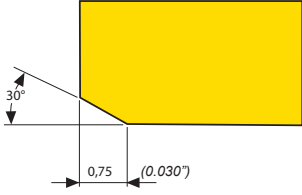
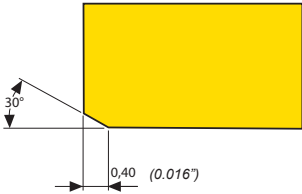
La calibrare utilizați un comparator micrometric și o cală de calibrare.



## Alegerea geometriei - Aplicații

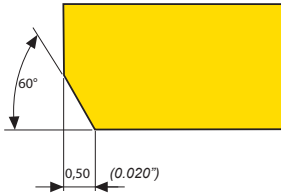
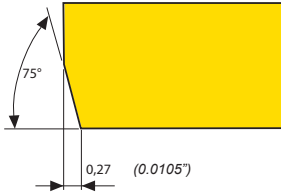
Geometria vârfului - EB45	
<p>Controlul asupra formării așchiilor ++                      Finisarea suprafeței +++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math>                      (Finisarea suprafeței +++ <math>R_a</math> 31 - 47 <math>\mu\text{in}</math>)                      Versatil</p>	
Geometria vârfului - EBS45	
<p>Controlul asupra formării așchiilor +++                      Finisarea suprafeței + <math>R_a</math> 0,8- 1,2                      (Finisarea suprafeței + <math>R_a</math> 31- 47 <math>\mu\text{in}</math>)                      Scurt EB45</p>	
Geometria vârfului - EB845	
<p>Controlul asupra formării așchiilor ++                      Finisarea suprafeței +++ <math>R_a</math> 0,2 - 0,8 <math>\mu\text{m}</math>                      (Finisarea suprafeței +++ <math>R_a</math> 8 - 31 <math>\mu\text{in}</math>)</p>	

## Alegerea geometriei - Aplicații

<p><b>Geometria vârfului - EB25</b></p>	
<p>Performanța avansului +++                  Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math>                  (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>)                  Controlul asupra formării așchiilor +</p>	
<p><b>Geometria vârfului - EB30</b></p>	
<p>Performanța avansului +++                  Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math>                  (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>)                  Controlul asupra formării așchiilor +</p>	
<p><b>Geometria vârfului - EBS30</b></p>	
<p>Performanța avansului +++                  Finisarea suprafeței ++ <math>R_a</math> 0,4 - 0,8 <math>\mu\text{m}</math>                  (Finisarea suprafeței ++ <math>R_a</math> 16 - 31 <math>\mu\text{in}</math>)                  Controlul asupra formării așchiilor +                  Scurt EB30</p>	



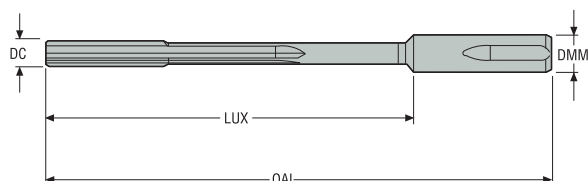
## Alegerea geometriei - Aplicații

Geometria vârfului - EB60	
<p>Performanța avansului + Finisarea suprafeței ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 31 - 47 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor ++</p>	
Geometria vârfului - EB75	
<p>Performanța avansului + Finisarea suprafeței ++ <math>R_a</math> 0,8 - 1,2 <math>\mu\text{m}</math> (Finisarea suprafeței ++ <math>R_a</math> 31 - 47 <math>\mu\text{in}</math>) Controlul asupra formării așchiilor ++</p>	

Calități		
	RX2000	<b>Coated</b> High performance coated grade suitable for all materials.
	CP20	<b>Acoperită</b> O calitate acoperită potrivită pentru majoritatea materialelor, cu excepția aluminiului. TiN
	H15	<b>Neacoperită</b> O calitate rezistentă a microstructurii pentru toate materialele. Potrivită pentru operațiuni de alezare fină datorită unei muchii foarte ascuțite.
	RN2010	<b>Neacoperită</b> Microstructură neacoperită cu geometrie pentru materiale N (neferoase).
	RM2020	<b>Acoperită</b> O calitate rezilientă acoperită potrivită pentru alezare de finisare cu o geometrie optimizată pentru materiale M.
	RM2090	<b>Acoperită</b> Calitate acoperită rezistență la uzură cu geometrie specifică materialelor M. Optimizare în materiale M.
	RK2050	<b>Acoperită</b> A tough coated grade suitable for fine reaming operation with optimized geometries for K materials.
	RS2090	<b>Acoperită</b> Calitate acoperită rezistență la uzură cu geometrie specifică materialelor S. Optimizare în materiale S.

## Alezoare pentru găuri înfundate și străpuse

Ø 2,97-12,05 mm / 0.116-0.474"



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

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

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

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Reper Nr.	Număr reper	DC	Hole dia min-max			LUX	DMM	OAL		Geometrii			Calități		
			mm Inci	mm Inci	mm Inci					mm Inci	mm Inci	mm Inci	mm Inci	EB45	EB845
NF10-12.01H7-EB45	02729012	12,01 0.4728	12,01 0.4728	12,028 0.4735	114,0 4.4880	10,0 0.3940	125,0 4.9210	6	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NF10-12.02H7-EB45	02729013	12,02 0.4732	12,02 0.4732	12,038 0.4739	114,0 4.4880	10,0 0.3940	125,0 4.9210	6	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NF10-12.03H7-EB45	02729014	12,03 0.4736	12,03 0.4736	12,048 0.4743	114,0 4.4880	10,0 0.3940	125,0 4.9210	6	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NF10-12.04H7-EB45	02729015	12,04 0.4740	12,04 0.4740	12,058 0.4747	114,0 4.4880	10,0 0.3940	125,0 4.9210	6	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NF10-12.05H7-EB45	02729016	12,05 0.4744	12,05 0.4744	12,068 0.4751	114,0 4.4880	10,0 0.3940	125,0 4.9210	6	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

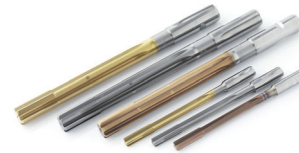
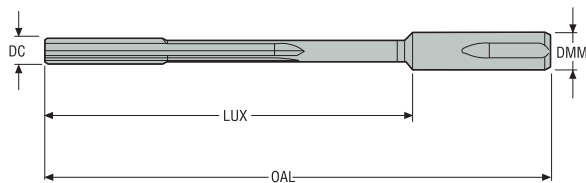
Stoc standard.  Non stoc standard.

Notă! La comandarea unor alezoare intermediare, vă rugăm să precizați: Ø și toleranța găurii de alezat, geometria vârfului (EN1, EN2 or EN3).

Exemplu de comandă: NF10-10,187/10,213-EB845, RX2000.

## Diametre intermediare

Straight flute, long version



- Pentru regimurile de aşchiere vezi pag. 391-396
- Pentru alegerea geometriei, vezi pag. 373-375

Reper Nr.	DCN	DCX	LUX	DMM	OAL	Mărim corpului	Geometrii	Calități						
	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				H15	RK2050	RX2000	RN2010	RM2020	RM2090
NF06-2.970-XX-XXXX	2,97 0.117	3,05 0.120	40,0 1.575	6,0 0.236	60,0 2.362	4	NFQF06-xx EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NF06-3.051-XX-XXXX	3,051 0.120	6,05 0.238	60,0 2.362	6,0 0.236	80,0 3.150	4	NFQF06-xx EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NF10-6.051-XX-XXXX	6,051 0.238	8,05 0.317	83,0 3.268	10,0 0.394	115,0 4.528	6	NFQF10-xx EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NF10-8.051-XX-XXXX	8,051 0.317	10,05 0.396	93,0 3.661	10,0 0.394	125,0 4.921	6	NFQF10-xx EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NF10-10.051-XX-XXXX	10,051 0.396	12,05 0.474	114,0 4.488	10,0 0.394	145,0 5.709	6	NFQF10-xx EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

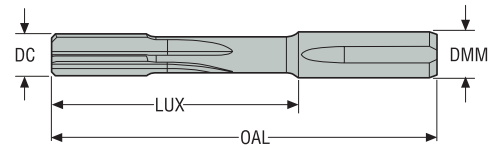
= Stoc non standard Stocul se poate modifica pe parcurs, consultați lista de stocuri și prețuri curentă.

Notă: La comandarea alezatoarelor Nanofix pentru diametre intermediare, vă rugăm să precizați diametrul și toleranța găurii de alezat.

Exemplu de comandă: NF10-10,187/10,213-EB845, RX2000.

## Alezoare pentru găuri înfundate și străpunse – versiunea scurtă

Ø 2,97-12,05 mm / 0.116-0.474"



Reper Nr.	Număr reper	DC	Hole dia min-max			LUX	DMM	OAL		Geometrii			Calități		
			mm Inci	mm Inci	mm Inci					mm Inci	mm Inci	mm Inci	EB45	EB845	EB30
NS06-2.97H7-EB...	-	2,97 0.1169	2,97 0.1169	2,98 0.1173	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-2.98H7-EB...	-	2,98 0.1173	2,98 0.1173	2,99 0.1177	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-2.99H7-EB...	-	2,99 0.1177	2,99 0.1177	3,00 0.1181	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.00H7-EB...	-	3,0 0.1181	3,00 0.1181	3,01 0.1185	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3H7-EB30	10019456	3,0 0.1181	3,01 0.1185	3,00 0.1181	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.01H7-EB...	-	3,01 0.1185	3,01 0.1185	3,02 0.1190	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.02H7-EB...	-	3,02 0.1189	3,02 0.1189	3,03 0.1194	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.03H7-EB...	-	3,03 0.1193	3,03 0.1193	3,04 0.1198	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.04H7-EB...	-	3,04 0.1197	3,04 0.1197	3,05 0.1202	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.05H7-EB...	-	3,05 0.1201	3,05 0.1201	3,06 0.1206	25,0 0.9840	6,0 0.2360	45,0 1.7720	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.167H7-EB...	-	3,167 0.1247	3,18 0.1252	3,17 0.1247	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.175H7-EB...	-	3,175 0.1250	3,18 0.1250	3,19 0.1255	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.49H7-EB...	-	3,49 0.1374	3,49 0.1374	3,50 0.1379	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.50H7-EB...	-	3,5 0.1378	3,50 0.1378	3,51 0.1383	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.51H7-EB...	-	3,51 0.1382	3,51 0.1382	3,52 0.1387	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.52H7-EB...	-	3,52 0.1386	3,52 0.1386	3,53 0.1391	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.97H7-EB...	-	3,97 0.1563	3,97 0.1563	3,98 0.1568	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.98H7-EB...	-	3,98 0.1567	3,98 0.1567	3,99 0.1572	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-3.99H7-EB...	-	3,99 0.1571	3,99 0.1571	4,00 0.1576	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.00H7-EB...	-	4,0 0.1575	4,00 0.1575	4,01 0.1580	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4H7-EB30	10019457	4,0 0.1575	4,01 0.1580	4,00 0.1575	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.01H7-EB...	-	4,01 0.1579	4,01 0.1579	4,02 0.1583	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.02H7-EB...	-	4,02 0.1583	4,02 0.1583	4,03 0.1587	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	



Reper Nr.	Număr reper	DC	Hole dia min-max			LUX	DMM	OAL		Geometrii			Calități		
			mm Inci	mm Inci	mm Inci					mm Inci	mm Inci	mm Inci	mm Inci	EB45	EB845
NS06-4.03H7-EB...	-	4,03 0.1587	4,03 0.1587	4,04 0.1591	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.04H7-EB...	-	4,04 0.1591	4,04 0.1591	4,05 0.1595	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.05H7-EB...	-	4,05 0.1594	4,05 0.1594	4,06 0.1599	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.50H7-EB...	-	4,5 0.1772	4,50 0.1772	4,51 0.1776	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.750H7-EB...	-	4,75 0.1870	4,75 0.1870	4,76 0.1875	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.750H7-EB30	10019458	4,75 0.1870	4,76 0.1875	4,75 0.1870	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.762H7-EB...	-	4,762 0.1875	4,76 0.1875	4,77 0.1880	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.97H7-EB...	-	4,97 0.1957	4,97 0.1957	4,98 0.1961	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.98H7-EB...	-	4,98 0.1961	4,98 0.1961	4,99 0.1965	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-4.99H7-EB...	-	4,99 0.1965	4,99 0.1965	5,00 0.1969	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.00H7-EB...	-	5,0 0.1969	5,00 0.1969	5,01 0.1973	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5H7-EB30	10019459	5,0 0.1969	5,01 0.1973	5,00 0.1969	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.01H7-EB...	-	5,01 0.1972	5,01 0.1972	5,02 0.1977	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.02H7-EB...	-	5,02 0.1976	5,02 0.1976	5,03 0.1981	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.03H7-EB...	-	5,03 0.1980	5,03 0.1980	5,04 0.1985	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.04H7-EB...	-	5,04 0.1984	5,04 0.1984	5,05 0.1989	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.05H7-EB...	-	5,05 0.1988	5,05 0.1988	5,06 0.1993	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.50H7-EB...	-	5,5 0.2165	5,50 0.2165	5,51 0.2170	30,0 1.1810	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.97H7-EB...	-	5,97 0.2350	5,97 0.2350	5,98 0.2355	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.98H7-EB...	-	5,98 0.2354	5,98 0.2354	5,99 0.2359	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-5.99H7-EB...	-	5,99 0.2358	5,99 0.2358	6,00 0.2363	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6.00H7-EB...	-	6,0 0.2362	6,00 0.2362	6,01 0.2367	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6H7-EB30	10019460	6,0 0.2362	6,01 0.2367	6,00 0.2362	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6.01H7-EB...	-	6,01 0.2366	6,01 0.2366	6,03 0.2372	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6.02H7-EB...	-	6,02 0.2370	6,02 0.2370	6,04 0.2376	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6.03H7-EB...	-	6,03 0.2374	6,03 0.2374	6,05 0.2380	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6.04H7-EB...	-	6,04 0.2378	6,04 0.2378	6,06 0.2384	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS06-6.05H7-EB...	-	6,05 0.2382	6,05 0.2382	6,07 0.2388	31,0 1.2200	6,0 0.2360	50,0 1.9690	4	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-6.334H7-EB...	-	6,334 0.2494	6,33 0.2494	6,35 0.2500	46,0 1.8110	10,0 0.3940	78,0 3.0710	6	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-6.334H7-EB30	10019461	6,334 0.2494	6,35 0.2500	6,33 0.2494	46,0 1.8110	10,0 0.3940	78,0 3.0710	4	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

Introducere

Găuire

Alezare

Alezare adâncă

Anexă

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

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

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Reper Nr.	Număr reper	DC			Hole dia min-max		LUX	DMM	OAL		Geometrii			Calități		
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci					mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
NS10-11.05H7-EB...	-	11,05 0.4350	11,05 0.4350	11,07 0.4357	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-11.112H7-EB...	-	11,112 0.4375	11,11 0.4375	11,13 0.4382	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-11.50H7-EB...	-	11,5 0.4528	11,50 0.4528	11,52 0.4535	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-11.97H7-EB...	-	11,97 0.4713	11,97 0.4713	11,99 0.4720	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-11.98H7-EB...	-	11,98 0.4717	11,98 0.4717	12,00 0.4724	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-11.99H7-EB...	-	11,99 0.4720	11,99 0.4720	12,01 0.4728	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12.00H7-EB...	-	12,0 0.4724	12,00 0.4724	12,02 0.4731	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12H7-EB30	10019468	12,0 0.4724	12,02 0.4731	12,00 0.4724	57,0 2.2440	10,0 0.3940	88,0 3.4650	4		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12.01H7-EB...	-	12,01 0.4728	12,01 0.4728	12,03 0.4735	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12.02H7-EB...	-	12,02 0.4732	12,02 0.4732	12,04 0.4739	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12.03H7-EB...	-	12,03 0.4736	12,03 0.4736	12,05 0.4743	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12.04H7-EB...	-	12,04 0.4740	12,04 0.4740	12,06 0.4747	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
NS10-12.05H7-EB...	-	12,05 0.4744	12,05 0.4744	12,07 0.4751	57,0 2.2440	10,0 0.3940	88,0 3.4650	6		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	

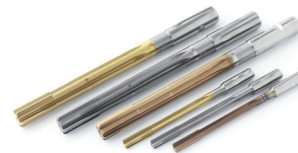
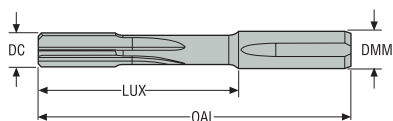
■ Stoc standard. □ Non stoc standard.

Notă! La comandarea unor alezoare intermediare, vă rugăm să precizați: Ø și toleranța găurii de alezat, geometria vârfului (EN1, EN2 or EN3).

Exemplu de comandă: NF10-10,187/10,213-EB845, RX2000.

## Diametre intermediare

Straight flute, short version



- Pentru regimurile de aşchiere vezi pag. 391-396
- Pentru alegerea geometriei, vezi pag. 373-375

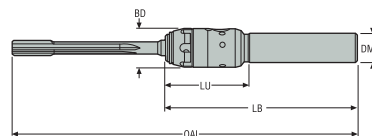
Reper Nr.	DCN	DCX	LUX	DMM	OAL	Mărimea corpului	Geometria	Calități							
	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			H15	RK2050	RX2000	RN2010	RM2020	RM2090	RS2090	
NS06-2.970-XX-XXXX	2,97 0.117	3,05 0.120	25,0 0.984	6,0 0.236	45,0 1.772	4	NFQF06-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NS06-3.051-XX-XXXX	3,051 0.120	6,05 0.238	30,0 1.181	6,0 0.236	50,0 1.969	4	NFQF06-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NS10-6.051-XX-XXXX	6,051 0.238	10,05 0.396	46,0 1.811	10,0 0.394	78,0 3.071	6	NFQF10-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
NS10-10.051-XX-XXXX	10,051 0.396	12,05 0.474	57,0 2.244	10,0 0.394	88,0 3.465	6	NFQF10-xx	EB45 EB845 EB30	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

= Stoc non standard Stocul se poate modifica pe parcurs, consultați lista de stocuri și prețuri curentă.

Notă: La comandarea alezozelor Nanofix pentru diametre intermediare, vă rugăm să precizați diametrul și toleranța găurii de alezat.

Exemplu de comandă: NS10-10,187/10,213-EB845, RS2090.

## Portscule Nanofix



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

### Piese de schimb

DC	Set piese schimb prindere	Cheie
2,97-6,050		
6,051-12,050		

#### Setul de piese de schimb pentru prindere pentru Nanofix include:

- 1 piuliță de prindere
- 1 arc de oprire pentru inel axial
- 3 bile de prindere (dia 3,5 mm pentru NF06 & dia 5 mm pentru NF10)
- 1 bilă anti-eroare (dia 3 mm pentru NF06 & dia 4 mm pentru NF10)
- 1 O-ring

Note: bila anti-eroare nu apare în vederea de mai sus.

Regimuri de aşchiere – NF/NS...-EB45 metric

SMG		a <sub>p</sub> (Z)		f		v <sub>c</sub>						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RN2010	RM2020	RM2090	RS2090
P1	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	-	-	-
P2	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	-	-	-
P3	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,30	0,20-0,60	25 (15-30)	60 (30-100)	80 (30-150)	-	-	-	-
P4	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P5	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P6	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P7	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P8	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	-	-	-
P11	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	-	-	-
P12	NF/NS-EB45	0,10-0,15	0,1-0,20	0,10-0,20	0,20-0,50	12 (8-15)	25 (15-45)	30 (15-65)	-	-	-	-
M1	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	12 (9-15)	25 (15-40)	35 (20-60)	-	25 (15-40)	40 (20-60)	-
M2	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	-	25 (15-40)	35 (20-60)	-	25 (15-40)	40 (20-60)	-
M3	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	-	25 (15-40)	35 (20-60)	-	25 (15-40)	40 (20-60)	-
M4	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	-	20 (10-30)	25 (15-40)	-	25 (10-30)	30 (15-40)	-
M5	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,50	-	20 (10-30)	25 (15-40)	-	25 (10-30)	30 (15-40)	-
K1	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	60 (40-100)	80 (30-150)	-	-	-	-
K2	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	-	25 (20-40)	40 (30-70)	-	-	-	-
K3	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	60 (40-100)	80 (30-150)	-	-	-	-
K4	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	45 (30-70)	70 (40-120)	-	-	-	-
K5	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	25 (15-30)	45 (30-70)	70 (40-120)	-	-	-	-
K6	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	-	60 (40-100)	80 (30-150)	-	-	-	-
K7	NF/NS-EB45	0,10-0,20	0,10-0,25	0,10-0,30	0,20-0,60	-	60 (40-100)	80 (30-150)	-	-	-	-
N1	NF/NS-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	-	-	-
N2	NF/NS-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	-	-	-
N3	NF/NS-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	-	-	-
N4	NF/NS-EB45	0,10-0,20	0,10-0,30	0,10-0,30	0,20-0,60	50 (20-80)	-	80 (30-150)	50 (20-80)	-	-	-
S1	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	-	15 (8-20)	20 (10-25)	-	-	-	20 (10-25)
S2	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	-	15 (8-20)	20 (10-25)	-	-	-	20 (10-25)
S3	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	-	15 (8-20)	20 (10-25)	-	-	-	25 (10-25)
S11	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	30 (20-50)
S12	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	30 (20-50)
S13	NF/NS-EB45	0,08-0,15	0,10-0,15	0,10-0,20	0,20-0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	30 (20-50)

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Regimuri de aşchiere – NF/NS...-EB45 metric

SMG		$a_p$ (∅)		f		$v_c$						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
H3	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H5	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H7	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H8	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H11	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H12	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H21	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H31	NF/NS-EB45	0,08- 0,15	0,10- 0,15	0,10- 0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
PM1	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,20	0,20- 0,50	-	50 (30-80)	70 (40-100)	-	-	-	-
PM2	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,20	0,20- 0,50	-	50 (30-80)	70 (40-100)	-	-	-	-
PM3	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,20	0,20- 0,50	-	50 (30-80)	70 (40-100)	-	-	-	-
TS1	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TS2	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TS3	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TS4	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TP1	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TP2	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TP3	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
TP4	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	20 (15-25)	-	40 (20-60)	-	-	-	-
GR1	NF/NS-EB45	0,10- 0,15	0,1- 0,20	0,10- 0,30	0,20- 0,60	40 (80-20)	-	60 (30-120)	-	-	-	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire



Regimuri de aşchiere – NF/NS...EB45 inci

SMG		a <sub>p</sub> (Z)		f		v <sub>c</sub>						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RN2010	RM2020	RM2090	RS2090
P1	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	-	-	-	-
P2	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	-	-	-	-
P3	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	80 (50-100)	195 (100-330)	260 (100-490)	-	-	-	-
P4	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P5	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P6	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P7	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P8	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	50 (35-65)	115 (65-195)	130 (65-260)	-	-	-	-
P11	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	50 (35-65)	115 (65-195)	130 (65-260)	-	-	-	-
P12	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	40 (25-50)	80 (50-150)	100 (50-215)	-	-	-	-
M1	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	40 (30-50)	80 (50-130)	115 (65-195)	-	80 (50-130)	130 (65-195)	-
M2	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	-	80 (50-130)	115 (65-195)	-	80 (50-130)	130 (65-195)	-
M3	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	-	80 (50-130)	115 (65-195)	-	80 (50-130)	130 (65-195)	-
M4	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	-	65 (35-100)	80 (50-130)	-	65 (35-100)	100 (50-130)	-
M5	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.020	-	65 (35-100)	80 (50-130)	-	65 (35-100)	100 (50-130)	-
K1	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	195 (130-330)	260 (100-490)	-	-	-	-
K2	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	-	80 (65-130)	130 (100-230)	-	-	-	-
K3	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	195 (130-330)	260 (100-490)	-	-	-	-
K4	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	150 (100-230)	230 (130-395)	-	-	-	-
K5	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	80 (50-100)	150 (100-230)	230 (130-395)	-	-	-	-
K6	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	-	195 (130-330)	260 (100-490)	-	-	-	-
K7	NF/NS-EB45	0.004-0.008	0.004-0.010	0.004-0.012	0.008-0.024	-	195 (130-330)	260 (100-490)	-	-	-	-
N1	NF/NS-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	-	260 (100-490)	165 (65-260)	-	-	-
N2	NF/NS-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	-	260 (100-490)	165 (65-260)	-	-	-
N3	NF/NS-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	-	260 (100-490)	165 (65-260)	-	-	-
N4	NF/NS-EB45	0.004-0.787	0.004-0.012	0.004-0.012	0.008-0.024	165 (65-260)	-	260 (100-490)	165 (65-260)	-	-	-
S1	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	50 (25-65)	65 (35-80)	-	-	-	65 (35-80)
S2	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	50 (25-65)	65 (35-80)	-	-	-	65 (35-80)
S3	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	50 (25-65)	65 (35-80)	-	-	-	80 (35-80)
S11	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	100 (65-165)
S12	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	100 (65-165)
S13	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	100 (65-165)

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Regimuri de aşchiere – NF/NS...-EB45 inci

SMG		$a_p$ (∅)		f		$v_c$						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RN2010	RM2020	RM2090	RS2090
H3	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H5	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H7	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H8	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H11	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H12	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H21	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
H31	NF/NS-EB45	0.003-0.006	0.004-0.006	0.004-0.008	0.008-0.012	-	-	35 (25-50)	-	-	-	-
PM1	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	-	165 (100-260)	230 (130-350)	-	-	-	-
PM2	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	-	165 (100-260)	230 (130-350)	-	-	-	-
PM3	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.008	0.008-0.020	-	165 (100-260)	230 (130-350)	-	-	-	-
TS1	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TS2	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TS3	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TS4	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TP1	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TP2	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TP3	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
TP4	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	65 (50-80)	-	130 (65-195)	-	-	-	-
GR1	NF/NS-EB45	0.004-0.006	0.004-0.008	0.004-0.012	0.008-0.024	130 (65-260)	-	195 (100-395)	-	-	-	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – NF/NS...-EB845 metric

SMG		a <sub>p</sub> (Z)		f		v <sub>c</sub>						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,30	0,20 -0,60	-	60 (30-100)	80 (30-150)	-	-	-	-
P4	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	-	50 (30-80)	60 (30-120)	-	-	-	-
P5	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P6	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P7	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	20 (10-25)	50 (30-80)	60 (30-120)	-	-	-	-
P8	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	-	-	-
P11	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	15 (10-20)	35 (20-60)	40 (20-80)	-	-	-	-
P12	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	12 (8-15)	25 (15-45)	30 (15-65)	-	-	-	-
M1	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	12 (9-15)	25 (15-45)	35 (20-60)	-	25 (15-40)	40 (20-60)	-
M2	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	-	25 (15-45)	35 (20-60)	-	25 (15-40)	40 (20-60)	-
M3	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	-	25 (15-45)	35 (20-60)	-	25 (15-40)	40 (20-60)	-
M4	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	-	20 (10-30)	25 (15-40)	-	25 (10-30)	30 (15-40)	-
M5	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20 -0,50	-	20 (10-30)	25 (15-40)	-	25 (10-30)	30 (15-40)	-
K1	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	-	-
K2	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	-	25 (20-40)	40 (30-70)	45 (35-80)	-	-	-
K3	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)	-	-	-
K4	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (30-150)	-	-	-
K5	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)	-	-	-
K6	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	-	60 (40-100)	80 (30-150)	90 (35-170)	-	-	-
K7	NF/NS-EB845	0,10 -0,20	0,10 -0,25	0,10 -0,30	0,20 -0,60	-	60 (40-100)	80 (30-150)	90 (35-170)	-	-	-
S1	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	15 (8-20)	20 (10-25)	-	-	-	20 (10-25)
S2	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	15 (8-20)	20 (10-25)	-	-	-	20 (10-25)
S3	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	15 (8-20)	20 (10-25)	-	-	-	25 (10-25)
S11	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	30 (20-50)
S12	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	30 (20-50)
S13	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	20 (15-30)	30 (15-40)	40 (20-50)	-	-	-	30 (20-50)
H3	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H5	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H7	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H8	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H11	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H12	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H21	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
H31	NF/NS-EB845	0,08 -0,15	0,10 -0,15	0,10 -0,20	0,20- 0,30	-	-	10 (8-15)	-	-	-	-
PM1	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	-	50 (30-80)	70 (40-100)	-	-	-	-
PM2	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	-	50 (30-80)	70 (40-100)	-	-	-	-
PM3	NF/NS-EB845	0,10 -0,15	0,1 -0,20	0,10 -0,20	0,20 -0,50	-	50 (30-80)	70 (40-100)	-	-	-	-

SMG = Grupa de material Seco

a<sub>p</sub> = mm

f = mm/rev

v<sub>c</sub> = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – NF/NS...-EB845 inci

SMG		a <sub>p</sub> (°)		f		v <sub>c</sub>						
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050	RM2020	RM2090	RS2090
P3	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.012	0.008 -0.024	-	195 (100-330)	260 (100-490)	-	-	-	-
P4	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	-	165 (100-260)	195 (100-395)	-	-	-	-
P5	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P6	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P7	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	65 (35-80)	165 (100-260)	195 (100-395)	-	-	-	-
P8	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	50 (35-65)	115 (65-195)	130 (65-260)	-	-	-	-
P11	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	50 (35-65)	115 (65-195)	130 (65-260)	-	-	-	-
P12	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	40 (25-50)	80 (50-150)	100 (50-125)	-	-	-	-
M1	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.02	40 (30-50)	80 (50-150)	115 (65-200)	-	80 (50-130)	130 (65-195)	-
M2	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.02	-	80 (50-150)	115 (65-200)	-	80 (50-130)	130 (65-195)	-
M3	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.02	-	80 (50-150)	115 (65-200)	-	80 (50-130)	130 (65-195)	-
M4	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.02	-	65 (30-100)	80 (50-135)	-	80 (35-100)	100 (50-130)	-
M5	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.02	-	65 (30-100)	80 (50-135)	-	80 (35-100)	100 (50-130)	-
K1	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	-	-
K2	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	-	80 (65-130)	130 (100-230)	145 (110-260)	-	-	-
K3	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)	-	-	-
K4	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	80 (50-100)	150 (100-330)	230 (130-395)	260 (145-440)	-	-	-
K5	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	80 (50-100)	150 (100-330)	230 (130-395)	260 (145-440)	-	-	-
K6	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	-	195 (130-330)	260 (100-490)	290 (110-550)	-	-	-
K7	NF/NS-EB845	0.004 -0.008	0.004 -0.010	0.004 -0.012	0.008 -0.024	-	195 (130-330)	260 (100-490)	290 (110-550)	-	-	-
S1	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	50 (25-65)	65 (35-80)	-	-	-	65 (35-80)
S2	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	50 (25-65)	65 (35-80)	-	-	-	65 (35-80)
S3	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	50 (25-65)	65 (35-80)	-	-	-	65 (35-80)
S11	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	100 (65-165)
S12	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	100 (65-165)
S13	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	65 (50-100)	100 (50-130)	130 (65-165)	-	-	-	100 (65-165)
H3	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H5	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H7	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H8	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H11	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H12	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H21	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
H31	NF/NS-EB845	0.003 -0.006	0.004 -0.006	0.004 -0.008	0.008 -0.012	-	-	35 (25-50)	-	-	-	-
PM1	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	-	165 (100-260)	230 (130-350)	-	-	-	-
PM2	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	-	165 (100-260)	230 (130-350)	-	-	-	-
PM3	NF/NS-EB845	0.004 -0.006	0.004 -0.008	0.004 -0.008	0.008 -0.020	-	165 (100-260)	230 (130-350)	-	-	-	-

SMG = Grupa de material Seco

a<sub>p</sub> = inci

f = in/rev

v<sub>c</sub> = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – NF/NS...-EB25/EB30 metric

SMG		$a_p (\varnothing)$		f		$v_c$			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	-
P2	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	-
P3	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	25 (15-30)	60 (30-100)	80 (30-150)	-
P4	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	-
P5	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	-
P6	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	-
P7	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,7	0,5-1	20 (10-25)	50 (30-80)	60 (30-120)	-
M1	NF/NS-EB25/EB30	0,08-0,15	0,10-0,15	0,3-0,7	0,5-1	-	25 (15-40)	35 (20-60)	-
K1	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)
K2	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	-	25 (20-40)	40 (30-70)	45 (35-80)
K3	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	60 (40-100)	80 (30-150)	90 (35-170)
K4	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)
K5	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	25 (15-30)	45 (30-70)	70 (40-120)	80 (45-135)
K6	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	-	60 (40-100)	80 (30-150)	90 (35-170)
K7	NF/NS-EB25/EB30	0,10-0,20	0,10-0,25	0,3-0,9	0,5-1,2	-	60 (40-100)	80 (30-150)	90 (35-170)
N1	NF/NS-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	-	-	-
N2	NF/NS-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	-	-	-
N3	NF/NS-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	-	-	-
N11	NF/NS-EB25/EB30	0,10-0,20	0,10-0,30	0,3-0,9	0,5-1,2	50 (20-80)	-	-	-
PM1	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	-	50 (30-80)	70 (40-100)	-
PM2	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	-	50 (30-80)	70 (40-100)	-
PM3	NF/NS-EB25/EB30	0,10-0,15	0,1-0,20	0,3-0,9	0,5-1,2	-	50 (30-80)	70 (40-100)	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – EB25/EB30 inci

SMG		$a_p$ (∅)		f		$v_c$			
		z=4	z=6	z=4	z=6	H15	CP20	RX2000	RK2050
P1	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.035	0.020-0.047	80 (50-100)	195 (100-330)	260 (100-490)	-
P2	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.035	0.020-0.047	80 (50-100)	195 (100-330)	260 (100-490)	-
P3	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.035	0.020-0.047	80 (50-100)	195 (100-330)	260 (100-490)	-
P4	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.028	0.020-0.039	65 (35-80)	165 (100-265)	195 (100-395)	-
P5	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.028	0.020-0.039	65 (35-80)	165 (100-265)	195 (100-395)	-
P6	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.028	0.020-0.039	65 (35-80)	165 (100-265)	195 (100-395)	-
P7	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.028	0.020-0.039	65 (35-80)	165 (100-265)	195 (100-395)	-
M1	NF/NS-EB25/EB30	0.003-0.006	0.004-0.006	0.012-0.028	0.020-0.039	-	80 (50-130)	115 (65-195)	-
K1	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)
K2	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	-	80 (65-130)	130 (100-230)	145 (110-260)
K3	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	80 (50-100)	195 (130-330)	260 (100-490)	290 (110-550)
K4	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)
K5	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	80 (50-100)	150 (100-230)	230 (130-395)	260 (145-440)
K6	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	-	195 (130-330)	260 (100-490)	290 (110-550)
K7	NF/NS-EB25/EB30	0.004-0.008	0.004-0.010	0.012-0.035	0.020-0.047	-	195 (130-330)	260 (100-490)	290 (110-550)
N1	NF/NS-EB25/EB30	0.004-0.787	0.004-0.012	0.012-0.035	0.020-0.047	165 (65-265)	-	-	-
N2	NF/NS-EB25/EB30	0.004-0.787	0.004-0.012	0.012-0.035	0.020-0.047	165 (65-265)	-	-	-
N3	NF/NS-EB25/EB30	0.004-0.787	0.004-0.012	0.012-0.035	0.020-0.047	165 (65-265)	-	-	-
N11	NF/NS-EB25/EB30	0.004-0.787	0.004-0.012	0.012-0.035	0.020-0.047	165 (65-265)	-	-	-
PM1	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.035	0.020-0.047	-	165 (100-265)	230 (130-330)	-
PM2	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.035	0.020-0.047	-	165 (100-265)	230 (130-330)	-
PM3	NF/NS-EB25/EB30	0.004-0.006	0.004-0.008	0.012-0.035	0.020-0.047	-	165 (100-265)	230 (130-330)	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

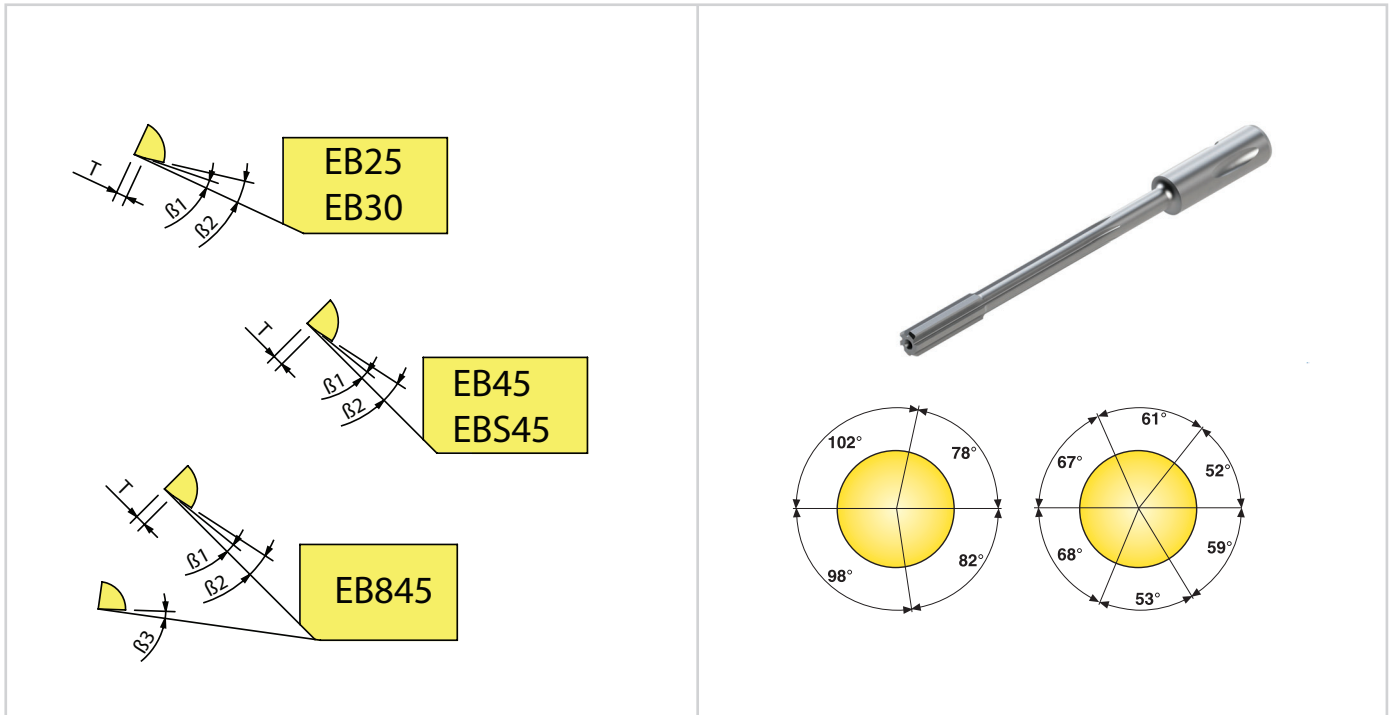
## Instrucțiuni pentru reascuțire

### Specificații

Roată diamantată pentru ascuțire  
Granulația:  
D6 pentru primul unghi de degajare ( $\beta_1 - \beta_3$ )  
D64 pentru al doilea unghi de degajare ( $\beta_2$ )

### Important:

Reascuțirea reduce diametrul alezătorului.  
Reacoperirea poate duce la mărirea diametrului.  
Bătaie radială la șanfenări de intrare 10  $\mu\text{m}$  (394  $\mu\text{in}$ ).



$\varnothing$ Nanofix mm (inci)	$\beta_1$	$\beta_2$	$\beta_3$	T mm (inci)
2,97-9,999 (0,1169-0,3936)	8°	25°	10°	0,15 (0,006)
10,12-12,050 (0,3937-0,4744)	8°	25°	10°	0,15 (0,006)



## Bifix®

Alezoarele cu lame amovibile Bifix® aduc performanțe de înaltă precizie pentru toate grupele de materiale de prelucrat

- Permit toleranțe între 8 și 16  $\mu\text{m}$  și o finisare a suprafeței de Ra 0,25 (RMS 12 micro/inci)
- Lamele amovibile dispun de două muchii așchietoare per lamă
- Trei plăcuțe de ghidare cermet și un sistem de reglare precis



## Prezentare generală

	Ø Gamă	Adâncimea de alezare	Toleranța Ø burghiului	Diametre intermediare	Finisarea suprafeței
<b>SR80 Pentru găuri străpuse</b> 	6,875-60,500 mm (0.2707-2.3819")	5-7 x D	IT 6	Da, disponibil în Custom design	R <sub>a</sub> 0,2-0,8 μm (R <sub>a</sub> 8-31 μin)
<b>SR81 Pentru găuri infundate</b> 	7,875-60,500 mm (0.3100-2.3819")	5-7 x D	IT 6-7	Da, disponibil în Custom design	R <sub>a</sub> 0,2-0,8 μm (R <sub>a</sub> 8-31 μin)
<b>SR82 Pentru găuri infundate versiunea scurtă</b> 	7,875-60,500 mm (0.3100-2.3819")	3-5 x D	IT 6-7	Da, disponibil în Custom design	R <sub>a</sub> 0,2-0,8 μm (R <sub>a</sub> 8-31 μin)

## Codificări

### Alezoare

Tipul alezorului:  
Tip 80: Gaură străpunsă  
Tip 81: Gaură înfundată  
Tip 82: Gaură înfundată, versiunea scurtă



Tipul alezorului:  
Tip 80: Gaură străpunsă  
Tip 81: Gaură înfundată  
Tip 82: Gaură înfundată, versiunea scurtă

Diametrul găurii  
și toleranța

Tipul geometriei vârfului  
EN1, EN2, EN3

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

**0.6624"-0.6628"**

Tip coadă prindere: (va fi precizat dacă nu este tip standard)  
SR80 și SR81: R1 fără aplatizare este standard  
SR82: R9 cu aplatizare este standard

### Lame

**Important:**  
Alezorul și lama trebuie să aibă aceeași geometrie.

Mărime alamei:  
P0, P1, P2, P4

Unghi de degajare:  
0°, 6°, 12°

**P2** - **EN1** - **06** - **CP20**

Tipul geometriei vârfului  
EN1, EN2, EN3

Calități de carbură:  
CP20, H15

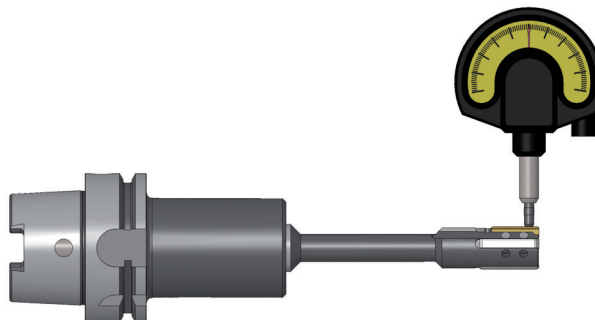
## Setare și regimuri de așchiere

### Aplicații dinamice

Bătaia radială maximă recomandată: 0,02 mm (0,0008").  
Se recomandă o portsculă de precizie: Prindere hidraulică, Mandrină cu pensete tip D, mandrină cu pensete 5672 sau fretare.

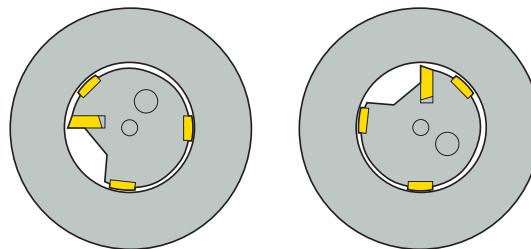
#### Sculă statică

Utilizați o port-sculă flotantă Seco, consultați pagina 480-484.



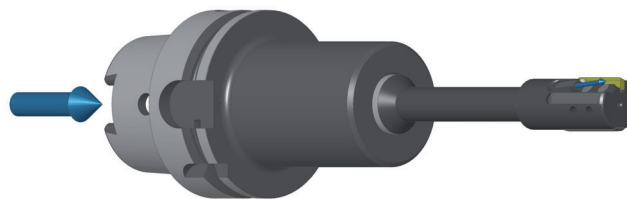
### Pentru o evacuare optimă a așchiilor

Orientarea recomandată a lamelor pentru aplicații statice (vezi desenul, vedere frontală a sculei).



### Cerințele lichidului de răcire

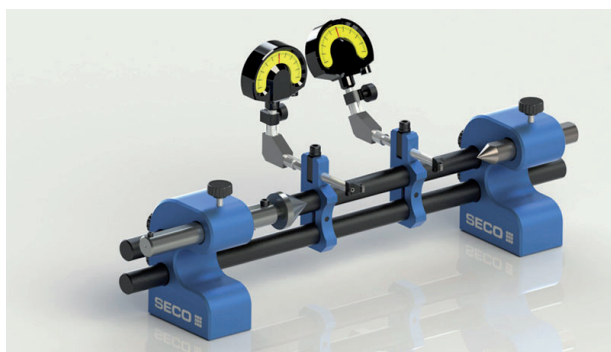
Pentru a obține o viață lungă a sculei și o calitate ridicată a găurii, trebuie ținut cont de următoarele caracteristici ale lichidului de răcire. Se recomandă răcirea interioară. Se poate utiliza răcire externă pentru adâncimea alezajului < 2 x D. Ulei solubil de calitate cu minim 40% ulei mineral. Se recomandă ulei curat pentru oțel inoxidabil. Filtrare 30–50 μm (1200-2000 μin). Volum min. 0,5 l/min/mm (3,35 gal/min/inci) din diametrul sculei. Ex: Alezor Ø 10, volum min. este 5 l/min (1,3 gal/min).



### Prindere de reglare

#### SF-60200-C160C190: Nr. piesă 02885396

- Stand orizontal
- Prima alegere pentru diametru mai mic de 60 mm (2,362")
- 2 comparatoare
- Diametru maxim al sculei: 60,5 mm (2,382")
- Lungime maximă a sculei: 200 mm (7,784")



## Opțiune de geometrie – lame

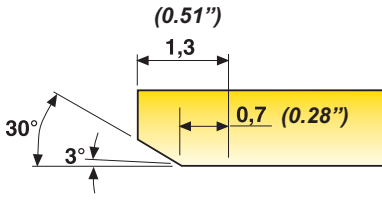
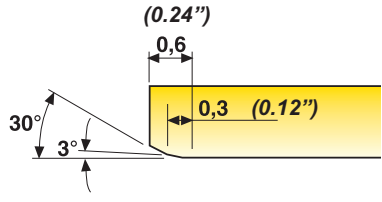
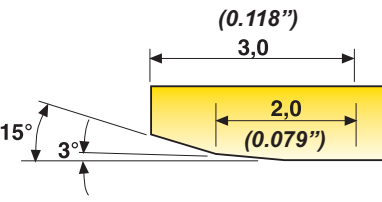
Alezorul și lama trebuie să aibă aceeași geometrie.

### Calitate și unghi de degajare

Utilizați tabelele de la paginile 666-672 pentru a clasifica materialul piesei de prelucrat în SMG.

Utilizați tabelul de recomandări de regimuri de frezare de la pagina 413415 pentru alegerea calității și a unghiului de degajare.

Gama de lame se regăsește la paginile 411, 412.

EN1 – Aplicație	
<p>Toleranță de prelucrare maximă la <math>\varnothing 0,5</math> mm (0,020")                      Finisarea suprafeței + <math>R_a</math> 0,3 - 0,8 <math>\mu</math>m                      (Finisarea suprafeței + <math>R_a</math> 12 - 31 <math>\mu</math>in)</p>	
EN2 - Timp scurt de prelucrare	
<p>Toleranță de prelucrare maximă la <math>\varnothing 0,3</math> mm (0,012")                      Finisarea suprafeței + <math>R_a</math> 0,4 - 1,2 <math>\mu</math>m                      (Finisarea suprafeței + <math>R_a</math> 16 - 47 <math>\mu</math>in)                      Rată maximă de avans 0,2 mm/rot (0,008" in/rot).                      A se utiliza doar când este necesar un pas mic                      Conceput cu așchiere finală</p>	
EN3 – Finisare de excepție a suprafeței	
<p>Toleranță de prelucrare maximă la <math>\varnothing 0,5</math> mm (0,020")                      Finisare a suprafeței + <math>R_a</math> 0,2 - 0,6 <math>\mu</math>m                      (Finisare a suprafeței + <math>R_a</math> 8 - 24 <math>\mu</math>in)                      Adecvat pentru toate materialele, cu excepția aluminiului                      A se utiliza când <math>R_a</math> trebuie să fie &lt; 0,3-0,4 <math>\mu</math>m (12-16 <math>\mu</math>in)</p>	




## Optimizare/Calități

Utilizați tabelul de selectare a lamelor pentru alegerea lamelor alternative pentru productivitate mai mare sau o mai bună siguranță

### Opțiuni de lame

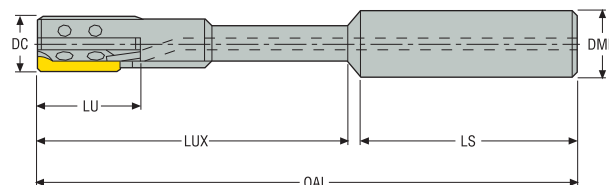
Mărimile lamei	Oțel	Oțel inoxidabil	Fontă	Neferoase	Aluminiu	Rezistență la uzură ↔ Tenacitate		Reper Nr.		
						Productivitate	Uniwersalność	Siguranță	Lamă	Calitate
P0, P1, P2, P4			•	•				X	Pxx-ENx-00	H15
	•		•		•			X	Pxx-ENx-06	H15
		•		•	•			X	Pxx-ENx-12	H15
	•					X			Pxx-ENx-00	CP20
	•		•				X		Pxx-ENx-06	CP20
	•	•					X		Pxx-ENx-12	CP20
	•		•			X			Pxx-ENx-00	CP15
	•		•			X			Pxx-ENx-06	CP15
	•	•		•	•	X			Pxx-ENx-12	CP15

### Calități

	CP15	<b>Acoperită</b> Calitate acoperită rezistentă la uzură alternativă la CP20. Pentru optimizare în fontă și oțeluri. Se poate folosi și în materiale neferoase. Ti(C, N)
	CP20	<b>Acoperită</b> O calitate acoperită potrivită pentru majoritatea materialelor, cu excepția aluminiului. TiN
	H15	<b>Neacoperită</b> O calitate rezistentă a microstructurii pentru toate materialele. Potrivită pentru operațiuni de alezare fină datorită unei muchii foarte ascuțite.

## Pentru găuri străpuse $\varnothing$ 7H6-26H6

Tip de coadă R1, cilindrică fără aplatizare, SR80



- Informații despre lame la pag. 411, 412
- Răcire internă

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR80-7H6-EN1	7	105	40	63	25	10	P0-EN1-xx
SR80-8H6-EN1	8	115	40	73	25	10	P0-EN1-xx
SR80-9H6-EN1	9	115	40	73	25	10	P1-EN1-xx
SR80-10H6-EN1	10	115	40	74	25	10	P1-EN1-xx
SR80-11H6-EN1	11	133	48	81	25	16	P1-EN1-xx
SR80-12H6-EN1	12	133	48	81	25	16	P1-EN1-xx
SR80-13H6-EN1	13	133	48	81	25	16	P2-EN1-xx
SR80-14H6-EN1	14	133	48	81	25	16	P2-EN1-xx
SR80-15H6-EN1	15	133	48	82	25	16	P2-EN1-xx
SR80-16H6-EN1	16	133	48	82	25	16	P2-EN1-xx
SR80-17H6-EN1	17	155	50	100	25	20	P2-EN1-xx
SR80-18H6-EN1	18	155	50	100	25	20	P2-EN1-xx
SR80-19H6-EN1	19	155	50	100	25	20	P2-EN1-xx
SR80-20H6-EN1	20	155	50	100	30	20	P4-EN1-xx
SR80-21H6-EN1	21	191	56	128	30	25	P4-EN1-xx
SR80-22H6-EN1	22	191	56	129	30	25	P4-EN1-xx
SR80-23H6-EN1	23	191	56	129	30	25	P4-EN1-xx
SR80-24H6-EN1	24	191	56	129	30	25	P4-EN1-xx
SR80-25H6-EN1	25	191	56	129	30	25	P4-EN1-xx
SR80-26H6-EN1	26	191	56	129	30	25	P4-EN1-xx

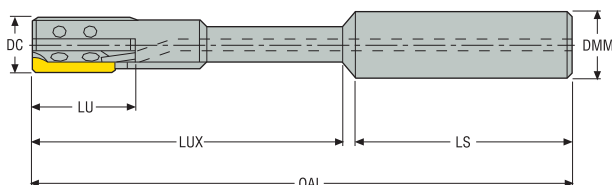
### Piese de schimb

Pentru $\varnothing$ (mm)	Șurub reglaj	Clamp	Șurub clemă	Cheie raglaj	Bilă suport	Cheie dinamometrică*	Valoare cuplu
7-8	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	-	-
9	SH2025	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
10-12	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
13-19	SH2540	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509	0,9 Nm
20-60	SH3060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

\*Torque key is delivered with driving blade

## Pentru găuri străpuse $\varnothing$ 27H6-60H6

Tip de coadă R1, cilindrică fără aplatizare, SR80



- Informații despre lame la pag. 411, 412
- Răcire internă

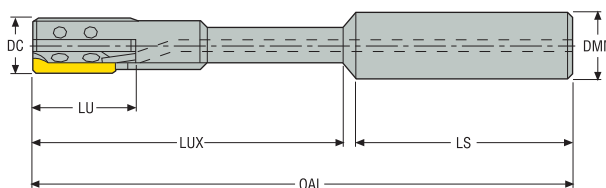
Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR80-27H6-EN1	27	221	56	159	30	25	P4-EN1-xx
SR80-28H6-EN1	28	221	56	159	30	25	P4-EN1-xx
SR80-29H6-EN1	29	221	56	159	30	25	P4-EN1-xx
SR80-30H6-EN1	30	221	56	159	30	25	P4-EN1-xx
SR80-31H6-EN1	31	221	56	160	30	25	P4-EN1-xx
SR80-32H6-EN1	32	221	56	160	30	25	P4-EN1-xx
SR80-34H6-EN1	34	226	56	165	30	25	P4-EN1-xx
SR80-35H6-EN1	35	226	56	165	30	25	P4-EN1-xx
SR80-36H6-EN1	36	226	56	166	30	25	P4-EN1-xx
SR80-38H6-EN1	38	226	56	166	30	25	P4-EN1-xx
SR80-40H6-EN1	40	226	56	166	30	25	P4-EN1-xx
SR80-42H6-EN1	42	226	56	167	30	25	P4-EN1-xx
SR80-44H6-EN1	44	226	56	167	30	25	P4-EN1-xx
SR80-48H6-EN1	48	226	56	168	30	25	P4-EN1-xx
SR80-50H6-EN1	50	226	56	168	30	25	P4-EN1-xx
SR80-52H6-EN1	52	226	56	169	30	25	P4-EN1-xx
SR80-54H6-EN1	54	226	56	169	30	25	P4-EN1-xx
SR80-58H6-EN1	58	226	56	169	30	25	P4-EN1-xx
SR80-60H6-EN1	60	226	56	169	30	25	P4-EN1-xx

### Piese de schimb

Pentru $\varnothing$ (mm)	Șurub reglaj	Clamp	Șurub clemă	Cheie raglaj	Bilă suport	Cheie dinamometrică*	Valoare cuplu
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

## Pentru găuri străpunse – Diametre intermediare

Tip de coadă R1, cilindrică fără aplatizare, SR80



- Informații despre lame la pag. 411, 412
- Important! Alezorul și lama trebuie să aibă aceeași geometrie de atac
- Pentru alegerea geometriei vârfului EN1, EN2 sau EN3 vezi pag. 402

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR80-6.875-XX-XXXX-EN	6,875 - 7,874	105,0	40,0	63,0	15,0	10,0	P0-EN-xx
SR80-7.875-XX-XXXX-EN	7,875 - 8,749	115,0	40,0	73,0	25,0	10,0	P0-EN-xx
SR80-8.750-XX-XXXX-EN	8,75 - 9,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR80-9.750-XX-XXXX-EN	9,75 - 10,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR80-10.750-XX-XXXX-EN	10,75 - 12,749	133,0	48,0	81,0	25,0	16,0	P1-EN-xx
SR80-12.750-XX-XXXX-EN	12,75 - 16,749	133,0	48,0	81,0	25,0	16,0	P2-EN-xx
SR80-16.750-XX-XXXX-EN	16,75 - 19,499	155,0	50,0	100,0	25,0	20,0	P2-EN-xx
SR80-19.500-XX-XXXX-EN	19,5 - 20,499	155,0	50,0	100,0	30,0	20,0	P3-EN-xx
SR80-20.500-XX-XXXX-EN	20,5 - 26,499	191,0	56,0	129,0	30,0	25,0	P4-EN-xx
SR80-26.500-XX-XXXX-EN	26,5 - 32,499	221,0	56,0	160,0	30,0	25,0	P4-EN-xx
SR80-32.500-XX-XXXX-EN	32,5 - 38,499	226,0	56,0	165,0	30,0	25,0	P4-EN-xx
SR80-38.500-XX-XXXX-EN	38,5 - 40,499	226,0	56,0	166,0	30,0	25,0	P4-EN-xx
SR80-40.500-XX-XXXX-EN	40,5 - 44,499	226,0	56,0	167,0	30,0	25,0	P4-EN-xx
SR80-44.500-XX-XXXX-EN	44,5 - 50,499	226,0	56,0	168,0	30,0	25,0	P4-EN-xx
SR80-50.500-XX-XXXX-EN	50,5 - 60,5	226,0	56,0	169,0	30,0	25,0	P4-EN-xx

### Piese de schimb

### Accesorii

Pentru Ø (mm)	Șurub reglaj	Clemă	Șurub clemă	Cheie de reglare	Bilă suport	Cheie dinamometrică
6,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	-
8,750-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305
9,750-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,750-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.0	H00-1509
19,500-60,500	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020

\*Torque key is delivered with driving blade

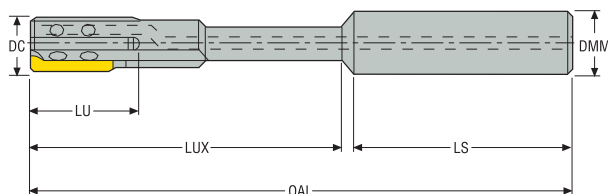
Notă! La comandarea unor alezoare intermediare, vă rugăm să precizați: Ø și toleranța găurii de alezat, geometria vârfului (EN1, EN2 or EN3).

Exemplu de comandă: SR80-11.50 H7-EN2, P1-EN2-06, CP20.



## Pentru găuri înfundate Ø 8H6-26H6

Tip de coadă R1, cilindrică fără aplatizare, SR81



- Informații despre lame la pag. 411, 412
- Răcire internă

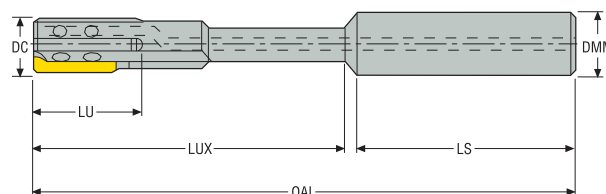
Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR81-8H6-EN1	8	115	40	73	25	10	P0-EN1-xx
SR81-9H6-EN1	9	115	40	73	25	10	P1-EN1-xx
SR81-11H6-EN1	11	133	48	81	25	16	P1-EN1-xx
SR81-13H6-EN1	13	133	48	81	25	16	P2-EN1-xx
SR81-14H6-EN1	14	133	48	81	25	16	P2-EN1-xx
SR81-15H6-EN1	15	133	48	82	25	16	P2-EN1-xx
SR81-16H6-EN1	16	133	48	82	25	16	P2-EN1-xx
SR81-17H6-EN1	17	155	50	100	25	20	P2-EN1-xx
SR81-18H6-EN1	18	155	50	100	25	20	P2-EN1-xx
SR81-19H6-EN1	19	155	50	100	25	20	P2-EN1-xx
SR81-20H6-EN1	20	155	50	100	30	20	P4-EN1-xx
SR81-21H6-EN1	21	191	56	128	30	25	P4-EN1-xx
SR81-22H6-EN1	22	191	56	129	30	25	P4-EN1-xx
SR81-23H6-EN1	23	191	56	129	30	25	P4-EN1-xx
SR81-25H6-EN1	25	191	56	129	30	25	P4-EN1-xx
SR81-26H6-EN1	26	191	56	129	30	25	P4-EN1-xx

### Piese de schimb

Pentru Ø (mm)	Șurub reglaj	Clamp	Șurub clemă	Cheie raglaj	Bilă suport	Cheie dinamometrică*	Valoare cuplu
8	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	-	-
9	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
10-12	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305	0,5 Nm
13-19	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509	0,9 Nm
20-60	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020	2,0 Nm

## Pentru găuri înfundate $\varnothing$ 27H6–60H6







Tip de coadă R1, cilindrică fără aplatizare, SR81



- Informații despre lame la pag. 411, 412
- Răcire internă

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR81-27H6-EN1	27	221	56	159	30	25	P4-EN1-xx
SR81-28H6-EN1	28	221	56	159	30	25	P4-EN1-xx
SR81-29H6-EN1	29	221	56	159	30	25	P4-EN1-xx
SR81-30H6-EN1	30	221	56	159	30	25	P4-EN1-xx
SR81-31H6-EN1	31	221	56	160	30	25	P4-EN1-xx
SR81-32H6-EN1	32	221	56	160	30	25	P4-EN1-xx
SR81-34H6-EN1	34	226	56	165	30	25	P4-EN1-xx
SR81-35H6-EN1	35	226	56	165	30	25	P4-EN1-xx
SR81-36H6-EN1	36	226	56	166	30	25	P4-EN1-xx
SR81-38H6-EN1	38	226	56	166	30	25	P4-EN1-xx
SR81-40H6-EN1	40	226	56	166	30	25	P4-EN1-xx
SR81-42H6-EN1	42	226	56	167	30	25	P4-EN1-xx
SR81-44H6-EN1	44	226	56	167	30	25	P4-EN1-xx
SR81-48H6-EN1	48	226	56	168	30	25	P4-EN1-xx
SR81-50H6-EN1	50	226	56	168	30	25	P4-EN1-xx
SR81-52H6-EN1	52	226	56	169	30	25	P4-EN1-xx
SR81-54H6-EN1	54	226	56	169	30	25	P4-EN1-xx
SR81-58H6-EN1	58	226	56	169	30	25	P4-EN1-xx
SR81-60H6-EN1	60	226	56	169	30	25	P4-EN1-xx

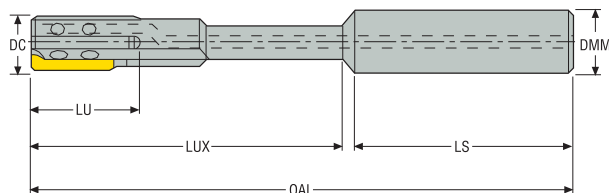
### Piese de schimb

Pentru $\varnothing$ (mm)	Șurub reglaj	Clamp	Șurub clemă	Cheie raglaj	Bilă suport	Cheie dinamometrică*	Valoare cuplu
20-60	 SH4060	 SR-B5	 LH4010	 2SMS795	 BB3.0	 H00-2020	2,0 Nm

\*Torque key is delivered with driving blade

## Pentru găuri înfundate – Diametre intermediare

Tip de coadă R1, cilindrică fără aplatizare, SR81



- Informații despre lame la pag. 411, 412
- Important! Alezorul și lama trebuie să aibă aceeași geometrie de atac
- Pentru alegerea geometriei vârfului EN1, EN2 sau EN3 vezi pag. 402

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR81-7.875-XX-XXXX-EN	7,875 - 8,749	115,0	40,0	73,0	25,0	10,0	P0-EN-xx
SR81-8.750-XX-XXXX-EN	8,75 - 9,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR81-9.750-XX-XXXX-EN	9,75 - 10,749	115,0	40,0	73,0	25,0	10,0	P1-EN-xx
SR81-10.750-XX-XXXX-EN	10,75 - 12,749	133,0	48,0	81,0	25,0	16,0	P1-EN-xx
SR81-12.750-XX-XXXX-EN	12,75 - 16,749	133,0	48,0	81,0	25,0	16,0	P2-EN-xx
SR81-16.750-XX-XXXX-EN	16,75 - 19,499	155,0	50,0	100,0	25,0	20,0	P2-EN-xx
SR81-19.500-XX-XXXX-EN	19,5 - 20,499	155,0	50,0	100,0	30,0	20,0	P4-EN-xx
SR81-20.500-XX-XXXX-EN	20,5 - 26,499	191,0	56,0	129,0	30,0	25,0	P4-EN-xx
SR81-26.500-XX-XXXX-EN	26,5 - 32,499	221,0	56,0	160,0	30,0	25,0	P4-EN-xx
SR81-32.500-XX-XXXX-EN	32,5 - 38,499	226,0	56,0	165,0	30,0	25,0	P4-EN-xx
SR81-38.500-XX-XXXX-EN	38,5 - 40,499	226,0	56,0	166,0	30,0	25,0	P4-EN-xx
SR81-40.500-XX-XXXX-EN	40,5 - 44,499	226,0	56,0	167,0	30,0	25,0	P4-EN-xx
SR81-44.500-XX-XXXX-EN	44,5 - 50,499	226,0	56,0	168,0	30,0	25,0	P4-EN-xx
SR81-50.500-XX-XXXX-EN	50,5 - 60,5	226,0	56,0	169,0	30,0	25,0	P4-EN-xx

### Piese de schimb

### Accesorii

Pentru Ø (mm)	Șurub reglaj	Clemă	Șurub clemă	Cheie de reglare	Bilă suport	Cheie dinamometrică
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	-
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305

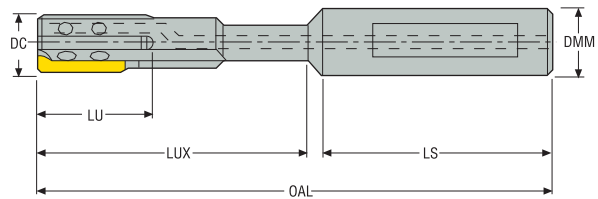
\*Torque key is delivered with driving blade

Notă! La comandarea unor alezoare intermediare, vă rugăm să precizați: Ø și toleranța găurii de alezat, geometria vârfului (EN1, EN2 or EN3).

Exemplu de comandă: SR81-11.50 H7-EN2, P1-EN2-06, CP20.

## Pentru găuri înfundate – Gamă scurtă pentru aplicații de strujire

Tip de coadă R9, cilindrică cu aplatizare, SR82



- Informații despre lame la pag. 411, 412
- Important! Alezorul și lama trebuie să aibă aceeași geometrie de atac
- Pentru alegerea geometriei vârfului EN1, EN2 sau EN3 vezi pag. 402

Reper Nr.	DC	OAL	LS	LUX	LU	DMM	Blade size
	mm	mm	mm	mm	mm	mm	
SR82-7.875-XX-XXXX-EN	7,875 - 8,749	95,0	40,0	53,0	25,0	10,0	P0-EN-xx
SR82-8.750-XX-XXXX-EN	8,75 - 9,749	95,0	40,0	53,0	25,0	10,0	P1-EN-xx
SR82-9.750-XX-XXXX-EN	9,75 - 10,749	95,0	40,0	53,0	25,0	10,0	P1-EN-xx
SR82-10.750-XX-XXXX-EN	10,75 - 12,749	113,0	40,0	61,0	25,0	16,0	P1-EN-xx
SR82-12.750-XX-XXXX-EN	12,75 - 16,749	113,0	48,0	61,0	25,0	16,0	P2-EN-xx
SR82-16.750-XX-XXXX-EN	16,75 - 19,499	113,0	48,0	60,0	25,0	20,0	P2-EN-xx
SR82-19.500-XX-XXXX-EN	19,5 - 20,499	115,0	50,0	60,0	30,0	20,0	P4-EN-xx
SR82-20.500-XX-XXXX-EN	20,5 - 32,499	115,0	50,0	89,0	30,0	25,0	P4-EN-xx
SR82-32.500-XX-XXXX-EN	32,5 - 36,499	151,0	56,0	105,0	30,0	25,0	P4-EN-xx
SR82-36.500-XX-XXXX-EN	36,5 - 40,499	166,0	56,0	106,0	30,0	25,0	P4-EN-xx
SR82-40.500-XX-XXXX-EN	40,5 - 44,499	166,0	56,0	107,0	30,0	25,0	P4-EN-xx
SR82-44.500-XX-XXXX-EN	44,5 - 50,499	166,0	56,0	108,0	30,0	25,0	P4-EN-xx
SR82-50.500-XX-XXXX-EN	50,5 - 60,5	166,0	56,0	109,0	30,0	25,0	P4-EN-xx

### Piese de schimb

### Accesorii

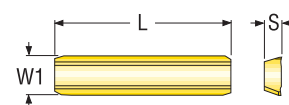
Pentru Ø (mm)	Șurub reglaj	Clemă	Șurub clemă	Cheie de reglare	Bilă suport	Cheie dinamometrică
9,75-12,749	SH2525	SR-B2	LH2540	1.3SMS795	BB2.0	H00-1305
12,75-19,499	SH3040	SR-B3	LH3050	1.5SMS795	BB2.5	H00-1509
19,5-60,5	SH4060	SR-B5	LH4010	2SMS795	BB3.0	H00-2020
7,875-8,749	SH2020	SR-B0	LH2040	0.9SMS795	BB1.5	-
8,75-9,749	SH2525	SR-B1	LH2540	1.3SMS795	BB2.0	H00-1305

\*Torque key is delivered with driving blade

Notă! La comandarea unor alezoare intermediare, vă rugăm să precizați: Ø și toleranța găurii de alezat, geometria vârfului (EN1, EN2 or EN3).

Exemplu de comandă: SR82-11.50 H7EN2, P1-EN2-06, CP20.

## P0-P4 Lame



Reper Nr.	Plăcuță amovibilă	L	S	W1	Calități	
		mm Inci	mm Inci	mm Inci	H15	CP20
P0-EN1-0	P0	20 0.787	1,2 0.047	2,5 0.098	00098229	00098244
P0-EN1-06	P0	20 0.787	1,2 0.047	2,5 0.098	00091786	00091762
P0-EN1-12	P0	20 0.787	1,2 0.047	2,5 0.098	00097299	00091971
P0-EN2-0	P0	20 0.787	1,2 0.047	2,5 0.098	00098234	00098249
P0-EN2-06	P0	20 0.787	1,2 0.047	2,5 0.098	00098160	00098170
P0-EN2-12	P0	20 0.787	1,2 0.047	2,5 0.098	00098165	00098175
P0-EN3-0	P0	20 0.787	1,2 0.047	2,5 0.098	00098239	00098254
P0-EN3-06	P0	20 0.787	1,2 0.047	2,5 0.098	00098185	00098195
P0-EN3-12	P0	20 0.787	1,2 0.047	2,5 0.098	00098190	00098200
P1-EN1-0	P1	20 0.787	1,5 0.059	3,0 0.118	00098230	00098245
P1-EN1-06	P1	20 0.787	1,5 0.059	3,0 0.118	00091787	00091764
P1-EN1-12	P1	20 0.787	1,5 0.059	3,0 0.118	00097300	00091972
P1-EN2-0	P1	20 0.787	1,5 0.059	3,0 0.118	00098235	00098250
P1-EN2-06	P1	20 0.787	1,5 0.059	3,0 0.118	00098161	00098171
P1-EN2-12	P1	20 0.787	1,5 0.059	3,0 0.118	00098166	00098176
P1-EN3-0	P1	20 0.787	1,5 0.059	3,0 0.118	00098240	00098255
P1-EN3-06	P1	20 0.787	1,5 0.059	3,0 0.118	00098186	00094702
P1-EN3-12	P1	20 0.787	1,5 0.059	3,0 0.118	00098191	00098201
P2-EN1-0	P2	20 0.787	2,0 0.079	4,5 0.177	00098231	00098246
P2-EN1-06	P2	20 0.787	2,0 0.079	4,5 0.177	00091788	00091765
P2-EN1-12	P2	20 0.787	2,0 0.079	4,5 0.177	00097301	00091973
P2-EN2-0	P2	20 0.787	2,0 0.079	4,5 0.177	00098236	00098251
P2-EN2-06	P2	20 0.787	2,0 0.079	4,5 0.177	00098162	00098172
P2-EN2-12	P2	20 0.787	2,0 0.079	4,5 0.177	00098167	00098177
P2-EN3-0	P2	20 0.787	2,0 0.079	4,5 0.177	00098241	00098256

Reper Nr.	Plăcuță amovibilă	L	S	W1	Calități	
		mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	H15	CP20
P2_EN3-06	P2	20 <i>0.787</i>	2,0 <i>0.079</i>	4,5 <i>0.177</i>	00098187	00098197
P2-EN3-12	P2	20 <i>0.787</i>	2,0 <i>0.079</i>	4,5 <i>0.177</i>	00098192	00098202
P4-EN1-0	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098232	00098247
P4-EN1-06	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00091789	00091766
P4-EN1-12	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098128	00091974
P4-EN2-0	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098237	00098252
P4-EN2-06	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098163	00098173
P4-EN2-12	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098168	00098178
P4-EN3-0	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098242	00098257
P4-EN3-06	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098188	00098198
P4-EN3-12	P4	25,0 <i>0.984</i>	2,3 <i>0.091</i>	7,0 <i>0.276</i>	00098193	00098203

Introducere

Găurire

Alezare

Alezare adâncă

Anexă

Regimuri de aşchiere – Pxx-EN1/EN2-00 metric

SMG		$a_p (\varnothing)$		f	$v_c$	
		$\varnothing < 9$	$\varnothing \geq 9$		CP20	CP15
P5	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P6	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P7	Pxx-EN1/EN2-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
K1	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K2	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	35 (25-50)	50 (25-70)
K3	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K4	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K5	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K6	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K7	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
PM1	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM2	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM3	Pxx-EN1/EN2-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-EN1/EN2-00 inci

SMG		$a_p (\varnothing)$		f	$v_c$	
		$\varnothing < 9$	$\varnothing \geq 9$		CP20	CP15
P5	Pxx-EN1/EN2-00	0.004–0.006	0.004–0.008	0.004–0.012	130 (100-165)	-
P6	Pxx-EN1/EN2-00	0.004–0.006	0.004–0.008	0.004–0.012	130 (100-165)	-
P7	Pxx-EN1/EN2-00	0.004–0.006	0.004–0.008	0.004–0.012	130 (100-165)	-
K1	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	295 (260-330)	395 (260-490)
K2	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	115 (80-165)	165 (80-230)
K3	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	295 (260-330)	395 (260-490)
K4	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	230 (195-260)	295 (260-330)
K5	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	230 (195-260)	295 (260-330)
K6	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	295 (260-330)	395 (260-490)
K7	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	295 (260-330)	395 (260-490)
PM1	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	165 (80-230)	-
PM2	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	165 (80-230)	-
PM3	Pxx-EN1/EN2-00	0.004–0.008	0.004–0.012	0.004–0.012	165 (80-230)	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-EN1/EN2-06 metric

SMG		$a_p$ (∅)		f	$v_c$		
		∅ < 9	∅ ≥ 9		H15	CP20	CP15
P1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M4	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
M5	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
K1	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K2	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	35 (25-50)	50 (25-70)
K3	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K4	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K5	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K6	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K7	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
N11	Pxx-EN1/EN2-06	0,10-0,30	0,20-0,50	0,10-0,30	65 (50-150)	90 (70-150)	-
S1	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
S2	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
S3	Pxx-EN1/EN2-06	0,10-0,15	0,10-0,20	0,10-0,30	-	25 (15-30)	-
PM1	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN1/EN2-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire



Regimuri de aşchiere – Pxx-EN1/EN2-06 inci

SMG		$a_p$ (°)		f	$v_c$		
		$\varnothing < 9$	$\varnothing \geq 9$		H15	CP20	CP15
P1	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P2	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P3	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P4	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P5	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P6	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P7	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P8	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	100 (80-130)	165 (100-195)	195 (130-230)
P11	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	100 (80-130)	165 (100-195)	195 (130-230)
P12	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	130 (80-150)	150 (100-180)
M1	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	115 (80-130)	115 (80-130)
M2	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	115 (80-130)	115 (80-130)
M3	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	115 (80-130)	115 (80-130)
M4	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	65 (50-100)	100 (80-130)	100 (80-130)
M5	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	65 (50-100)	100 (80-130)	100 (80-130)
K1	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	395 (260-490)
K2	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	115 (80-165)	165 (80-230)
K3	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	395 (260-490)
K4	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	230 (195-260)	295 (260-330)
K5	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	230 (195-260)	295 (260-330)
K6	Pxx-EN1/EN2-06	0.004-0.012	0.008-0.020	0.004-0.012	215 (165-150)	295 (230-490)	-
K7	Pxx-EN1/EN2-06	0.004-0.012	0.008-0.020	0.004-0.012	215 (165-150)	295 (230-490)	-
N11	Pxx-EN1/EN2-06	0.004-0.012	0.008-0.020	0.004-0.012	215 (165-150)	295 (230-490)	-
S1	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	-	80 (50-100)	-
S2	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	-	80 (50-100)	-
S3	Pxx-EN1/EN2-06	0.004-0.006	0.004-0.008	0.004-0.012	-	80 (50-100)	-
PM1	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-
PM2	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-
PM3	Pxx-EN1/EN2-06	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-EN1/EN2-12 metric

SMG		$a_p (\varnothing)$		f	$v_c$		
		$\varnothing < 9$	$\varnothing \geq 9$		H15	CP20	CP15
P1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	35 (25-40)	35 (25-40)
M4	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
M5	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	20 (15-30)	30 (25-40)	30 (25-40)
K1	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	90 (80-100)	–
K3	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	90 (80-100)	–
K4	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	70 (60-80)	–
K5	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	70 (60-80)	–
N11	Pxx-EN1/EN2-12	0,10-0,30	0,20-0,50	0,10-0,30	65 (50-150)	90 (70-150)	–
S1	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
S2	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
S3	Pxx-EN1/EN2-12	0,10-0,15	0,10-0,20	0,10-0,30	–	25 (15-30)	–
PM1	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–
PM2	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–
PM3	Pxx-EN1/EN2-12	0,10-0,20	0,10-0,30	0,10-0,30	–	50 (25-70)	–

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-EN1/EN2-12 inci

SMG		$a_p$ (inci)		f	$v_c$		
		$\varnothing < 9$	$\varnothing \geq 9$		H15	CP20	CP15
P1	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P2	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P3	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P4	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P5	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P6	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P7	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P8	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	100 (80-130)	165 (100-195)	195 (130-230)
P11	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	100 (80-130)	165 (100-195)	195 (130-230)
P12	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	130 (80-150)	150 (100-180)
M1	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	115 (80-130)	115 (80-130)
M2	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	115 (80-130)	115 (80-130)
M3	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	115 (80-130)	115 (80-130)
M4	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	65 (50-100)	100 (80-130)	100 (80-130)
M5	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	65 (50-100)	100 (80-130)	100 (80-130)
K1	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	-
K3	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	-
K4	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	230 (195-260)	-
K5	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	230 (195-260)	-
N11	Pxx-EN1/EN2-12	0.004-0.012	0.008-0.020	0.004-0.012	215 (165-490)	295 (230-490)	-
S1	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	-	80 (50-100)	-
S2	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	-	80 (50-100)	-
S3	Pxx-EN1/EN2-12	0.004-0.006	0.004-0.008	0.004-0.012	-	80 (50-100)	-
PM1	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-
PM2	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-
PM3	Pxx-EN1/EN2-12	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

### Regimuri de aşchiere – Pxx-EN3-00 metric

SMG		$a_p$ (°)		f	$v_c$	
		$\varnothing < 9$	$\varnothing \geq 9$		CP20	CP15
P5	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P6	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
P7	Pxx-EN3-00	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-50)	-
K1	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K2	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	35 (25-50)	50 (25-70)
K3	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K4	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K5	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	70 (60-80)	90 (80-100)
K6	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
K7	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	90 (80-100)	120 (80-150)
PM1	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM2	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-
PM3	Pxx-EN3-00	0,10-0,20	0,10-0,30	0,10-0,30	50 (25-70)	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pomire

### Regimuri de aşchiere – Pxx-EN3-00 inci

SMG		$a_p$ (°)		f	$v_c$	
		$\varnothing < 9$	$\varnothing \geq 9$		CP20	CP15
P5	Pxx-EN3-00	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-165)	-
P6	Pxx-EN3-00	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-165)	-
P7	Pxx-EN3-00	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-165)	-
K1	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	295 (260-330)	395 (260-490)
K2	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	115 (80-165)	165 (80-230)
K3	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	295 (260-330)	395 (260-490)
K4	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	230 (195-260)	295 (260-330)
K5	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	230 (195-260)	295 (260-330)
K6	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	295 (260-330)	395 (260-490)
K7	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	295 (260-330)	395 (260-490)
PM1	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	165 (80-230)	-
PM2	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	165 (80-230)	-
PM3	Pxx-EN3-00	0.004-0.008	0.004-0.012	0.004-0.012	165 (80-230)	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pomire

## Regimuri de aşchiere – Pxx-EN3-06 metric

SMG		$a_p$ (°)		f	$v_c$		
		$\varnothing < 9$	$\varnothing \geq 9$		H15	CP20	CP15
P1	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
M1	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M2	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M3	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	35 (25-40)
M4	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	30 (25-40)
M5	Pxx-EN3-06	0,10-0,15	0,10-0,20	0,10-0,30	-	-	30 (25-40)
K1	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K2	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	35 (25-50)	50 (25-70)
K3	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K4	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K5	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	90 (80-100)
K6	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
K7	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	120 (80-150)
PM1	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN3-06	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Grupa de material Seco

 $a_p$  = mm

f = mm/rev

 $v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-E3-06 inci

SMG		$a_p$ (∅)		f	$v_c$		
		∅ < 9	∅ ≥ 9		H15	CP20	CP15
P1	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P2	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P3	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	130 (100-195)	345 (295-395)	395 (295-490)
P4	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P5	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P6	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P7	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	115 (80-130)	195 (130-230)	260 (195-330)
P8	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	100 (80-130)	165 (100-195)	195 (130-230)
P11	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	100 (80-130)	165 (100-195)	195 (130-230)
P12	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	80 (65-100)	130 (80-150)	150 (100-180)
M1	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	-	-	115 (80-130)
M2	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	-	-	115 (80-130)
M3	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	-	-	115 (80-130)
M4	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	-	-	100 (80-130)
M5	Pxx-EN3-06	0.004-0.006	0.004-0.008	0.004-0.012	-	-	100 (80-130)
K1	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	395 (260-490)
K2	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	115 (80-165)	165 (80-230)
K3	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	395 (260-490)
K4	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	230 (195-260)	295 (260-330)
K5	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	230 (195-260)	295 (260-330)
K6	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	395 (260-490)
K7	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	295 (260-330)	395 (260-490)
PM1	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-
PM2	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-
PM3	Pxx-EN3-06	0.004-0.008	0.004-0.012	0.004-0.012	-	165 (80-230)	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-EN3-12 metric

SMG		$a_p (\varnothing)$		f	$v_c$		
		$\varnothing < 9$	$\varnothing \geq 9$		H15	CP20	CP15
P1	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P2	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P3	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	40 (30-60)	105 (90-120)	120 (90-150)
P4	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P5	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P6	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P7	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	35 (25-40)	60 (40-70)	80 (60-100)
P8	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P11	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	30 (25-40)	50 (30-60)	60 (40-70)
P12	Pxx-EN3-12	0,10-0,15	0,10-0,20	0,10-0,30	25 (20-30)	40 (25-45)	45 (30-55)
K1	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	-
K3	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	90 (80-100)	-
K4	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	-
K5	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	70 (60-80)	-
PM1	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM2	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-
PM3	Pxx-EN3-12	0,10-0,20	0,10-0,30	0,10-0,30	-	50 (25-70)	-

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – Pxx-EN3-12 inci

SMG		$a_p (\varnothing)$		f	$v_c$		
		$\varnothing < 9$	$\varnothing \geq 9$		H15	CP20	CP15
P1	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	130 (100-195)	345 (295-395)	395 (295-490)
P2	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	130 (100-195)	345 (295-395)	395 (295-490)
P3	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	130 (100-195)	345 (295-395)	395 (295-490)
P4	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	115 (80-130)	195 (130-230)	260 (195-330)
P5	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	115 (80-130)	195 (130-230)	260 (195-330)
P6	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	115 (80-130)	195 (130-230)	260 (195-330)
P7	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	115 (80-130)	195 (130-230)	260 (195-330)
P8	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	100 (80-130)	165 (100-195)	195 (130-230)
P11	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	100 (80-130)	165 (100-195)	195 (130-230)
P12	Pxx-EN3-12	0.004–0.006	0.004–0.008	0.004–0.012	80 (65-100)	130 (80-150)	150 (100-180)
K1	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	295 (260-330)	-
K3	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	295 (260-330)	-
K4	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	230 (195-260)	-
K5	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	230 (195-260)	-
PM1	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	165 (80-230)	-
PM2	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	165 (80-230)	-
PM3	Pxx-EN3-12	0.004–0.008	0.004–0.012	0.004–0.012	-	165 (80-230)	-

SMG = Grupa de material Seco


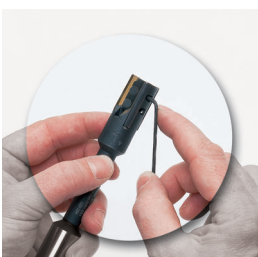
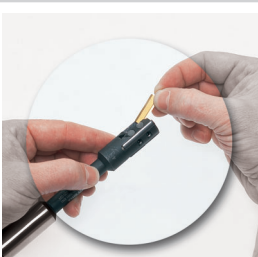

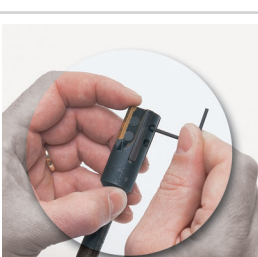

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

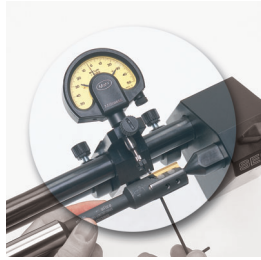
## Instrucțiuni de reglare

Introducere	<p>1.</p> 	<p>Slăbește cele două șuruburi de reglaj (7) cu 1/4 tură.</p>
Găurire	<p>2.</p> 	<p>Slăbiți cele două șuruburi (5).</p>
Alezare	<p>3.</p> 	<p>Curăță bine locașul lamei apoi reșază lama folosită (2) sau înlocuiește-o.</p>
Alezare atâncă	<p>4.</p> 	<p>Firmly push the blade against the axial end stop and the adjustment balls (6).</p>
Anexă	<p>5.</p> 	<p>Strânge șurubul de fixare cu grijă. (Ține cheia de partea ei scurtă pentru un cuplu corect).</p>
	<p>6.</p> 	<p>Reglează micrometrul la zero folosind partea dorsală cilindrică a ghidajelor (3).</p>




## Instrucțiuni de reglare

**7.**




Setați capătul posterior a lamei la un diametru astfel încât să obțineți o conicitate inversă de 0,01 mm/10 mm (0,0004" la fiecare 0,394") din lungimea lamei (a se vedea fig. 2).

**8.**



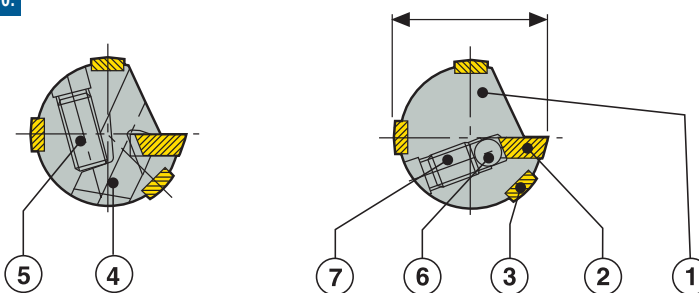
Reglează micrometrul la zero folosind partea frontală cilindrică a ghidajelor (3).

**9.**



Reglați partea frontală a lamei la 0,02 mm sau 0,015 mm (0,0008" or 0,0006") deasupra ghidajelor (3) comparator A, a se vedea fig. 1.  
Verifică încă o dată valoarea înclinației (pasul 6 și 7) ceas B.

**10.**



Notă: Dacă diametrul dorit este depășit la reglare, începeți încă o dată de la început pentru a elimina jocul șurubului de reglare.

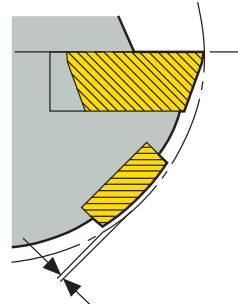


fig. 1

0,015 mm ( $\varnothing \leq 10$  mm)  
0,020 mm ( $\varnothing > 10$  mm)  
Valoarea comparatorului A pentru setarea diametrului 0,0006" ( $\varnothing \leq 0,394$ ")  
0,0008" ( $\varnothing > 0,394$ ")  
Valoarea comparatorului A pentru setarea diametrului

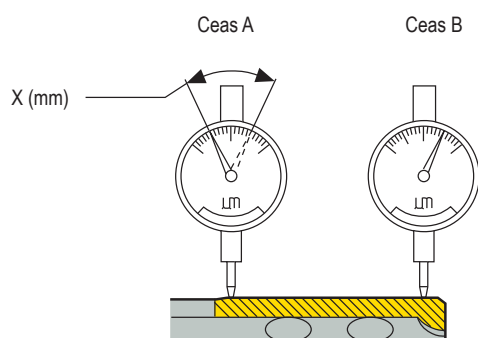


fig. 2

Ceas A      Ceas B

X (mm)

**Grafic de setare**

Interval de diametre mm (inci)	Mărimea lamei	Comparator față A	Comparator spate B
6,875-8,749 (0,271-0,344")	P0	+15	-5
8,750-10,000 (0,344-0,394")	P1	+15	-5
10,001-12,749 (0,394-0,502")	P1	+20	0
12,750-19,499 (0,502-0,768")	P2	+20	0
19,500-60,500 (0,768-2,382")	P4	+20	0

- Unitate comparator = 1  $\mu$ m (39  $\mu$ in)
- Valorile comparatoarelor față și spate valide după reglarea la zero pe un ghidaj adiacent
- Valorile comparatorului spate calculate pentru o conicitate inversă de 1  $\mu$ m/mm (0,0004") de lamă

## Depanare

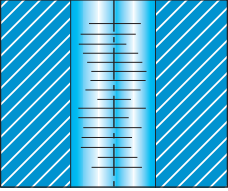
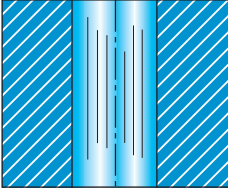
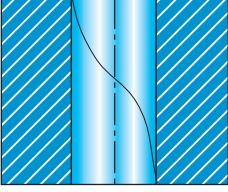
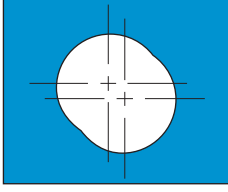
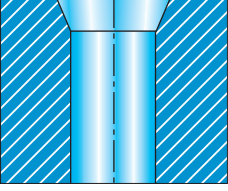
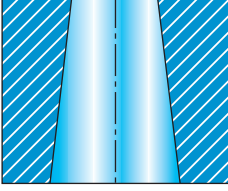
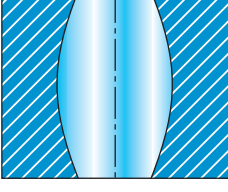
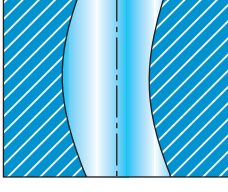
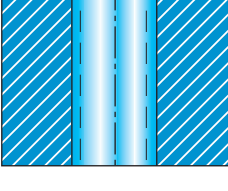
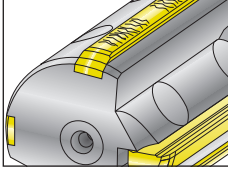
Introducere

Găurire

Alezare

Alezare atâncă

Anexă

<p><b>Finisare slabă a suprafeței</b></p> <ul style="list-style-type: none"> <li>• Verificați toleranțele materialului</li> <li>• Îmbunătățiți condițiile lichidului de răcire (tipul ieșirii, presiunea, calitatea)</li> <li>• Reduceți rata avansului</li> <li>• Schimbați lama (geometrie incorectă a vârfului sau unghi de degajare incorect)</li> <li>• Verificați poziționarea axială a lamei</li> </ul> 	<p><b>Fațete</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățește centrarea (piesă/sculă)</li> <li>• Mărește conicitatea inversă</li> </ul> 
<p><b>Urme de retragere</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți condițiile lichidului de răcire (tipul ieșirii, presiunea, calitatea)</li> <li>• Îmbunătățiți centrarea (piesă/sculă)</li> <li>• Măriți conicitatea inversă</li> </ul> 	<p><b>Excentricitate/Ovalitate</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățește prinderea (deformarea piesei de lucru)</li> <li>• Verifică adaosul de prelucrare</li> <li>• Îmbunătățește centrarea (piesă/sculă)</li> <li>• Verifică poziționarea axială a lamei</li> </ul> 
<p><b>Intrare conică</b></p> <ul style="list-style-type: none"> <li>• Micșorează avansul</li> <li>• Îmbunătățește centrarea (piesă/sculă)</li> <li>• Micșorează bătaia radială</li> <li>• Reduceți bătaia radială</li> </ul> 	<p><b>Gaură conică</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățește centrarea (piesă/sculă)</li> <li>• Verifică conicitatea inversă</li> </ul> 
<p><b>Gaură deformată</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățiți prinderea (deformarea piesei de lucru)</li> </ul> 	<p><b>Gaură curbă</b></p> <ul style="list-style-type: none"> <li>• Schimbă lama (geometrie greșită a vârfului)</li> <li>• Verifică poziționarea axială a lamei</li> </ul> 
<p><b>Diametru prea mare</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățește centrarea (piesă/sculă)</li> <li>• Reglează diametrul (prea mare)</li> </ul> 	<p><b>Aderențe pe ghidaje</b></p> <ul style="list-style-type: none"> <li>• Îmbunătățește condițiile de răcire (tipul ieșirii, presiunea, calitatea)</li> <li>• Reglează diametrul (prea mic)</li> </ul> 



## Xfix™

Alezoarele Xfix™ de diametru mare, cu mai mulți dinți, contribuie la obținerea celor mai înalte performanțe și precizii posibile în realizarea găurilor.

- Adâncimi de așchiere de până la  $6,5xD$  cu un interval de diametre de la 39,5 până la 154,5 mm (2,03'-6,083')
- Ușor și rapid de reglat, este necesar un singur șurub per dinte pentru a seta diametrul și un singur șurub pentru setarea fiecărui dinte
- Sistem de reglare precis pentru a obține toleranțe mici între 16 și 25  $\mu\text{m}$  (0,0006-0,0010')
- Plăcuțe care au fie patru, fie opt muchii numerotate

## Prezentare generală

	Ø Gamă	Adâncimea de alezare	Toleranța Ø burghiului	Diametre intermediare	Finisarea suprafeței
<p>Xfix™</p> 	39,500-154,500 mm (1.5551-6.0827")	2,5-6,5 x D	IT 6	Da, disponibil în Custom design	R <sub>a</sub> 0,8-1,2 μm (R <sub>a</sub> 31-47 μin)

Xfix™ este un program special de alezare dezvoltat de Seco, dedicat pentru Ø 39,5 la 154,5 mm (1.555" – 6.083").

Designul include plăcuțe amovibile reglabile cu care se poate atinge toleranța IT6, precum și un adaptor integrat reglabil pentru controlul bătăii radiale pentru a garanta calitatea prelucrării.

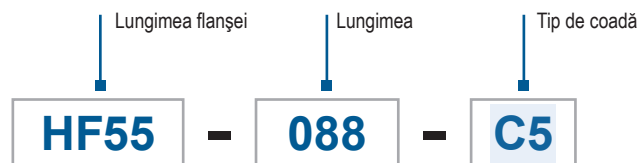
Construcția cu mai mulți dinți și sistemul brevetat de suporturi de ghidare oferă un maxim de stabilitate și productivitate la operațiile de alezare a Ø mari.

## Caracteristici - detalii

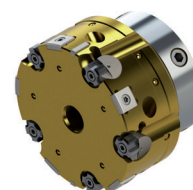
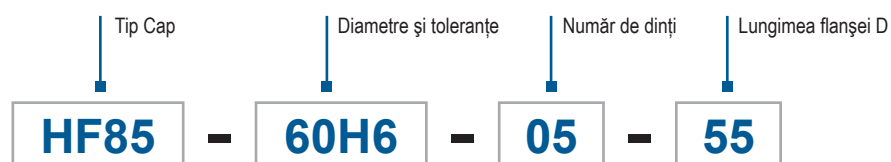
<ul style="list-style-type: none"> <li>• 4 sau 8 muchii de aşchiere pentru optimizare pentru toate materialele</li> <li>• Sistem de prindere stabil</li> <li>• Ajustare ușoară cu 1 șurub de reglaj pentru ajustare simplă</li> <li>• Opțiuni de calitate și geometrie pentru aplicații diferite</li> </ul> <ul style="list-style-type: none"> <li>• Manșoane de ghidare pre-reglate brevetate pentru stabilitatea aplicației</li> <li>• Lubrifierea ghidajelor pentru performanță și siguranță</li> </ul>		Introducere
<ul style="list-style-type: none"> <li>• Adaptor ajustabil integrat pentru controlul bătăii radiale</li> </ul>		Găurire
<ul style="list-style-type: none"> <li>• Gama de cozi și extensii din catalogul de port-scule al Seco oferă modularitate maximă</li> </ul>		Alezare
		Alezare adâncă
		Anexă

## Codificări

### Adaptoare



### Capete standard



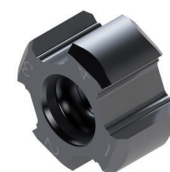
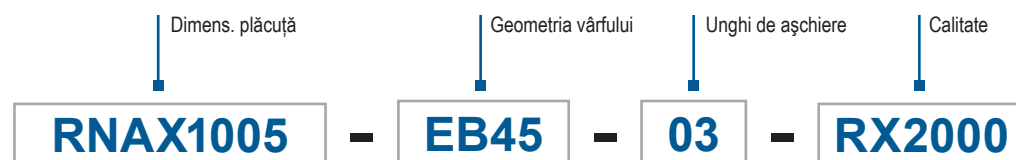
### Capete intermediare



Informații despre tipul capului:

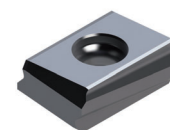
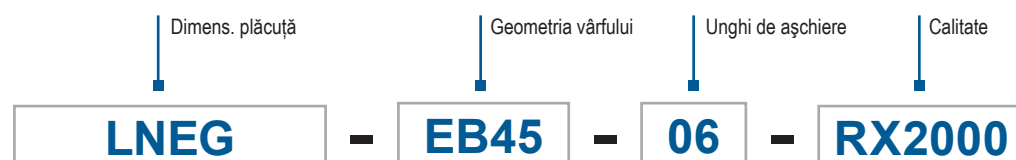
- HF85, alezaj străpuns, materiale cu așchii scurte
- HF85B, alezaj înfundat, materiale cu așchii scurte
- HF86, alezaj străpuns, toate materialele
- HF86B, alezaj înfundat, toate materialele

### Plăcuțe amovibile



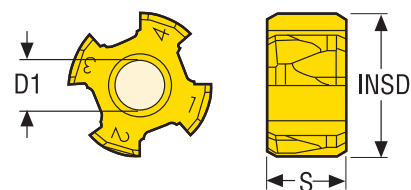
Plăcuță RNAX pentru capete Xfix HF85 și HF 85B

### Plăcuțe amovibile



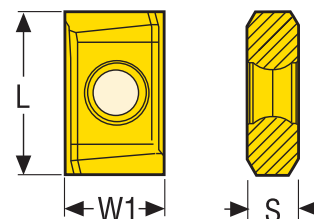
Plăcuță LNEG pentru capete Xfix HF86 și HF86B

## RNAX



Reper Nr.	Plăcuțe amovibile	INSD	S	D1	Calități		Unghi de așchiere
					RX1500	RX2000	
		mm Inci	mm Inci	mm Inci			
RNAX1005-EB1570-03	RNAX	10,0 0.394	5,5 0.217	3,5 0.138	02687601	02687603	3,0 °
RNAX1005-EB45-03	RNAX	10,0 0.394	5,5 0.217	3,5 0.138	02687600	02688608	3,0 °
RNAX1005-EB845-03	RNAX	10,0 0.394	5,5 0.217	3,5 0.138	02687593	02688606	3,0 °

## LNEG



Reper Nr.	Plăcuțe amovibile	L	S	W1	Calități			Unghi de așchiere
					RX1500	RX2000	CF	
		mm Inci	mm Inci	mm Inci				
LNEG1003-EB45-03	LNEG	10,0 0.394	3,5 0.138	6,35 0.250		02781311		3,0 °
LNEG1003-EB45-06	LNEG	10,0 0.394	3,5 0.138	6,35 0.250	02904277	02781313	02904276	6,0 °
LNEG1003-EB845-03	LNEG	10,0 0.394	3,5 0.138	6,35 0.250		02781314		3,0 °
LNEG1003-EB845-06	LNEG	10,0 0.394	3,5 0.138	6,35 0.250		02781315		6,0 °

## Geometria vârfului

Geometria vârfului EB45 – aplicație	
<p>Controlul asupra formării așchiilor +++                      Finisarea suprafeței + <math>R_a</math> 1,2 - 2 <math>\mu\text{m}</math>                      (Finisarea suprafeței + <math>R_a</math> 0,047 - 0,0787 <math>\mu\text{in}</math>)                      Prima alegere pentru geometrie</p>	
Geometria vârfului EB845 – aplicație	
<p>Controlul asupra formării așchiilor ++                      Finisarea suprafeței +++ <math>R_a</math> 0,4 - 1,2 <math>\mu\text{m}</math>                      (Finisarea suprafeței +++ <math>R_a</math> 0,0157 - 0,047 <math>\mu\text{in}</math>)</p>	
Geometria vârfului EB1570 – aplicație	
<p>Controlul asupra formării așchiilor ++                      Finisarea suprafeței ++ <math>R_a</math> 0,8 - 1,6 <math>\mu\text{m}</math>                      (Finisarea suprafeței ++ <math>R_a</math> 0,031 - 0,0630 <math>\mu\text{in}</math>)                      Stabilitate pentru aplicații cu rază lungă +++</p>	

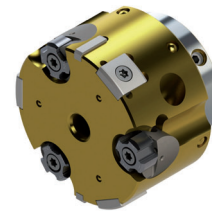
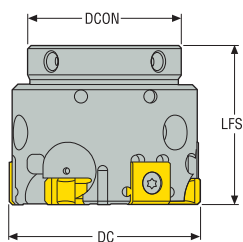
## Calități

Calități		
	<p><b>RX1500</b></p>	<p><b>Cermet acoperit</b>                      O calitate acoperită rezistentă la uzură pentru optimizarea performanțelor în oțel și fontă.</p>
	<p><b>RX2000</b></p>	<p><b>Coated</b>                      High performance coated grade suitable for all materials.</p>
	<p><b>CF</b></p>	<p><b>Cermet</b>                      O calitate rezistentă la uzură pentru performanțe optime în oțel.</p>




# HF85



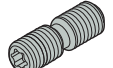




Capete pentru RNAX Plăcuțe amovibile, spre alezaj Ø 39,5-59,499 mm / 1.555-2.342"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85-39.5/44.499-03-32	39,5 1.555	44,499 1.752	33,0 1.299	32,0 1.260	0,41 0.900	3 RNAX1005...
HF85-44.5/49.499-03-32	44,5 1.752	49,499 1.949	33,0 1.299	32,0 1.260	0,51 1.120	3 RNAX1005...
HF85-49.5/54.499-03-32	49,5 1.949	54,499 2.146	33,0 1.299	32,0 1.260	0,62 1.370	3 RNAX1005...
HF85-54.5/59.499-03-32	54,5 2.146	59,499 2.342	33,0 1.299	32,0 1.260	0,74 1.630	3 RNAX1005...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85 03-32	SH4075S	CARTCYHF16	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

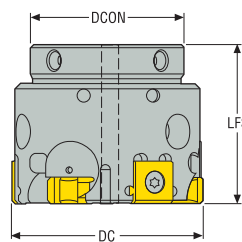
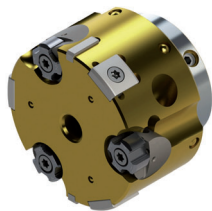
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85 03-32	H00-2020	T00-09P20


Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF85B



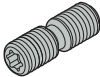




Capete pentru RNAX Plăcuțe amovibile, gaură înfundată Ø 39,5-59,499 mm / 1.555-2.342"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCN	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85B-39.5/44.499-03-32	39,5 1.555	44,499 1.752	33,0 1.299	32,0 1.260	0,41 0.900	3 RNAX1005...
HF85B-44.5/49.499-03-32	44,5 1.752	49,499 1.949	33,0 1.299	32,0 1.260	0,51 1.120	3 RNAX1005...
HF85B-49.5/54.499-03-32	49,5 1.949	54,499 2.146	33,0 1.299	32,0 1.260	0,62 1.370	3 RNAX1005...
HF85B-54.5/59.499-03-32	54,5 2.146	59,499 2.342	33,0 1.299	32,0 1.260	0,74 1.630	3 RNAX1005...

### Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 03-32	SH4075S	CARTCYHF16B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

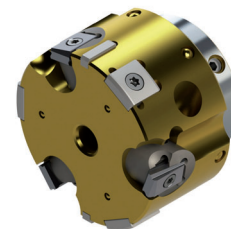
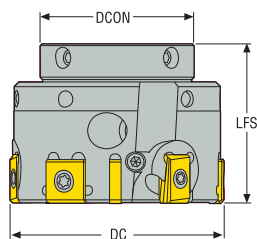
### Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 03-32	H00-2020	T00-09P20

Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

# HF86

Capete pentru LNEG Plăcuțe amovibile, spre alezaj Ø 39,5-59,499 mm / 1.555-2.342"



- Pentru plăcuțe, calitate și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86-39.5/44.499-03-32	39,5 1.555	44,499 1.752	33,0 1.299	32,0 1.260	0,41 0.900	3 LNEG1003...
HF86-44.5/49.499-03-32	44,5 1.752	49,499 1.949	33,0 1.299	32,0 1.260	0,51 1.120	3 LNEG1003...
HF86-49.5/54.499-03-32	49,5 1.949	54,499 2.146	33,0 1.299	32,0 1.260	0,62 1.370	3 LNEG1003...
HF86-54.5/59.499-03-32	54,5 2.146	59,499 2.342	33,0 1.299	32,0 1.260	0,74 1.630	3 LNEG1003...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF86 03-32	SH4075S	CARTCYLN16	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

## Accesorii

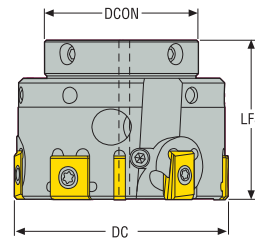
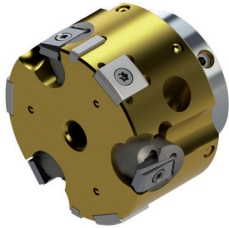
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF86 03-32	H00-2020	T00-07P09

Valoare cuplu T00-07P09: 0,9 Nm.


Valoare cuplu H00-2020: 2 Nm.

## HF86B



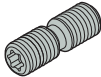




Capete pentru LNEG Plăcuțe amovibile, gaură înfundată Ø 39,5-59,499 mm / 1.555-2.342"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCN	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86B-39.5/44.499-03-32	39,5 1.555	44,499 1.752	33,0 1.299	32,0 1.260	0,41 0.900	3 LNEG1003...
HF86B-44.5/49.499-03-32	44,5 1.752	49,499 1.949	33,0 1.299	32,0 1.260	0,51 1.120	3 LNEG1003...
HF86B-49.5/54.499-03-32	49,5 1.949	54,499 2.146	33,0 1.299	32,0 1.260	0,62 1.370	3 LNEG1003...
HF86B-54.5/59.499-03-32	54,5 2.146	59,499 2.342	33,0 1.299	32,0 1.260	0,74 1.630	3 LNEG1003...

### Piese de schimb

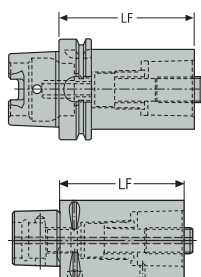
Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86B 03-32	SH4075S	CARTCYLN16B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

### Accesorii

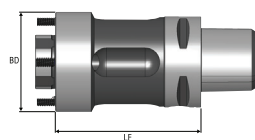
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86B 03-32	H00-2020	T00-07P09

Valoare cuplu T00-07P09: 0,9 Nm.  
Valoare cuplu H00-2020: 2 Nm.

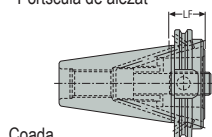
## HF32

Seco-Capto™ coadă pentru  $\varnothing$  39,5-59,499 mm

Extensie



Portsculă de alezat



Coadă



Reper Nr. Port-sculă de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF32-050-C3	02688610	–	50	C3	32	0,3
HF32...HSKA63	–	65	245	HSK-A63	32	0,0
HF32...HSKA80	–	100	209	HSK-A80	32	0,0
HF32...HSKA100	–	70	245	HSK-A100	32	0,0
HF32...DIN40ADB	–	60	252	DIN40ADB	32	0,0
HF32...DIN50ADB	–	60	317	DIN50ADB	32	0,0
HF32...BT40ADB	–	65	252	BT40ADB	32	0,0
HF32...BT50ADB	–	75	317	BT50ADB	32	0,0

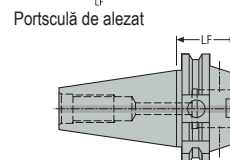
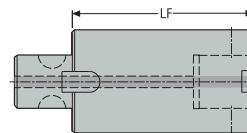
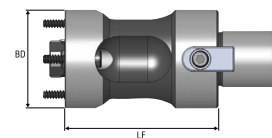
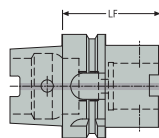
Cozi și extensii pentru HF32-050-C3 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C3-390.410-63075C	75039871	75	HSK-A63	C3	0,9
C3-390.410-100080A	75039873	80	HSK-A100	C3	2,3
C3-390B.140-40030	02924104	30	DIN40 ADB	C3	0,8
C3-390B.55-40030	02925959	30	BT40 ADB	C3	0,9
C3-390B.55-40060	02925960	60	BT40 ADB	C3	1,1
C3-390B.140-50030	02924106	30	DIN50 ADB	C3	2,6
C3-390B.140-50060	02924107	60	DIN50 ADB	C3	2,7
C3-390B.58-50040	02925961	40	BT50 ADB	C3	3,5
C3-390B.58-50070	02925962	70	BT50 ADB	C3	3,7

Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C3-391.01-32060A	75039884	–	C3	C3	0,34
C3-391.01-32080A	00090847	–	C3	C3	0,45
C4-391.02-32055A	75039889	–	C4	C3	0,42
C4-391.02-32070A	02535687	–	C4	C3	0,56
C5-391.02-32060A	75039890	–	C5	C3	0,64
C6-391.02-32070A	75039892	–	C6	C3	1,06

## HF32

Graflex® coadă pentru  $\varnothing$  39,5-59,499 mm



Extensie

Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF32-050-G3	02698870	-	50	G3	32	0,4
HF32...HSKA63	-	65	245	HSK-A63	32	0,0
HF32...HSKA80	-	100	209	HSK-A80	32	0,0
HF32...HSKA100	-	70	245	HSK-A100	32	0,0
HF32...DIN40ADB	-	60	252	DIN40ADB	32	0,0
HF32...DIN50ADB	-	60	317	DIN50ADB	32	0,0
HF32...BT40ADB	-	65	252	BT40ADB	32	0,0
HF32...BT50ADB	-	75	317	BT50ADB	32	0,0

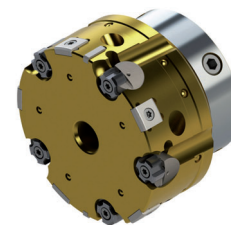
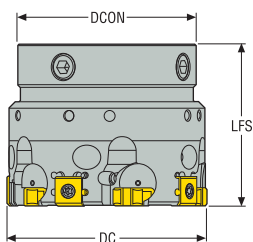
Cozi și extensii pentru HF32-050-G3 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93044011850	00086918	50	HSK-A63	G3	0,73
EM93064011855	00086925	55	HSK-A100	G3	2,1
EM34694011835	02420097	35	DIN40 ADB	G3	0,91
EM346940118100	02503298	100	DIN40 ADB	G3	1,22
EM34144011840	02503366	40	BT40 ADB	G3	1,07
EM341440118100	02503367	100	BT40 ADB	G3	1,31
EM34714011835	02503307	35	DIN50 ADB	G3	2,67
EM34164011845	02503376	45	BT50 ADB	G3	3,58
EM341640118120	02503377	120	BT50 ADB	G3	3,9


Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402330	00056758	-	G3	G3	0,24
M402331	75056759	-	G3	G3	0,36

# HF85



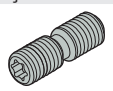




Capete pentru RNAX Plăcuțe amovibile, spre alezaj Ø 59,5-84,499 mm / 2.343-3.327"





• Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85-59.5/64.499-05-55	59,5 2.343	64,499 2.539	50,0 1.969	55,0 2.165	1,3 2.870	5 RNAX1005...
HF85-64.5/69.499-05-55	64,5 2.539	69,499 2.736	50,0 1.969	55,0 2.165	1,5 3.310	5 RNAX1005...
HF85-69.5/74.499-05-55	69,5 2.736	74,499 2.933	50,0 1.969	55,0 2.165	1,75 3.860	5 RNAX1005...
HF85-74.5/79.499-05-55	74,5 2.933	79,499 3.130	50,0 1.969	55,0 2.165	2,0 4.410	5 RNAX1005...
HF85-79.5/84.499-05-55	79,5 3.130	84,499 3.327	50,0 1.969	55,0 2.165	2,2 4.850	5 RNAX1005...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85 05-55	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

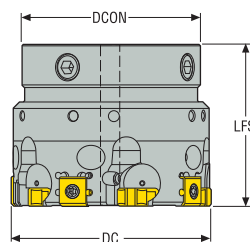
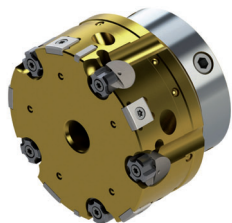
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85 05-55	H00-2020	T00-09P20


Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF85B



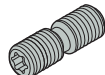




Capete pentru RNAX Plăcuțe amovibile, gaură înfundată Ø 59,5-84,499 mm / 2.343-3.327"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCN	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85B-59.5/64.499-05-55	59,5 2.343	64,499 2.539	50,0 1.969	55,0 2.165	1,3 2.870	5 RNAX1005...
HF85B-64.5/69.499-05-55	64,5 2.539	69,499 2.736	50,0 1.969	55,0 2.165	1,5 3.310	5 RNAX1005...
HF85B-69.5/74.499-05-55	69,5 2.736	74,499 2.933	50,0 1.969	55,0 2.165	1,75 3.860	5 RNAX1005...
HF85B-74.5/79.499-05-55	74,5 2.933	79,499 3.130	50,0 1.969	55,0 2.165	2,0 4.410	5 RNAX1005...
HF85B-79.5/84.499-05-55	79,5 3.130	84,499 3.327	50,0 1.969	55,0 2.165	2,2 4.850	5 RNAX1005...

### Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 05-55	SH4075S	CARTCYHF20B	LDH4012	C03010-T09P	H2.0-2D	2SMS795	B6027

### Accesorii

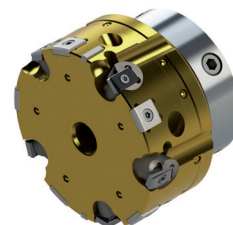
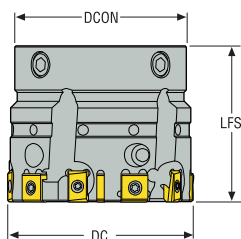
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 05-55	H00-2020	T00-09P20

Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.




# HF86



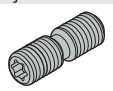




Capete pentru LNEG Plăcuțe amovibile, spre alezaj Ø 59,5-84,499 mm / 2.343-3.327"





• Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86-59.5-64.499-05-55	59,5 2.343	64,499 2.539	50,0 1.969	55,0 2.165	1,3 2.870	5 LNEG1003...
HF86-64.5-69.499-05-55	64,5 2.539	69,499 2.736	50,0 1.969	55,0 2.165	1,5 3.310	5 LNEG1003...
HF86-69.5-74.499-05-55	69,5 2.736	74,499 2.933	50,0 1.969	55,0 2.165	1,75 3.860	5 LNEG1003...
HF86-74.5-79.499-05-55	74,5 2.933	94,499 3.720	50,0 1.969	55,0 2.165	2,0 4.410	5 LNEG1003...
HF86-79.5-84.499-05-55	79,5 3.130	84,499 3.327	50,0 1.969	55,0 2.165	2,2 4.850	5 LNEG1003...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF86 05-55	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

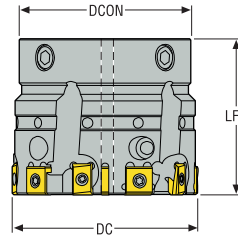
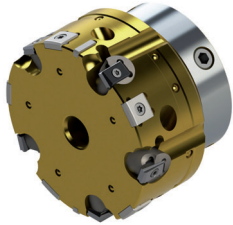
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF86 05-55	H00-2020	T00-07P09


Valoare cuplu T00-07P09: 0,9 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF86B








Capete pentru LNEG Plăcuțe amovibile, gaură înfundată Ø 59,5-84,499 mm / 2.343-3.327"





- Pentru plăcuțe, calitate și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCN	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86B-59.5/64.499-05-55	59,5 2.343	64,499 2.539	50,0 1.969	55,0 2.165	1,3 2.870	5 LNEG1003...
HF86B-64.5/69.499-05-55	64,5 2.539	69,499 2.736	50,0 1.969	55,0 2.165	1,5 3.310	5 LNEG1003...
HF86B-69.5/74.499-05-55	69,5 2.736	74,499 2.933	50,0 1.969	55,0 2.165	1,75 3.860	5 LNEG1003...
HF86B-74.5/79.499-05-55	74,5 2.933	79,499 3.130	50,0 1.969	55,0 2.165	2,0 4.410	5 LNEG1003...
HF86B-79.5/84.499-05-55	79,5 3.130	84,499 3.327	50,0 1.969	55,0 2.165	2,2 4.850	5 LNEG1003...

### Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF86B 05-55	 SH4075S	 CARTCYLN20B	 LDH4010	 C02506-T07P	 H2.0-2D	 2SMS795	 B6027

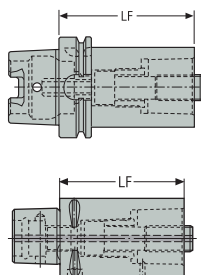
### Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF86B 05-55	 H00-2020	 T00-07P09

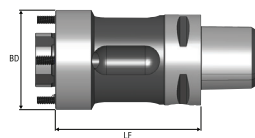
Valoare cuplu T00-07P09: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

# HF55

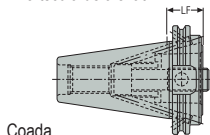
Seco-Capto™ coadă pentru Ø 59,5-84,499 mm



Extensie



Portsculă de alezat



Coadă



Reper Nr. Port-sculă de alezat	Număr reper	LF min	LF max	Con	bd	Greutate
		mm	mm	mm	mm	kg
HF55-080-C5	02688647	-	80	C5	55	1,5
HF55...HSKA63	-	80	239	HSK-A63	55	0,0
HF55...HSKA80	-	100	239	HSK-A80	55	0,0
HF55...HSKA100	-	100	239	HSK-A100	55	0,0
HF55...DIN40ADB	-	80	239	DIN40ADB	55	0,0
HF55...DIN50ADB	-	80	304	DIN50ADB	55	0,0
HF55...BT40ADB	-	80	239	BT40ADB	55	0,0
HF55...BT50ADB	-	80	304	BT50ADB	55	0,0

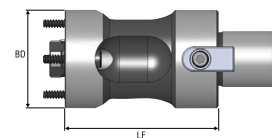
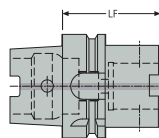
Cozi și extensii pentru HF55-080-C5 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C5-390.410-63090C	75039878	90	HSK-A63	C5	1,41
C5-390.410-100100A	75039880	100	HSK-A100	C5	2,9
C5-390B.140-40040	02924112	40	DIN40 ADB	C5	0,9
C5-390B.140-40080	02924113	80	DIN40 ADB	C5	1,5
C5-390B.55-40050	02925967	50	BT40 ADB	C5	1,1
C5-390B.55-40090	02925968	90	BT40 ADB	C5	1,7
C5-390B.140-50030	02924114	30	DIN50 ADB	C5	2,6
C5-390B.140-50070	02924115	70	DIN50 ADB	C5	3,1
C5-390B.58-50040	02925969	40	BT50 ADB	C5	3,4
C5-390B.58-50080	02925970	80	BT50 ADB	C5	4,0

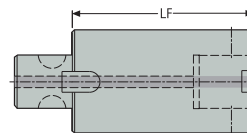
Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C5-391.01-50080A	75039886	-	C5	C5	1,12
C5-391.01-50100A	00004773	-	C5	C5	1,39
C6-391.02-50080A	75039894	-	C6	C5	1,45
C6-391.02-50110A	02207400	-	C6	C5	2,15
C8-391.02-50080B	03080011	-	-	-	2,4

## HF55

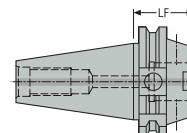
Graflex® coadă pentru  $\varnothing 59,5-84,499$  mm



Portsculă de alezat



Extensie



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF55-080-G5	02698871	-	80	G5	55	1,3
HF55...HSKA63	-	80	239	HSK-A63	55	0,0
HF55...HSKA80	-	100	239	HSK-A80	55	0,0
HF55...HSKA100	-	100	239	HSK-A100	55	0,0
HF55...DIN40ADB	-	80	239	DIN40ADB	55	0,0
HF55...DIN50ADB	-	80	304	DIN50ADB	55	0,0
HF55...BT40ADB	-	80	239	BT40ADB	55	0,0
HF55...BT50ADB	-	80	304	BT50ADB	55	0,0

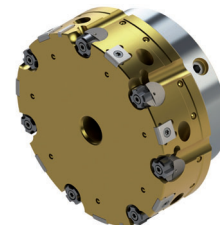
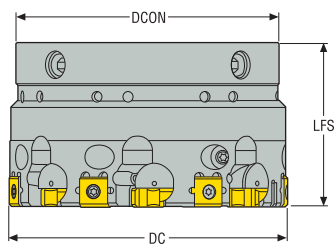
Cozi și extensii pentru HF55-080-G5 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93044012860	00086920	60	HSK-A63	G5	0,98
EM930440128100	00086921	100	HSK-A63	G5	1,58
EM930440128140	00086922	140	HSK-A63	G5	2,18
EM93064012865	00086927	65	HSK-A100	G5	2,37
EM930640128110	00086928	110	HSK-A100	G5	3,02
EM930640128150	00086929	150	HSK-A100	G5	3,7
EM34694012840	02458421	40	DIN40 ADB	G5	0,93
EM34694012880	02503301	80	DIN40 ADB	G5	1,5
EM346940128120	02503302	120	DIN40 ADB	G5	2,08
EM34144012845	02457989	45	BT40 ADB	G5	1,12
EM34144012880	02503371	80	BT40 ADB	G5	1,54
EM341440128120	02503372	120	BT40 ADB	G5	2,12
EM34714012840	02503312	40	DIN50 ADB	G5	2,75
EM341640128100	02503381	100	BT50 ADB	G5	4,22
EM34164012855	02503380	55	BT50 ADB	G5	4,0
EM341640128140	02503382	140	BT50 ADB	G5	4,8

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402550	00056762	-	G5	G5	0,72
M402551	00056763	-	G5	G5	1,12
M402552	00056764	-	G5	G5	1,48

# HF85

Capete pentru RNAX Plăcuțe amovibile, spre alezaj Ø 84,5-119,499 mm / 3.327-4.705"



• Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85-84.5/89.499-07-80	84,5 3.327	89,499 3.524	50,0 1.969	80,0 3.150	1,68 3.700	7 RNAX1005...
HF85-89.5/94.499-07-80	89,5 3.524	94,499 3.720	50,0 1.969	80,0 3.150	1,85 4.080	7 RNAX1005...
HF85-94.5/99.499-07-80	94,5 3.720	99,499 3.917	50,0 1.969	80,0 3.150	2,02 4.450	7 RNAX1005...
HF85-99.5/104.499-07-80	99,5 3.917	104,499 4.114	50,0 1.969	80,0 3.150	2,2 4.850	7 RNAX1005...
HF85-104.5/109.499-07-80	104,5 4.114	109,499 4.311	50,0 1.969	80,0 3.150	2,4 5.290	7 RNAX1005...
HF85-109.5/114.499-07-80	109,5 4.311	114,499 4.508	50,0 1.969	80,0 3.150	2,61 5.750	7 RNAX1005...
HF85-114.5/119.499-07-80	114,5 4.508	119,499 4.705	50,0 1.969	80,0 3.150	2,82 6.220	7 RNAX1005...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF85 07-80	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

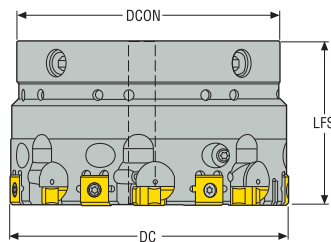
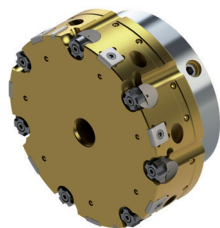
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF85 07-80	H00-2020	T00-09P20


Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF85B



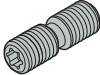




Capete pentru RNAX Plăcuțe amovibile, gaură înfundată Ø 84,5-119,499 mm / 3.327-4.705"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCN	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85B-84.5/89.499-07-80	84,5 3.327	89,499 3.524	50,0 1.969	80,0 3.150	1,68 3.700	7 RNAX1005...
HF85B-89.5/94.499-07-80	89,5 3.524	94,499 3.720	50,0 1.969	80,0 3.150	1,85 4.080	7 RNAX1005...
HF85B-94.5/99.499-07-80	94,5 3.720	99,499 3.917	50,0 1.969	80,0 3.150	2,02 4.450	7 RNAX1005...
HF85B-99.5/104.499-07-80	99,5 3.917	104,499 4.114	50,0 1.969	80,0 3.150	2,2 4.850	7 RNAX1005...
HF85B-104.5/109.499-07-80	104,5 4.114	109,499 4.311	50,0 1.969	80,0 3.150	2,4 5.290	7 RNAX1005...
HF85B-109.5/114.499-07-80	109,5 4.311	114,499 4.508	50,0 1.969	80,0 3.150	2,61 5.750	7 RNAX1005...
HF85B-114.5/119.499-07-80	114,5 4.508	119,499 4.705	50,0 1.969	80,0 3.150	2,82 6.220	7 RNAX1005...

### Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
							
HF85B 07-80	SH4075S	CARTCYHF20B	LDH4010	C03010-T09P	H2.0-2D	2SMS795	B6027

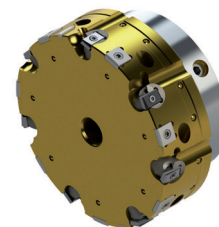
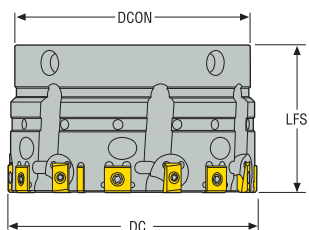
### Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
		
HF85B 07-80	H00-2020	T00-09P20

Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

# HF86

Capete pentru LNEG Plăcuțe amovibile, spre alezaj Ø 84,5-119,499 mm / 3.327-4.705"



• Pentru plăcuțe, calitate și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86-84.5/89.499-07-80	84,5 3.327	89,499 3.524	50,0 1.969	80,0 3.150	1,68 3.700	7 LNEG1003...
HF86-89.5/94.499-07-80	89,5 3.524	94,499 3.720	50,0 1.969	80,0 3.150	1,85 4.080	7 LNEG1003...
HF86-94.5/99.499-07-80	94,5 3.720	99,499 3.917	50,0 1.969	80,0 3.150	2,02 4.450	7 LNEG1003...
HF86-99.5/104.499-07-80	99,5 3.917	104,499 4.114	50,0 1.969	80,0 3.150	2,2 4.850	7 LNEG1003...
HF86-104.5/109.499-07-80	104,5 4.114	109,499 4.311	50,0 1.969	80,0 3.150	2,4 5.290	7 LNEG1003...
HF86-109.5/114.499-07-80	109,5 4.311	114,499 4.508	50,0 1.969	80,0 3.150	2,61 5.750	7 LNEG1003...
HF86-114.5/119.499-07-80	114,5 4.508	119,499 4.705	50,0 1.969	80,0 3.150	2,82 6.220	7 LNEG1003...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF86 07-80	SH4075S	CARTCYLN20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

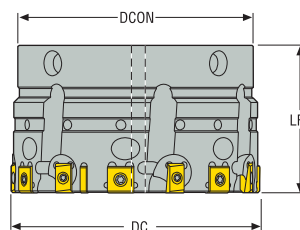
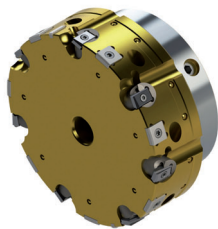
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF86 07-80	H00-2020	T00-07P09


Valoare cuplu T00-07P09: 0,9 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF86B



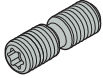




Capete pentru LNEG Plăcuțe amovibile, gaură înfundată Ø 84,5-119,499 mm / 3.327-4.705"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86B-84.5/89.499-07-80	84,5 3.327	89,499 3.524	50,0 1.969	80,0 3.150	1,68 3.700	7 LNEG1003...
HF86B-89.5/94.499-07-80	89,5 3.524	94,499 3.720	50,0 1.969	80,0 3.150	1,85 4.080	7 LNEG1003...
HF86B-94.5/99.499-07-80	94,5 3.720	99,499 3.917	50,0 1.969	80,0 3.150	2,02 4.450	7 LNEG1003...
HF86B-99.5/104.499-07-80	99,5 3.917	104,499 4.114	50,0 1.969	80,0 3.150	2,2 4.850	7 LNEG1003...
HF86B-104.5/109.499-07-80	104,5 4.114	109,499 4.311	50,0 1.969	80,0 3.150	2,4 5.290	7 LNEG1003...
HF86B-109.5/114.499-07-80	109,5 4.311	114,499 4.508	50,0 1.969	80,0 3.150	2,61 5.750	7 LNEG1003...
HF86B-114.5/119.499-07-80	114,5 4.508	119,499 4.705	50,0 1.969	80,0 3.150	2,82 6.220	7 LNEG1003...

### Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF86B	 SH4075S	 CARTCYLN20B	 LDH4010	 C02506-T07P	 H2.0-2D	 2SMS795	 B6027

### Accesorii

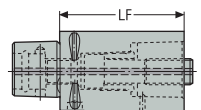
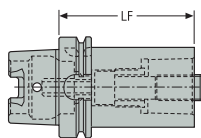
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF86B	 H00-2020	 T00-07P09

Valoare cuplu T00-07P09: 0,9 Nm.  
Valoare cuplu H00-2020: 2 Nm.

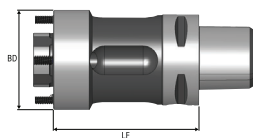


# HF80

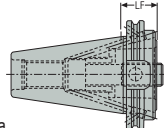
Seco-Capto™ coadă pentru Ø 84,5-119,499 mm



Extensie



Portsculă de alezat



Coadă



Reper Nr. Port-sculă de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF80-080-C6	02688648	-	80	C6	80	2,5
HF80...HSKA80	-	100	239	HSK-A80	80	0,0
HF80...HSKA100	-	100	239	HSK-A100	80	0,0
HF80...DIN50ADB	-	80	304	DIN50ADB	80	0,0
HF80...BT50ADB	-	80	304	BT50ADB	80	0,0

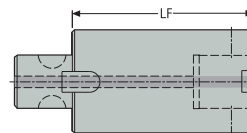
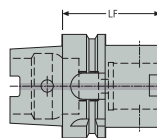
Cozi și extensii pentru HF80-080-C6 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C6-390.410-100110A	75039882	110	HSK-A100	C6	3,56
C6-390B.140-40085	02924116	85	DIN40 ADB	C6	1,8
C6-390B.140-50030	02924117	30	DIN50 ADB	C6	2,5
C6-390B.140-50080	02924118	80	DIN50 ADB	C6	3,6
C6-390B.55-40075	02925971	75	BT40 ADB	C6	1,7
C6-390B.58-50100	02925973	100	BT50 ADB	C6	4,6
C6-390B.58-50050	02925972	50	BT50 ADB	C6	3,5

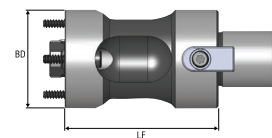
Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C6-391.01-63100A	75039887	-	C6	C6	2,2
C6-391.01-63140A	00004840	-	C6	C6	3,1
C6-391.01-63060	02300834	-	C6	C6	1,31

## HF80

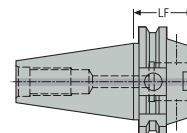
Graflex® coadă pentru  $\varnothing$  84,5-119,499 mm



Extensie



Portsculă de alezat



Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF80-080-G6	02698873	-	80	G6	80	3,0
HF80...HSKA80	-	100	239	HSK-A80	80	0,0
HF80...HSKA100	-	100	239	HSK-A100	80	0,0
HF80...DIN50ADB	-	80	304	DIN50ADB	80	0,0
HF80...BT50ADB	-	80	304	BT50ADB	80	0,0

Cozi și extensii pentru HF80-080-G6 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

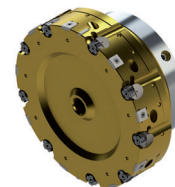
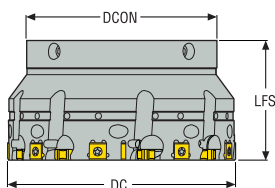
Reper Nr. Coadă	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93044013670	00086923	70	HSK-A63	G6	1,21
EM930440136120	00086924	120	HSK-A63	G6	2,38
EM930640136120	00086931	120	HSK-A100	G6	3,82
EM930640136160	00086932	160	HSK-A100	G6	4,72
EM34694013660	02503303	60	DIN40 ADB	G6	1,24
EM346940136120	02503304	120	DIN40 ADB	G6	2,65
EM34144013650	02503373	50	BT40 ADB	G6	1,13
EM341440136120	02503374	120	BT40 ADB	G6	2,78
EM34714013645	02503317	45	DIN50 ADB	G6	2,88
EM347140136100	02503318	100	DIN50 ADB	G6	4,1
EM347140136140	02503319	140	DIN50 ADB	G6	4,99
EM34164013663	02503383	63	BT50 ADB	G6	4,2
EM341640136100	02503384	100	BT50 ADB	G6	4,6
EM341640136140	02503385	140	BT50 ADB	G6	5,54

Cozi și extensii pentru HF32-050-G3 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402660	00056765	-	G6	G6	1,38
M402661	00056766	-	G6	G6	2,1
M402662	00056767	-	G6	G6	2,82

# HF85

Capete pentru RNAX Plăcuțe amovibile, spre alezaj  $\varnothing$  119,5-154,499 mm / 4.705-6.083"



• Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85-119.5/124.499-09-100	119,5 4.705	124,499 4.902	63,0 2.480	100,0 3.937	3,89 8.580	9 RNAX1005...
HF85-124.5/129.499-09-100	124,5 4.902	129,499 5.098	63,0 2.480	100,0 3.937	4,15 9.150	9 RNAX1005...
HF85-129.5/134.499-09-100	129,5 5.098	134,499 5.295	63,0 2.480	100,0 3.937	4,42 9.740	9 RNAX1005...
HF85-134.5/139.499-09-100	134,5 5.295	139,499 5.492	63,0 2.480	100,0 3.937	4,7 10.360	9 RNAX1005...
HF85-139.5/144.499-09-100	139,5 5.492	144,499 5.689	63,0 2.480	100,0 3.937	4,99 11.000	9 RNAX1005...
HF85-144.5/149.499-09-100	144,5 5.689	149,499 5.886	63,0 2.480	100,0 3.937	5,29 11.660	9 RNAX1005...
HF85-149.5/154.499-09-100	149,5 5.886	154,499 6.083	63,0 2.480	100,0 3.937	5,6 12.350	9 RNAX1005...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF85 09-100	SH4075S	CARTCYHF20	LDH4012	C03010-T09P	H2.0-2D	4SMS795	B6027

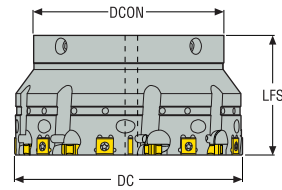
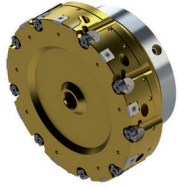
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF85 09-100	H00-2020	T00-09P20


Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF85B



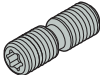




Capete pentru RNAX Plăcuțe amovibile, gaură înfundată Ø 119,5-154,499 mm / 4.705-6.083"





- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF85B-119.5/124.499-09-100	119,5 4.705	124,499 4.902	63,0 2.480	100,0 3.937	3,89 8.580	9 RNAX1005...
HF85B-124.5/129.499-09-100	124,5 4.902	129,499 5.098	63,0 2.480	100,0 3.937	4,15 9.150	9 RNAX1005...
HF85B-134.5/139.499-09-100	134,5 5.295	139,499 5.492	63,0 2.480	100,0 3.937	4,7 10.360	9 RNAX1005...
HF85B-139.5/144.499-09-100	139,5 5.492	144,499 5.689	63,0 2.480	100,0 3.937	4,99 11.000	9 RNAX1005...
HF85B-144.5/149.499-09-100	144,5 5.689	149,499 5.886	63,0 2.480	100,0 3.937	5,29 11.660	9 RNAX1005...
HF85B-149.5/154.499-09-100	149,5 5.886	154,499 6.083	63,0 2.480	100,0 3.937	5,6 12.350	9 RNAX1005...

### Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF85B 09-100	 SH4075S	 CARTCYHF20B	 LDH4012	 C03010-T09P	 H2.0-2D	 2SMS795	 B6027

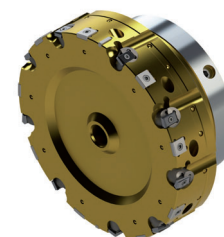
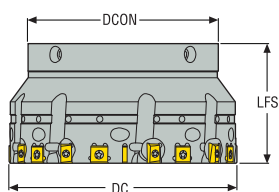
### Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF85B 09-100	 H00-2020	 T00-09P20

Valoare cuplu T00-09P20: 2 Nm.  
Valoare cuplu H00-2020: 2 Nm.

# HF86

Capete pentru LNEG Plăcuțe amovibile, spre alezaj  $\varnothing$  119,5-154,499 mm / 4.705-6.083"



• Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCON	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86-119.5/124.499-09-100	119,5 4.705	124,499 4.902	63,0 2.480	100,0 3.937	3,89 8.580	9 LNEG1003...
HF86-124.5/129.499-09-100	124,5 4.902	129,499 5.098	63,0 2.480	100,0 3.937	4,15 9.150	9 LNEG1003...
HF86-129.5/134.499-09-100	129,5 5.098	134,499 5.295	63,0 2.480	100,0 3.937	4,42 9.740	9 LNEG1003...
HF86-134.5/139.499-09-100	134,5 5.295	139,499 5.492	63,0 2.480	100,0 3.937	4,7 10.360	9 LNEG1003...
HF86-139.5/144.499-09-100	139,5 5.492	144,499 5.689	63,0 2.480	100,0 3.937	4,99 11.000	9 LNEG1003...
HF86-144.5/149.499-09-100	144,5 5.689	149,499 5.886	63,0 2.480	100,0 3.937	5,29 11.660	9 LNEG1003...
HF86-149.5/154.499-09-100	149,5 5.886	154,499 6.083	63,0 2.480	100,0 3.937	5,6 12.350	9 LNEG1003...

## Piese de schimb

Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF86 09-100	SH4075S	CARTCYHF20	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

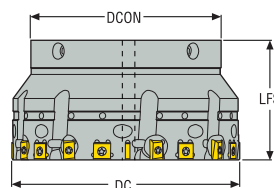
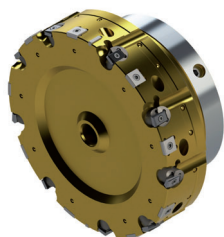
## Accesorii

Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF86 09-100	H00-2020	T00-07P09

Valoare cuplu T00-07P09: 0,9 Nm.  
Valoare cuplu H00-2020: 2 Nm.

## HF86B

Capete pentru LNEG Plăcuțe amovibile, gaură înfundată Ø 119,5-154,499 mm / 4.705-6.083"



- Pentru plăcuțe, calități și geometrii vezi pag. 429-430

Reper Nr.	DCN	DCX	LFS	DCN	Greutate	Plăcuță amovibilă
	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
HF86B-119.5/124.499-09-100	119,5 4.705	124,499 4.902	63,0 2.480	100,0 3.937	3,89 8.580	9 LNEG1003...
HF86B-124.5/129.499-09-100	124,5 4.902	129,499 5.098	63,0 2.480	100,0 3.937	4,15 9.150	9 LNEG1003...
HF86B-129.5/134.499-09-100	129,5 5.098	134,499 5.295	63,0 2.480	100,0 3.937	4,42 9.740	9 LNEG1003...
HF86B-134.5/139.499-09-100	134,5 5.295	139,499 5.492	63,0 2.480	100,0 3.937	4,7 10.360	9 LNEG1003...
HF86B-139.5/144.499-09-100	139,5 5.492	144,499 5.689	63,0 2.480	100,0 3.937	4,99 11.000	9 LNEG1003...
HF86B-144.5/149.499-09-100	144,5 5.689	149,499 5.886	63,0 2.480	100,0 3.937	5,29 11.660	9 LNEG1003...
HF86B-149.5/154.499-09-100	149,5 5.886	154,499 6.083	63,0 2.480	100,0 3.937	5,6 12.350	9 LNEG1003...

### Piese de schimb

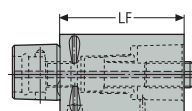
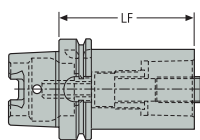
Pentru cap	Șurub reglaj	Cartuș	Șurub clemă	Șurub plăcuță	Cheie (steag)	Cheie de reglare	Clemă pană
HF86B 09-100	SH4075S	CARTCYLN20B	LDH4010	C02506-T07P	H2.0-2D	2SMS795	B6027

### Accesorii

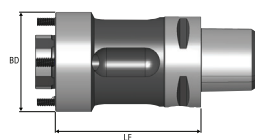
Pentru cap	Cheie dinamometrică	Torx driver for insert/holder locking screw
HF86B 09-100	H00-2020	T00-07P09

Valoare cuplu T00-07P09: 0,9 Nm.  
Valoare cuplu H00-2020: 2 Nm.

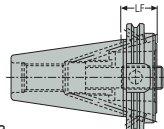
## HF100

Seco-Capto™ coadă pentru  $\varnothing$  119,5-154,499 mm

Extensie



Portsculă de alezat



Coadă



Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF100-100-C8	02688649	–	100	C8	100	4,9
HF100...HSKA80	–	100	238	HSK-A80	100	0,0
HF100...HSKA100	–	100	238	HSK-A100	100	0,0
HF100...DIN50ADB	–	100	238	DIN50ADB	100	0,0
HF100...BT50ADB	–	100	238	BT50ADB	100	0,0

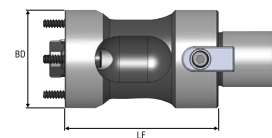
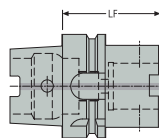
Cozi și extensii pentru HF100-100-C8 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C8-390.410-100120A	75039883	120	HSK-A100	C8	4,72
C8-390B.140-50070	02924119	70	DIN50 ADB	C8	3,7
C8-390B.140-50120	02924120	120	DIN50 ADB	C8	5,6
C8-390B.58-50070	02925974	70	BT50 ADB	C8	4,0
C8-390B.58-50120	02925975	120	BT50 ADB	C8	5,9

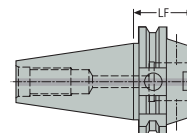
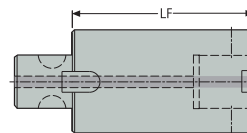
Reper Nr. Extensie	Număr reper	LF	Con	Dim. Seco-Capto	Greutate
		mm			kg
C8-391.01-80100A	75039888	–	C8	C8	3,62
C8-391.01-80125A	00004841	–	C8	C8	4,54

## HF100

Graflex® coadă pentru  $\varnothing$  119,5-154,499 mm



Portsculă de alezat



Extensie

Coadă

Reper Nr. Port-scule de alezat	Număr reper	LF min	LF max	Con	BD	Greutate
		mm	mm		mm	kg
HF100-100-G7	02698874	-	100	G7	100	5,2
HF100...HSKA80	-	100	238	HSK-A80	100	0,0
HF100...HSKA100	-	100	238	HSK-A100	100	0,0
HF100...DIN50ADB	-	100	238	DIN50ADB	100	0,0
HF100...BT50ADB	-	100	238	BT50ADB	100	0,0

Cozi și extensii pentru HF100-100-G7 (Vezi catalogul Sisteme de scule pentru mai multe detalii).

Reper Nr. Coadă	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
EM93064014685	00074385	85	HSK-A100	G7	3,99
EM930640146160	00086933	160	HSK-A100	G7	7,67
EM34714014650	02503320	50	DIN50 ADB	G7	3,23
EM347140146120	02503321	120	DIN50 ADB	G7	6,48
EM347140146200	02503324	200	DIN50 ADB	G7	10,4
EM34164014665	02503386	65	BT50 ADB	G7	4,4
EM341640146120	02503387	120	BT50 ADB	G7	6,8
EM341640146200	02503388	200	BT50 ADB	G7	10,7

Reper Nr. Extensie	Număr reper	LF	Con	Mărime Graflex	Greutate
		mm			kg
M402770	00056768	-	G7	G7	2,9
M402771	00056769	-	G7	G7	4,03
M402772	00056770	-	G7	G7	5,8



Regimuri de aşchiere – LNEG...-EB45 metric

SMG		a <sub>p</sub> (∅)	f				v <sub>c</sub>		
			z=3	z=5	z=7	z=9	RX2000	CF	RX1500
P1	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	120 (80-200)	180 (120-250)	220 (120-300)
P2	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	120 (80-200)	180 (120-250)	220 (120-300)
P3	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	120 (80-200)	180 (120-250)	220 (120-300)
P4	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P5	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P6	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P7	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)	80 (60-150)	100 (80-200)
P8	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)	60 (50-100)	80 (60-120)
P11	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)	60 (50-100)	80 (60-120)
P12	LNEG1003-EB45	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	30 (25-55)	45 (40-80)	65 (45-95)
M1	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	35 (25-60)	-	-
M2	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	35 (25-60)	-	-
M3	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	35 (25-60)	-	-
M4	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	25 (20-50)	-	-
M5	LNEG1003-EB45	0,10-0,20	0,15-0,30	0,25-0,50	0,35-0,70	0,45-0,90	25 (20-50)	-	-
K1	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	-	220 (150-300)
K2	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)	-	70 (50-120)
K3	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	-	220 (150-300)
K4	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	100 (60-120)	150 (110-200)
K5	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	100 (60-120)	150 (110-200)
K6	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	-	220 (150-300)
K7	LNEG1003-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	-	220 (150-300)
H3	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H5	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H7	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H8	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H11	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H12	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H21	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-
H31	LNEG1003-EB45	0,10-0,20	0,1-0,25	0,15-0,40	0,25-0,5	0,30-0,7	20 (10-30)	-	-

SMG = Grupa de material Seco

a<sub>p</sub> = mm

f = mm/rev

v<sub>c</sub> = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – LNEG...-EB45 inci

SMG		$a_p (\varnothing)$	f				$v_c$		
			z=3	z=5	z=7	z=9	RX2000	CF	RX1500
P1	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	395 (260-655)	590 (395-820)	720 (395-985)
P2	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	395 (260-655)	590 (395-820)	720 (395-985)
P3	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	395 (260-655)	590 (395-820)	720 (395-985)
P4	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	195 (130-395)	260 (195-490)	330 (260-655)
P5	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	195 (130-395)	260 (195-490)	330 (260-655)
P6	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	195 (130-395)	260 (195-490)	330 (260-655)
P7	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	195 (130-395)	260 (195-490)	330 (260-655)
P8	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	130 (100-230)	195 (165-330)	260 (195-395)
P11	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	130 (100-230)	195 (165-330)	260 (195-395)
P12	LNEG1003-EB45	0.006-0.010	0.006-0.018	0.010-0.030	0.010-0.041	0.010-0.053	100 (85-185)	150 (135-265)	215 (150-315)
M1	LNEG1003-EB45	0.004-0.008	0.006-0.012	0.010-0.020	0.014-0.028	0.018-0.035	115 (80-195)	-	-
M2	LNEG1003-EB45	0.004-0.008	0.006-0.012	0.010-0.020	0.014-0.028	0.018-0.035	115 (80-195)	-	-
M3	LNEG1003-EB45	0.004-0.008	0.006-0.012	0.010-0.020	0.014-0.028	0.018-0.035	115 (80-195)	-	-
M4	LNEG1003-EB45	0.004-0.008	0.006-0.012	0.010-0.020	0.014-0.028	0.018-0.035	80 (65-165)	-	-
M5	LNEG1003-EB45	0.004-0.008	0.006-0.012	0.010-0.020	0.014-0.028	0.018-0.035	80 (65-165)	-	-
K1	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	330 (195-655)	-	720 (490-985)
K2	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	165 (115-260)	-	230 (165-395)
K3	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	330 (195-655)	-	720 (490-985)
K4	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	230 (165-395)	330 (195-395)	490 (360-655)
K5	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	230 (165-395)	330 (195-395)	490 (360-655)
K6	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	330 (195-655)	-	720 (490-985)
K7	LNEG1003-EB45	0.008-0.020	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	330 (195-655)	-	720 (490-985)
H3	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H5	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H7	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H8	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H11	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H12	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H21	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-
H31	LNEG1003-EB45	0.004-0.008	0.004-0.010	0.006-0.016	0.010-0.020	0.012-0.028	65 (35-100)	-	-

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pomire

### Regimuri de aşchiere – LNEG...-EB845 metric

SMG		$a_p (\varnothing)$	f				$v_c$ RX2000
			z=3	z=5	z=7	z=9	
P1	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P2	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P3	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	120 (80-200)
P4	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P5	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P6	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P7	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	60 (40-120)
P8	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	40 (30-70)
P11	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	40 (30-70)
P12	LNEG1003-EB845	0,15-0,25	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	30 (25-55)
M1	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M2	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M3	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	35 (25-60)
M4	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	25 (20-50)
M5	LNEG1003-EB845	0,10-0,20	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	25 (20-50)
K1	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K2	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	50 (35-80)
K3	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K4	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)
K5	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)
K6	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)
K7	LNEG1003-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – LNEG...-EB845 inci

SMG		$a_p$ (∅)	f				$v_c$ RX2000
			z=3	z=5	z=7	z=9	
P1	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	395 (260-655)
P2	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	395 (260-655)
P3	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	395 (260-655)
P4	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	195 (130-395)
P5	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	195 (130-395)
P6	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	195 (130-395)
P7	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	195 (130-395)
P8	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	130 (100-230)
P11	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	130 (100-230)
P12	LNEG1003-EB845	0.006-0.010	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	100 (85-185)
M1	LNEG1003-EB845	0.004-0.008	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	115 (80-195)
M2	LNEG1003-EB845	0.004-0.008	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	115 (80-195)
M3	LNEG1003-EB845	0.004-0.008	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	115 (80-195)
M4	LNEG1003-EB845	0.004-0.008	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	80 (65-165)
M5	LNEG1003-EB845	0.004-0.008	0.006-0.018	0.010-0.030	0.010-0.041	0.018-0.053	80 (65-165)
K1	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	330 (195-655)
K2	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	165 (115-260)
K3	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	330 (195-655)
K4	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	230 (165-395)
K5	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	230 (165-395)
K6	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	330 (195-655)
K7	LNEG1003-EB845	0.008-0.020	0.006-0.024	0.010-0.039	0.014-0.055	0.018-0.071	330 (195-655)

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – LNEG...-EB1570 metric

SMG		$a_p (\varnothing)$	f				$v_c$ RX2000
			z=3	z=5	z=7	z=9	
P4	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P5	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P6	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P7	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	60 (40-120)
P8	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)
P11	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	40 (30-70)
P12	LNEG1005-EB1570	0,15-0,25	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	30 (25-55)
K1	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K2	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)
K3	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K4	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)
K5	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)
K6	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)
K7	LNEG1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – LNEG...-EB1570 inci

SMG		$a_p (\varnothing)$	f				$v_c$ RX2000
			z=3	z=5	z=7	z=9	
P4	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130–395)
P5	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130–395)
P6	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130–395)
P7	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	195 (130–395)
P8	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	130 (100–230)
P11	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	130 (100–230)
P12	LNEG1005-EB1570	0.006–0.010	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	100 (85–185)
K1	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195–655)
K2	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	165 (115–260)
K3	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195–655)
K4	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165–395)
K5	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165–395)
K6	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195–655)
K7	LNEG1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195–655)

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – RNAX...-EB45 metric

SMG		$a_p$ (∅)	f				$v_c$	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K2	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)	70 (50-120)
K3	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K4	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K5	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K6	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K7	RNAX1005-EB45	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – RNAX...-EB45 inci

SMG		$a_p$ (∅)	f				$v_c$	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490-985)
K2	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	165 (115-260)	230 (165-395)
K3	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490-985)
K4	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165-395)	490 (360-655)
K5	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165-395)	490 (360-655)
K6	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490-985)
K7	RNAX1005-EB45	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490-985)

SMG = Grupa de material Seco

$a_p$  = inci

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

## Regimuri de aşchiere – RNAX...-EB845 metric

SMG		$a_p$ (∅)	f				$v_c$	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)
K2	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	50 (35-80)	70 (50-120)
K3	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)
K4	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)	150 (110-200)
K5	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	70 (50-120)	150 (110-200)
K6	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)
K7	RNAX1005-EB845	0,20-0,50	0,15-0,60	0,25-1	0,35-1,4	0,45-1,80	100 (60-200)	220 (150-300)

SMG = Grupa de material Seco

 $a_p$  = mm

f = mm/rev

 $v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

## Regimuri de aşchiere – RNAX...-EB845 inci

SMG		$a_p$ (∅)	f				$v_c$	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	330 (195-655)	720 (490-985)
K2	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	165 (115-260)	230 (165-395)
K3	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	330 (195-655)	720 (490-985)
K4	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	230 (165-395)	490 (360-655)
K5	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	230 (165-395)	490 (360-655)
K6	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	330 (195-655)	720 (490-985)
K7	RNAX1005-EB845	0.008–0.020	0.006–0.024	0.010–0.039	0.014–0.055	0.018–0.071	330 (195-655)	720 (490-985)

SMG = Grupa de material Seco

 $a_p$  = inci

f = in/rev

 $v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – RNAX...-EB1570 metric

SMG		$a_p$ (∅)	f				$v_c$	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K2	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	50 (35-80)	70 (50-120)
K3	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K4	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K5	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	70 (50-120)	150 (110-200)
K6	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)
K7	RNAX1005-EB1570	0,20-0,50	0,15-0,45	0,25-0,75	0,25-1,05	0,45-1,35	100 (60-200)	220 (150-300)

SMG = Grupa de material Seco

$a_p$  = mm

f = mm/rev

$v_c$  = m/min

Toate regimurile de aşchiere sunt valori de pornire

Regimuri de aşchiere – RNAX...-EB1570 inci

SMG		$a_p$ (∅)	f				$v_c$	
			z=3	z=5	z=6	z=9	RX2000	RX1500
K1	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490- 985)
K2	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	165 (115-260)	230 (165- 395)
K3	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490- 985)
K4	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165-395)	490 (360- 655)
K5	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	230 (165-395)	490 (360- 655)
K6	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490- 985)
K7	RNAX1005-EB1570	0.008–0.020	0.006–0.018	0.010–0.030	0.010–0.041	0.018–0.053	330 (195-655)	720 (490- 985)

SMG = Grupa de material Seco

$a_p$  = inci

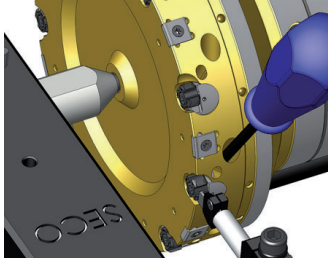
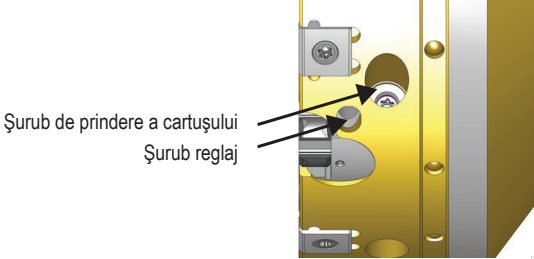
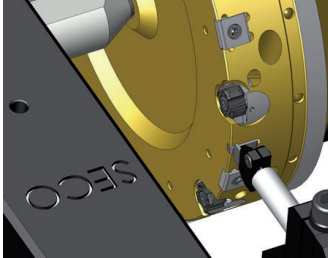
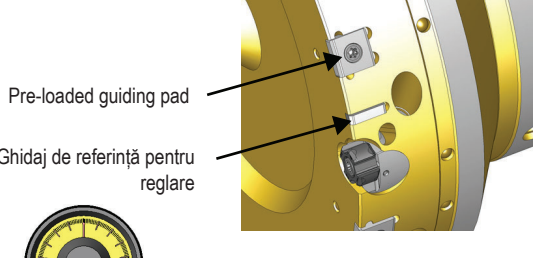
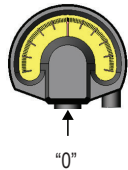
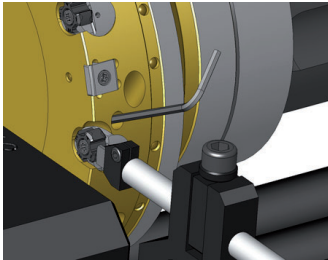
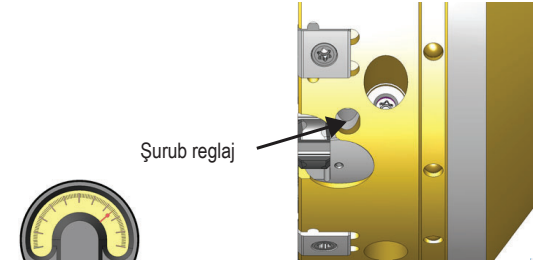
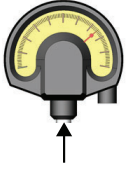

f = in/rev

$v_c$  = sf/min

Toate regimurile de aşchiere sunt valori de pornire



## Instrucțiuni de reglare

<p><b>1.</b></p> <ul style="list-style-type: none"> <li>• Slăbiți șurubul de prindere al cartușului.</li> <li>• Rotiți sau înlocuiți plăcuța.</li> <li>• Desfaceți șurubul de reglare un sfert de tură și împingeți cartușul înapoi.</li> <li>• Strângeți la loc cu grijă șurubul de prindere al cartușului la 0,5 Nm aprox. (4,4 in/lbs).</li> </ul>	 
<p><b>2.</b></p> <ul style="list-style-type: none"> <li>• Setati comparatorul la zero pe ghidajul de referință.</li> <li>• Asigurați-vă că punctul de măsurare se află după unghiul de avans.</li> </ul>	  
<p><b>3.</b></p> <ul style="list-style-type: none"> <li>• Setati plăcuța 0,025 mm (0,001") deasupra ghidajului de referință utilizând șurubul de reglare.</li> <li>• Repetați procesul de reglare pentru toate plăcuțele.</li> </ul>	  
<p><b>4.</b></p> <ul style="list-style-type: none"> <li>• Strângeți șurubul de prindere al cartușului la 2 Nm (17.7 in/lbs).</li> </ul>	

Notă: Dacă diametrul dorit este depășit la reglare, începeți încă o dată de la început pentru a elimina jocul șurubului de reglare.

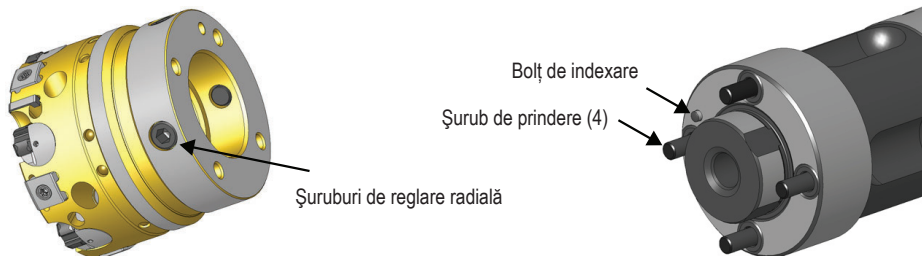
## Instrucțiuni de reglare, adaptor

1.

### Asamblare

- Curățați temeinic suprafața de contact a flanșei.
- Slăbiți cele 4 șuruburi de reglare radială în așa fel încât să nu încurce asamblarea.
- Amplasați capul alezorului în adaptor (pin de rotație) și strângeți cele 4 șuruburi de prindere.

### Asamblare (schița 1)

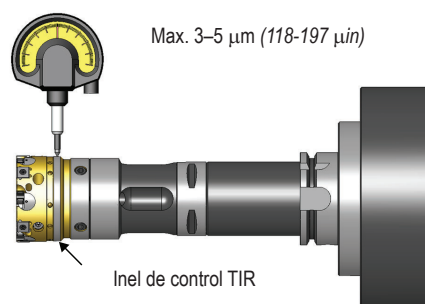


2.

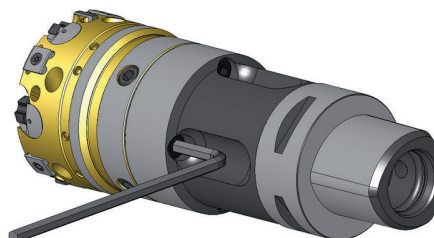
### Setare

- Montați scula în capul de alezare al utilajului.
- Plasați comparatorul  $\mu\text{m}$  după cum este indicat în (schița 2).
- Deblocați capul de alezare pentru a putea fi rotit liber cu mâna.
- Începeți corectarea bății radiale utilizând cele 4 șuruburi de reglare (schița 3).
- Bătaie radială max.  $5 \mu\text{m}$  ( $197 \mu\text{in}$ ).
- Când valorile bății radiale coboară sub  $10 \mu\text{m}$  ( $394 \mu\text{in}$ ), treceți la strângerea finală (schița 1), consultați tabelul cu cuplul de strângere pentru valorile recomandate de cuplu.

### Setarea operației pe capul de alezare al utilajului (schița 2)



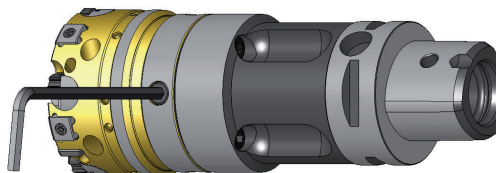
### Șuruburi de prindere (schița 3)



3.

- Finalizați reglarea bății radiale, max.  $5 \mu\text{m}$  (max.  $197 \mu\text{in}$ ).

### Șuruburi de reglare radială (schița 4)



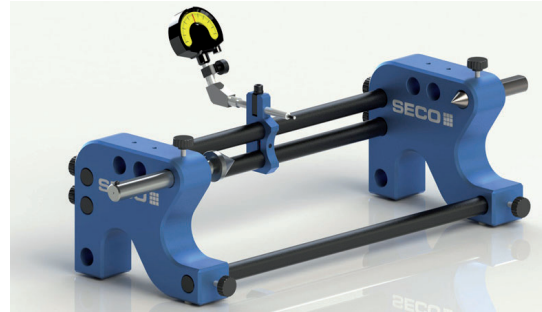
### Cuplul de strângere

Diametru mm	Diametru inci	Mărimea adaptorului	Șurub de prindere	Cuplul de strângere Nm	Cuplul de strângere in/lbs
39,5-59,499	1,555-2,342	HF32	CHC M3 x 16	2,7	24
59,5-84,499	2,342-3,372	HF55	CHC M5 x 25	5,7	50
84,5-119,499	3,372-4,705	HF80	CHC M6 x 25	9,8	87
119,5-154,499	4,705-6,083	HF100	CHC M8 x 30	24	212

## Prindere de reglare – comparator unic

### SF-210340-C160: Nr. reper pt. comandă 02885391

- Stand orizontal
- Prima alegere pentru alezările Xfix
- 1 comparator
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 340 mm (13,386")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8
- Punct central SSC5700 inclus la livrare



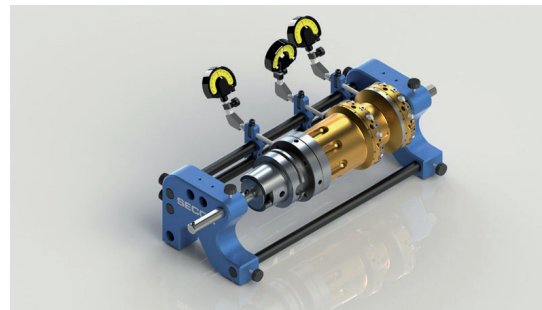
### SF-210290V-C160: Nr. reper pt. comandă 02885392

- Stand vertical
- Prima alegere pentru alezările Xfix
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 290 mm (11,417")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8
- Punct central SSC5700 inclus la livrare



## Prindere de reglare – mai multe comparatoare

Posibilități de configurare cu mai multe comparatoare, consultați capitoul referitor la prinderea de reglare de la paginile 485-490 pentru mai multe detalii



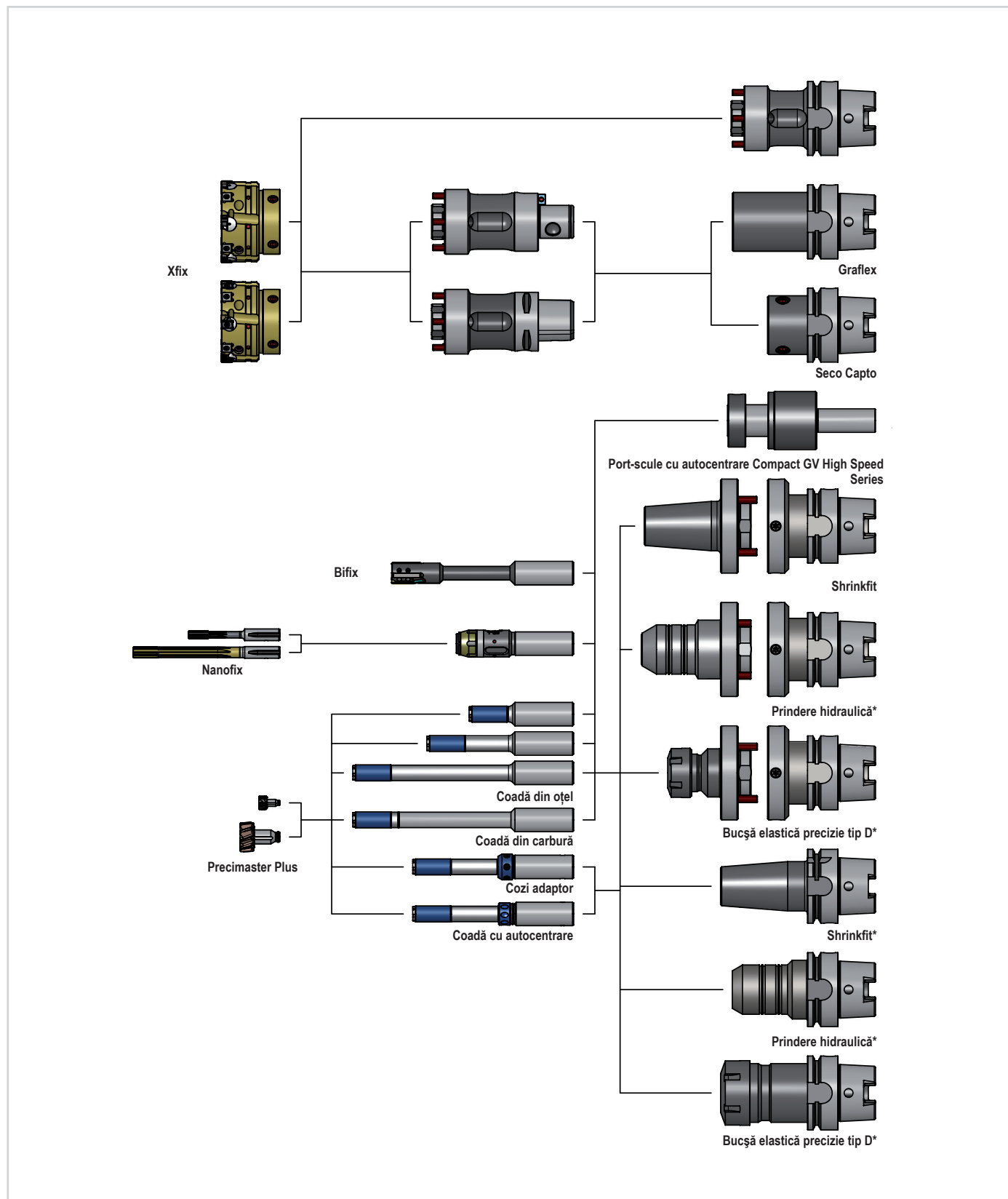
## Vedere generală asupra sistemelor de scule



Diametru mm	Diametru inci	Raport diametru/ lungime maxim
39,5-59,499	1,555-2,342	6,5 x D
59,5-84,499	2,342-3,372	4,5 x D
84,5-119,499	3,372-4,705	3,3 x D
119,5-154,499	4,705-6,083	2,5 x D

Notă: Pentru diametre > 100 mm (3,937") sau L > 3 x D verificați greutatea maximă a sculei acceptată de utilaj.

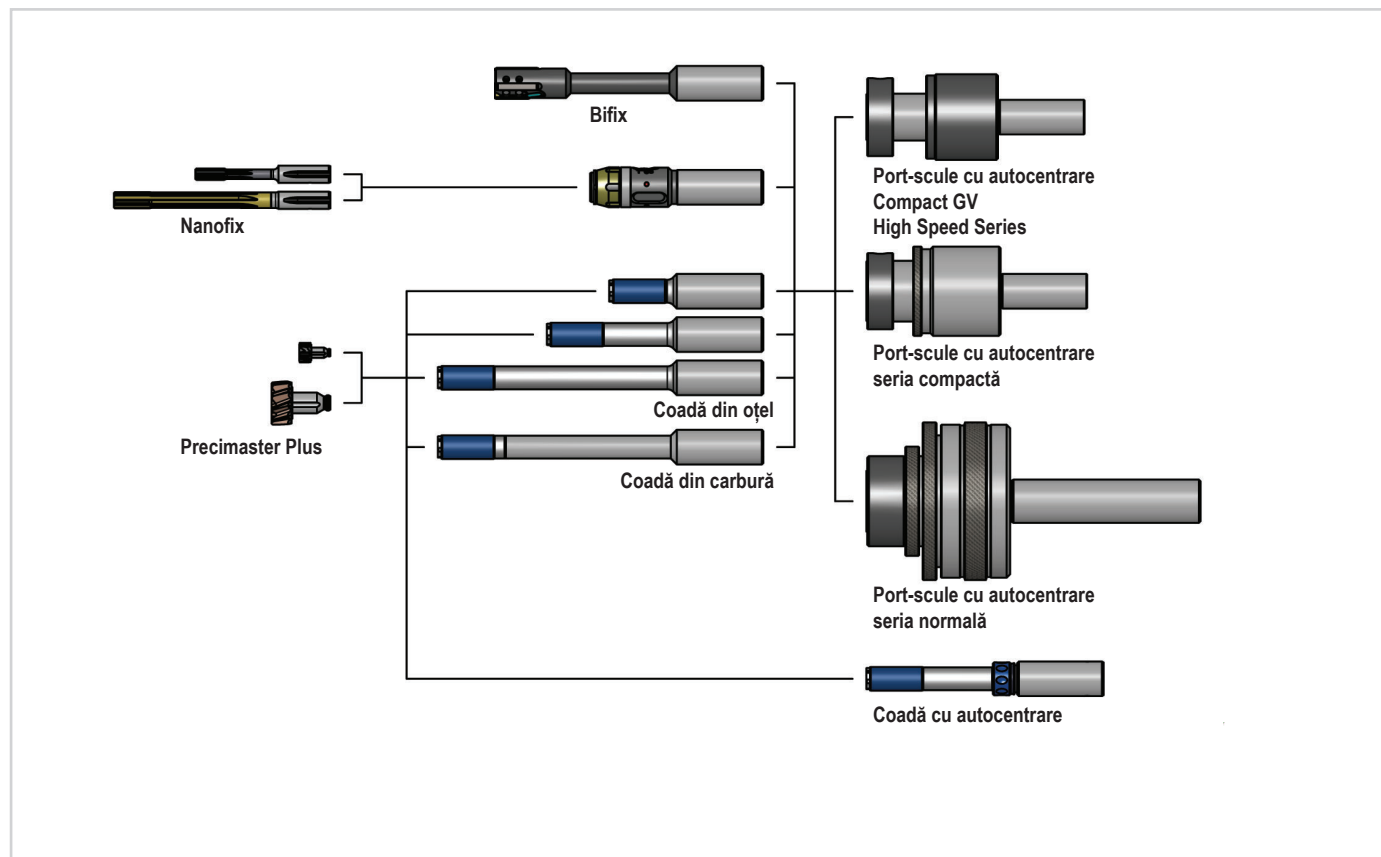
Aplicații dinamice



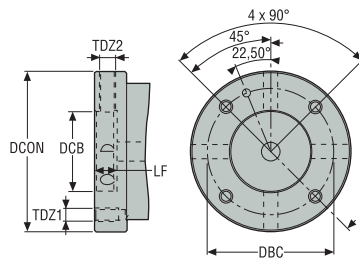
\*Consultați catalogul PORT-SCULE

Cele mai bune performanțe se obțin cu prinderile rigide (prindere hidraulică, tip D sau Shrinkfit)

## Aplicații statice

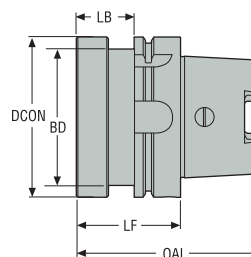


## Dimensiunea flanșei



DCON	DBC +/- 0,1	DCB F8	Lf	TDZ1	TDZ2
60	44	30	12	M5	M8x1
70	53	35	12	M6	M8x1
80	63	40	12	M6	M8x1
100	79	50	14	M8	M10x1
117	96	60	14	M8	M10x1
140	119	80	14	M10	M10x1

## Capăt spre mașină HSK-A

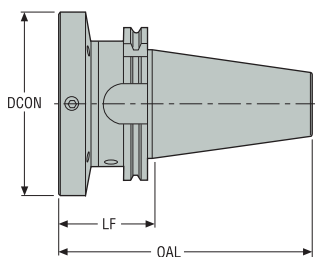


- Notă: Tuburi de răcire și șuruburi incluse

Reper Nr.	Număr reper	Con	DCON	BD	LB	LF	OAL	Greutate
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs
SAH-23405100001	02836663	HSK-A 100	60,0 2.362	60,0 2.362	26,0 1.024	55,0 2.165	105,0 4.134	2,5 5.510
SAH-23405100002	02836665	HSK-A 100	80,0 3.150	80,0 3.150	26,0 1.024	55,0 2.165	105,0 4.134	2,9 6.390
SAH-23405100003	02836666	HSK-A 100	100,0 3.937	85,0 3.346	36,0 1.417	65,0 2.559	115,0 4.528	3,5 7.720
SAH-23405100007	02836664	HSK-A 100	70,0 2.756	70,0 2.756	26,0 1.024	55,0 2.165	105,0 4.134	2,8 6.170
SAH-23405400001	02836564	HSK-A 40	60,0 2.362	34,0 1.339	35,0 1.378	55,0 2.165	75,0 2.953	0,8 1.760
SAH-23405500001	02836566	HSK-A 50	60,0 2.362	42,0 1.654	34,0 1.339	60,0 2.362	85,0 3.346	0,95 2.090
SAH-23405500002	02836573	HSK-A 50	80,0 3.150	42,0 1.654	34,0 1.339	60,0 2.362	85,0 3.346	1,2 2.650
SAH-23405500003	02836567	HSK-A 50	70,0 2.756	42,0 1.654	34,0 1.339	60,0 2.362	85,0 3.346	1,0 2.200
SAH-23405630001	02836574	HSK-A 63	60,0 2.362	53,0 2.087	34,0 1.339	60,0 2.362	92,0 3.622	1,2 2.650
SAH-23405630002	02836576	HSK-A 63	80,0 3.150	53,0 2.087	34,0 1.339	60,0 2.362	92,0 3.622	1,4 3.090
SAH-23405630003	02836575	HSK-A 63	70,0 2.756	53,0 2.087	34,0 1.339	60,0 2.362	92,0 3.622	1,3 2.870
SAH-23405630004	02836577	HSK-A 63	100,0 3.937	53,0 2.087	39,0 1.535	65,0 2.559	97,0 3.819	1,95 4.300
SAH-23405800001	02836655	HSK-A 80	60,0 2.362	60,0 2.362	24,0 0.945	50,0 1.969	90,0 3.543	1,4 3.090
SAH-23405800002	02836658	HSK-A 80	80,0 3.150	67,0 2.638	34,0 1.339	60,0 2.362	100,0 3.937	1,6 3.530
SAH-23405800003	02836657	HSK-A 80	70,0 2.756	67,0 2.638	34,0 1.339	60,0 2.362	100,0 3.937	1,5 3.310
SAH-23405800004	02836660	HSK-A 80	100,0 3.937	67,0 2.638	39,0 1.535	65,0 2.559	105,0 4.134	2,2 4.850



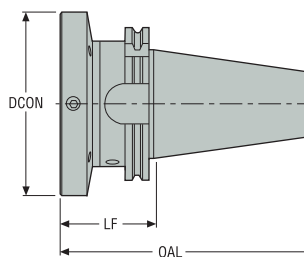
## Capăt spre mașină DIN 69871



- Notă: Șuruburi incluse la livrare

Reper Nr.	Număr reper	Con	DCON	LF	OAL	Greutate
			mm Inci	mm Inci	mm Inci	kg lbs
SAH-2340640201	02836683	DIN40 ADB	60,0 2.362	50,0 1.969	118,4 4.661	1,1 2.430
SAH-2340640202	02836685	DIN40 ADB	80,0 3.150	55,0 2.165	123,4 4.858	1,5 3.310
SAH-2340640203	02836686	DIN40 ADB	100,0 3.937	60,0 2.362	128,4 5.055	2,3 5.070
SAH-2340640204	02836684	DIN40 ADB	70,0 2.756	50,0 1.969	118,4 4.661	1,2 2.650
SAH-2340650201	02836687	DIN50 ADB	60,0 2.362	50,0 1.969	151,8 5.976	3,1 6.830
SAH-2340650202	02836690	DIN50 ADB	80,0 3.150	50,0 1.969	151,8 5.976	3,6 7.940
SAH-2340650203	02836691	DIN50 ADB	100,0 3.937	60,0 2.362	161,8 6.370	4,3 9.480
SAH-2340650206	02836688	DIN50 ADB	70,0 2.756	50,0 1.969	151,8 5.976	3,3 7.280

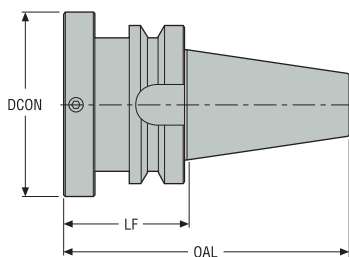
## Capăt spre mașină ANSI CAT



- Notă: Șuruburi incluse la livrare
- Bolț cu filet imperial

Reper Nr.	Număr reper	Con	DCON		LF		OAL		Greutate	
			mm	Inci	mm	Inci	mm	Inci	kg	lbs
SAH-2784940201	02836698	CAT 40	60,0	2.362	50,0	1.969	118,4	4.661	1,1	2.430
SAH-2784940202	02836702	CAT 40	80,0	3.150	55,0	2.165	123,4	4.858	1,5	3.310
SAH-2784940203	02836704	CAT 40	100,0	3.937	60,0	2.362	128,4	5.055	2,3	5.070
SAH-2784950201	02836707	CAT 50	60,0	2.362	50,0	1.969	151,8	5.976	3,1	6.830
SAH-2784950202	02836709	CAT 50	80,0	3.150	50,0	1.969	151,8	5.976	3,4	7.500
SAH-2784950203	02836710	CAT 50	100,0	3.937	60,0	2.362	161,8	6.370	5,5	12.130
SAH-2784950206	02836708	CAT 50	70,0	2.756	50,0	1.969	151,8	5.976	3,3	7.280

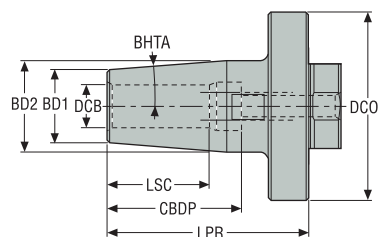
## Capăt spre mașină BT



- Notă: Șuruburi incluse la livrare

Reper Nr.	Număr reper	Con	DCON		LF		OAL		Greutate	
			mm	Inci	mm	Inci	mm	Inci	kg	lbs
SAH-2340740001	02836717	BT40 ADB	60,0	2.362	55,0	2.165	120,4	4.740	1,4	3.090
SAH-2340740002	02836719	BT40 ADB	80,0	3.150	65,0	2.559	130,4	5.134	2,0	4.410
SAH-2340740003	02836721	BT40 ADB	100,0	3.937	60,0	2.362	125,4	4.937	2,7	5.950
SAH-2340740004	02836718	BT40 ADB	70,0	2.756	55,0	2.165	120,4	4.740	1,5	3.310
SAH-2340750001	02836724	BT50 ADB	60,0	2.362	70,0	2.756	171,8	6.764	4,2	9.260
SAH-2340750002	02836725	BT50 ADB	70,0	2.756	70,0	2.756	171,8	6.764	4,4	9.700
SAH-2340750003	02836726	BT50 ADB	80,0	3.150	70,0	2.756	171,8	6.764	4,6	10.140
SAH-2340750004	02836727	BT50 ADB	100,0	3.937	70,0	2.756	171,8	6.764	4,9	10.800

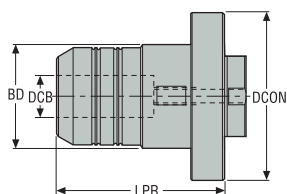
## Prindere Shrink-fit spre semifabricat



- Notă: Șuruburi de reglaj incluse la livrare

Reper Nr.	Număr reper	DCON	BD2	BD1	DCB	LSC	CBDP	LPR	Greutate	BHTA°
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
SAH-2341006235	02836735	60,0 2.362	27,0 1.063	21,0 0.827	6,0 0.236	22,0 0.866	37,5 1.476	70,0 2.756	0,5 1.100	4,5
SAH-2341010237	02836736	60,0 2.362	32,0 1.260	24,0 0.945	10,0 0.394	31,0 1.220	42,5 1.673	70,0 2.756	0,5 1.100	4,5
SAH-2341012238	02836737	60,0 2.362	32,0 1.260	24,0 0.945	12,0 0.472	34,0 1.339	47,5 1.870	70,0 2.756	0,52 1.150	4,5
SAH-2341016241	02836741	70,0 2.756	34,0 1.339	27,0 1.063	16,0 0.630	39,0 1.535	50,5 1.988	75,0 2.953	0,7 1.540	4,5
SAH-2341020251	02836742	80,0 3.150	42,0 1.654	33,0 1.299	20,0 0.787	41,0 1.614	52,5 2.067	80,0 3.150	1,0 2.200	4,5
SAH-2341025260	02836743	100,0 3.937	53,0 2.087	44,0 1.732	25,0 0.984	47,0 1.850	58,5 2.303	80,0 3.150	2,2 4.850	4,5
SAH-2341032261	02836744	100,0 3.937	53,0 2.087	44,0 1.732	32,0 1.260	51,0 2.008	62,5 2.461	80,0 3.150	2,5 5.510	4,5

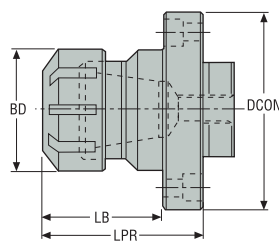
## Prindere hidraulică spre semifabricat



• Notă: Șuruburi de reglaj incluse la livrare

Reper Nr.	Număr reper	DCON	BD	DCB	LPR	Greutate
		mm Inci	mm Inci	mm Inci	mm Inci	kg lbs
SAH-2341112255	02836752	80,0 3.150	32,0 1.260	12,0 0.472	77,5 3.051	1,1 2.430
SAH-2341112259	02836757	100,0 3.937	32,0 1.260	12,0 0.472	90,0 3.543	1,9 4.190
SAH-2341116253	02836749	70,0 2.756	38,0 1.496	16,0 0.630	50,0 1.969	0,75 1.650
SAH-2341116256	02836754	80,0 3.150	38,0 1.496	16,0 0.630	82,5 3.248	1,2 2.650
SAH-2341120257	02836755	80,0 3.150	42,0 1.654	20,0 0.787	82,5 3.248	1,3 2.870
SAH-2341125258	02836756	80,0 3.150	50,0 1.969	25,0 0.984	90,0 3.543	1,7 3.750
SAH-2341125260	02836758	100,0 3.937	50,0 1.969	25,0 0.984	100,0 3.937	2,8 6.170
SAH-2341132261	02836759	100,0 3.937	60,0 2.362	32,0 1.260	103,0 4.055	2,9 6.390

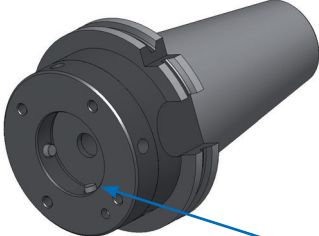
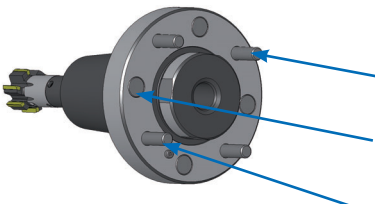
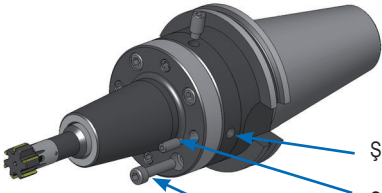
## Prindere spre semifabricat cu pensete ER



- Notă: Șuruburi de reglaj incluse la livrare

Reper Nr.	Număr reper	Mărime	DCON	BD	LB	LPR	Greutate
			mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	kg <i>lbs</i>
SAH-23412ER25254	02836762	ER25	80,0 3.150	42,0 1.654	45,0 1.772	60,0 2.362	1,0 2.200
SAH-23412ER32255	02836763	ER32	80,0 3.150	50,0 1.969	45,0 1.772	60,0 2.362	1,2 2.650
SAH-23412ER40256	02836764	ER40	100,0 3.937	63,0 2.480	50,0 1.969	70,0 2.756	1,6 3.530

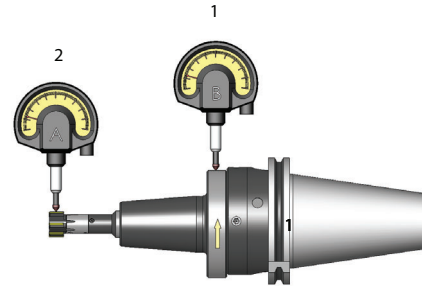
## Instrucțiuni de asamblare

 <p>Șuruburi de reglare radială</p>	<ul style="list-style-type: none"> <li>• Curățați suprafața de contact</li> <li>• Asigurați-vă că șuruburile de reglare radială nu încurcă asamblarea</li> </ul>	Introducere
 <p>Șurub de prindere Șuruburi de reglare unghiulară Știft de corectare (opțional)</p>	<ul style="list-style-type: none"> <li>• Asigurați-vă că șuruburile de reglare unghiulară nu încurcă asamblarea</li> </ul>	Găurire
 <p>Șuruburi de reglare radială (4 buc.) Șuruburi de reglare unghiulară (4 buc.) Șuruburi de prindere (4 buc.)</p>	<ul style="list-style-type: none"> <li>• Treceți la asamblare și strângeți ușor șuruburile de prindere (x4)</li> </ul>	Alezare
		Alezare adâncă
		Anexă

## Instrucțiuni de reglare

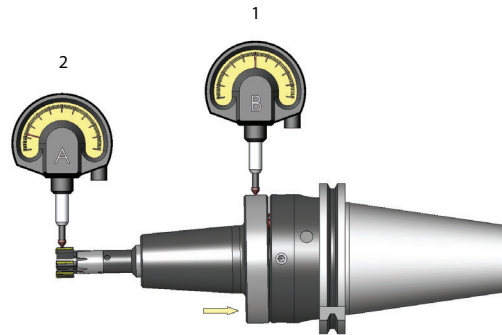
Introducere

- Montați scula în capul de alezare al utilajului
- Reglați comparatorul 1 după cum este indicat (comparatorul 2 nu este necesar acum)
- Rotiți manual scula până se ajunge la punctul cel mai de jos
- Treceți la compensarea bătaii radiale, după cum indică săgeata
- Verificați și repetați compensarea, dacă este nevoie



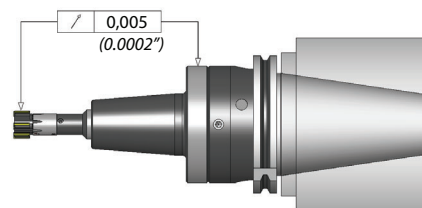
Găurire

- Reglați comparatorul 2 după cum este indicat
- Rotiți manual scula până se ajunge la punctul cel mai de jos
- Treceți la compensarea bătaii radiale, după cum indică săgeata
- Verificați și repetați compensarea, dacă este nevoie



Alezare

- După ce ați terminat reglarea, bătaia radială <math>< 5 \mu\text{m}</math> (- Adaptorul reglabil poate fi presetat neatășat la utilaj, utilizând orice dispozitiv de presetare a sculelor disponibil în atelier
- Reglarea finală trebuie efectuată întotdeauna pe capul de alezare al utilajului
- Trebuie utilizat un comparator în microni. Se poate utiliza un singur comparator pentru ambele operații



Alezare atâncă

Anexă



## Privire generală

Se recomandă utilizarea unei port-scule Seco cu autocentrare

- Când bătaia radială depășește 0,02 mm (0,0008")
- Pentru scule staționare

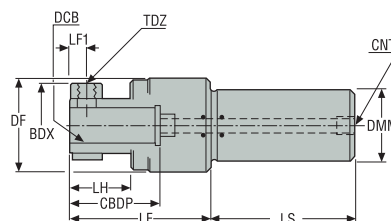
<p><b>Seria compactă GV pentru viteze mari</b></p> <ul style="list-style-type: none"> <li>• Prima alegere pentru scule rotative</li> <li>• Nu necesită reglare (presetare din fabrică)</li> <li>• Turație de până la 3000 rotații pe minut, în funcție de aplicație</li> <li>• Adecvată pentru aplicații statice</li> </ul>	
<p><b>Seria compactă</b></p> <ul style="list-style-type: none"> <li>• Prima alegere pentru scule statice</li> <li>• Doar cu reglare radială</li> <li>• Adecvată pentru aplicații rotative – max. 800 rotații pe minut</li> </ul>	
<p><b>Seria normală</b></p> <ul style="list-style-type: none"> <li>• Atunci când este necesară corecție unghiulară și radială</li> <li>• Adecvată pentru aplicații rotative – max. 800 rotații pe minut</li> </ul>	

Toate port-sculele cu autocentrare pentru agent de răcire complet.  
2 tipuri de admisie a lichidului de răcire disponibile.

JJL: intrare laterală  
JJ: prin coadă

Manual de utilizare inclus în livrare.

## Seria compactă GV pentru viteze mari

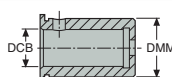


Număr reper	Reper Nr.	DCB	DMM	LF	LS	DF	BDX	LH	CBDP	CNT	LF1	TDZ	ADJRG	Greutate
		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg
00088959	SFH-GV11019JJ	10,0	19,05	47,5	40,0	33,0	30,0	11,5	25,0	1/8	5,5	M6	0,2	0,7
00088945	SFH-GV11020JJ	10,0	20,0	47,5	40,0	33,0	30,0	11,5	25,0	1/8	5,5	M6	0,2	0,8
00076815	SFH-GV21619JJ	16,0	19,05	66,0	50,0	49,5	39,0	24,5	40,0	1/8	8,0	M8	0,2	0,8
00072133	SFH-GV21620JJ	16,0	20,0	66,0	50,0	49,5	39,0	24,5	40,0	1/8	8,0	M8	0,2	0,8
00076827	SFH-GV22019JJ	20,0	19,05	76,0	50,0	49,5	45,0	34,5	50,0	1/8	8,0	M8	0,2	0,8
00072134	SFH-GV22020JJ	20,0	20,0	76,0	50,0	49,5	45,0	34,5	50,0	1/8	8,0	M8	0,2	0,8
00076828	SFH-GV32525JJ	25,0	25,4	89,0	60,0	62,0	52,0	43,5	60,0	1/4	11,0	M10	0,3	1,4
00072135	SFH-GV32525MJJ	25,0	25,0	89,0	60,0	62,0	52,0	43,5	60,0	1/4	11,0	M10	0,3	1,4
00088960	SFH-GV325425JJ	25,4	25,4	89,0	60,0	62,0	52,0	43,5	60,0	1/4	11,0	M10	0,3	1,4
02602671	SFH-GV43232JJ	32,0	32,0	90,0	80,0	72,0	60,0	34,0	60,0	3/8	9,0	M10	0,3	2,2

### Accesorii

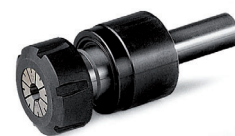
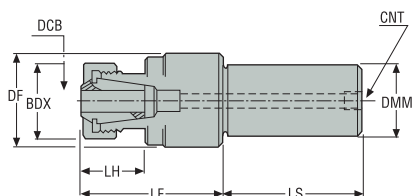
Reper Nr.

Inel de reducție



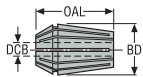

	DCB	DMM
SRR-BR11016	10	16
SRR-BR11216	12	16
SRR-BR11220	12	20
SRR-BR21620	16	20
SRR-BR31625	16	25
SRR-BR32025	20	25
SRR-GV42532	25	32

## Seria compactă GV pentru viteze mari cu bucășă elastică



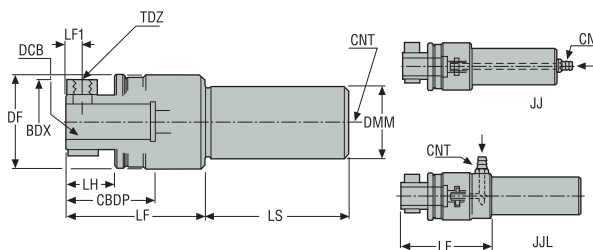
Număr reper	Reper Nr.	CZC	DMM	LF	LS	DF	BDX	LH	CNT	ADJRG	Greutate
			mm	mm	mm	mm	mm	mm		mm	kg
00088946	SFH-GV3BC25MJJ	ER32	25,0	80,0	60,0	62,0	50,0	35,0	1/4	0,3	1,3
00088961	SFH-GV3BC25JJ	ER32	25,4	80,0	60,0	62,0	50,0	35,0	1/4	0,3	1,3
00088962	SFH-GV4BC31JJ	ER40	31,75	94,0	80,0	72,0	63,0	39,0	3/8	0,3	0,7
00088947	SFH-GV4BC32JJ	ER40	32,0	94,0	80,0	72,0	63,0	39,0	3/8	0,3	2,4

### Accesorii

Reper Nr.	Mărimea	Bucșă*	Mărimea	Cheie fixă*		
						
		DCB	BD	OAL		
58803210	ER32	10	33	40	ER32	03B587532
58803212	ER32	12	33	40	-	-
58803213	ER32	13	33	40	-	-
58803216	ER32	16	33	40	-	-
58803220	ER32	20	33	40	-	-
58804016	ER40	16	41	46	ER40	03B537540
58804020	ER40	20	41	46	-	-
58804025	ER40	25	41	46	-	-
58804026	ER40	26	41	46	-	-

\*Bucșele și cheile nu sunt livrate împreună cu mandrina.

## Seria compactă

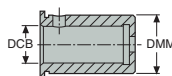


Număr reper	Reper Nr.	DCB	DMM	LF	LS	DF	BDX	LH	CBDP	CNT	LF1	TDZ	ADJRG	Greutate
		mm	mm	mm	mm	mm	mm	mm	mm		mm		mm	kg
00088963	SFH-C01019JJ	10,0	19,05	44,5	40,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,575
00088964	SFH-C01019JJL	10,0	19,05	62,0	60,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,575
00088965	SFH-C21619JJL	16,0	19,05	87,0	60,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	1,1
00076829	SFH-C21619CJJ	16,0	19,05	67,5	50,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	0,97
00088966	SFH-C22019JJL	20,0	19,05	97,0	70,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	1,1
00076830	SFH-C22019CJJ	20,0	19,05	77,5	50,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	0,97
00088948	SFH-C01020JJ	10,0	20,0	44,5	40,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,59
00088949	SFH-C01020JJL	10,0	20,0	62,0	60,0	38,5	30,0	11,0	25,0	1/8	6,0	M6	1,0	0,59
00088950	SFH-C21620JJL	16,0	20,0	87,0	60,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	1,1
00072142	SFH-C21620CJJ	16,0	20,0	67,5	50,0	51,5	34,0	17,0	40,0	1/4	8,0	M6	1,5	0,97
00072145	SFH-C22020CJJ	20,0	20,0	77,5	50,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	1,0
00088951	SFH-C22020JJL	20,0	20,0	97,0	60,0	51,5	44,0	27,0	50,0	1/4	8,0	M8	1,5	1,1
00076846	SFH-C32525JJ	25,0	25,4	90,0	110,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,7
00088967	SFH-C32525JJL	25,0	25,4	125,0	70,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,98
00072149	SFH-C32525MJJ	25,0	25,0	90,0	110,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,7
00088952	SFH-C32525MJL	25,0	25,0	125,0	70,0	59,5	50,0	31,0	60,0	3/8	11,0	M8	1,5	1,98

### Accesorii

Reper Nr.

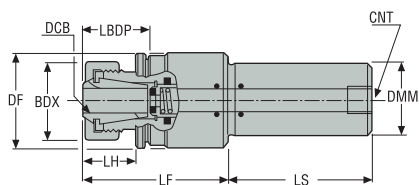
Inel de reducere



	DCB	DMM
SRR-BR11016	10	16
SRR-BR11216	12	16
SRR-BR11220	12	20
SRR-BR21620	16	20
SRR-BR31625	16	25
SRR-BR32025	20	25

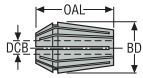

Adaptorul pentru furtun nu este inclus în pachetul de livrare.

## Seria compactă cu bușă elastică



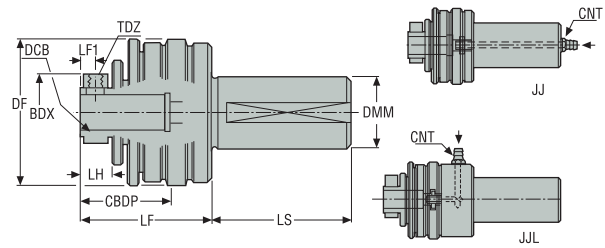
Număr reper	Reper Nr.	CZC	DMM	LF	LS	DF	BDX	CBDP	LH	CNT	ADJRG	Greutate
			mm	mm	mm	mm	mm	mm	mm		mm	kg
00088953	SFH-C65BC25MCJJ	ER32	25,0	94,0	50,0	64,5	50,0	42,0	33,0	3/8	1,5	1,7
00088968	SFH-C65BC25CJJ	ER32	25,4	94,0	50,0	64,5	50,0	42,0	33,0	3/8	1,5	1,7

### Accesorii

Reper Nr.	Mărimea	Bușă*	Mărimea	Cheie fixă*		
						
		DCB	BD	OAL		
58803210	ER32	10	33	40	ER32	03B587532
58803212	ER32	12	33	40	-	-
58803213	ER32	13	33	40	-	-
58803216	ER32	16	33	40	-	-
58803220	ER32	20	33	40	-	-
58804016	ER40	16	41	46	ER40	03B537540
58804020	ER40	20	41	46	-	-
58804025	ER40	25	41	46	-	-
58804026	ER40	26	41	46	-	-

\*Bușele și cheile nu sunt livrate împreună cu mandrina.

## Seria normală

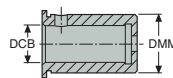


Număr reper	Reper Nr.	DCB	DMM	LF	LS	DF	BDX	LH	CBDP	CNT	LF1	TDZ	ADJRG	ANADJ	Greutate
		mm	mm	mm	mm	mm	mm	mm	mm		mm		mm		kg
00088969	SFH-11619JJ	16,0	19,05	64,0	50,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	0,9
00088970	SFH-11619JJL	16,0	19,05	81,0	40,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	1,32
00088954	SFH-11620JJ	16,0	20,0	64,0	50,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	0,95
00088955	SFH-11620JJL	16,0	20,0	81,0	40,0	62,0	34,0	16,0	40,0	1/4	8,0	M6	1,5	1,0 °	1,34
00088971	SFH-22025JJ	20,0	25,4	74,0	65,0	82,0	44,0	16,0	50,0	3/8	8,0	M8	1,5	1,0 °	1,9
00088972	SFH-22025JJL	20,0	25,4	98,0	70,0	82,0	44,0	16,0	50,0	1/4	8,0	M8	1,5	1,0 °	2,2
00088956	SFH-22025MJJ	20,0	25,0	74,0	65,0	82,0	44,0	16,0	50,0	3/8	8,0	M8	1,5	1,0 °	1,9
00088957	SFH-22025MJJL	20,0	25,0	98,0	70,0	82,0	44,0	16,0	50,0	1/4	8,0	M8	1,5	1,0 °	2,2
00088973	SFH-32525JJ	25,0	25,4	82,5	110,0	91,0	52,0	22,0	60,0	3/8	11,0	M8	2,0	1,0 °	2,5
00088958	SFH-32525MJJ	25,0	25,0	82,5	110,0	91,0	52,0	22,0	60,0	3/8	11,0	M8	2,0	1,0 °	2,5

### Accesorii

Reper Nr.

Inel de reducere



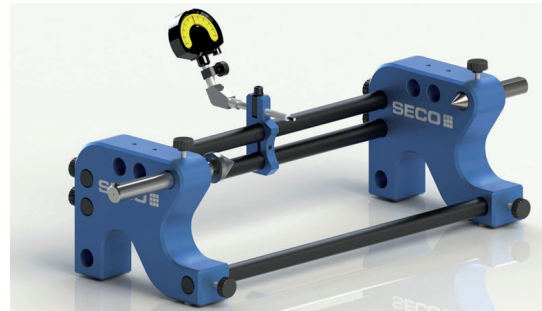
	DCB	DMM
SRR-BR11016	10	16
SRR-BR11216	12	16
SRR-BR11220	12	20
SRR-BR21620	16	20
SRR-BR31625	16	25
SRR-BR32025	20	25

Adaptorul pentru furtun nu este inclus în pachetul de livrare.

## Prindere de reglare – comparator unic

**SF-210340-C160: Nr. reper pt. comandă 02885391**

- Stand orizontal
- Prima alegere pentru alezările Xfix
- 1 comparator
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 340 mm (13,386")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare

**SF-210290V-C160: Nr. reper pt. comandă 02885392**

- Stand vertical
- Prima alegere pentru alezările Xfix
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 290 mm (11,417")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare



## Prindere de reglare – comparator dublu

**SF-210340-C160C190: Nr. reper pt. comandă 02885393**

- Stand orizontal
- Prima alegere pentru alezările Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 340 mm (13,386")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare

**SF-210290V-C160C190: Nr. reper pt. comandă 02885394**

- Stand vertical
- Prima alegere pentru alezările Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 290 mm (11,417")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare



Pentru informații despre comandare, contactați reprezentantul local Seco Tools.

## Prindere de reglare – comparator unic de mare capacitate

**SF-210740-C160: Nr. reper pt. comandă 02885385**

- Stand orizontal
- Prima alegere pentru alezările Xfix
- 1 comparator
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 740 mm (29,134")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare

**SF-210690V-C160: Nr. reper pt. comandă 02885387**

- Stand vertical
- Prima alegere pentru alezările Xfix
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 690 mm (27,165")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare



## Prindere de reglare – comparator dublu de mare capacitate

**SF-210740-C160C190: Nr. reper pt. comandă 02885388**

- Stand orizontal
- Prima alegere pentru alezările Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 740 mm (29,134")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare

**SF-210690V-C160C190: Nr. reper pt. comandă 02885390**

- Stand vertical
- Prima alegere pentru alezările Bifix
- 2 comparatoare
- Ø maxim al sculei: 210 mm (8,268")
- Lungime maximă a sculei: 690 mm (27,165")
- În plus Ø 57 mm (2,244") centrare cu arc pentru HSK 63/80/100 și Capto C8 Punct central SSC5700 inclus la livrare



Pentru informații despre comandare, contactați reprezentantul local Seco Tools.



## Prindere de reglare – compact

**SF-60200-C160: Nr. reper pt. comandă 02885395**

- Stand orizontal
- Prima alegere pentru  $\varnothing$  mai mici de 60 mm (2,362")
- 1 comparator
- $\varnothing$  maxim al sculei: 60,5 mm (82,382")
- Lungime maximă a sculei: 200 mm (7,874")

**SF-60200-C160C190: Nr. reper pt. comandă 02885396**

- Stand orizontal
- Prima alegere pentru  $\varnothing$  mai mici de 60 mm (2,362")
- 2 comparatoare
- $\varnothing$  maxim al sculei: 60,5 mm (82,382")
- Lungime maximă a sculei: 200 mm (7,874")



Pentru informații despre comandare, contactați reprezentantul local Seco Tools.

## Brațe de măsurare suplimentare

	<p><b>SFB-60: Nr. reper pt. comandă 02208619</b></p> <ul style="list-style-type: none"> <li>• Braț de măsurare 60°</li> <li>• Ceas comparator inclus în livrare</li> <li>• Vârful de măsurare nu este inclus, consultați pagina 489</li> </ul>
	<p><b>SFB-60 WC: Nr. reper pt. comandă 02885754</b></p> <ul style="list-style-type: none"> <li>• Braț de măsurare 60°</li> <li>• Ceas comparator inclus în livrare</li> <li>• Vârful de măsurare nu este inclus, consultați pagina 489</li> </ul>
	<p><b>SFB-90: Nr. reper pt. comandă 02208622</b></p> <ul style="list-style-type: none"> <li>• Braț de măsurare 90°</li> <li>• Ceas comparator inclus în livrare</li> <li>• Vârful de măsurare nu este inclus, consultați pagina 489</li> </ul>
	<p><b>SFB-90 WC: Nr. reper pt. comandă 02885755</b></p> <ul style="list-style-type: none"> <li>• Braț de măsurare 90°</li> <li>• Ceas comparator inclus în livrare</li> <li>• Vârful de măsurare nu este inclus, consultați pagina 489</li> </ul>
	<p><b>DG-1: Nr. reper pt. comandă 75079579</b></p> <ul style="list-style-type: none"> <li>• Ceas comparator, 1 <math>\mu\text{m}</math> (39 <math>\mu\text{in}</math>)</li> </ul>

## Exemplu de ansamblu de fixare cu mai multe comparatoare



## Accesorii

	<p><b>SMES-406: Nr. reper pt. comandă 02819156</b></p> <ul style="list-style-type: none"> <li>• Punct de măsurare pentru alezoare Xfix</li> <li>• Ø 4mm (0,157")</li> <li>• Cu vârf din carbură</li> </ul>
	<p><b>SMES-900: Nr. reper pt. comandă 02208610</b></p> <ul style="list-style-type: none"> <li>• Vârf de măsurare pentru alezoarele Bifix</li> <li>• Cu vârf din carbură</li> </ul>
	<p><b>SMES-909: Nr. reper pt. comandă 02980090</b></p> <ul style="list-style-type: none"> <li>• Punct de măsurare pentru alezoare Bifix</li> <li>• Cu vârf din carbură</li> <li>• 9 mm (0,354") decalat</li> </ul>
	<p><b>SMES-915: Nr. reper pt. comandă 02208616</b></p> <ul style="list-style-type: none"> <li>• Punct de măsurare pentru alezoare Bifix</li> <li>• Cu vârf din carbură</li> <li>• 15 mm (0,591") decalat</li> </ul>
	<p><b>SFHS-20: Nr. reper pt. comandă 02884025</b></p> <ul style="list-style-type: none"> <li>• Șurub pentru fixare manuală</li> <li>• Adecvat pentru întreaga gamă de prindere de reglare</li> </ul>
	<p><b>SFVST-100: Nr. reper pt. comandă 02884026</b></p> <ul style="list-style-type: none"> <li>• Stand din oțel (set de 3)</li> <li>• Ø 100 mm (3,937")</li> <li>• Adecvat pentru a schimba prinderea de reglare orizontală la poziție verticală</li> </ul>

## Vârfuri de centrare

Introducere

Găurire

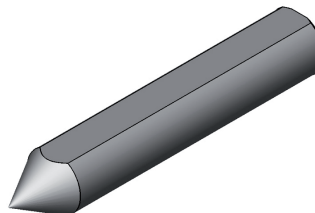
Alezare

Alezare atâncă

Anexă

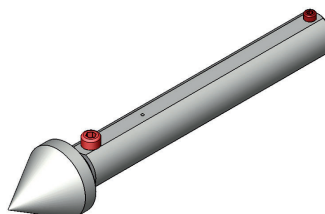
**SFC-2000HM: Nr. reper pt. comandă 02884023**

- Punct central fix din carbură
- Ø 20 mm (0,787")
- Adecvat pentru gamele Xfix și Bifix standard și speciale
- A se utiliza în partea frontală a sculei



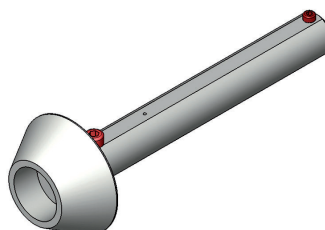
**SSC-3400: Nr. reper pt. comandă 02208617**

- Punct central cu arc
- Ø 34 mm (1,339")
- Adecvat pentru gamele Xfix și Bifix standard și speciale
- A se utiliza în partea posterioară a sculei
- Nu este adecvat pentru HSK63/80/100 și Capto C8



**SSC5700: Nr. reper pt. comandă 02208620**

- Punct central cu arc
- Trunchi de con Ø 57 mm (2,244")
- Adecvat pentru gamele Xfix și Bifix standard și speciale
- A se utiliza în partea posterioară a sculei
- Adecvat pentru HSK63/80/100 și Capto C8



## CAPETE DE ALEZAT



# CAPETE DE ALEZARE DE DEGROȘARE ȘI DE PRECIZIE, CONCEPTE PENTRU FLEXIBILITATE ȘI REZULTATE EXCELENTE

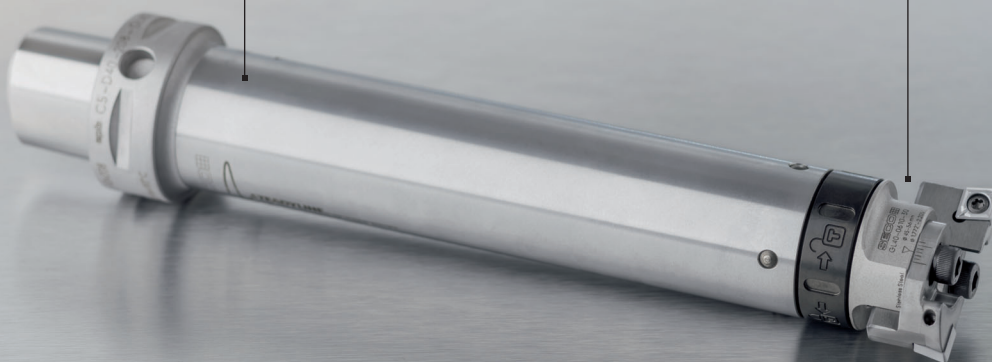
Seco oferă o gamă largă de capete de alezare cu conexiuni Graflex® și Seco-Capto™ pe partea utilajului. Capetele de alezare de degroșare oferă ansambluri robuste și rigide pentru a asigura rate ridicate de evacuare a materialului și va permite precizia geometrică a găurii, începând cu găuri turnate, tăiate cu flacără sau perforate. Capetele de alezare de precizie setează precizii de până la  $2,5 \mu\text{m}$  ( $98,43 \mu\text{in}$ ) în diametru, asigurând o finisare excelentă a suprafeței și toleranțe IT5 foarte mici.

### PORT-SCULE ASOCIATE

- Sisteme modulare Graflex® și Seco-Capto™ pentru ansambluri optimizate și polivalente
- Soluții Steadyline® de amortizare a vibrațiilor disponibile pentru performanțe excelente la aplicații de găurire adâncă

### CAPETE DE ALEZAT

- Diametrele variază între 0,3 mm și 3205 mm ( $0,0118''$  până la  $126,181''$ )
- Capete de alezare de degroșare, pentru rate de evacuare ridicate
- Capete de alezare de precizie pentru înaltă precizie, până la IT5, cu finisare excelentă a suprafeței



## Privire generală

### Graflex® and Seco-Capto™

Graflex® and Seco-Capto™ arbors, extensions and reducers to build boring bars



Page(s) 494-553, 554

- Boring bars assemblies can be rapidly built together to the closest required needs, either by using the Graflex or the Seco-Capto modular systems including a wide range of arbors and intermediaries.
- Both systems offer a rigid and precise connection to be used for roughing applications or finishing holes.
- The modules can also receive a large number of tool holders like collet chucks, hydro chucks etc. (see Tooling systems catalog).

### Capete de alezare RB750, alezare de degroșare

Cap de alezare cu două port-plăcuțe cu mecanism de cuplare



Pag. 560-566

- Rată mare de îndepărtare a materialului, geometrie și poziționare precise ale găurii
- Setare simetrică și alternantă
- Reglare simultană datorită mecanismului de cuplare a suporturilor de plăcuță
- Cu conexiuni Graflex® sau Seco-Capto™

Interval de diametre între 18 mm și 205 mm  
(0,709 și 8,071")

IT 9/10

### Capete de alezare RB 610, alezare de degroșare

Capete de așchiere pereche



Pag. 572-575

- Rată mare de îndepărtare a materialului, geometrie și poziționare precise ale găurii
- Setare simetrică și alternantă
- Cu conexiune Graflex® pentru sistem modular Graflex®
- Cu conexiune GL sau BA pentru bare antivibrații Steadyline®

Interval de diametre între 28 mm și 116 mm  
(1,102 și 4,567")

IT 9/10

### Capete de alezare FB 760, tip Axiabore™, alezare de precizie

Capete de alezat de finisare, cu scule montate axial



Pag. 583-594

- Reglare micrometrică pentru o precizie a găurii de până la IT5
- Rigiditate mare a sculei pentru poziționare și geometrie precise ale găurii
- Cap Nanobore™ pentru diametre mai mici
- Axialibabore™ și - Axialibabore™ Plus - pot fi echilibrate de precizie, adecvate HSM
- Adaptor multifuncțional (MPA) pentru diametre de alezare mai mari, teșire a muchilor OD și canelare
- Cu conexiuni Graflex® sau Seco-Capto™

Interval de diametre între 0,3 și 108 mm  
(0,012 și 4,252")

+ teșire a muchilor OD și prelucrare canale frontale

IT 5/6

## Privire generală

## Capete de alezare FB 620, FB 780 și FB 790, tip radial

## Capete de alezare fină, cu port-plăcuțe radiale



Pag. 613-621

- Reglare micrometrică pentru o precizie a găurii de până la IT5
- Poziționare și geometrie precise ale găurii
- Capetele A790 Libraflex® pot fi echilibrate cu precizie, suport de plăcuță adecvat HSM, pentru cea mai înaltă fiabilitate
- Se pot executa alezaje lungi, cu extensii din carbură (până la 7xD) sau cu bare Steadyline® (până la 10xD)
- Se pot utiliza la șanfenare sau alezare inversă
- Cu conexiuni Graflex® sau Seco-Capto™ pentru sisteme modulare
- Cu conexiune GL sau BA pentru barele antivibrații Steadyline®

Interval de diametre între 15 mm și 205 mm  
(0,591 și 8,071")

IT 5/6

## Traverse de alezat și capete de alezare mari

## Pentru degroșarea și alezarea fină a diametrelor mari



Pag. 623-640

- Blocuri de alezare pentru alezare de degroșare și de precizie, teșire a muchiiilor OD și alezare inversă
- Model robust pentru o rată mare de îndepărtare a materialului la alezarea de degroșare
- Reglare micrometrică pentru alezare de precizie
- Model optimizat de blocuri de alezat și bare de alezat mari realizate din aluminiu rezistent la efort pentru viteze mari
- Destinate instalării în suporturi de freză, tip de prindere cu flanșă

Interval de diametre între 204 și 3205 mm  
(8,031-126,181")IT 5/6 (alezare de precizie) sau  
9/10 (alezare de degroșare)  
+ teșire a muchiiilor

IT6

## Plăcuțe amovibile pentru alezare



Pag. 642-654

- Pentru operații de alezare în toate materialele
- Reziliență mare pentru degroșare
- Geometrii pozitive pentru finisare
- Calități pentru o durată mare de viață a sculei

## Sistem modular port-sculă Graflex® sau Seco-Capto™



Pag. 655-657

- Capetele de alezare dispun de coadă cu conexiune Graflex® sau Seco-Capto™ pe partea utilajului, permițând o gamă completă de lungimi și diametre de alezare
- Selectați arborii și intermediarele Graflex® sau Seco-Capto™ necesare din catalogul PORT-SCULE (HSK, DIN, BT, ANSI-CAT, Seco-Capto™)
- Piese de schimb pentru conexiunile Graflex® pentru capetele de alezare sunt prezentate în acel capitol



## Graflex®

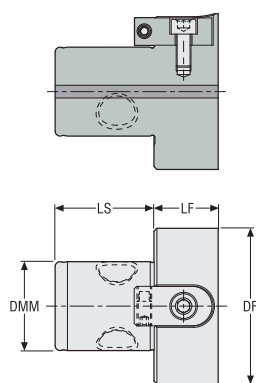
Ansamblurile Graflex® includ arbori, intermediare, port-scule și capete de alezare care pot fi asamblate rapid atunci când sunt necesare. Adecvate pentru frezare, găurire, filetare, alezare și alezare adâncă, modulele Graflex® oferă scule de lungimi și diametre variate și pot fi instalate pe toate tipurile de utilaje prin simpla înlocuire a arborelui de bază Graflex®.

- Rigiditate excelentă a conexiunii
- Gama largă de module oferă flexibilitate ridicată
- Posibilități de agent de răcire complet

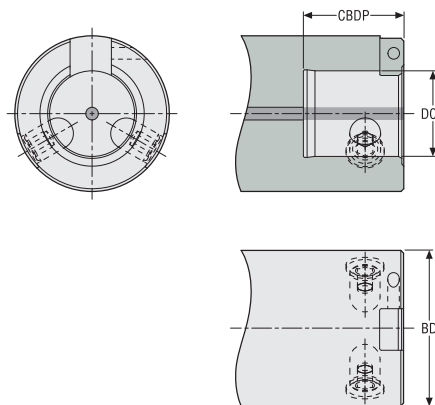


Graflex®, norme dimensionale

Spre mașină



Spre semifabricat



Descriere catalog partea dinspre mașină		Gaură pentru cip RFID*	DF	DMM	LS	LF
			mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>
G0	Nu		16 0.630	8 0.315	12 0.472	8 0.315
G1	Nu		20 0.787	11 0.433	13 0.512	9,5 0.374
G2	Nu		25 0.984	14 0.551	16 0.630	11 0.433
G3	Nu		32 1.260	18 0.709	20 0.787	14 0.551
G4	Nu		40 1.575	22 0.866	24 0.945	17 0.669
G5	Nu		50 1.969	28 1.102	30 1.181	20 0.787
G6	Nu		63 2.480	36 1.417	40 1.575	26 1.024
G7	Nu		90 3.543	46 1.811	50 1.969	26 1.024

Spre catalog partea dinspre mașină		Gaură pentru cip RFID*	CBDP	DCB	BD
			mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>
G0	Nu		16 0.630	8 0.315	12 0.472
G1	Nu		20 0.787	11 0.433	13 0.512
G2	Nu		25 0.984	14 0.551	16 0.630
G3	Nu		32 1.260	18 0.709	20 0.787
G4	Nu		40 1.575	22 0.866	24 0.945
G5	Nu		50 1.969	28 1.102	30 1.181
G6	Nu		63 2.480	36 1.417	40 1.575
G7	Nu		90 3.543	46 1.811	50 1.969

Introducere

Găuire

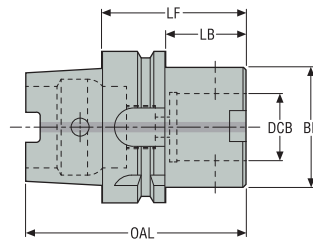
Alezare

Alezare adâncă

Anexă

## G 401 – Arbori Graflex®

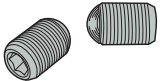
HSK-A/ ISO12164-1-HSK-A




- Pentru dopurile HSK, tuburi pentru lichid de răcire, și chei, vezi pag. 523

Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
EM93034012870	00086917	HSK-A50	G5	28,0 1.102	70,0 2.756	44,0 1.732	50,0 1.969	95,0 3.740	1	PB	0,79 1.740
EM93044011445	02469722	HSK-A63	G2	14,0 0.551	45,0 1.772	19,0 0.748	25,0 0.984	77,0 3.031	1	G6.3	0,69 1.520
EM93044011850	00086918	HSK-A63	G3	18,0 0.709	50,0 1.969	24,0 0.945	32,0 1.260	82,0 3.228	1	G6.3	0,73 1.610
EM93044012255	00088217	HSK-A63	G4	22,0 0.866	55,0 2.165	29,0 1.142	40,0 1.575	87,0 3.425	1	G6.3	0,83 1.830
EM93044012860	00086920	HSK-A63	G5	28,0 1.102	60,0 2.362	34,0 1.339	50,0 1.969	92,0 3.622	1	PB	0,98 2.160
EM930440128100	00086921	HSK-A63	G5	28,0 1.102	100,0 3.937	74,0 2.913	50,0 1.969	132,0 5.197	1	PB	1,58 3.480
EM930440128140	00086922	HSK-A63	G5	28,0 1.102	140,0 5.512	114,0 4.488	50,0 1.969	172,0 6.772	1	PB	2,18 4.810
EM93044013670	00086923	HSK-A63	G6	36,0 1.417	70,0 2.756	44,0 1.732	63,0 2.480	102,0 4.016	1	PB	1,21 2.670
EM930440136120	00086924	HSK-A63	G6	36,0 1.417	120,0 4.724	94,0 3.701	63,0 2.480	152,0 5.984	1	PB	2,38 5.250
EM93064011855	00086925	HSK-A100	G3	18,0 0.709	55,0 2.165	26,0 1.024	32,0 1.260	105,0 4.134	1	G6.3	2,1 4.630
EM93064012260	00086926	HSK-A100	G4	22,0 0.866	60,0 2.362	31,0 1.220	40,0 1.575	110,0 4.331	1	G6.3	2,19 4.830
EM93064012865	00086927	HSK-A100	G5	28,0 1.102	65,0 2.559	36,0 1.417	50,0 1.969	115,0 4.528	1	PB	2,37 5.220
EM930640128110	00086928	HSK-A100	G5	28,0 1.102	110,0 4.331	81,0 3.189	50,0 1.969	160,0 6.299	1	PB	3,02 6.660
EM930640128150	00086929	HSK-A100	G5	28,0 1.102	150,0 5.906	121,0 4.764	50,0 1.969	200,0 7.874	1	PB	3,7 8.160
EM93064013675	00083432	HSK-A100	G6	36,0 1.417	75,0 2.953	46,0 1.811	63,0 2.480	125,0 4.921	1	PB	2,6 5.730
EM930640136120	00086931	HSK-A100	G6	36,0 1.417	120,0 4.724	91,0 3.583	63,0 2.480	170,0 6.693	1	PB	3,82 8.420
EM930640136160	00086932	HSK-A100	G6	36,0 1.417	160,0 6.299	131,0 5.157	63,0 2.480	210,0 8.268	1	PB	4,72 10.410
EM93064014685	00074385	HSK-A100	G7	46,0 1.811	85,0 3.346	56,0 2.205	90,0 3.543	135,0 5.315	1	PB	3,99 8.800
EM930640146160	00086933	HSK-A100	G7	46,0 1.811	160,0 6.299	131,0 5.157	90,0 3.543	210,0 8.268	1	PB	7,67 16.910
HSKA125-G6-120	03229653	HSK-A125	G6	36,0 1.417	120,0 4.724	91,0 3.583	63,0 2.480	183,0 7.205	1	PB	5,1 11.240
HSKA125-G7-120	03229654	HSK-A125	G7	46,0 1.811	120,0 4.724	91,0 3.583	90,0 3.543	183,0 7.205	1	PB	7,1 15.650

## Piese de schimb

Pentru mărimea	Șurub ansamblu
	
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

## Accesorii

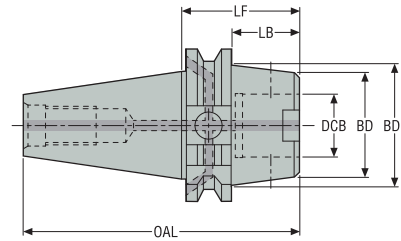
Pentru mărimea	Cheie de blocare
	
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

## G 401 – Arbori Graflex®

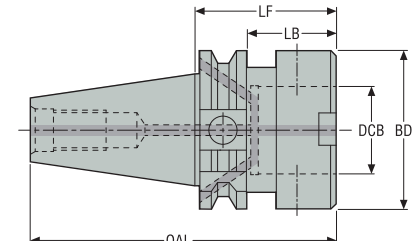
DIN 69871-ADB



Typ 1




Typ 2



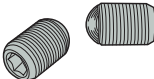

Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				mm Inci
EM34694011190	02503292	DIN40 ADB	G1	11,0 0.433	90,0 3.543	70,9 2.791	-	20,0 0.787	158,4 6.236	2	1	G6.3	0,94 2.070
EM34694011435	02469729	DIN40 ADB	G2	14,0 0.551	35,0 1.378	15,9 0.626	-	25,0 0.984	103,4 4.071	2	1	G6.3	0,83 1.830
EM34694011490	02503293	DIN40 ADB	G2	14,0 0.551	90,0 3.543	70,9 2.791	-	25,0 0.984	158,4 6.236	2	1	G6.3	1,02 2.250
EM34694011835	02420097	DIN40 ADB	G3	18,0 0.709	35,0 1.378	15,9 0.626	50,0 1.969	32,0 1.260	103,4 4.071	1	1	G6.3	0,91 2.010
EM346940118100	02503298	DIN40 ADB	G3	18,0 0.709	100,0 3.937	80,9 3.185	-	32,0 1.260	168,4 6.630	2	1	G6.3	1,22 2.690
EM34694012235	02503299	DIN40 ADB	G4	22,0 0.866	35,0 1.378	15,9 0.626	50,0 1.969	40,0 1.575	103,4 4.071	1	1	G6.3	0,92 2.030
EM346940122100	02503300	DIN40 ADB	G4	22,0 0.866	100,0 3.937	80,9 3.185	-	40,0 1.575	168,4 6.630	2	1	G6.3	1,44 3.170
EM34694012840	02458421	DIN40 ADB	G5	28,0 1.102	40,0 1.575	20,9 0.823	-	50,0 1.969	108,4 4.268	2	1	PB	0,93 2.050
EM34694012880	02503301	DIN40 ADB	G5	28,0 1.102	80,0 3.150	60,9 2.398	-	50,0 1.969	148,4 5.843	2	1	PB	1,5 3.310
EM346940128120	02503302	DIN40 ADB	G5	28,0 1.102	120,0 4.724	100,9 3.972	-	50,0 1.969	188,4 7.417	2	1	PB	2,08 4.590
EM34694013660	02503303	DIN40 ADB	G6	36,0 1.417	60,0 2.362	40,9 1.610	-	63,0 2.480	128,4 5.055	2	1	PB	1,24 2.730
EM346940136120	02503304	DIN40 ADB	G6	36,0 1.417	120,0 4.724	100,9 3.972	-	63,0 2.480	188,4 7.417	2	1	PB	2,65 5.840
EM347140114100	02503306	DIN50 ADB	G2	14,0 0.551	100,0 3.937	80,9 3.185	-	25,0 0.984	201,7 7.941	2	1	G6.3	2,8 6.170
EM34714011835	02503307	DIN50 ADB	G3	18,0 0.709	35,0 1.378	15,9 0.626	-	32,0 1.260	136,7 5.382	2	1	G6.3	2,67 5.890
EM347140118110	02503308	DIN50 ADB	G3	18,0 0.709	110,0 4.331	90,9 3.579	-	32,0 1.260	211,7 8.335	2	1	G6.3	3,0 6.610
EM34714012235	02503309	DIN50 ADB	G4	22,0 0.866	35,0 1.378	15,9 0.626	80,0 3.150	40,0 1.575	136,7 5.382	1	1	G6.3	2,88 6.350
EM347140122120	02503311	DIN50 ADB	G4	22,0 0.866	120,0 4.724	100,9 3.972	-	40,0 1.575	221,7 8.728	2	1	G6.3	3,5 7.720
EM34714012840	02503312	DIN50 ADB	G5	28,0 1.102	40,0 1.575	20,9 0.823	-	50,0 1.969	141,7 5.579	2	1	PB	2,75 6.060
EM347140128100	02503315	DIN50 ADB	G5	28,0 1.102	100,0 3.937	80,9 3.185	-	50,0 1.969	201,7 7.941	2	1	PB	3,56 7.850
EM347140128140	02503316	DIN50 ADB	G5	28,0 1.102	140,0 5.512	120,9 4.760	-	50,0 1.969	241,7 9.516	2	1	PB	4,08 8.990
EM34714013645	02503317	DIN50 ADB	G6	36,0 1.417	45,0 1.772	25,9 1.020	-	63,0 2.480	146,7 5.776	2	1	PB	2,88 6.350
EM347140136100	02503318	DIN50 ADB	G6	36,0 1.417	100,0 3.937	80,9 3.185	-	63,0 2.480	201,7 7.941	2	1	PB	4,1 9.040
EM347140136140	02503319	DIN50 ADB	G6	36,0 1.417	140,0 5.512	120,9 4.760	-	63,0 2.480	241,7 9.516	2	1	PB	4,99 11.000

Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
EM34714014650	02503320	DIN50 ADB	G7	46,0 1.811	50,0 1.969	30,9 1.217	–	90,0 3.543	151,7 5.972	2	1	PB	3,23 7.120
EM347140146120	02503321	DIN50 ADB	G7	46,0 1.811	120,0 4.724	100,9 3.972	–	90,0 3.543	221,7 8.728	2	1	PB	6,48 14.290
EM347140146200	02503324	DIN50 ADB	G7	46,0 1.811	200,0 7.874	180,9 7.122	–	90,0 3.543	301,7 11.878	2	1	PB	10,4 22.930

## Accesorii

Pentru mărimea	Cheie de blocare
	
DIN40/ G1	03H02
DIN40/ G2	03H025
DIN40/ G3	03H03
DIN40/ G4	03H04
DIN40/ G5	03H05
DIN40/ G6	03H06
DIN50/ G2	03H025
DIN50/ G3	03H03
DIN50/ G4	03H04
DIN50/ G5	03H05
DIN50/ G6	03H06
DIN50/ G7	03H10
EM34714014650	03H10

## Piese de schimb

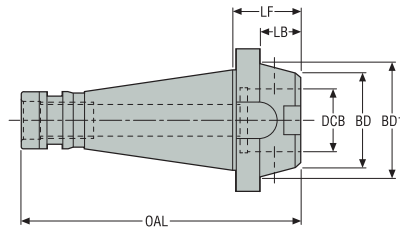
Pentru mărimea	Șurub ansamblu	Sealing Screws
		
DIN40/ G1	90F1	950A0406
DIN40/ G2	90F2	950A0406
DIN40/ G3	90F3	950A0406
DIN40/ G4	90F4	950A0406
DIN40/ G5	90F5	950A0406
DIN40/ G6	90F6	950A0406
DIN50/ G2	90F2	950A0606
DIN50/ G3	90F3	950A0606
DIN50/ G4	90F4	950A0606
DIN50/ G5	90F5	950A0606
DIN50/ G6	90F6	950A0606
DIN50/ G7	90F7	950A0606
EM34714014650	90F71	950A0606

## G 401 – Arbori Graflex®

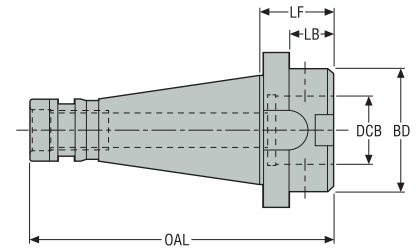
DIN 2080



Typ 1



Typ 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
EM00404013650	00076707	DIN(2080)40	G6	36,0 1.417	50,0 1.969	0,0 0.0	-	63,0 2.480	143,4 5.646	2	0	PB	1,27 2.800
EM00504012835	00076710	DIN(2080)50	G5	28,0 1.102	35,0 1.378	19,8 0.780	78,0 3.071	50,0 1.969	161,8 6.370	1	0	PB	2,94 6.480
EM00504013640	00076714	DIN(2080)50	G6	36,0 1.417	40,0 1.575	24,8 0.976	-	63,0 2.480	166,8 6.567	2	0	PB	2,82 6.220
EM00504014645	00076718	DIN(2080)50	G7	46,0 1.811	45,0 1.772	29,8 1.173	-	90,0 3.543	171,8 6.764	2	0	PB	3,34 7.360

### Accesorii

Pentru mărimea

Cheie de blocare



G5 03H05

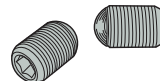
G6 03H06

G7 03H10

### Piese de schimb

Pentru mărimea

Șurub ansamblu



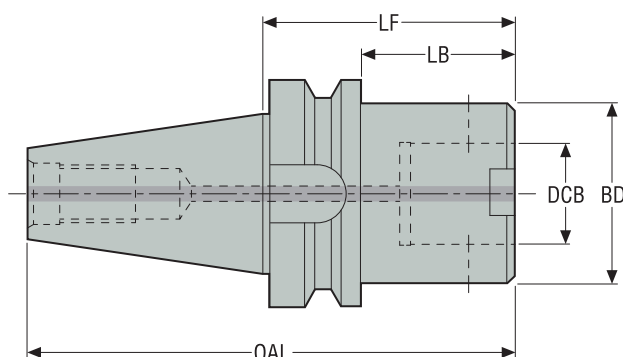
G5 90F5

G6 90F6

G7 90F7

## G 401 – Arbori Graflex®

BT JIS B 6339-AD



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
EM40404011835	00056699	BT30 AD	G3	18,0 0.709	35,0 1.378	13,0 0.512	32,0 1.260	83,4 3.283	0	G6.3	0,41 0.900
EM40404012850	00056705	BT30 AD	G5	28,0 1.102	50,0 1.969	25,0 0.984	50,0 1.969	98,4 3.874	0	PB	0,62 1.370

### Accesorii

Pentru

Cheie de blocare



EM40404011835

03H03

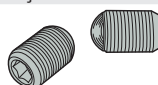
EM40404012850

03H05

### Piese de schimb

Pentru

Șurub ansamblu



EM40404011835

90F3

EM40404012850

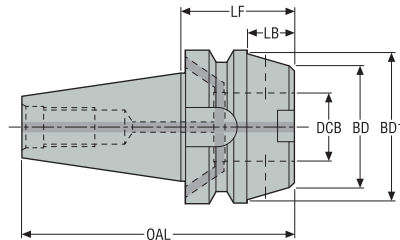
90F5

## G 401 – Arbori Graflex®

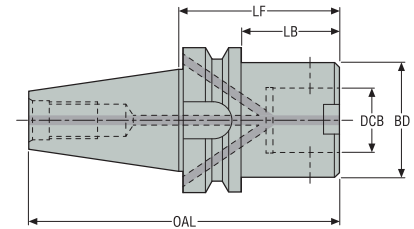
BT JIS B 6339-ADB



Typ 1



Typ 2




Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
EM34144011190	02503364	BT40 ADB	G1	11,0 0.433	90,0 3.543	63,0 2.480	-	20,0 0.787	155,4 6.118	2	1	G6.3	1,06 2.340
EM34144011440	02469725	BT40 ADB	G2	14,0 0.551	40,0 1.575	13,0 0.512	-	25,0 0.984	105,4 4.150	2	1	G6.3	0,98 2.160
EM34144011490	02503365	BT40 ADB	G2	14,0 0.551	90,0 3.543	63,0 2.480	-	25,0 0.984	155,4 6.118	2	1	G6.3	1,15 2.540
EM34144011840	02503366	BT40 ADB	G3	18,0 0.709	40,0 1.575	13,0 0.512	62,0 2.441	32,0 1.260	105,4 4.150	1	1	G6.3	1,07 2.360
EM341440118100	02503367	BT40 ADB	G3	18,0 0.709	100,0 3.937	73,0 2.874	-	32,0 1.260	165,4 6.512	2	1	G6.3	1,31 2.890
EM34144012245	02503368	BT40 ADB	G4	22,0 0.866	45,0 1.772	18,0 0.709	62,0 2.441	40,0 1.575	110,4 4.346	1	1	G6.3	1,14 2.510
EM341440122100	02503370	BT40 ADB	G4	22,0 0.866	100,0 3.937	73,0 2.874	-	40,0 1.575	165,4 6.512	2	1	G6.3	1,54 3.400
EM34144012845	02457989	BT40 ADB	G5	28,0 1.102	45,0 1.772	18,0 0.709	62,0 2.441	50,0 1.969	110,4 4.346	1	1	PB	1,12 2.470
EM34144012880	02503371	BT40 ADB	G5	28,0 1.102	80,0 3.150	53,0 2.087	-	50,0 1.969	145,4 5.724	2	1	PB	1,54 3.400
EM341440128120	02503372	BT40 ADB	G5	28,0 1.102	120,0 4.724	93,0 3.661	-	50,0 1.969	185,4 7.299	2	1	PB	2,12 4.670
EM34144013650	02503373	BT40 ADB	G6	36,0 1.417	50,0 1.969	0,0 -	-	63,0 2.480	115,4 4.543	2	0	PB	1,13 2.490
EM341440136120	02503374	BT40 ADB	G6	36,0 1.417	120,0 4.724	0,0 -	-	63,0 2.480	185,4 7.299	2	1	PB	2,78 6.130
EM341640114110	02503375	BT50 ADB	G2	14,0 0.551	110,0 4.331	72,0 2.835	-	25,0 0.984	211,8 8.339	2	1	G6.3	3,7 8.160
EM34164011845	02503376	BT50 ADB	G3	18,0 0.709	45,0 1.772	7,0 0.276	70,0 2.756	32,0 1.260	146,8 5.780	1	1	G6.3	3,58 7.890
EM341640118120	02503377	BT50 ADB	G3	18,0 0.709	120,0 4.724	82,0 3.228	-	32,0 1.260	221,8 8.732	2	1	G6.3	3,9 8.600
EM34164012250	02503378	BT50 ADB	G4	22,0 0.866	50,0 1.969	12,0 0.472	70,0 2.756	40,0 1.575	151,8 5.976	1	1	G6.3	3,66 8.070
EM341640122140	02503379	BT50 ADB	G4	22,0 0.866	140,0 5.512	102,0 4.016	-	40,0 1.575	241,8 9.520	2	1	G6.3	4,5 9.920
EM34164012855	02503380	BT50 ADB	G5	28,0 1.102	55,0 2.165	17,0 0.669	98,0 3.858	50,0 1.969	156,8 6.173	1	1	PB	4,0 8.820
EM341640128100	02503381	BT50 ADB	G5	28,0 1.102	100,0 3.937	62,0 2.441	-	50,0 1.969	201,8 7.945	2	1	PB	4,22 9.300
EM341640128140	02503382	BT50 ADB	G5	28,0 1.102	140,0 5.512	102,0 4.016	-	50,0 1.969	241,8 9.520	2	1	PB	4,8 10.580
EM34164013663	02503383	BT50 ADB	G6	36,0 1.417	63,0 2.480	25,0 0.984	98,0 3.858	63,0 2.480	164,8 6.488	1	1	PB	4,2 9.260
EM341640136100	02503384	BT50 ADB	G6	36,0 1.417	100,0 3.937	62,0 2.441	-	63,0 2.480	201,8 7.945	2	1	PB	4,6 10.140
EM341640136140	02503385	BT50 ADB	G6	36,0 1.417	140,0 5.512	102,0 4.016	-	63,0 2.480	241,8 9.520	2	1	PB	5,54 12.210

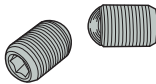



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
EM34164014665	02503386	BT50 ADB	G7	46,0 1.811	65,0 2.559	27,0 1.063	98,0 3.858	90,0 3.543	166,8 6.567	1	1	PB	4,4 9.700
EM341640146120	02503387	BT50 ADB	G7	46,0 1.811	120,0 4.724	82,0 3.228	–	90,0 3.543	221,8 8.732	2	1	PB	6,8 14.990
EM341640146200	02503388	BT50 ADB	G7	46,0 1.811	200,0 7.874	162,0 6.378	–	90,0 3.543	301,8 11.882	2	1	PB	10,7 23.590

## Accesorii

For Taper/ size	Cheie de blocare
	
BT40/ G1	03H02
BT40/ G2	03H025
BT40/ G3	03H03
BT40/ G4	03H04
BT40/ G5	03H05
BT40/ G6	03H06
BT50/ G2	03H025
BT50/ G3	03H03
BT50/ G4	03H04
BT50/ G5	03H05
BT50/ G6	03H06
BT50/ G7	03H10

## Piese de schimb

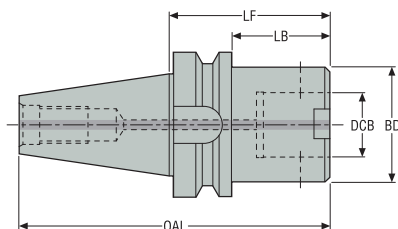
For Taper/ size	Șurub ansamblu	Sealing Screws
		
BT40/ G1	90F1	950A0406
BT40/ G2	90F2	950A0406
BT40/ G3	90F3	950A0406
BT40/ G4	90F4	950A0406
BT40/ G5	90F5	950A0406
BT40/ G6	90F6	950A0406
BT50/ G2	90F2	950A0606
BT50/ G3	90F3	950A0606
BT50/ G4	90F4	950A0606
BT50/ G5	90F5	950A0606
BT50/ G6	90F6	950A0606
BT50/ G7	90F7	950A0606

## G 401 – Arbori Graflex®

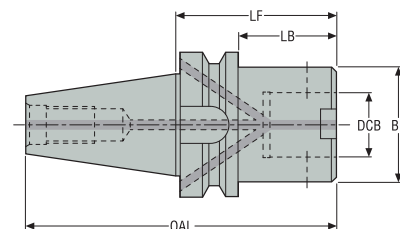
BT TF-AD/ADB



Typ 1



Typ 2



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
EM40024011850	02998757	BT30 TF AD	G3	18,0 0.709	50,0 1.969	28,0 1.102	32,0 1.260	98,4 3.874	1	0	G6.3	0,5 1.100
EM40024012250	02998758	BT30 TF AD	G4	22,0 0.866	50,0 1.969	28,0 1.102	40,0 1.575	98,4 3.874	1	0	G6.3	0,6 1.320
EM321440122100	02998754	BT40 TF ADB	G4	22,0 0.866	100,0 3.937	73,0 2.874	40,0 1.575	165,4 6.512	2	1	G6.3	1,6 3.530
EM321440128120	02926006	BT40 TF ADB	G5	28,0 1.102	120,0 4.724	93,0 3.661	50,0 1.969	185,4 7.299	2	1	PB	2,1 4.630
EM321440136120	02998755	BT40 TF ADB	G6	36,0 1.417	120,0 4.724	93,0 3.661	63,0 2.480	185,4 7.299	2	1	PB	2,8 6.170
EM321640128140	02998756	BT50 TF ADB	G5	28,0 1.102	140,0 5.512	102,0 4.016	50,0 1.969	241,8 9.520	2	1	PB	4,9 10.800
EM321640136140	02926009	BT50 TF ADB	G6	36,0 1.417	140,0 5.512	102,0 4.016	63,0 2.480	241,8 9.520	2	1	PB	5,6 12.350
EM321640146200	02926010	BT50 TF ADB	G7	46,0 1.811	200,0 7.874	162,0 6.378	90,0 3.543	301,8 11.882	2	1	PB	10,7 23.590

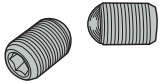

### Accesorii

Pentru	Cheie de blocare
EM40024011850	03H03
EM40024012250	03H04
EM321440122100	03H04
EM321440128120	03H05
EM321440136120	03H06
EM321640128140	03H05
EM321640136140	03H06
EM321640146200	03H10

Cheie de blocare



Piese de schimb

Pentru	Șurub ansamblu	Sealing Screws
		
EM40024011850	90F3	-
EM40024012250	90F4	-
EM321440122100	90F4	950A0406
EM321440128120	90F5	950A0406
EM321440136120	90F6	950A0406
EM321640128140	90F5	950A0606
EM321640136140	90F6	950A0606
EM321640146200	90F7	950A0606

Introducere

Găurire

Alezare

Alezare adâncă

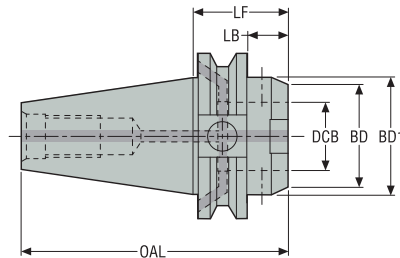
Anexă

## G 401 – Arbori Graflex®

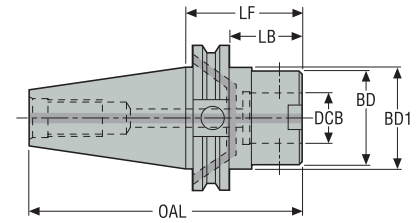
CAT / ASME B5.50-1994-ADB



Typ 1



Typ 2




Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD1	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>				<i>lbs</i>
EM25024011435	02469734	CAT40 ADB	G2	0.551	1.380	0.630	1.750	0.984	4.070	1	1	G6.3	2.120
EM25024011835	00056660	CAT40 ADB	G3	0.709	1.380	0.630	1.750	1.260	4.070	1	1	G6.3	2.090
EM25024012235	00056661	CAT40 ADB	G4	0.866	1.380	0.630	1.750	1.575	4.070	1	1	G6.3	2.030
EM25024012840	00056663	CAT40 ADB	G5	1.102	1.570	0.820	1.750	1.969	4.270	2	1	PB	1.980
EM250240128100	00056662	CAT40 ADB	G5	1.102	3.940	3.190	1.750	1.969	7.420	2	1	PB	3.860
EM25024013660	00056665	CAT40 ADB	G6	1.417	2.360	1.610	1.750	2.480	5.060	2	1	PB	2.710
EM25044011835	00056666	CAT50 ADB	G3	0.709	1.380	0.630	2.750	1.260	5.380	1	1	G6.3	6.720
EM25044012235	00056667	CAT50 ADB	G4	0.866	1.380	0.630	2.750	1.575	5.380	1	1	G6.3	6.530
EM25044012840	00056669	CAT50 ADB	G5	1.102	1.570	0.820	2.750	1.969	5.580	2	1	PB	6.590
EM250440128100	00056668	CAT50 ADB	G5	1.102	3.940	3.190	2.750	1.969	7.940	2	1	PB	8.380
EM25044013645	00056671	CAT50 ADB	G6	1.417	1.770	1.020	2.750	2.480	5.780	1	1	PB	7.050
EM250440136120	00056670	CAT50 ADB	G6	1.417	4.720	3.970	2.750	2.480	9.520	1	1	PB	10.140
EM25044014665	00056675	CAT50 ADB	G7	1.811	2.560	1.810	2.750	3.543	5.970	2	1	PB	8.330
EM250440146120	00056673	CAT50 ADB	G7	1.811	4.720	3.970	2.750	3.543	8.730	2	1	PB	13.800
EM250440146200	00056674	CAT50 ADB	G7	1.811	7.870	7.120	2.750	3.543	11.880	2	1	PB	22.750

### Accesorii

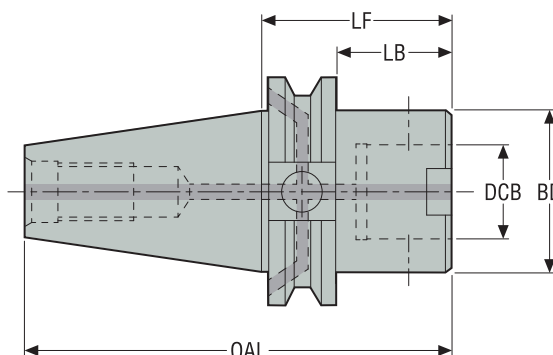
For Taper/ size	Cheie de blocare
CAT40/ G2	03H025
CAT40/ G3	03H03
CAT40/ G4	03H04
CAT40/ G5	03H05
CAT40/ G6	03H06
CAT50/ G3	03H03
CAT50/ G4	03H04
CAT50/ G5	03H05
CAT50/ G6	03H06
CAT50/ G7	03H10

## Piese de schimb

For Taper/ size	Șurub ansamblu	Sealing Screws
		
CAT40/ G2	90F2	950A0406
CAT40/ G3	90F3	950A0406
CAT40/ G4	90F4	950A0406
CAT40/ G5	90F5	950A0406
CAT40/ G6	90F6	950A0406
CAT50/ G3	90F3	950A0606
CAT50/ G4	90F4	950A0606
CAT50/ G5	90F5	950A0606
CAT50/ G6	90F6	950A0606
CAT50/ G7	90F7	950A0606


## G 401 – Arbori Graflex®

CAT TF / ASME B5.50-2009-ADB

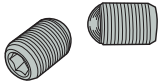



Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>				lbs
EM26424011880	02998750	CAT40 TF ADB	G3	0.709	3.150	2.398	1.260	5.843	2	1	G6.3	2.650
EM26424012280	02998751	CAT40 TF ADB	G4	0.866	3.150	2.398	1.575	5.843	2	1	G6.3	3.090
EM264240128100	02998752	CAT40 TF ADB	G5	1.102	3.937	3.185	1.969	6.630	2	1	PB	4.190
EM264240136100	02998753	CAT40 TF ADB	G6	1.417	3.937	3.185	2.480	6.630	2	1	PB	5.070
EM264440122100	02964322	CAT50 TF ADB	G4	0.866	3.937	3.185	1.575	7.943	2	1	G6.3	7.280
EM264440128100	02964323	CAT50 TF ADB	G5	1.102	3.937	3.185	1.969	7.943	2	1	PB	7.940
EM264440136120	02926850	CAT50 TF ADB	G6	1.417	4.724	3.972	2.480	8.732	1	1	PB	10.140
EM264440146200	02926851	CAT50 TF ADB	G7	1.811	7.874	7.122	3.543	11.880	2	1	PB	22.710

### Accesorii

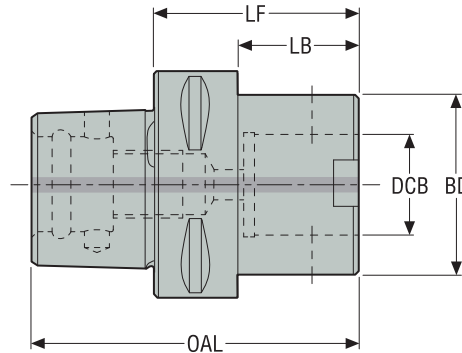
Pentru	Cheie de blocare
	
EM26424011880	03H03
EM26424012280	03H04
EM264240128100	03H05
EM264240136100	03H06
EM264440122100	03H04
EM264440128100	03H05
EM264440136120	03H06
EM264440146200	03H10

## Piese de schimb

Pentru	Șurub ansamblu	Sealing Screws
		
EM26424011880	90F3	950A0406
EM26424012280	90F4	950A0406
EM264240128100	90F5	950A0406
EM264240136100	90F6	950A0406
EM264440122100	90F4	950A0606
EM264440128100	90F5	950A0606
EM264440136120	90F6	950A0606
EM264440146200	90F7	950A0606

## G 401 – Adaptorii Graflex®


Seco-Capto™



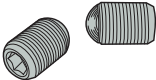
Reper Nr.	Număr reper	CTMS	CTWS	DCB	LF	LB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
C3-391.0401-08025	02532939	C3	G0	8,0 0.315	25,0 0.984	7,0 0.276	16,0 0.630	44,0 1.732	0	G6.3	0,14 0.310
C3-391.0401-11025	02532940	C3	G1	11,0 0.433	25,0 0.984	7,0 0.276	20,0 0.787	44,0 1.732	0	G6.3	0,14 0.310
C3-391.0401-14025	02532941	C3	G2	14,0 0.551	25,0 0.984	7,0 0.276	25,0 0.984	44,0 1.732	0	G6.3	0,15 0.330
C3-391.0401-18030	02532942	C3	G3	18,0 0.709	30,0 1.181	0,0 -	32,0 1.260	49,0 1.929	0	G6.3	0,16 0.350
C4-391.0401-18035	02532943	C4	G3	18,0 0.709	35,0 1.378	12,0 0.472	32,0 1.260	59,0 2.323	0	G6.3	0,31 0.680
C4-391.0401-22035	02532944	C4	G4	22,0 0.866	35,0 1.378	0,0 -	40,0 1.575	59,0 2.323	0	G6.3	0,31 0.680
C5-391.0401-14030	02532945	C5	G2	14,0 0.551	30,0 1.181	7,0 0.276	25,0 0.984	60,0 2.362	1	G6.3	0,47 1.040
C5-391.0401-18035	02532947	C5	G3	18,0 0.709	35,0 1.378	12,0 0.472	32,0 1.260	65,0 2.559	1	G6.3	0,47 1.040
C5-391.0401-22035	02532948	C5	G4	22,0 0.866	35,0 1.378	12,0 0.472	40,0 1.575	65,0 2.559	1	G6.3	0,51 1.120
C5-391.0401-28045	02532949	C5	G5	28,0 1.102	45,0 1.772	22,0 0.866	50,0 1.969	75,0 2.953	1	PB	0,64 1.410
C6-391.0401-18035	02532950	C6	G3	18,0 0.709	35,0 1.378	10,0 0.394	32,0 1.260	73,0 2.874	1	G6.3	0,84 1.850
C6-391.0401-22040	02532951	C6	G4	22,0 0.866	40,0 1.575	15,0 0.591	40,0 1.575	78,0 3.071	1	G6.3	0,89 1.960
C6-391.0401-28050	02532952	C6	G5	28,0 1.102	50,0 1.969	25,0 0.984	50,0 1.969	88,0 3.465	1	PB	1,04 2.290
C6-391.0401-36055	02532953	C6	G6	36,0 1.417	55,0 2.165	0,0 -	63,0 2.480	93,0 3.661	1	PB	1,19 2.620
C8-391.0401-28050	02532954	C8	G5	28,0 1.102	50,0 1.969	17,0 0.669	50,0 1.969	98,0 3.858	1	PB	1,92 4.230
C8-391.0401-36055	02532955	C8	G6	36,0 1.417	55,0 2.165	22,0 0.866	63,0 2.480	103,0 4.055	1	PB	2,02 4.450
C8-391.0401-46065	02532956	C8	G7	46,0 1.811	65,0 2.559	35,0 1.378	90,0 3.543	113,0 4.449	1	PB	2,71 5.970



## Accesorii

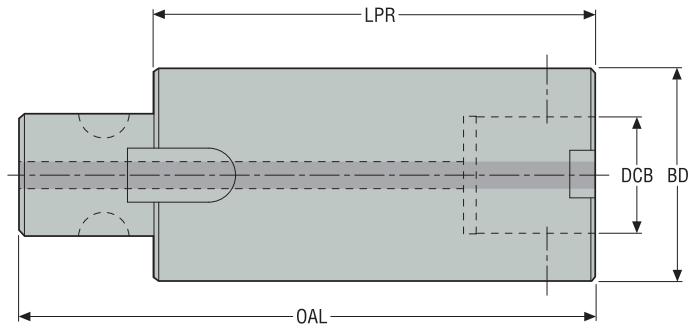
Pentru mărimea	Cheie de blocare
	
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

## Piese de schimb

Pentru mărimea	Șurub ansamblu
	
G0	90F0
G1	90F1
G2	90F2
G3	90F3
G4	90F4
G5	90F5
G6	90F6
G7	90F7

## G 402 – Extensii Graflex®

Graflex®



Reper Nr.	Număr reper	CTMS	CTWS	LPR	DCB	BD	OAL	RFID hole	Echili-brare	Greutate
				mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>			kg <i>lbs</i>
M402000	00056752	G0	G0	30,0 1.181	8,0 0.315	16,0 0.630	42,0 1.654	0	PB	0,05 0.110
M402001	00056753	G0	G0	50,0 1.969	8,0 0.315	16,0 0.630	62,0 2.441	0	PB	0,08 0.180
M402110	00056754	G1	G1	30,0 1.181	11,0 0.433	20,0 0.787	43,0 1.693	0	PB	0,07 0.150
M402111	00056755	G1	G1	50,0 1.969	11,0 0.433	20,0 0.787	63,0 2.480	0	PB	0,12 0.260
M402220	00056756	G2	G2	30,0 1.181	14,0 0.551	25,0 0.984	46,0 1.811	0	PB	0,11 0.240
M402221	00056757	G2	G2	50,0 1.969	14,0 0.551	25,0 0.984	66,0 2.598	0	PB	0,18 0.400
M402330	00056758	G3	G3	40,0 1.575	18,0 0.709	32,0 1.260	60,0 2.362	0	PB	0,24 0.530
M402331	75056759	G3	G3	60,0 2.362	18,0 0.709	32,0 1.260	80,0 3.150	0	PB	0,36 0.790
M402440	00056760	G4	G4	40,0 1.575	22,0 0.866	40,0 1.575	64,0 2.520	0	PB	0,37 0.820
M402441	00056761	G4	G4	60,0 2.362	22,0 0.866	40,0 1.575	84,0 3.307	0	PB	0,57 1.260
M402444	02786252	G4	G4	200,0 7.874	22,0 0.866	40,0 1.575	224,0 8.819	0	PB	1,95 4.300
M402550	00056762	G5	G5	50,0 1.969	28,0 1.102	50,0 1.969	80,0 3.150	0	PB	0,72 1.590
M402551	00056763	G5	G5	75,0 2.953	28,0 1.102	50,0 1.969	105,0 4.134	0	PB	1,12 2.470
M402552	00056764	G5	G5	100,0 3.937	28,0 1.102	50,0 1.969	130,0 5.118	0	PB	1,48 3.260
M402554	02786254	G5	G5	250,0 9.843	28,0 1.102	50,0 1.969	280,0 11.024	0	PB	3,9 8.600
M402660	00056765	G6	G6	60,0 2.362	36,0 1.417	63,0 2.480	100,0 3.937	0	PB	1,38 3.040
M402661	00056766	G6	G6	90,0 3.543	36,0 1.417	63,0 2.480	130,0 5.118	0	PB	2,1 4.630
M402662	00056767	G6	G6	120,0 4.724	36,0 1.417	63,0 2.480	160,0 6.299	0	PB	2,82 6.220
M402664	02786255	G6	G6	300,0 11.811	36,0 1.417	63,0 2.480	340,0 13.386	0	PB	7,2 15.870
M402770	00056768	G7	G7	60,0 2.362	46,0 1.811	90,0 3.543	110,0 4.331	0	-	2,9 6.390
M402771	00056769	G7	G7	90,0 3.543	46,0 1.811	90,0 3.543	140,0 5.512	0	-	4,03 8.880

Reper Nr.	Număr reper	CTMS	CTWS	LPR	DCB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
M402772	00056770	G7	G7	120,0 4.724	46,0 1.811	90,0 3.543	170,0 6.693	0	-	5,8 12.790
M402774	02786257	G7	G7	300,0 11.811	46,0 1.811	90,0 3.543	350,0 13.780	0	-	14,6 32.190

## Accesorii

Pentru mărirea

Cheie de blocare



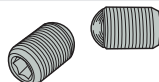
G0	03H02
G1	03H02
G2	03H025
G3	03H03
G4	03H04
G5	03H05
G6	03H06
G7	03H10

## Piese de schimb

Pentru mărirea

Șurub ansamblu

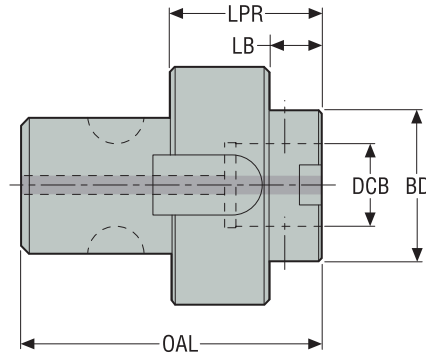
Cep



G0	90F0	90M0
G1	90F1	90M1
G2	90F2	90M2
G3	90F3	90M3
G4	90F4	90M4
G5	90F5	90M5
G6	90F6	90M6
G7	90F7	90M7


## G 403 – Reducții Graflex®

Graflex®

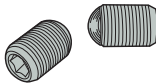



Reper Nr.	Număr reper	CTMS	CTWS	LPR	LB	DCB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
M40310	00056771	G1	G0	30,0 1.181	22,0 0.866	8,0 0.315	16,0 0.630	43,0 1.693	0	PB	0,06 0.130
M40320	00056772	G2	G0	30,0 1.181	19,0 0.748	8,0 0.315	16,0 0.630	46,0 1.811	0	PB	0,08 0.180
M40321	00056773	G2	G1	30,0 1.181	19,0 0.748	11,0 0.433	20,0 0.787	46,0 1.811	0	PB	0,1 0.220
M40330	00056774	G3	G0	30,0 1.181	16,0 0.630	8,0 0.315	16,0 0.630	50,0 1.969	0	PB	0,15 0.330
M40331	00056775	G3	G1	30,0 1.181	16,0 0.630	11,0 0.433	20,0 0.787	50,0 1.969	0	PB	0,15 0.330
M40332	00056776	G3	G2	30,0 1.181	16,0 0.630	14,0 0.551	25,0 0.984	50,0 1.969	0	PB	0,16 0.350
M40341	00056778	G4	G1	30,0 1.181	13,0 0.512	11,0 0.433	20,0 0.787	54,0 2.126	0	PB	0,25 0.550
M40342	00056779	G4	G2	30,0 1.181	13,0 0.512	14,0 0.551	25,0 0.984	54,0 2.126	0	PB	0,27 0.600
M40343	00056780	G4	G3	30,0 1.181	13,0 0.512	18,0 0.709	32,0 1.260	54,0 2.126	0	PB	0,27 0.600
M40350	00056781	G5	G0	40,0 1.575	20,0 0.787	8,0 0.315	16,0 0.630	70,0 2.756	0	PB	0,47 1.040
M40351	00056783	G5	G1	40,0 1.575	20,0 0.787	11,0 0.433	20,0 0.787	70,0 2.756	0	PB	0,49 1.080
M40352	00056785	G5	G2	40,0 1.575	20,0 0.787	14,0 0.551	25,0 0.984	70,0 2.756	0	PB	0,49 1.080
M40353	00056787	G5	G3	40,0 1.575	20,0 0.787	18,0 0.709	32,0 1.260	70,0 2.756	0	PB	0,52 1.150
M40354	00056789	G5	G4	40,0 1.575	20,0 0.787	22,0 0.866	40,0 1.575	70,0 2.756	0	PB	0,55 1.210
M40363	00056797	G6	G3	40,0 1.575	14,0 0.551	18,0 0.709	32,0 1.260	80,0 3.150	0	PB	0,98 2.160
M40364	00056799	G6	G4	40,0 1.575	14,0 0.551	22,0 0.866	40,0 1.575	80,0 3.150	0	PB	0,97 2.140
M40365	00056807	G6	G5	45,0 1.772	19,0 0.748	28,0 1.102	50,0 1.969	85,0 3.346	0	PB	1,04 2.290
M40375	00056811	G7	G5	50,0 1.969	24,0 0.945	28,0 1.102	50,0 1.969	100,0 3.937	0	-	2,08 4.590
M40376	00056812	G7	G6	55,0 2.165	29,0 1.142	36,0 1.417	63,0 2.480	105,0 4.134	0	-	2,23 4.920

## Accesorii

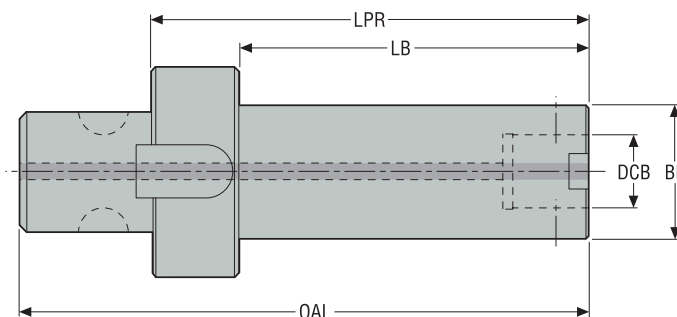
Pentru mărimea	Cheie de blocare
	
M40310	03H02
M40320	03H02
M40321	03H02
M40330	03H02
M40331	03H02
M40332	03H025
M40341	03H02
M40342	03H025
M40343	03H03
M40350	03H02
M40351	03H02
M40352	03H025
M40353	03H03
M40354	03H04
M40363	03H03
M40364	03H04
M40365	03H05
M40375	03H05
M40376	03H06

## Piese de schimb

Pentru mărimea	Șurub ansamblu	Cep
		
M40310	90F0	90M1
M40320	90F0	90M2
M40321	90F1	90M2
M40330	90F0	90M3
M40331	90F1	90M3
M40332	90F2	90M3
M40341	90F1	90M4
M40342	90F2	90M4
M40343	90F3	90M4
M40350	90F0	90M5
M40351	90F1	90M5
M40352	90F2	90M5
M40353	90F3	90M5
M40354	90F4	90M5
M40363	90F3	90M6
M40364	90F4	90M6
M40365	90F5	90M6
M40375	90F5	90M7
M40376	90F6	90M7

## G 403 – Reducții lungi Graflex®

Graflex®



Reper Nr.	Număr reper	CTMS	CTWS	LPR	LB	DCB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
M40350070	00056782	G5	G0	70,0 2.756	50,0 1.969	8,0 0.315	16,0 0.630	100,0 3.937	0	PB	0,51 1.120
M40351080	00056784	G5	G1	80,0 3.150	60,0 2.362	11,0 0.433	20,0 0.787	110,0 4.331	0	PB	0,57 1.260
M40352100	00056786	G5	G2	100,0 3.937	80,0 3.150	14,0 0.551	25,0 0.984	130,0 5.118	0	PB	0,71 1.570
M40353120	00056788	G5	G3	120,0 4.724	100,0 3.937	18,0 0.709	32,0 1.260	150,0 5.906	0	PB	1,02 2.250
M40354150	00056790	G5	G4	150,0 5.906	130,0 5.118	22,0 0.866	40,0 1.575	180,0 7.087	0	PB	1,62 3.570
M40361090	00056794	G6	G1	90,0 3.543	64,0 2.520	11,0 0.433	20,0 0.787	130,0 5.118	0	PB	1,08 2.380
M40362110	00056796	G6	G2	110,0 4.331	84,0 3.307	14,0 0.551	25,0 0.984	150,0 5.906	0	PB	1,23 2.710
M40363120	00056798	G6	G3	120,0 4.724	94,0 3.701	18,0 0.709	32,0 1.260	160,0 6.299	0	PB	1,46 3.220
M40364150	00056800	G6	G4	150,0 5.906	124,0 4.882	22,0 0.866	40,0 1.575	190,0 7.480	0	PB	2,07 4.560
M40365190	00056808	G6	G5	190,0 7.480	164,0 6.457	28,0 1.102	50,0 1.969	230,0 9.055	0	PB	3,2 7.050

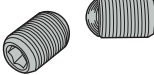

### Accesorii

Pentru	Cheie de blocare
M40350070	03H02
M40351080	03H02
M40352100	03H025
M40353120	03H03
M40354150	03H04
M40361090	03H02
M40362110	03H025
M40363120	03H03
M40364150	03H04
M40365190	03H05

Cheie de blocare



Piese de schimb

Pentru	Șurub ansamblu	Cep
		
M40350070	90F0	90M5
M40351080	90F1	90M5
M40352100	90F2	90M5
M40353120	90F3	90M5
M40354150	90F4	90M5
M40361090	90F1	90M6
M40362110	90F2	90M6
M40363120	90F3	90M6
M40364150	90F4	90M6
M40365190	90F5	90M6

Introducere

Găurire

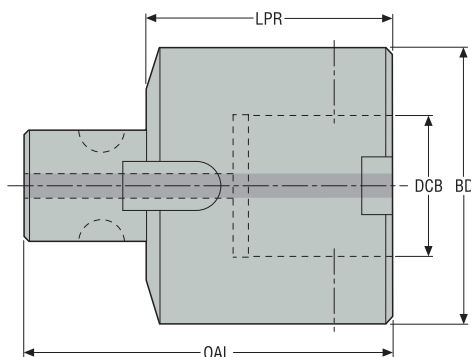
Alezare

Alezare adâncă

Anexă

## G 403 – Reducții Graflex®

Graflex®



Reper Nr.	Număr reper	CTMS	CTWS	LPR	DCB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
M40356	00056791	G5	G6	55,0 2.165	36,0 1.417	63,0 2.480	85,0 3.346	0	PB	1,08 2.380
M40367	00056810	G6	G7	80,0 3.150	46,0 1.811	90,0 3.543	120,0 4.724	0	PB	3,46 7.630

### Accesorii

Pentru	Cheie de blocare
M40356	03H06
M40367	03H10

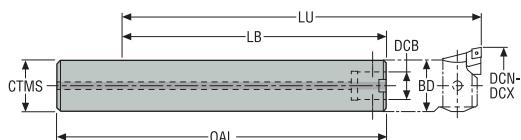
### Piese de schimb

Pentru	Șurub ansamblu	Cep
M40356	90F6	90M5
M40367	90F7	90M6



## G 401 – Arbori Graflex®, oțel

Cilindrică



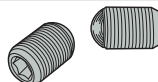
- Potrivite pentru alezare de finisare până la lungimea LU cu capete A780 sau A790
- Coada cilindrică spre mașină CTMS cu toleranța h5, compatibilă cu Shrinkfit

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			
M4011408	00086938	14	G0	8,0 0.315	15,0 0.591	18,5 0.728	120,0 4.724	14,0 0.551	110,0 4.331	75,0 2.953	0	G6.3	0,12 0.260
M4011608	00086935	16	G0	8,0 0.315	18,0 0.709	23,5 0.925	150,0 5.906	16,0 0.630	137,0 5.394	102,0 4.016	0	G6.3	0,2 0.440
M4012011	00086936	20	G1	11,0 0.433	23,0 0.906	31,0 1.220	150,0 5.906	20,0 0.787	140,0 5.512	100,0 3.937	0	G6.3	0,33 0.730
M4012514	00086937	25	G2	14,0 0.551	30,0 1.181	40,0 1.575	150,0 5.906	25,0 0.984	139,0 5.472	93,0 3.661	0	G6.3	0,53 1.170
M4013218	00086939	32	G3	18,0 0.709	39,0 1.535	51,0 2.008	150,0 5.906	32,0 1.260	155,0 6.102	90,0 3.543	0	G6.3	0,87 1.920

## Piese de schimb

Pentru

Șurub ansamblu



M4011408

90F01

M4011608

90F0

M4012011

90F1

M4012514

90F2

M4013218

90F3

## Accesorii

Pentru

Cheie de blocare



M4011408

03H025

M4011608

03H02

M4012011

03H02

M4012514

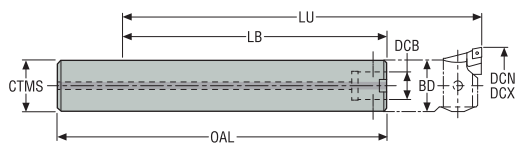
03H025

M4013218

03H03

## G 401 – Arbori Graflex®, oțel

Cilindrică



- Potrivite pentru alezare de finisare până la lungimea LU cu capete A780 sau A790
- Coda cilindrică spre mașină CTMS cu toleranța h5, compatibilă cu Shrinkfit

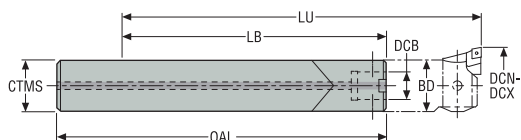
Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID hole	Echilibrare	Greutate
		<i>Inci</i>		<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>			lbs
M40107511	00056741	0.750	G1	0.433	0.906	1.220	5.906	0.827	5.510	3.906	0	G6.3	0.640

### Piese de schimb

Pentru	Șurub ansamblu	Cheie de blocare
M40107511	90F1	03H02

## G 401 – Arbori Graflex®, carbură

Cilindrică



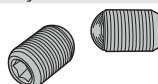
- Potrivite pentru alezare de finisare până la lungimea LU cu capete A780 sau A790
- CTMS toleranță h5

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	OAL	BD	LU	LB	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
M4011408C	00073004	14	G0	8,0 0.315	15,0 0.591	18,5 0.728	152,0 5.984	14,0 0.551	140,0 5.512	105,0 4.134	0	G6.3	0,31 0.680
M4011608C	00056747	16	G0	8,0 0.315	18,0 0.709	23,5 0.925	175,0 6.890	16,0 0.630	160,0 6.299	125,0 4.921	0	G6.3	0,47 1.040
M4012011C	00056749	20	G1	11,0 0.433	23,0 0.906	31,0 1.220	212,0 8.346	20,0 0.787	200,0 7.874	160,0 6.299	0	G6.3	0,89 1.960
M4012514C	00056750	25	G2	14,0 0.551	30,0 1.181	40,0 1.575	262,0 10.315	25,0 0.984	250,0 9.843	204,0 8.031	0	G6.3	1,71 3.770
M4013218C	00056751	32	G3	18,0 0.709	39,0 1.535	51,0 2.008	317,0 12.480	32,0 1.260	320,0 12.598	255,0 10.039	0	G6.3	3,44 7.580

### Piese de schimb

Pentru

Șurub ansamblu



M4011408C	90F01
M4011608C	90F0
M4012011C	90F1
M4012514C	90F2
M4013218C	90F3

### Accesorii

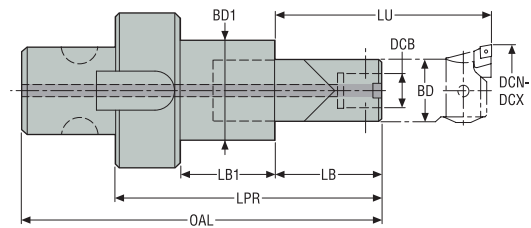
Pentru

Cheie de blocare



M4011408C	03H025
M4011608C	03H02
M4012011C	03H02
M4012514C	03H025
M4013218C	03H03

## G 403 – Reducții foarte lungi Graflex®, carbură



- Extensia este fabricată din carbură
- Potrivite pentru alezare de finisare până la lungimea LU cu capete A780 sau A790

Reper Nr.	Număr reper	CTMS	CTWS	DCB	DCN	DCX	LPR	LU	BD	BD1	LB1	LB	OAL	RFID hole	Echili-brare	Greutate
				mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>			kg <i>lbs</i>
M40350C150	00057604	G5	G0	8,0 0.315	18,0 0.709	23,5 0.925	150,0 5.906	130,0 5.118	16,0 0.630	32,0 1.260	35,0 1.378	95,0 3.740	180,0 7.087	0	PB	1,0 2.200
M40351C180	00056943	G5	G1	11,0 0.433	23,0 0.906	31,0 1.220	180,0 7.087	160,0 6.299	20,0 0.787	36,0 1.417	40,0 1.575	120,0 4.724	210,0 8.268	0	PB	1,33 2.930
M40352C220	00057605	G5	G2	14,0 0.551	30,0 1.181	40,0 1.575	220,0 8.661	200,0 7.874	25,0 0.984	41,0 1.614	45,0 1.772	155,0 6.102	250,0 9.843	0	PB	2,01 4.430

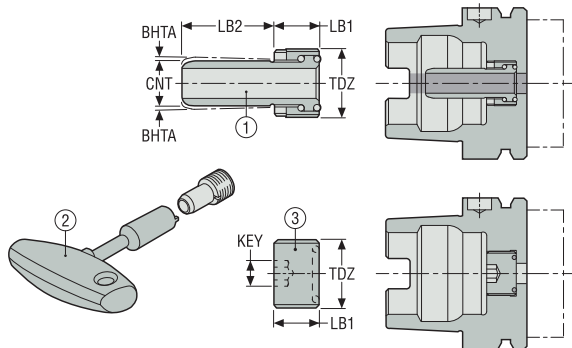
### Piese de schimb

Pentru	Șurub ansamblu	Cep
M40350C150	90F0	90M5
M40351C180	90F1	90M5
M40352C220	90F2	90M5

### Accesorii

Pentru	Cheie de blocare
M40350C150	03H02
M40351C180	03H02
M40352C220	03H025

## HSK tuburi de răcire, chei tubulare și dopuri de etanșare



- Port-sculele HSK-A la Seco-Capto sunt livrate cu un furtun specific pentru lichidul de răcire, disponibil ca piesă de schimb, și necesită cheie cu tub de răcire specifică; consultați paginile de produs 530, 531-532, 533

Descriere	Reper Nr.	Număr reper	Pentru portscule HSK Tip A și E	LB1	LB2	KEY	CNT	TDZ	BHTA°
				mm Inci	mm Inci	mm Inci	mm		
Tuburi răcire (1) *	20E9301	00088814	HSK-A32 & HSK-E32	5,5 0.217	20,5 0.807	-	6	M10x1	1,0
	20E9302	00088815	HSK-A40 & HSK-E40	7,5 0.295	22,0 0.866	-	8	M12x1	1,0
	20E9303	00086740	HSK-A50 & HSK-E50	9,5 0.374	23,5 0.925	-	6	M16x1	1,0
	20E9304	00086741	HSK-A63 & HSK-E63	11,5 0.453	25,0 0.984	-	8	M18x1	1,0
	20E9306	00086742	HSK-A100 & HSK-E100	15,5 0.610	28,5 1.122	-	6	M24x1,5	1,0
	20E9307	00088816	HSK-A125	17,5 0.689	30,5 1.201	-	18	M30x1,5	1,0
	Chei pentru tuburi răcire (2)	03E9301	00088811	HSK-A32 & HSK-E32	-	-	-	-	-
03E9302		00088812	HSK-A40 & HSK-E40	-	-	-	-	-	-
03E9303		00069969	HSK-A50 & HSK-E50	-	-	-	-	-	-
03E9304		00069970	HSK-A63 & HSK-E63	-	-	-	-	-	-
03E9305		00032296	HSK-A80 & HSK-E80	-	-	-	-	-	-
03E9306		00084012	HSK-A100 & HSK-E100	-	-	-	-	-	-
5680094-07		03248614	HSK-A125	-	-	-	-	-	-
Dopuri de etanșare (3)	02E9301	00031588	HSK-A32 & HSK-E32	5,0 0.197	-	3,0 0.118	-	M10x1	-
	02E9302	00031593	HSK-A40 & HSK-E40	7,0 0.276	-	4,0 0.157	-	M12x1	-
	02E9303	00001002	HSK-A50 & HSK-E50	9,0 0.354	-	5,0 0.197	-	M16x1	-
	02E9304	00010101	HSK-A63 & HSK-E63	11,0 0.433	-	6,0 0.236	-	M18x1	-
	02E9306	00014002	HSK-A100 & HSK-E100	15,0 0.591	-	10,0 0.394	-	M24x1,5	-
	02E9307	00033649	HSK-A125	17,0 0.669	-	12,0 0.472	-	M30x1,5	-



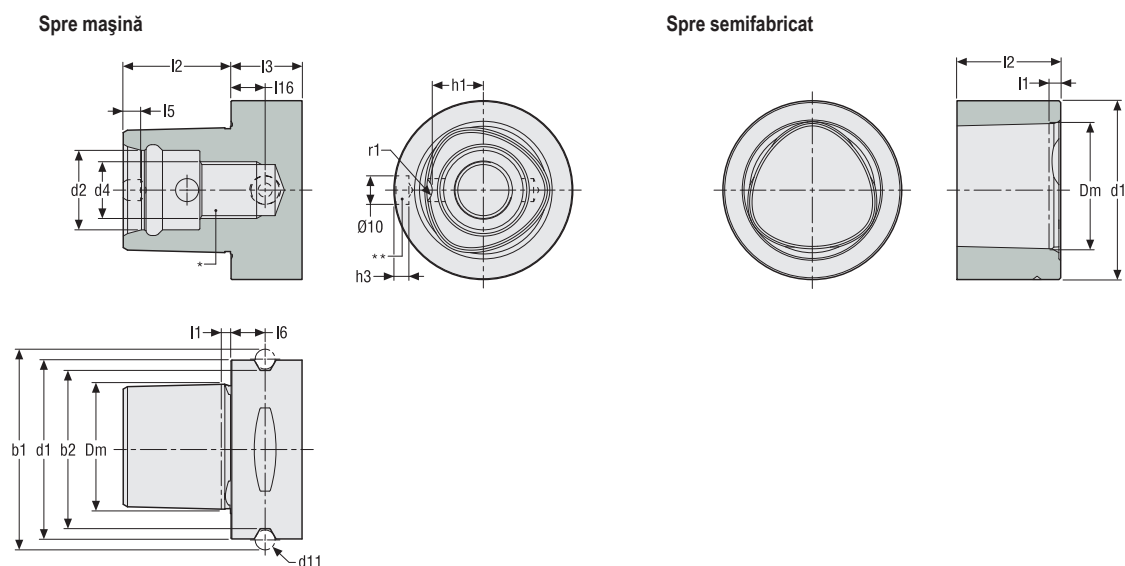
## Seco-Capto™

Seco-Capto™ este un sistem port-sculă cu schimbare rapidă de top, pentru configurarea și înlocuirea rapidă a suporturilor de muchie așchietoare. Gama modulară Seco-Capto™ utilizează cuplare poligonală a cozii (PSC) în conformitate cu ISO 26623 și dispune de o îmbinare conică autoblocantă.

- Gamă de port-scule, precum Shrinkfit, mandrină cu pensete și freză autoportantă
- Arbori de bază Seco-Capto™ cu conexiuni HSK, DIN, BT
- Casetă Seco-Capto™ pentru fiabilitate mai mare și o mai bună prindere a plăcuței

# Seco-Capto™, norme dimensionale

ISO 26623-1-PSC/ ISO 26623-2-PSC

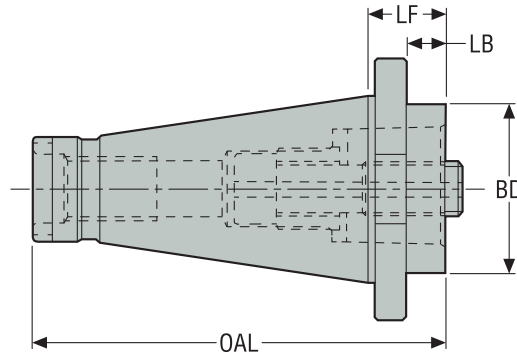


Descriere catalog partea dinspre mașină	Gaură pentru cip RFID**	d <sub>1</sub>	d <sub>2</sub>	d <sub>4</sub>	d <sub>11</sub>	Dm	b <sub>1</sub>	b <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3 min</sub>	l <sub>5</sub>	l <sub>6</sub>	l <sub>16</sub>	h <sub>1</sub>	h <sub>3</sub>	r <sub>1</sub>
		mm Inci	mm Inci		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
C3	Nu**	32 1.260	15 0.591	M12	5 0.197	22 0.866	39 1.535	28,3 1.114	2,5 0.098	19 0.748	15 0.591	3,2 0.126	6 0.236	9 0.354	9 0.354	5,4 0.213	3 0.118
C4	Nu**	40 1.575	18 0.709	M14	5 0.197	28 1.102	46 1.811	35,3 1.390	2,5 0.098	24 0.945	20 0.787	4 0.157	8 0.315	12 0.472	11 0.433	5,2 0.205	3 0.118
C5	**	50 1.969	21 0.827	M16	7 0.276	35 1.378	59,3 2.335	44,4 1.748	3 0.118	30 1.181	20 0.787	5,3 0.209	10 0.394	12 0.472	14 0.551	5,1 0.201	4 0.157
C6	**	63 2.480	28 1.102	M20	7 0.276	44 1.732	70,7 2.783	55,8 2.197	3 0.118	38 1.496	22 0.866	6,2 0.244	12 0.472	12 0.472	18 0.709	5 0.197	5 0.197
C8	**	80 3.150	32 1.260	M20	7 0.276	55 2.165	86 3.386	71,1 2.799	3 0.118	48 1.890	30 1.181	8 0.315	12 0.472	12 0.472	22,2 0.874	4,9 0.193	6 0.236

Spre catalog partea dinspre mașină	Gaură pentru cip RFID**	d <sub>1 min</sub>	d <sub>3</sub>	Dm	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci
C3	Nu	32 1.260	2 0.079	22 0.866	2,3 0.091	18,4 0.724	16,5 0.650	9,4 0.370
C4	Nu	40 1.575	2,5 0.098	28 1.102	2,3 0.091	23,4 0.921	21 0.827	11,5 0.453
C5	Nu	50 1.969	3 0.118	35 1.378	2,8 0.110	29,4 1.157	26 1.024	14,5 0.571
C6	**	63 2.480	4 0.157	44 1.732	2,8 0.110	37,4 1.472	33,5 1.319	18,5 0.728
C8	**	80 3.150	5 0.197	55 2.165	2,8 0.110	47,4 1.866	43 1.693	22,8 0.898

## C 00 – Portscule DIN 2080 la Seco-Capto™ – ISO 26623-2

DIN 2080



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
C3-390.00-40030	75039844	DIN(2080)40	C3	30,0 1.181	18,4 0.724	32,0 1.260	123,4 4.858	0	-	0,8 1.760
C4-390.00-40030	75039848	DIN(2080)40	C4	30,0 1.181	18,4 0.724	40,0 1.575	123,4 4.858	0	-	0,82 1.810
C4-390.00-40060	75039849	DIN(2080)40	C4	60,0 2.362	48,4 1.906	40,0 1.575	153,4 6.039	0	-	1,08 2.380
C5-390.00-40030	75039852	DIN(2080)40	C5	30,0 1.181	18,4 0.724	50,0 1.969	123,4 4.858	0	-	0,81 1.790
C6-390.00-40075	00048158	DIN(2080)40	C6	75,0 2.953	0,0 -	63,0 2.480	168,4 6.630	0	-	1,82 4.010
C3-390.00-50030	75039846	DIN(2080)50	C3	30,0 1.181	14,8 0.583	32,0 1.260	156,8 6.173	0	-	2,5 5.510
C3-390.00-50060	75039847	DIN(2080)50	C3	60,0 2.362	44,8 1.764	32,0 1.260	186,8 7.354	0	-	2,5 5.510
C4-390.00-50030	75039850	DIN(2080)50	C4	30,0 1.181	14,8 0.583	40,0 1.575	156,8 6.173	0	-	2,5 5.510
C4-390.00-50060	75039851	DIN(2080)50	C4	60,0 2.362	44,8 1.764	40,0 1.575	186,8 7.354	0	-	2,5 5.510
C5-390.00-50030	75039854	DIN(2080)50	C5	30,0 1.181	14,8 0.583	50,0 1.969	156,8 6.173	0	-	2,62 5.780
C5-390.00-50070	75039855	DIN(2080)50	C5	70,0 2.756	54,8 2.157	50,0 1.969	196,8 7.748	0	-	3,29 7.250
C6-390.00-50030	75039856	DIN(2080)50	C6	30,0 1.181	14,8 0.583	63,0 2.480	156,8 6.173	0	-	2,56 5.640
C6-390.00-50080	75039857	DIN(2080)50	C6	80,0 3.150	64,8 2.551	63,0 2.480	206,8 8.142	0	-	3,27 7.210
C8-390.00-50070	75039858	DIN(2080)50	C8	70,0 2.756	54,8 2.157	80,0 3.150	196,8 7.748	0	-	3,8 8.380
C8-390.00-50120	75039859	DIN(2080)50	C8	120,0 4.724	104,8 4.126	80,0 3.150	246,8 9.717	0	-	5,6 12.350

### Accesorii

Pentru	Prelungitor	Cheie fixă
C3	5680015-05	5680065-13
C4	5680015-05	5680065-10
C5	5680015-01	5680065-11
C6-400	5680015-01	5680065-12
C6-500	5680015-02	5680065-12
C8	5680015-02	5680065-12



Piese de schimb

Pentru	Șurub central	Piuliță de fixare
C3	5512063-10	5512091-04
C4	5512063-07	5512091-03
C5	5512063-08	5512091-01
C6-400	5512063-13	5512091-02
C6-500	5512063-09	5512091-02
C8	5512063-09	5512091-02

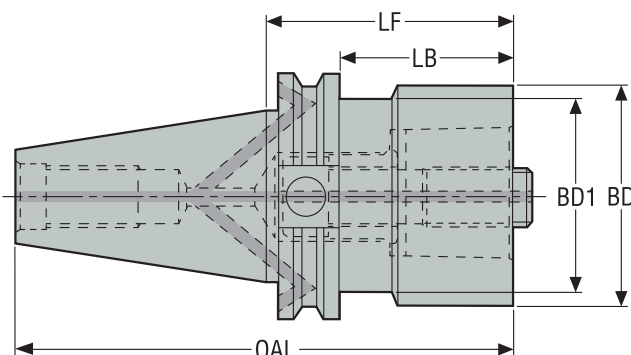
Accesorii / Piese de schimb

Accesorii:  
3 = Prelungitor  
4 = Cheie fixă

Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare

## C 55/58 – Portscule CAT la Seco-Capto™

CAT / ASME B5.50-2009-ADB



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>				<i>lbs</i>
C3-A390B.45-40060	02925929	CAT40 ADB	C3	2.362	1.610	1.260	1.260	5.055	2	0	PB	2.200
C4-A390B.45-40030	02925932	CAT40 ADB	C4	1.181	0.429	1.575	1.575	3.874	2	0	PB	1.830
C4-A390B.45-40060	02925933	CAT40 ADB	C4	2.362	1.610	1.575	1.575	5.055	2	0	PB	2.430
C5-A390B.45-40040	02925935	CAT40 ADB	C5	1.575	0.823	1.969	1.969	4.268	2	0	PB	2.050
C5-A390B.45-40080	02925936	CAT40 ADB	C5	3.150	2.398	1.969	1.969	5.843	2	0	PB	3.310
C6-A390B.45-40085	02925939	CAT40 ADB	C6	3.346	1.378	2.480	2.480	6.039	2	0	PB	4.250
C3-A390B.45-50030	02925930	CAT50 ADB	C3	1.181	0.429	1.260	1.260	5.185	2	0	PB	5.730
C3-A390B.45-50060	02925931	CAT50 ADB	C3	2.362	1.610	1.260	1.260	6.366	2	0	PB	5.970
C4-A390B.45-50030	02925948	CAT50 ADB	C4	1.181	0.429	1.575	1.575	5.185	2	0	PB	5.780
C4-A390B.45-50060	02925934	CAT50 ADB	C4	2.362	1.610	1.969	1.575	6.366	2	0	PB	6.240
C5-A390B.45-50030	02925937	CAT50 ADB	C5	1.181	0.429	1.969	1.969	5.185	2	0	PB	5.730
C5-A390B.45-50070	02925938	CAT50 ADB	C5	2.756	2.004	1.969	1.969	6.760	2	0	PB	6.830
C6-A390B.45-50030	02925940	CAT50 ADB	C6	1.181	0.429	2.480	2.480	5.185	2	0	PB	5.530
C6-A390B.45-50080	02925941	CAT50 ADB	C6	3.150	2.398	2.480	2.480	7.154	2	0	PB	7.940
C8-A390B.45-50070	02925942	CAT50 ADB	C8	2.756	2.004	3.150	3.150	6.760	2	0	PB	8.220
C8-A390B.45-50120	02925943	CAT50 ADB	C8	4.724	3.972	3.150	3.150	8.728	2	0	PB	12.240

### Accesorii

Pentru mărimea	Prelungitor	Cheie fixă
CAT40/ C3	5680015-05	5680065-13
CAT40/ C4	5680015-05	5680065-10
CAT40/ C5	5680015-01	5680065-11
CAT40/ C6	5680015-01	5680065-12
CAT50/ C3	5680015-05	5680065-13
CAT50/ C4-50030	5680015-05	5680065-10
CAT50/ C4-50060	5680015-05	5680065-10
CAT50/ C5	5680015-01	5680065-11
CAT50/ C6	5680015-02	5680065-12
CAT50/ C8	5680015-02	5680065-12

Piese de schimb

Pentru mărimea	Șurub central	Dop	Piuliță de fixare
CAT40/ C3	5512063-10	564301701	5512091-04
CAT40/ C4	5512063-07	564301701	5512091-03
CAT40/ C5	5512063-08	564301701	5512091-01
CAT40/ C6	5512063-13	564301701	5512091-02
CAT50/ C3	5512063-10	564301702	5512091-04
CAT50/ C4-50030	5512063-07	564301701	5512091-03
CAT50/ C4-50060	5512063-07	564301702	5512091-03
CAT50/ C5	5512063-08	564301702	5512091-01
CAT50/ C6	5512063-09	564301702	5512091-02
CAT50/ C8	5512063-09	564301702	5512091-02

Accesorii / Piese de schimb

The diagram shows an exploded view of the tool assembly. Callout 1 points to the central screw, 2 to the locking nut, 3 to the O-ring, 4 to the extension sleeve, and 5 to the fixed key.

Accesorii:  
4 = Prelungitor  
5 = Cheie fixă

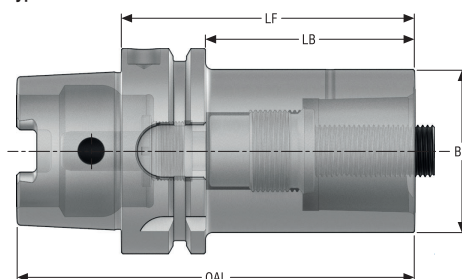
Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare  
3 = Dopuri de etanșare

## C 410 – Portscule HSK-A la Seco-Capto™ – ISO 26623-2

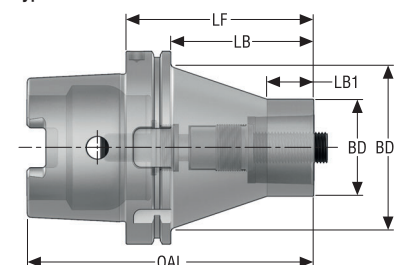
HSK-A/ ISO12164-1-HSK-A



Typ 1

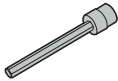
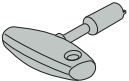
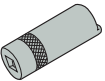


Typ 2



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
C3-390.410-63075C	75039871	HSK-A63	C3	75,0 2.953	49,0 1.929	-	32,0 1.260	-	107,0 4.213	1	0	PB	0,9 1.980
C4-390.410-63080C	02425047	HSK-A63	C4	80,0 3.150	54,0 2.126	-	40,0 1.575	-	112,0 4.409	1	0	PB	1,06 2.340
C5-390.410-63090C	75039878	HSK-A63	C5	90,0 3.543	64,0 2.520	-	50,0 1.969	-	122,0 4.803	1	0	PB	1,41 3.110
C3-390.410-100080A	75039873	HSK-A100	C3	80,0 3.150	51,0 2.008	-	32,0 1.260	-	130,0 5.118	1	0	-	2,3 5.070
C4-390.410-100090A	75039877	HSK-A100	C4	90,0 3.543	61,0 2.402	-	40,0 1.575	-	140,0 5.512	1	0	-	2,5 5.510
C5-390.410-100100A	75039880	HSK-A100	C5	100,0 3.937	71,0 2.795	-	50,0 1.969	-	150,0 5.906	1	0	-	2,9 6.390
C6-390.410-100110A	75039882	HSK-A100	C6	110,0 4.331	81,0 3.189	-	63,0 2.480	-	160,0 6.299	1	0	-	3,56 7.850
C8-390.410-100120A	75039883	HSK-A100	C8	120,0 4.724	91,0 3.583	-	80,0 3.150	-	170,0 6.693	1	0	-	4,72 10.410
HSKA125-C6-120	03229625	HSK-A125	C6	120,0 4.724	91,0 3.583	-	63,0 2.480	-	183,0 7.205	1	1	PB	5,3 11.680
HSKA125-C6-120-V	03229626	HSK-A125	C6	120,0 4.724	91,0 3.583	30,0 1.181	63,0 2.480	108,0 4.252	183,0 7.205	2	1	PB	6,4 14.110
HSKA125-C8-130	03229627	HSK-A125	C8	130,0 5.118	101,0 3.976	-	80,0 3.150	-	193,0 7.598	1	1	PB	6,5 14.330
HSKA125-C8-130-V	03229628	HSK-A125	C8	130,0 5.118	101,0 3.976	30,0 1.181	80,0 3.150	105,0 4.134	193,0 7.598	2	1	PB	7,8 17.200

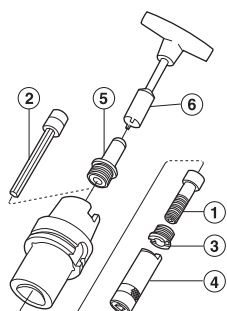
Accesorii

Pentru	Prelungitor	Cheie	Cheie fixă
			
C3-390.410-63075C	5680015-05	5680094-04	5680065-13
C4-390.410-63080C	5680015-05	5680094-04	5680065-10
C5-390.410-63090C	5680015-01	5680094-04	5680065-11
C3-390.410-100080A	5680015-05	5680094-06	5680065-13
C4-390.410-100090A	5680015-05	5680094-06	5680065-10
C5-390.410-100100A	5680015-01	5680094-06	5680065-11
C6-390.410-100110A	5680015-02	5680094-06	5680065-12
C8-390.410-100120A	5680015-02	5680094-06	5680065-12
HSKA125-C6-120	5680015-02	5680094-07	5680065-12
HSKA125-C6-120-V	5680015-02	5680094-07	5680065-12
HSKA125-C8-130	5680015-02	5680094-07	5680065-12
HSKA125-C8-130-V	5680015-02	5680094-07	5680065-12

Piese de schimb

Pentru	Șurub central	Tub răcire	Piuliță de fixare
			
C3-390.410-63075C	5512063-10	5692020-04	5512091-04
C4-390.410-63080C	5512063-07	5692020-04	5512091-03
C5-390.410-63090C	5512063-08	5692020-04	5512091-01
C3-390.410-100080A	5512063-10	5692020-06	5512091-04
C4-390.410-100090A	5512063-07	5692020-06	5512091-03
C5-390.410-100100A	5512063-08	5692020-06	5512091-01
C6-390.410-100110A	5512063-09	5692020-06	5512091-02
C8-390.410-100120A	5512063-09	5692020-06	5512091-02
HSKA125-C6-120	5512063-09	5692020-07	5512091-02
HSKA125-C6-120-V	5512063-09	5692020-07	5512091-02
HSKA125-C8-130	5512063-09	5692020-07	5512091-02
HSKA125-C8-130-V	5512063-09	5692020-07	5512091-02

Accesorii / Piese de schimb



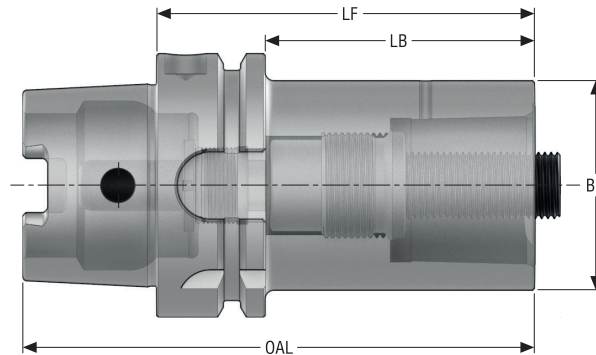
Accesorii:  
2 = Prelungitor  
4 = Cheie fixă  
6 = Cheie pentru tubul de răcire

Piese de schimb:  
1 = Șurub central  
3 = Piuliță de fixare  
5 = Tub răcire\*

\*Fiecare portsculă HSK-A la Seco-Capto™ se livrează cu o conductă specifică pentru lichidul de răcire

## C 411 – Portscule HSK-T la Seco-Capto™ – ISO 26623-2

HSK-T/ ISO12164-3-HSK-T



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
C4-390.411-63080	02786511	HSK-T63	C4	80,0 3.150	54,0 2.126	40,0 1.575	112,0 4.409	1	-	1,0 2.200
C5-390.411-63090	02786520	HSK-T63	C5	90,0 3.543	64,0 2.520	50,0 1.969	122,0 4.803	1	-	1,3 2.870
C4-390.411-100090	02786519	HSK-T100	C4	90,0 3.543	61,0 2.402	40,0 1.575	140,0 5.512	1	-	2,4 5.290
C5-390.411-100100	02786521	HSK-T100	C5	100,0 3.937	71,0 2.795	50,0 1.969	150,0 5.906	1	-	2,7 5.950
C6-390.411-100110	02786522	HSK-T100	C6	110,0 4.331	81,0 3.189	63,0 2.480	160,0 6.299	1	-	3,3 7.280
C8-390.411-100120	02786523	HSK-T100	C8	120,0 4.724	91,0 3.583	80,0 3.150	170,0 6.693	1	-	4,5 9.920

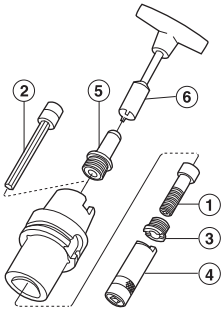
### Accesorii

Pentru	Prelungitor	Cheie	Cheie fixă
C4-390.411-63080	5680015-05	5680094-04	5680065-10
C5-390.411-63090	5680015-01	5680094-04	5680065-11
C4-390.411-100090	5680015-05	5680094-06	5680065-10
C5-390.411-100100	5680015-01	5680094-06	5680065-11
C6-390.411-100110	5680015-02	5680094-06	5680065-12
C8-390.411-100120	5680015-02	5680094-06	5680065-12

### Piese de schimb

Pentru	Șurub central	Tub răcire	Piuliță de fixare
C4-390.411-63080	5512063-07	5692020-04	5512091-03
C5-390.411-63090	5512063-08	5692020-04	5512091-01
C4-390.411-100090	5512063-07	20E9306	5512091-03
C5-390.411-100100	5512063-08	20E9306	5512091-01
C6-390.411-100110	5512063-09	5692020-06	5512091-02
C8-390.411-100120	5512063-09	5692020-06	5512091-02

## Accesorii / Piese de schimb



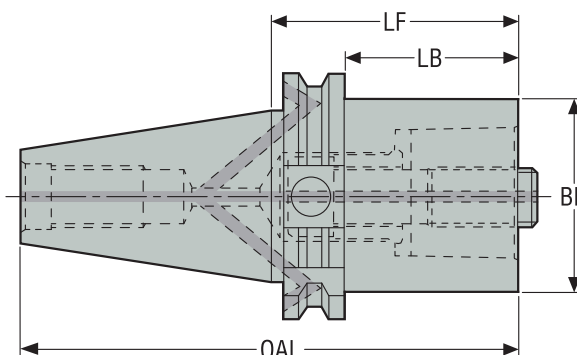
Accesorii:  
2 = Prelungitor  
4 = Cheie fixă  
6 = Cheie pentru tubul de răcire

Piese de schimb:  
1 = Șurub central  
3 = Piuliță de fixare  
5 = Tub răcire\*

\*Fiecare portsculă HSK-A la Seco-Capto™ se livrează cu o conductă specifică pentru lichidul de răcire

## C 140 – Portscule DIN la Seco-Capto™ – ISO 26623-2

DIN 69871-ADB



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
C3-390B.140-40030	02924104	DIN40 ADB	C3	30,0 1.181	10,9 0.429	32,0 1.260	98,4 3.874	0	PB	0,8 1.760
C3-390B.140-40060	02924105	DIN40 ADB	C3	60,0 2.362	40,9 1.610	32,0 1.260	128,4 5.055	0	PB	0,9 1.980
C4-390B.140-40030	02924108	DIN40 ADB	C4	30,0 1.181	10,9 0.429	40,0 1.575	98,4 3.874	0	PB	0,8 1.760
C4-390B.140-40060	02924109	DIN40 ADB	C4	60,0 2.362	40,9 1.610	40,0 1.575	128,4 5.055	0	PB	1,1 2.430
C5-390B.140-40040	02924112	DIN40 ADB	C5	40,0 1.575	20,9 0.823	50,0 1.969	108,4 4.268	0	PB	0,9 1.980
C5-390B.140-40080	02924113	DIN40 ADB	C5	80,0 3.150	60,9 2.398	50,0 1.969	148,4 5.843	0	PB	1,5 3.310
C6-390B.140-40085	02924116	DIN40 ADB	C6	85,0 3.346	65,9 2.594	63,0 2.480	153,4 6.039	0	PB	1,8 3.970
C3-390B.140-50030	02924106	DIN50 ADB	C3	30,0 1.181	10,9 0.429	32,0 1.260	131,7 5.185	0	PB	2,6 5.730
C3-390B.140-50060	02924107	DIN50 ADB	C3	60,0 2.362	40,9 1.610	32,0 1.260	161,7 6.366	0	PB	2,7 5.950
C4-390B.140-50030	02924110	DIN50 ADB	C4	30,0 1.181	10,9 0.429	40,0 1.575	131,7 5.185	0	PB	2,6 5.730
C4-390B.140-50060	02924111	DIN50 ADB	C4	60,0 2.362	40,9 1.610	40,0 1.575	161,7 6.366	0	PB	2,8 6.170
C5-390B.140-50030	02924114	DIN50 ADB	C5	30,0 1.181	10,9 0.429	50,0 1.969	131,7 5.185	0	PB	2,6 5.730
C5-390B.140-50070	02924115	DIN50 ADB	C5	70,0 2.756	50,9 2.004	50,0 1.969	171,7 6.760	0	PB	3,1 6.830
C6-390B.140-50030	02924117	DIN50 ADB	C6	30,0 1.181	10,9 0.429	63,0 2.480	131,7 5.185	0	PB	2,5 5.510
C6-390B.140-50080	02924118	DIN50 ADB	C6	80,0 3.150	60,9 2.398	63,0 2.480	181,7 7.154	0	PB	3,6 7.940
C8-390B.140-50070	02924119	DIN50 ADB	C8	70,0 2.756	50,9 2.004	80,0 3.150	171,7 6.760	0	PB	3,7 8.160
C8-390B.140-50120	02924120	DIN50 ADB	C8	120,0 4.724	100,9 3.972	80,0 3.150	221,7 8.728	0	PB	5,6 12.350



Accesorii

Pentru	Prelungitor	Cheie fixă
C3-400	5680015-05	5680065-13
C4-400	5680015-05	5680065-10
C5-400	5680015-01	5680065-11
C6-400	5680015-01	5680065-12
C3-500	5680015-05	5680065-13
C4-500	5680015-05	5680065-10
C5-500	5680015-01	5680065-11
C6-500	5680015-02	5680065-12
C8	5680015-02	5680065-12

Piese de schimb

Pentru	Șurub central	Dop	Piuliță de fixare
C3-400	5512063-10	564301701	5512091-04
C4-400	5512063-07	564301701	5512091-03
C5-400	5512063-08	564301701	5512091-01
C6-400	5512063-13	564301701	5512091-02
C3-500	5512063-10	564301702	5512091-04
C4-500	5512063-07	564301702	5512091-03
C5-500	5512063-08	564301702	5512091-01
C6-500	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Accesorii / Piese de schimb

Accesorii:  
4 = Prelungitor  
5 = Cheie fixă

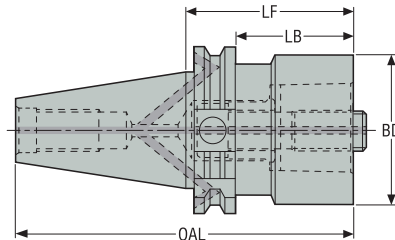
Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare  
3 = Dopuri de etanșare

## C 5191 – Portsicle standard Seco-Capto™ – ISO 26623-2

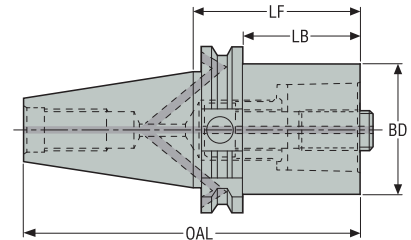
DIN TF-ADB



Typ 1



Typ 2

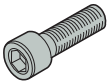




Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
E316951915050	03030258	DIN40 TF ADB	C5	50,0 1.969	30,9 1.217	50,0 1.969	118,4 4.661	2	0	PB	1,1 2.430
E316951916385	03030259	DIN40 TF ADB	C6	85,0 3.346	65,9 2.594	63,0 2.480	153,4 6.039	1	0	PB	1,9 4.190
E317151914030	03030260	DIN50 TF ADB	C4	30,0 1.181	10,9 0.429	40,0 1.575	131,7 5.185	2	0	-	2,7 5.950
E317151915030	03030261	DIN50 TF ADB	C5	30,0 1.181	10,9 0.429	50,0 1.969	131,7 5.185	2	0	-	2,8 6.170
E317151915070	03030264	DIN50 TF ADB	C5	70,0 2.756	50,9 2.004	50,0 1.969	171,7 6.760	2	0	-	3,15 6.940
E317151916350	03030262	DIN50 TF ADB	C6	50,0 1.969	30,9 1.217	63,0 2.480	151,7 5.972	2	0	-	2,4 5.290
E3171519163100	03030265	DIN50 TF ADB	C6	100,0 3.937	80,9 3.185	63,0 2.480	201,7 7.941	2	0	-	4,08 8.990
E317151918070	03030263	DIN50 TF ADB	C8	70,0 2.756	50,9 2.004	80,0 3.150	171,7 6.760	2	0	-	3,9 8.600
E3171519180120	03030266	DIN50 TF ADB	C8	120,0 4.724	100,9 3.972	80,0 3.150	221,7 8.728	2	0	-	5,62 12.390

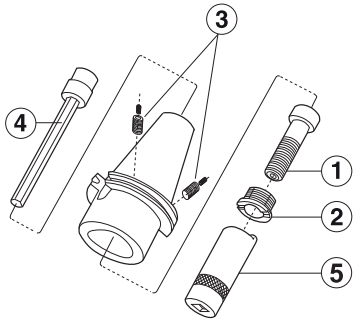
### Accesorii

Pentru	Prelungitor	Cheie fixă
DIN40 TF/ C5	5680015-01	5680065-11
DIN40 TF/ C6	5680015-01	5680065-12
DIN50 TF/ C4	5680015-05	5680065-10
DIN50 TF/ C5	5680015-01	5680065-11
DIN50 TF/ C6-C8	5680015-02	5680065-12

Piese de schimb

Pentru	Șurub central	Dop	Piuliță de fixare
		 1x	
DIN40 TF/ C5	5512063-08	564301701	5512091-01
DIN40 TF/ C6	5512063-13	564301701	5512091-02
DIN50 TF/ C4	5512063-07	564301702	5512091-03
DIN50 TF/ C5	5512063-08	564301702	5512091-01
DIN50 TF/ C6-C8	5512063-09	564301702	5512091-02

Accesorii / Piese de schimb



Accesorii:  
4 = Prelungitor  
5 = Cheie fixă

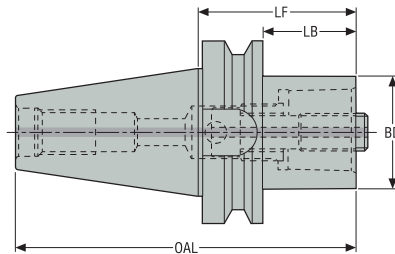
Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare  
3 = Dopuri de etanșare

## C 55/58 – Portscule BT la Seco-Capto™ – ISO 26623-2

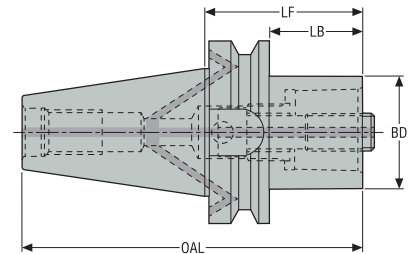
BT



Typ 1

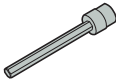
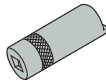


Typ 2

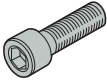




Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	Varianta	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
C3-390.55-30030	75039807	BT30 AD	C3	30,0 1.181	8,0 0.315	32,0 1.260	78,4 3.087	1	0	PB	0,53 1.170
C3-390.55-30060	75039808	BT30 AD	C3	60,0 2.362	38,0 1.496	32,0 1.260	108,4 4.268	1	0	PB	0,73 1.610
C3-390B.55-40030	02925959	BT40 ADB	C3	30,0 1.181	3,0 0.118	32,0 1.260	95,4 3.756	2	0	PB	0,9 1.980
C3-390B.55-40060	02925960	BT40 ADB	C3	60,0 2.362	33,0 1.299	32,0 1.260	125,4 4.937	2	0	PB	1,1 2.430
C4-390B.55-40030	02925963	BT40 ADB	C4	30,0 1.181	3,0 0.118	40,0 1.575	95,4 3.756	2	0	PB	0,9 1.980
C4-390B.55-40060	02925964	BT40 ADB	C4	60,0 2.362	33,0 1.299	40,0 1.575	125,4 4.937	2	0	PB	1,2 2.650
C5-390B.55-40050	02925967	BT40 ADB	C5	50,0 1.969	23,0 0.906	50,0 1.969	115,4 4.543	2	0	PB	1,1 2.430
C5-390B.55-40090	02925968	BT40 ADB	C5	90,0 3.543	63,0 2.480	50,0 1.969	155,4 6.118	2	0	PB	1,7 3.750
C6-390B.55-40075	02925971	BT40 ADB	C6	75,0 2.953	54,6 2.150	63,0 2.480	140,4 5.528	2	0	PB	1,7 3.750
C3-390B.58-50040	02925961	BT50 ADB	C3	40,0 1.575	2,0 0.079	32,0 1.260	141,8 5.583	2	0	PB	3,5 7.720
C3-390B.58-50070	02925962	BT50 ADB	C3	70,0 2.756	32,0 1.260	32,0 1.260	171,8 6.764	2	0	PB	3,7 8.160
C4-390B.58-50040	02925965	BT50 ADB	C4	40,0 1.575	2,0 0.079	40,0 1.575	141,8 5.583	2	0	PB	3,5 7.720
C4-390B.58-50070	02925966	BT50 ADB	C4	70,0 2.756	32,0 1.260	40,0 1.575	171,8 6.764	2	0	PB	3,8 8.380
C5-390B.58-50040	02925969	BT50 ADB	C5	40,0 1.575	2,0 0.079	50,0 1.969	141,8 5.583	2	0	PB	3,4 7.500
C5-390B.58-50080	02925970	BT50 ADB	C5	80,0 3.150	42,0 1.654	50,0 1.969	181,8 7.157	2	0	PB	4,0 8.820
C6-390B.58-50050	02925972	BT50 ADB	C6	50,0 1.969	12,0 0.472	63,0 2.480	151,8 5.976	2	0	PB	3,5 7.720
C6-390B.58-50100	02925973	BT50 ADB	C6	100,0 3.937	62,0 2.441	63,0 2.480	201,8 7.945	2	0	PB	4,6 10.140
C8-390B.58-50070	02925974	BT50 ADB	C8	70,0 2.756	32,0 1.260	80,0 3.150	171,8 6.764	2	0	PB	4,0 8.820
C8-390B.58-50120	02925975	BT50 ADB	C8	120,0 4.724	82,0 3.228	80,0 3.150	221,8 8.732	2	0	PB	5,9 13.010

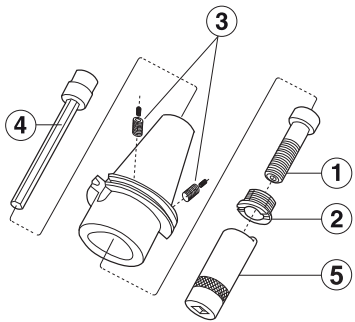
Accesorii

Pentru	Prelungitor	Cheie fixă
		
C3-390.55	5680015-05	5680065-13
C3-390B.55	5680015-05	5680065-13
C4-390B.55	5680015-05	5680065-10
C5-390B.55	5680015-01	5680065-11
C6-390B.55	5680015-01	5680065-12
C3-390B.58	5680015-05	5680065-13
C4-390B.58	5680015-05	5680065-10
C5-390B.58	5680015-01	5680065-11
C6-390B.58	5680015-02	5680065-12
C8	5680015-02	5680065-12

Piese de schimb

Pentru	Șurub central	Dop	Piuliță de fixare
		 1x	
C3-390.55	5512063-10	-	5512091-04
C3-390B.55	5512063-10	564301701	5512091-04
C4-390B.55	5512063-07	564301701	5512091-03
C5-390B.55	5512063-08	564301701	5512091-01
C6-390B.55	5512063-13	564301701	5512091-02
C3-390B.58	5512063-10	564301702	5512091-04
C4-390B.58	5512063-07	564301702	5512091-03
C5-390B.58	5512063-08	564301702	5512091-01
C6-390B.58	5512063-09	564301702	5512091-02
C8	5512063-09	564301702	5512091-02

Accesorii / Piese de schimb

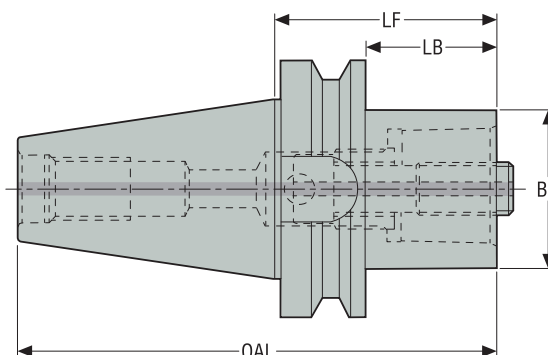
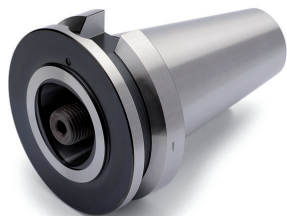


Accesorii:  
4 = Prelungitor  
5 = Cheie fixă

Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare  
3 = Dopuri de etanșare

## C 605 – Portscule BT Mazak la Seco-Capto™ – ISO 26623-2

BT Mazak



- Mazak design înseamnă poligon Seco-Capto™ rotit 90° comparativ cu portsculele clasice BT
- Pentru e-mașini Mazak

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci			kg lbs
C5-390.605-40030	02606358	BT40 AD Mazak	C5	30,0 1.181	3,0 0.118	50,0 1.969	95,4 3.756	0	-	1,1 2.430
C6-390.605-50040	02606354	BT50 AD Mazak	C6	40,0 1.575	2,0 0.079	63,0 2.480	141,8 5.583	0	-	3,3 7.280
C8-390.605-50070	02646032	BT50 AD Mazak	C8	70,0 2.756	70,0 2.756	80,0 3.150	171,8 6.764	0	-	4,1 9.040

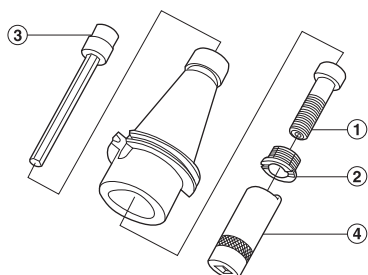
### Accesorii

Pentru mărimea	Prelungitor	Cheie fixă
C5	5680015-01	5680065-11
C6	5680015-02	5680065-12
C8	5680015-02	5680065-12

### Piese de schimb

Pentru mărimea	Șurub central	Piuliță de fixare
C5	5512063-08	5512091-01
C6	5512063-09	5512091-02
C8	5512063-09	5512091-02

## Accesorii / Piese de schimb



Accesorii:  
3 = Prelungitor  
4 = Cheie fixă

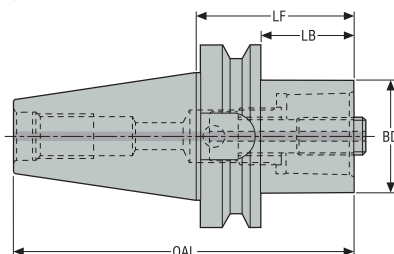
Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare

## C 5191 – Portsicle standard Seco-Capto™ – ISO 26623-2

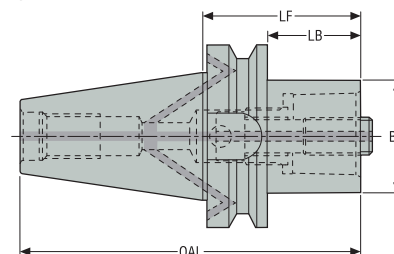
BT TF-AD/ADB



Typ 1



Typ 2



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	BD	OAL	Varianta	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
E400251913240	03030234	BT30 TF AD	C3	40,0 1.575	22,0 0.866	32,0 1.260	88,4 3.480	1	0	PB	0,454 1.000
E400251914060	03030235	BT30 TF AD	C4	60,0 2.362	22,0 0.866	40,0 1.575	108,4 4.268	1	0	PB	0,651 1.440
E311451914040	03030236	BT40 TF ADB	C4	40,0 1.575	13,0 0.512	40,0 1.575	105,4 4.150	2	0	PB	1,1 2.430
E311451915050	03030237	BT40 TF ADB	C5	50,0 1.969	23,0 0.906	50,0 1.969	115,4 4.543	2	0	PB	1,2 2.650
E311451916375	03030238	BT40 TF ADB	C6	75,0 2.953	48,0 1.890	63,0 2.480	140,4 5.528	2	0	PB	1,7 3.750
E311651914040	03030239	BT50 TF ADB	C4	40,0 1.575	2,0 0.079	50,0 1.969	141,8 5.583	2	0	PB	3,6 7.940
E311651915040	03030240	BT50 TF ADB	C5	40,0 1.575	2,0 0.079	50,0 1.969	141,8 5.583	2	0	PB	3,5 7.720
E311651916350	03030241	BT50 TF ADB	C6	50,0 1.969	12,0 0.472	63,0 2.480	151,8 5.976	2	0	PB	3,6 7.940
E3116519163100	03030242	BT50 TF ADB	C6	100,0 3.937	62,0 2.441	63,0 2.480	201,8 7.945	2	0	PB	4,63 10.210
E311651918070	03030243	BT50 TF ADB	C8	70,0 2.756	32,0 1.260	80,0 3.150	171,8 6.764	2	0	PB	4,2 9.260
E3116519180120	03030244	BT50 TF ADB	C8	120,0 4.724	82,0 3.228	80,0 3.150	121,8 4.795	2	0	PB	5,91 13.030

### Accesorii

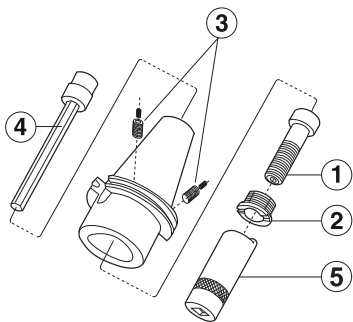
For Taper/ size	Prelungitor	Cheie fixă
BT30 TF/ C3	5680015-05	5680065-13
BT30 TF/ C4	5680015-05	5680065-10
BT40 TF/ C4	5680015-05	5680065-10
BT40 TF/ C5	5680015-01	5680065-11
BT40 TF/ C6	5680015-01	5680065-12
BT50 TF/ C4	5680015-05	5680065-10
BT50 TF/ C5	5680015-01	5680065-11
BT50 TF/ C6-C8	5680015-02	5680065-12



**Piese de schimb**

For Taper/ size	Șurub central	Dop	Piuliță de fixare
BT30 TF/ C3	5512063-10	–	5512091-04
BT30 TF/ C4	5512063-07	–	5512091-03
BT40 TF/ C4	5512063-07	564301701	5512091-03
BT40 TF/ C5	5512063-08	564301701	5512091-01
BT40 TF/ C6	5512063-13	564301701	5512091-02
BT50 TF/ C4	5512063-07	564301702	5512091-03
BT50 TF/ C5	5512063-08	564301702	5512091-01
BT50 TF/ C6-C8	5512063-09	564301702	5512091-02

**Accesorii / Piese de schimb**



Accesorii:  
4 = Prelungitor  
5 = Cheie fixă

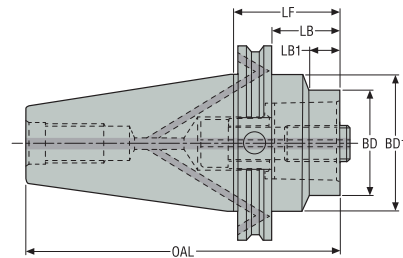
Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare  
3 = Dopuri de etanșare

## C 5191 – Portsicle standard Seco-Capto™

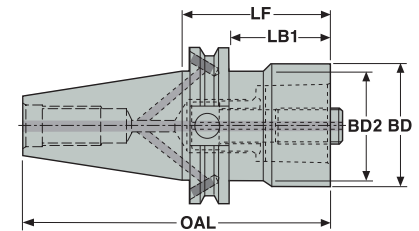
CAT TF / ASME B5.50-1994-ADB



Typ 1



Typ 2



Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>				<i>lbs</i>
E234251914040	03030246	CAT40 TF ADB	C4	1.575	0.140	0.140	1.575	1.750	4.270	1	0	PB	2.200
E234251915050	03030247	CAT40 TF ADB	C5	1.969	1.220	1.220	1.969	1.750	4.660	2	0	PB	2.250
E234451914040	03030249	CAT50 TF ADB	C4	1.575	0.090	0.090	1.575	2.750	5.580	1	0	–	6.830
E234451915040	03030250	CAT50 TF ADB	C5	1.575	0.090	0.090	1.969	2.750	5.580	1	0	–	6.390
E234451916340	03030251	CAT50 TF ADB	C6	1.575	0.120	0.120	2.480	2.750	5.580	1	0	–	6.390
E234451916390	03030252	CAT50 TF ADB	C6	3.543	2.085	2.085	2.480	2.750	7.543	1	0	–	8.660
E2344519180100	03030253	CAT50 TF ADB	C8	3.937	3.185	3.185	3.150	2.750	7.937	2	0	–	9.040
E2344519180150	03030254	CAT50 TF ADB	C8	5.906	5.154	5.154	3.150	2.750	9.906	2	0	–	14.350

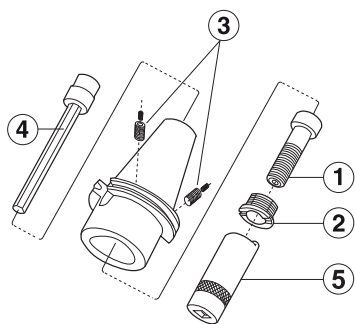
### Accesorii

Pentru mărimea	Prelungitor	Cheie fixă
CAT40/ C4	5680015-05	5680065-10
CAT40/ C5	5680015-01	5680065-11
CAT50/ C4	5680015-05	5680065-10
CAT50/ C5	5680015-01	5680065-11
CAT50/ C6	5680015-02	5680065-12
CAT50/ C8	5680015-02	5680065-12

### Piese de schimb

Pentru mărimea	Șurub central	Dop	Piuliță de fixare
CAT40/ C4	5512063-07	564301701	5512091-03
CAT40/ C5	5512063-08	564301701	5512091-01
CAT50/ C4	5512063-07	564301702	5512091-03
CAT50/ C5	5512063-08	564301702	5512091-01
CAT50/ C6	5512063-09	564301702	5512091-02
CAT50/ C8	5512063-09	564301702	5512091-02

## Accesorii / Piese de schimb



## Accesorii:

4 = Prelungitor

5 = Cheie fixă

## Piese de schimb:

1 = Șurub central

2 = Piuliță de fixare

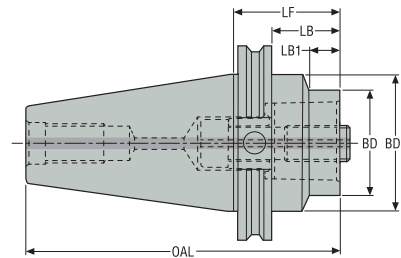
3 = Dopuri de etanșare

## C 5191 – Portsicle standard Seco-Capto™

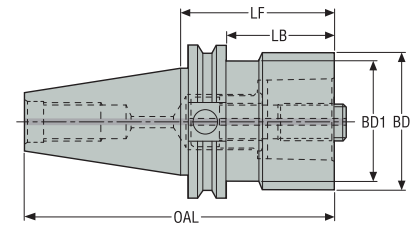
Utilaj CAT TF Mazak™ și seria Mori Seiki NT™



Typ 1



Typ 2



- 90° rotated polygon for precision tool tip control

Reper Nr.	Număr reper	CTMS	CTWS	LF	LB	LB1	BD	BD1	OAL	Varianta	RFID hole	Echilibrare	Greutate
				<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>	<i>Inci</i>				<i>lbs</i>
E947451916350	03030255	CAT50 TF AD Mazak	C6	1.969	0.510	0.510	2.480	2.750	5.960	1	0	-	6.830
E947451918070	03030256	CAT50 TF AD Mazak	C8	2.756	2.000	2.000	3.150	2.750	6.756	2	0	-	7.890
E945451918070	03030257	CAT50 TF AD Mazak	C8	2.756	2.000	2.000	3.150	3.543	6.756	1	0	-	9.040

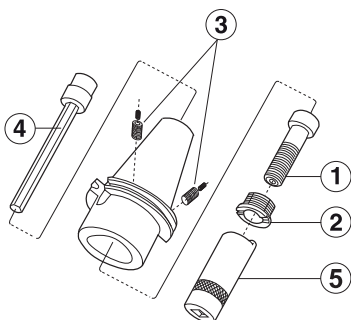
### Accesorii

Pentru mărimea	Prelungitor	Cheie fixă
E947451916350	5680015-02	5680065-12
E947451918070	5680015-02	5680065-12
E945451918070	5680015-02	5680065-12

### Piese de schimb

Pentru mărimea	Șurub central	Piuliță de fixare
E945451918070	5512067-04	5512091-02
E947451916350	5512063-09	5512091-02
E947451918070	5512063-09	5512091-02

### Accesorii / Piese de schimb

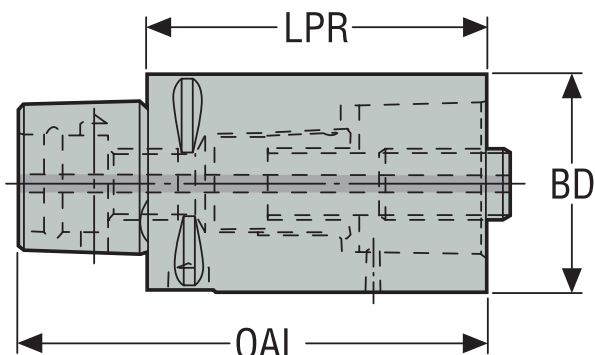


Accesorii:  
4 = Prelungitor  
5 = Cheie fixă

Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare  
3 = Dopuri de etanșare

## C 01 – Extensii Seco-Capto™

ISO 26623-1



Reper Nr.	Număr reper	CTMS	CTWS	LPR	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci			kg lbs
C3-391.01-32060A	75039884	C3	C3	60,0 2.362	32,0 1.260	79,0 3.110	0	-	0,34 0.750
C3-391.01-32080A	00090847	C3	C3	80,0 3.150	32,0 1.260	99,0 3.898	0	-	0,45 0.990
C4-391.01-40060A	75039885	C4	C4	60,0 2.362	40,0 1.575	84,0 3.307	0	-	0,54 1.190
C4-391.01-40080A	02207391	C4	C4	80,0 3.150	40,0 1.575	104,0 4.094	0	-	0,71 1.570
C5-391.01-50080A	75039886	C5	C5	80,0 3.150	50,0 1.969	110,0 4.331	0	-	1,12 2.470
C5-391.01-50100A	00004773	C5	C5	100,0 3.937	50,0 1.969	130,0 5.118	0	-	1,39 3.060
C6-391.01-63100A	75039887	C6	C6	100,0 3.937	63,0 2.480	138,0 5.433	0	-	2,2 4.850
C6-391.01-63140A	00004840	C6	C6	140,0 5.512	63,0 2.480	178,0 7.008	0	-	3,1 6.830
C8-391.01-80100A	75039888	C8	C8	100,0 3.937	80,0 3.150	148,0 5.827	0	-	3,62 7.980
C8-391.01-80125A	00004841	C8	C8	125,0 4.921	80,0 3.150	173,0 6.811	0	-	4,54 10.010

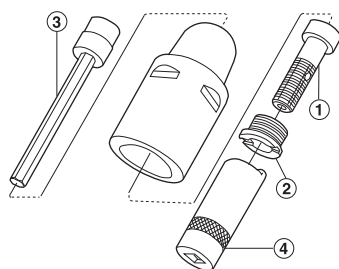
### Accesorii

Pentru mărirea	Prelungitor	Cheie fixă
C3	5680015-05	5680065-13
C4	5680015-05	5680065-10
C5	5680015-01	5680065-11
C6	5680015-02	5680065-12
C8	5680015-02	5680065-12

Piese de schimb

Pentru mărimea	Șurub central	Piuliță de fixare
C3	5512067-01	5512091-04
C4	5512067-02	5512091-03
C5	5512067-03	5512091-01
C6	5512067-04	5512091-02
C8	5512067-04	5512091-02

Accesorii / Piese de schimb



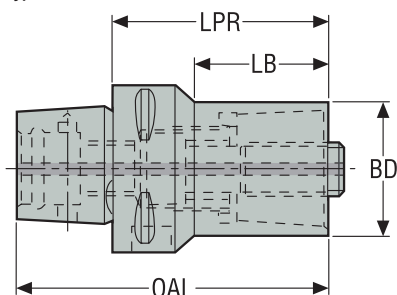
Accesorii:  
3 = Prolungitor  
4 = Cheie pentru piulița de fixare

Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare

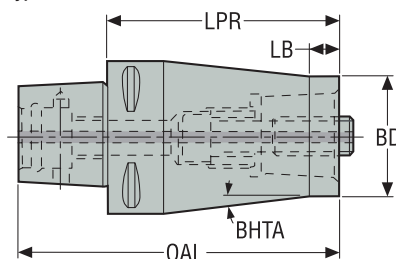
## C 02 – Reductori Seco-Capto™

ISO 26623-1

Typ 1



Typ 2



Reper Nr.	Număr reper	CTMS	CTWS	LPR	LB	BD	OAL	Varianta	BHTA°	RFID hole	Echili-brare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci					kg lbs
C4-391.02-32055A	75039889	C4	C3	55,0 2.165	31,0 1.220	32,0 1.260	79,0 3.110	1	-	0	-	0,42 0.930
C4-391.02-32070A	02535687	C4	C3	70,0 2.756	12,0 0.472	32,0 1.260	94,0 3.701	2	6,0	0	-	0,56 1.230
C5-391.02-32060A	75039890	C5	C3	60,0 2.362	34,8 1.370	32,0 1.260	90,0 3.543	1	-	0	-	0,64 1.410
C5-391.02-40065A	75039891	C5	C4	65,0 2.559	40,0 1.575	40,0 1.575	95,0 3.740	1	-	0	-	0,77 1.700
C6-391.02-32070A	75039892	C6	C3	70,0 2.756	39,0 1.535	32,0 1.260	108,0 4.252	1	-	0	-	1,06 2.340
C6-391.02-40080A	75039893	C6	C4	80,0 3.150	51,4 2.024	40,0 1.575	118,0 4.646	1	-	0	-	1,24 2.730
C6-391.02-50080A	75039894	C6	C5	80,0 3.150	51,5 2.028	50,0 1.969	118,0 4.646	1	-	0	-	1,45 3.200
C6-391.02-50110A	02207400	C6	C5	110,0 4.331	12,0 0.472	50,0 1.969	148,0 5.827	2	4,5	0	-	2,15 4.740
C8-391.02-32060B	03080008	C8	C3	60,0 2.362	20,7 0.815	32,0 1.260	108,0 4.252	1	-	0	-	2,0 4.410
C8-391.02-40070B	03080009	C8	C4	70,0 2.756	31,4 1.236	40,0 1.575	118,0 4.646	1	-	0	-	2,1 4.630
C8-391.02-50080B	03080011	C8	C5	80,0 3.150	42,8 1.685	50,0 1.969	128,0 5.039	1	-	0	-	2,4 5.290
C8-391.02-63080B	02527212	C8	C6	80,0 3.150	44,5 1.752	63,0 2.480	128,0 5.039	1	-	0	-	2,6 5.730
C8-391.02-63120A	02207176	C8	C6	120,0 4.724	12,0 0.472	63,0 2.480	168,0 6.614	2	6,0	0	-	3,96 8.730

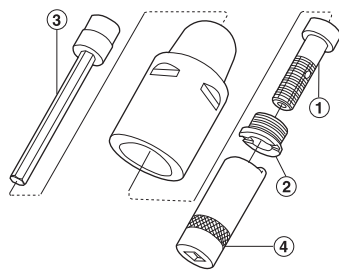
### Accesorii

Pentru mărimea	Prelungitor	Cheie fixă
C...-32	5680015-05	5680065-13
C...-40	5680015-05	5680065-10
C...-50	5680015-01	5680065-11
C...-63	5680015-02	5680065-12

Piese de schimb

Pentru mărimea	Șurub central	Piuliță de fixare
C...32	5512067-01	5512091-04
C...40	5512067-02	5512091-03
C...50	5512067-03	5512091-01
C...63	5512067-04	5512091-02

Accesorii / Piese de schimb



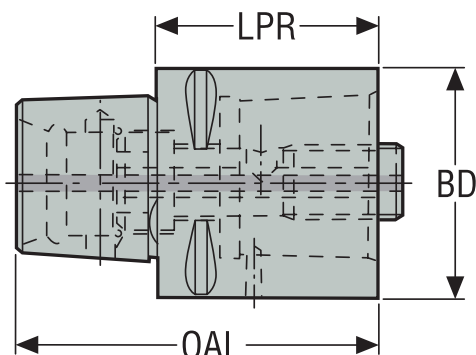
Accesorii:  
3 = Prelungitor  
4 = Cheie pentru piulița de fixare

Piese de schimb:  
1 = Șurub central  
2 = Piuliță de fixare



## C 01 – Extensii Seco-Capto™, versiunea scurtă, doar pentru prindere pe segment

ISO 26623-1



- Partea posterioară a extensiilor scurte Seco-Capto™ se poate monta doar în arbori cu prindere pe segment (nu cu prindere cu bolt central)

Reper Nr.	Număr reper	CTMS	CTWS	LPR	BD	OAL	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci			
C3-391.01-32035	02535685	C3	C3	35,0 1.378	32,0 1.260	54,0 2.126	0	-	0,21 0.460
C4-391.01-40040	02535686	C4	C4	40,0 1.575	40,0 1.575	64,0 2.520	0	-	0,37 0.820
C5-391.01-50050	02484934	C5	C5	50,0 1.969	50,0 1.969	80,0 3.150	0	-	0,7 1.540
C6-391.01-63060	02300834	C6	C6	60,0 2.362	63,0 2.480	98,0 3.858	0	-	1,31 2.890
C8-391.01-80065	02417041	C8	C8	65,0 2.559	80,0 3.150	113,0 4.449	0	-	2,3 5.070

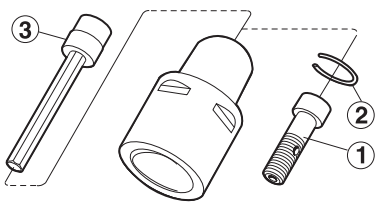
## Accesorii

Pentru	Prelungitor
C3-391.01-32035	5680015-05
C4-391.01-40040	5680015-05
C5-391.01-50050	5680015-05
C6-391.01-63060	5680015-02
C8-391.01-80065	5680015-02

## Piese de schimb

Pentru	Șurub central	Inel de siguranță
C3-391.01-32035	5512068-01	5545040-02
C4-391.01-40040	5512068-02	5545040-03
C5-391.01-50050	5512068-03	5545040-07
C6-391.01-63060	5512068-04	5545040-08
C8-391.01-80065	5512068-05	5545040-08

Accesorii / Piese de schimb

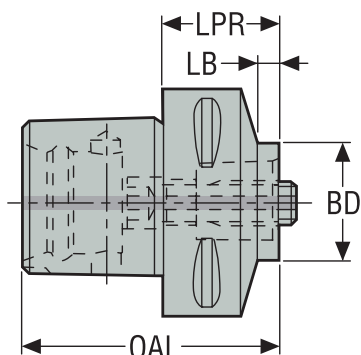


Accesorii:  
3 = Prelungitor

Piese de schimb:  
1 = Șurub central  
2 = Inel de siguranță

## C 02 – Reducții Seco-Capto™, versiunea scurtă, prindere pe segment

ISO 26623-1

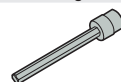


- Partea dinspre mașină a reducțiilor scurte Seco-Capto™ se pot fixa doar în arbori cu prindere pe segment (nu în cele cu fixare cu șurub central)
- \* Cu decalaj de 180° a părții spre mașină față de partea dinspre semifabricat

Reper Nr.	Număr reper	CTMS	CTWS	LPR	LB	BD	OAL	*	RFID hole	Echilibrare	Greutate
				mm Inci	mm Inci	mm Inci	mm Inci				kg lbs
C5-391.02-32033A	03080025	C5	C3	33,0 1.299	5,0 0.197	32,0 1.260	63,0 2.480		0	PB	0,5 1.100
C5-391.02-40040A	03079983	C5	C4	40,0 1.575	15,0 0.591	40,0 1.575	70,0 2.756		0	-	0,6 1.320
C6-391.02-32032	02535690	C6	C3	32,0 1.260	6,0 0.236	32,0 1.260	70,0 2.756		0	-	0,85 1.870
C6-391.02-40040	02459467	C6	C4	40,0 1.575	11,0 0.433	40,0 1.575	78,0 3.071		0	-	0,93 2.050
C6-391.02-50050A	03080019	C6	C5	50,0 1.969	20,0 0.787	50,0 1.969	88,0 3.465		0	-	1,0 2.200
C8-391.02-50045A	03080010	C8	C5	45,0 1.772	5,0 0.197	50,0 1.969	93,0 3.661		0	-	1,9 4.190
C8-391.02-63055A	03080012	C8	C6	55,0 2.165	15,0 0.591	63,0 2.480	103,0 4.055		0	-	2,1 4.630
C8-391.02R-63055A	03080030	C8	C6	55,0 2.165	15,0 0.591	63,0 2.480	103,0 4.055	*	0	-	1,9 4.190

## Accesorii

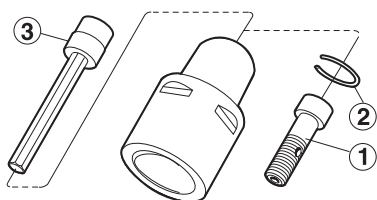
Pentru	Prelungitor
C5-391.02-32033A	5680015-05
C5-391.02-40040A	5680015-05
C6-391.02-32032	5680015-05
C6-391.02-40040	5680015-05
C6-391.02-50050A	5680015-01
C8-391.02-50045A	5680015-01
C8-391.02-63055A	5680015-02
C8-391.02R-63055A	5680015-02



Piese de schimb

Pentru	Șurub central	Inel de siguranță
C5-391.02-32033A	5512068-01	5545040-02
C5-391.02-40040A	5512068-06	5545040-07
C6-391.02-32032	5512068-01	5545040-02
C6-391.02-40040	5512068-02	5545040-03
C6-391.02-50050A	5512068-07	5545040-08
C8-391.02-50045A	5512068-08	5545040-08
C8-391.02-63055A	5512068-05	5545040-08
C8-391.02R-63055A	5512068-05	5545040-08

Accesorii / Piese de schimb



Accesorii:  
3 = Prelungitor

Piese de schimb:  
1 = Șurub central  
2 = Inel de siguranță



## Alezare de degroșare

Gama de produse Seco pentru alezare de degroșare maximizează ratele de evacuare a materialului și precizia prin performanțe robuste și foarte rigide. Concepută pentru modele simetrice și alternante. Soluțiile de amortizare a vibrațiilor Steadyline™ completează gama, pentru a oferi niveluri și mai mari de stabilitate pentru prelucrarea cavităților adânci, în care sunt necesare console de scule lungi.

- Capetele de alezare de degroșare RB 750 oferă cele mai înalte performanțe de alezare de degroșare posibile
- Capetele de alezare de degroșare RB 610 sunt capete de alezare scurte, simple, pentru operații de degroșare

## Vedere generală Capetele de alezat de degroșare

### Graflex®



Ø 18 - 24 (Ø 0.709"-0.945")



Ø 23 - 31 (Ø 0.906"-1.220")



Ø 30 - 40 (Ø 1.181"-1.575")



Ø 39 - 51 (Ø 1.535"-2.008")



Ø 50 - 65 (Ø 1.968"-2.559")



Ø 64 - 86 (Ø 2.520"-3.386")



Ø 85 - 144 (Ø 3.346"-5.669")



Ø 114 - 205  
(Ø 4.488"-8.071")

### Seco-Capto™



Ø 39 - 51 (Ø 1.535"-2.008")



Ø 50 - 65 (Ø 1.968"-2.559")



Ø 64 - 86 (Ø 2.520"-3.386")

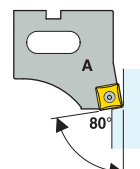
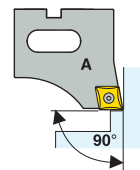
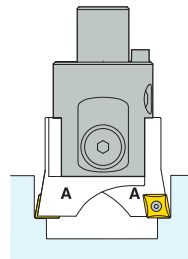


Ø 85 - 144 (Ø 3.346"-5.669")

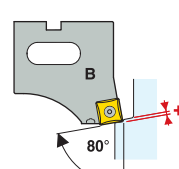
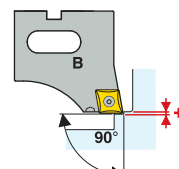
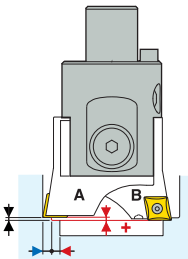


Ø 114 - 205  
(Ø 4.488"-8.071")

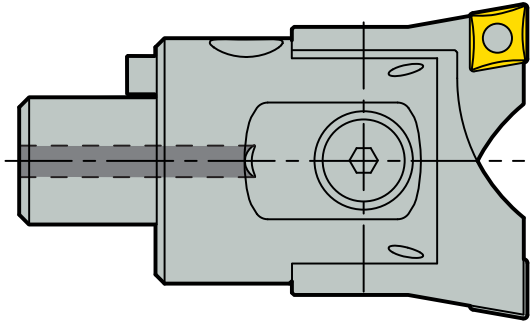
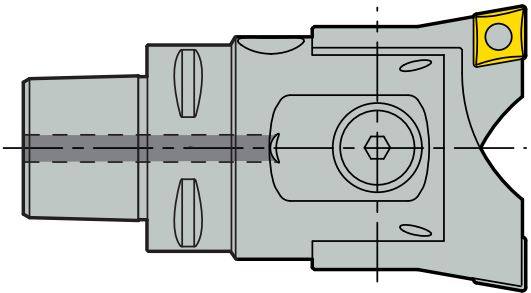
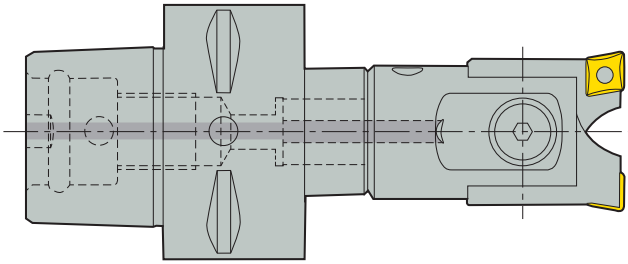
Alezare simetrică:  
 2 port-plăcuțe standard tip A



Alezare asimetrică:  
 1 port-plăcuță extinsă tip B și 1  
 standard tip A



## Caracteristici

<p><b>Capete de alezare de degroșare Graflex®</b></p> <ul style="list-style-type: none"> <li>• Ø 18-205 mm (0,709-8,071")</li> <li>• 8 capete de alezare de degroșare RB 750 cu conexiune Graflex® pentru alezaje cu diametrul între 18 și 205 mm (0,709-8,071")</li> </ul>		Introducere
<p><b>Capete de alezare de degroșare Seco-Capto™</b></p> <ul style="list-style-type: none"> <li>• <b>Notă:</b> Alezajul minim al celui mai mic cap de alezare de degroșare Capto™ este Ø 39 mm (1,535") cu cea mai mică conexiune Capto™ C3 disponibilă.</li> <li>• Pentru Ø 18-40 mm (0,709-1,575"), utilizați capete de alezare Graflex® cu mărimi de conexiune între G0 și G2 în combinație cu adaptorul Capto™/Graflex® adecvat.</li> </ul>		Găuire
<p><b>Capete de alezare de degroșare Seco-Capto™</b></p> <ul style="list-style-type: none"> <li>• <b>Notă:</b> Caracteristici, instrucțiuni (procedura de instalare a suportului de plăcuță, setarea diametrului, instrucțiuni pentru alezarea inversă, depanare, condiție recomandate de prelucrare, viteze maxime), suporturile de plăcuțe și plăcuțele adecvate sunt similare pentru ambele tipuri de capete de alezare de degroșare RB 750 cu capacitate de alezare similară, indiferent de tipul de conexiune.</li> <li>• Ansambluri modulare și condiții de prelucrare pentru adaptoare și extensii modulare Seco-Capto™ și Graflex®: consultați catalogul de port-scule.</li> </ul>		Alezare

## Caracteristici

Un ansamblu/cap pentru alezare de degroșare este compus dintr-un corp (cap) 2 portplăcuțe

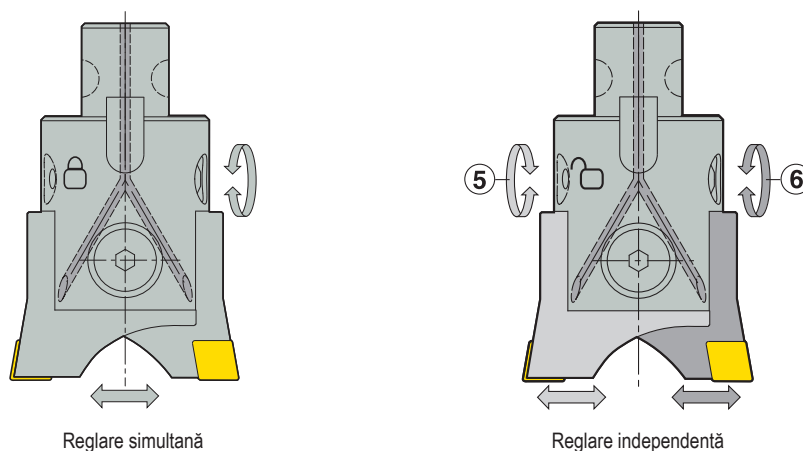
**Este posibilă reglarea simultană sau independentă a port-plăcuțelor:**

Reglare simultană cu ajutorul mecanismului de cuplare al suporturilor de plăcuță (capetele cele mai mici  $\varnothing$  18-24 mm (0,709-0,9445") nu au mecanism de cuplare).

Fiecare șurub de cuplare deplasează ambele portplăcuțe simultan (sunt cuplate).

Este posibilă reglarea diametrului fără preseter (1 treaptă = 0,1 mm (0,004") în diametru).

Este posibilă și reglarea independentă: decuplați mecanismul de cuplare și fiecare șurub de reglare va acționa doar asupra suportului său de plăcuță.



### Alezare simetrică:

Alezare simetrică înseamnă că ambele muchii de tăiere au același diametru:  
Sunt necesare două port-plăcuțe standard tip A identice (cu același unghi de atac).

### Alezare asimetrică:

Alezare alternantă înseamnă că o muchie așchietoare este decalată ca muchie așchietoare primară care funcționează la un diametru mai mic decât a doua muchie reglată la diametrul de executat. Necesită un suport de plăcuță standard tip A și un suport de plăcuță extins tip B, pentru a obține decalarea axială (+) dorită.

### Suporturi de plăcuțe cu unghi de avans de 90° sau 80°

Suporturile de plăcuțe A75...CC... și A75...CP... au un unghi de avans de 90° pentru plăcuțe rombice: în principal adecvate pentru găuri înfundate și necesită un cuplu mai mic al capului de alezare.

Port-plăcuțele A75...SC... au unghiul de atac de 80° pentru plăcuțele pătrate: folosite în general la găuri străpunse și în condiții grele. Orientarea unghiurilor de așchiere conform ISO.



## Caracteristici

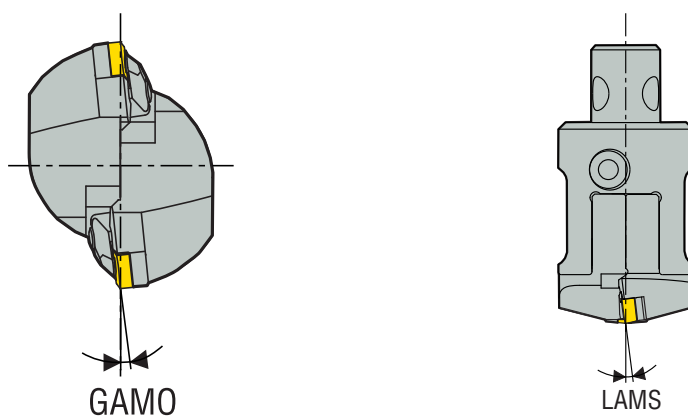
### Suporturi de plăcuță tip CC, CP, SC sau CN

Suporturile de plăcuță A750...CC..., A750...CP... și A750...SC... au unghi de degajare de  $0^\circ$  (GAMO) și unghi de înclinare  $0^\circ$  (LAMS).

Suporturile de plăcuță A750...CN... au unghi de degajare  $-6^\circ$  (GAMO) și unghi de înclinare  $-6^\circ$  (LAMS), permițând utilizarea de plăcuțe CNMM negative și, în special, plăcuțe CNMG cu 4 muchii așchietoare.

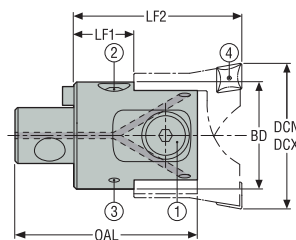
În acest caz, este important să se aleagă plăcuțele CN recomandate și să se respecte regimurile de așchiere recomandate (vezi pag. 646).

Folosind alte plăcuțe, ex. cu unghiul de tăiere diferit, și/sau alte regimuri de așchiere poate duce la deteriorarea utilajului și/sau a semifabricatului.



# RB750

Graflex®



- Este posibilă alezarea simetrică sau asimetrică
- Reglare simultană datorită mecanismului de cuplare a portplăcuțelor

1. Șurub de asamblare
2. Șurub reglaj
3. Șurubul e blocare al mecanismului de cuplare
4. Șurubul plăcuței

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat		OAL	LF1	LF2	BD	Greutate	Modul de reglare simultană		Mod de reglare independent		RPM max.
			Capacitatea DCN-DCX Ø							Da	Nu	Da	Nu	
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs					
A75000	00026687	G0	18,0 0.709	24,0 0.945	38,0 1.496	12,5 0.492	35,0 1.378	16,5 0.650	0,03 0.070		■	■		15000
A75010	00026688	G1	23,0 0.906	31,0 1.220	42,5 1.673	13,5 0.531	40,0 1.575	21,5 0.846	0,1 0.220	■		■		12000
A75020	00026689	G2	30,0 1.181	40,0 1.575	51,0 2.008	16,0 0.630	46,0 1.811	27,0 1.063	0,11 0.240	■		■		9500
A75030	00026690	G3	39,0 1.535	51,0 2.008	69,0 2.717	24,0 0.945	65,0 2.559	35,0 1.378	0,5 1.100	■		■		7500
A75040	00026691	G4	50,0 1.969	65,0 2.559	78,0 3.071	27,0 1.063	72,0 2.835	43,0 1.693	0,46 1.010	■		■		5700
A75050	00026692	G5	64,0 2.520	86,0 3.386	92,0 3.622	30,0 1.181	82,0 3.228	54,0 2.126	0,8 1.760	■		■		4500
A75060	00026693	G6	85,0 3.346	144,0 5.669	119,0 4.685	37,0 1.457	105,0 4.134	70,0 2.756	1,69 3.730	■		■		3500
A75070	00026694	G7	114,0 4.488	205,0 8.071	143,0 5.630	39,0 1.535	120,0 4.724	95,0 3.740	3,7 8.160	■		■		2500

Portplăcuțele se vor comanda separat, vezi pag. 562-566  
Note, weight is without insert holder

## Piese de schimb

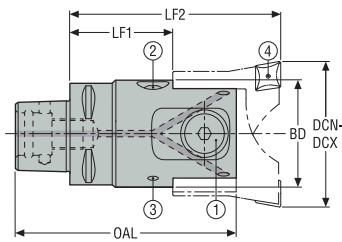
## Accesorii

Pentru cap	Șurub ansamblu	Cheie clemă	Cheie de ghidare	Cheie plăcuță	Cheie (tip T)	Cheie de reglare	Cep	Calibru de reglare
A75000	90A75000	03HL03	-	H4B-T07P	DOUBLE-T	H1.5-2D	90M0	-
A75010	90A75010	03HL03	H4B-T06P	H4B-T07P	DOUBLE-T	H1.5-2D	90M11	CAA75010
A75020	90A75020	03HL04	H4B-T07P	-	DOUBLE-T	H2.0-2D	90M21	CAA75020
A75030	90A75030	03HL05	H4B-T08P	-	DOUBLE-T	H2.0-2D	90M31	CAA75030
A75040	90A75040	03HL05	H4B-T09P	-	DOUBLE-T	H2.5-2D	90M41	CAA75040
A75050	90A75050	03HL06	-	-	DOUBLE-T	03M03C	90M51	CAA75050
A75060	90A75060	03HL08	-	-	DOUBLE-T	H04-4	90M61	CAA75060
A75070	90A75070	03HL10	H4B-T15P	H4B-T15PL	DOUBLE-T	H04-4	90M71	CAA75070

Accesorii, se vor comanda separat

RB750

Seco-Capto™



1. Șurub de asamblare
2. Șurub reglaj
3. Șurubul e blocare al mecanismului de cuplare
4. Șurubul plăcuței



- Este posibilă alezarea simetrică sau asimetrică
- Reglare simultană datorită mecanismului de cuplare a portplăcuțelor

Reper Nr.	Număr reper	Spre mașină	Spre semifabricat		OAL	LF1	LF2	BD	Greutate	Modul de reglare simultană		Mod de reglare independent		RPM max.
			Capacitatea DCN-DCX Ø							Da	Nu	Da	Nu	
C3-391.0750-30	02809726	C3	39,0 1.535	51,0 2.008	73,0 2.874	29,0 1.142	70,0 2.756	35,0 1.378	0,28 0.620	■		■		7500
C4-391.0750-40	02809728	C4	50,0 1.969	65,0 2.559	88,0 3.465	37,0 1.457	82,0 3.228	43,0 1.693	0,52 1.150	■		■		5700
C5-391.0750-50	02809733	C5	64,0 2.520	86,0 3.386	102,0 4.016	40,0 1.575	92,0 3.622	54,0 2.126	0,94 2.070	■		■		4500
C6-391.0750-60	02809735	C6	85,0 3.346	144,0 5.669	129,0 5.079	49,0 1.929	117,0 4.606	70,0 2.756	1,88 4.140	■		■		3500
C8-391.0750-70	02809736	C8	114,0 4.488	205,0 8.071	159,0 6.260	57,0 2.244	138,0 5.433	95,0 3.740	4,14 9.130	■		■		2500

Portplăcuțele se vor comanda separat, vezi pag. 562-566  
Note, weight is without insert holder

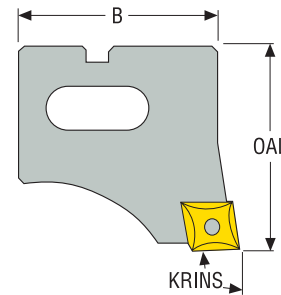
Piese de schimb

Accesorii

Pentru cap	Șurub ansamblu	Cheie clemă	Cheie de ghidare	Cheie (tip T)	Cheie de reglare	Calibru de reglare
C3-...-30	90A75030	03HL05	H4B-T08P	DOUBLE-T	H2.0-2D	CAA75030
C4-...-40	90A75040	03HL05	H4B-T09P	DOUBLE-T	H2.5-2D	CAA75040
C5-...-50	90A75050	03HL06	-	DOUBLE-T	03M03C	CAA75050
C6-...-60	90A75060	03HL08	-	DOUBLE-T	H04-4	CAA75060
C8-...-70	90A75070	03HL10	-	DOUBLE-T	H04-4	CAA75070

Accesorii, se vor comanda separat

## Insert holders 90° for CC.. and CP.. inserts



- Pentru montare în capetele RB 750
- Alezarea simetrică necesită două portplăcuțe standard tip A
- Alezarea asimetrică necesită o portplăcuță standard tip A și una extinsă tip B

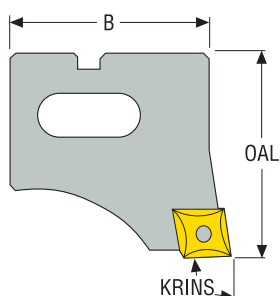
Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX Ø		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm Inci	mm Inci					
A75000CP0590	00026695	Standard type A	RB 75000	18,0 0.709	24,0 0.945	22,5 0.886	16,5 0.650	0,01 0.020	90	CP...0502...
A75010CC0690	00026696	Standard type A	RB 75010	23,0 0.906	31,0 1.220	26,5 1.043	21,5 0.846	0,02 0.040	90	CC...0602...
A75020CC0690	00026697	Standard type A	RB 75020	30,0 1.181	40,0 1.575	30,0 1.181	27,0 1.063	0,04 0.090	90	CC...0602...
A75030CC0990	00026698	Standard type A	RB 75030	39,0 1.535	51,0 2.008	41,0 1.614	35,0 1.378	0,08 0.180	90	CC...09T3...
A75040CC1290	00026699	Standard type A	RB 75040	50,0 1.969	65,0 2.559	45,0 1.772	43,0 1.693	0,14 0.310	90	CC...1204...
A75050CC1290	00026700	Standard type A	RB 75050	64,0 2.520	86,0 3.386	52,0 2.047	54,0 2.126	0,25 0.550	90	CC...1204...
A75060CC1290	00026701	Standard type A	RB 75060	85,0 3.346	115,0 4.528	68,0 2.677	70,0 2.756	0,55 1.210	90	CC...1204...
A75060CC1690	00030763	Standard type A	RB 75060	85,0 3.346	115,0 4.528	68,0 2.677	70,0 2.756	0,55 1.210	90	CC...1605...
A75065CC1290	00026702	Standard type A	RB 75060	114,0 4.488	144,0 5.669	68,0 2.677	100,0 3.937	0,89 1.960	90	CC...1204...
A75065CC1690	00030765	Standard type A	RB 75060	114,0 4.488	144,0 5.669	68,0 2.677	100,0 3.937	0,9 1.980	90	CC...1605...
A75070CC1290	00026703	Standard type A	RB 75070	114,0 4.488	160,0 6.299	81,0 3.189	95,0 3.740	1,18 2.600	90	CC...1204...
A75070CC1690	00030766	Standard type A	RB 75070	114,0 4.488	160,0 6.299	81,0 3.189	95,0 3.740	1,18 2.600	90	CC...1605...
A75075CC1290	00026704	Standard type A	RB 75070	159,0 6.260	205,0 8.071	81,0 3.189	141,0 5.551	2,0 4.410	90	CC...1204...
A75075CC1690	00030771	Standard type A	RB 75070	159,0 6.260	205,0 8.071	81,0 3.189	141,0 5.551	2,0 4.410	90	CC...1605...

## Piese de schimb

Pentru dimensiunea plăcuței	Cheie plăcuță	Cheie (tip T)	Șurub
CP...0502...	H4B-T07P	DOUBLE-T	C02245-T07P
CC...0602...	H4B-T07P	DOUBLE-T	C02504-T07P
CC...09T3...	H4B-T15P	DOUBLE-T	C04008-T15P
CC...1204...	H4B-T15P	DOUBLE-T	C05012-T15P
CC...1605...	H4B-T15P	DOUBLE-T	C05012-T15P

Pentru plăcuțe de degroșare recomandate, vezi pag. 646

## Insert holders 90° for CC.. and CP.. inserts



- Pentru montare în capetele RB 750
- Alezarea simetrică necesită două portplăcuțe standard tip A
- Alezarea asimetrică necesită o portplăcuță standard tip A și una extinsă tip B

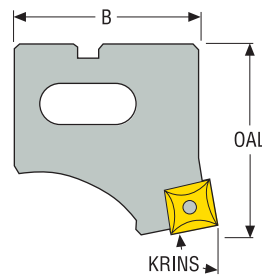
Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX Ø		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm Inci	mm Inci					
A75001CP0590	00026705	Extended type B	RB 75000	18,0 0.709	24,0 0.945	22,8 0.898	16,5 0.650	0,01 0.020	90	CP...0502...
A75011CC0690	00026706	Extended type B	RB 75010	23,0 0.906	31,0 1.220	26,85 1.057	21,5 0.846	0,02 0.040	90	CC...0602...
A75021CC0690	00026707	Extended type B	RB 75020	30,0 1.181	40,0 1.575	30,35 1.195	27,0 1.063	0,04 0.090	90	CC...0602...
A75031CC0990	00026708	Extended type B	RB 75030	39,0 1.535	51,0 2.008	41,4 1.630	35,0 1.378	0,08 0.180	90	CC...09T3...
A75041CC1290	00026709	Extended type B	RB 75040	50,0 1.969	65,0 2.559	46,5 1.831	43,0 1.693	0,13 0.290	90	CC...1204...
A75051CC1290	00026710	Extended type B	RB 75050	64,0 2.520	86,0 3.386	52,6 2.071	54,0 2.126	0,25 0.550	90	CC...1204...
A75061CC1290	00026711	Extended type B	RB 75060	85,0 3.346	115,0 4.528	68,6 2.701	70,0 2.756	0,55 1.210	90	CC...1204...
A75061CC1690	00030774	Extended type B	RB 75060	85,0 3.346	115,0 4.528	68,6 2.701	70,0 2.756	0,55 1.210	90	CC...1605...
A75066CC1290	00026712	Extended type B	RB 75060	114,0 4.488	144,0 5.669	68,6 2.701	100,0 3.937	0,91 2.010	90	CC...1204...
A75066CC1690	00030775	Extended type B	RB 75060	114,0 4.488	144,0 5.669	68,6 2.701	100,0 3.937	0,91 2.010	90	CC...1605...
A75071CC1290	00026713	Extended type B	RB 75070	114,0 4.488	160,0 6.299	81,6 3.213	95,0 3.740	1,16 2.560	90	CC...1204...
A75071CC1690	00030776	Extended type B	RB 75070	114,0 4.488	160,0 6.299	81,6 3.213	95,0 3.740	1,16 2.560	90	CC...1605...
A75076CC1290	00026714	Extended type B	RB 75070	159,0 6.260	205,0 8.071	81,6 3.213	141,0 5.551	2,0 4.410	90	CC...1204...
A75076CC1690	00030778	Extended type B	RB 75070	159,0 6.260	205,0 8.071	81,6 3.213	141,0 5.551	2,01 4.430	90	CC...1605...

### Piese de schimb

Pentru dimensiunea plăcuței	Cheie (tip T)	Cheie	Șurub
CP...0502...	DOUBLE-T	H4B-T07P	C02245-T07P
CC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
CC...09T3...	DOUBLE-T	-	C04008-T15P
CC...1204...	DOUBLE-T	-	C05012-T15P
CC...1605...	DOUBLE-T	-	C05012-T15P

Pentru plăcuțe de degroșare recomandate, vezi pag. 646

## Insert holders 80° for SC.. inserts






- Pentru montare în capetele RB 750
- Alezarea simetrică necesită două portplăcuțe standard tip A
- Alezarea asimetrică necesită o portplăcuță standard tip A și una extinsă tip B

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX Ø		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm Inci	mm Inci					
A75000SC0580	00026715	Standard type A	RB 75000	18,0 0.709	24,0 0.945	22,5 0.886	16,5 0.650	0,01 0.020	80	SC...0502...
A75010SC0680	00026716	Standard type A	RB 75010	23,0 0.906	31,0 1.220	26,5 1.043	21,5 0.846	0,02 0.040	80	SC...0602...
A75020SC0680	00026717	Standard type A	RB 75020	30,0 1.181	40,0 1.575	30,0 1.181	27,0 1.063	0,04 0.090	80	SC...0602...
A75030SC0980	00026718	Standard type A	RB 75030	39,0 1.535	51,0 2.008	41,0 1.614	35,0 1.378	0,08 0.180	80	SC...09T3...
A75040SC1280	00026719	Standard type A	RB 75040	50,0 1.969	65,0 2.559	45,0 1.772	43,0 1.693	0,03 0.070	80	SC...1204...
A75050SC1280	00051986	Standard type A	RB 75050	64,0 2.520	86,0 3.386	52,0 2.047	54,0 2.126	0,25 0.550	80	SC...1204...
A75060SC1280	00052207	Standard type A	RB 75060	85,0 3.346	115,0 4.528	68,0 2.677	70,0 2.756	0,56 1.230	80	SC...1204...
A75060SC1580	00039863	Standard type A	RB 75060	85,0 3.346	115,0 4.528	68,0 2.677	70,0 2.756	0,56 1.230	80	SC...1505...
A75065SC1280	00051989	Standard type A	RB 75060	114,0 4.488	144,0 5.669	68,0 2.677	100,0 3.937	0,94 2.070	80	SC...1204...
A75065SC1580	00039865	Standard type A	RB 75060	114,0 4.488	144,0 5.669	68,0 2.677	100,0 3.937	1,0 2.200	80	SC...1505...
A75070SC1280	00026723	Standard type A	RB 75070	114,0 4.488	160,0 6.299	81,4 3.205	95,0 3.740	1,2 2.650	80	SC...1204...
A75070SC1580	00039867	Standard type A	RB 75070	114,0 4.488	160,0 6.299	81,4 3.205	95,0 3.740	1,18 2.600	80	SC...1505...
A75075SC1280	00026724	Standard type A	RB 75070	159,0 6.260	205,0 8.071	81,4 3.205	141,0 5.551	2,09 4.610	80	SC...1204...
A75075SC1580	00039869	Standard type A	RB 75070	159,0 6.260	205,0 8.071	81,4 3.205	141,0 5.551	2,1 4.630	80	SC...1505...
A75001SC0580	00092946	Extended type B	RB 75000	18,0 0.709	24,0 0.945	23,2 0.913	16,5 0.650	0,01 0.020	80	SC...0502...
A75011SC0680	00092947	Extended type B	RB 75010	23,0 0.906	31,0 1.220	27,3 1.075	21,5 0.846	0,02 0.040	80	SC...0602...
A75021SC0680	00092948	Extended type B	RB 75020	30,0 1.181	40,0 1.575	30,9 1.217	27,0 1.063	0,04 0.090	80	SC...0602...
A75031SC0980	00092949	Extended type B	RB 75030	39,0 1.535	51,0 2.008	42,2 1.661	35,0 1.378	0,08 0.180	80	SC...09T3...
A75041SC1280	00092961	Extended type B	RB 75040	50,0 1.969	65,0 2.559	46,4 1.827	43,0 1.693	0,14 0.310	80	SC...1204...
A75051SC1280	00092962	Extended type B	RB 75050	64,0 2.520	86,0 3.386	53,7 2.114	54,0 2.126	0,26 0.570	80	SC...1204...
A75061SC1580	00039864	Extended type B	RB 75060	85,0 3.346	115,0 4.528	70,3 2.768	70,0 2.756	0,57 1.260	80	SC...1505...
A75061SC1280	00092963	Extended type B	RB 75060	85,0 3.346	115,0 4.528	69,8 2.748	70,0 2.756	0,57 1.260	80	SC...1204...

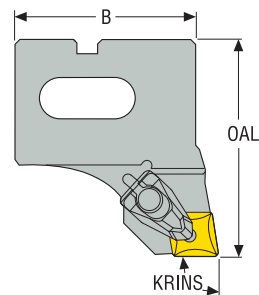
Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX Ø		OAL		B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm Inci	mm Inci	mm Inci	mm Inci				
A75066SC1280	00092964	Extended type B	RB 75060	114,0 4.488	144,0 5.669	69,8 2.748	100,0 3.937	100,0 3.937	0,96 2.120	80	SC...1204...
A75066SC1580	00039866	Extended type B	RB 75060	114,0 4.488	144,0 5.669	70,3 2.768	100,0 3.937	100,0 3.937	0,96 2.120	80	SC...1505...
A75071SC1280	00092965	Extended type B	RB 75070	114,0 4.488	160,0 6.299	82,8 3.260	95,0 3.740	95,0 3.740	1,21 2.670	80	SC...1204...
A75071SC1580	00039868	Extended type B	RB 75070	114,0 4.488	160,0 6.299	83,3 3.280	95,0 3.740	95,0 3.740	1,21 2.670	80	SC...1505...
A75076SC1280	00092968	Extended type B	RB 75070	159,0 6.260	205,0 8.071	82,8 3.260	141,0 5.551	141,0 5.551	2,16 4.760	80	SC...1204...
A75076SC1580	00039870	Extended type B	RB 75070	159,0 6.260	205,0 8.071	83,3 3.280	141,0 5.551	141,0 5.551	2,14 4.720	80	SC...1505...

### Piese de schimb

Pentru dimensiunea plăcuței	Cheie (tip T)	Cheie	Șurub
SC...0502...	 DOUBLE-T	 H4B-T07P	 C02245-T07P
SC...0602...	DOUBLE-T	H4B-T07P	C02504-T07P
SC...09T3...	DOUBLE-T	-	C04008-T15P
SC...1204...	DOUBLE-T	-	C05012-T15P
SC...1505...	DOUBLE-T	-	C05012-T15P

Pentru plăcuțe de degroșare recomandate, vezi pag. 646





## Insert holders 90° for CN.. inserts



- Pentru montare în capetele RB 750
- Alezarea simetrică necesită două port-plăcuțe tip A standard (port-plăcuțe tip B extins pentru plăcuțele CN.. nu sunt disponibile).
- GAMO = Unghiul de degajare = - 6°
- LAMS = Unghiul de înclinare = - 6°

Reper Nr.	Număr reper	Pas	Pentru cap	Capacitatea DCN-DCX Ø		OAL	B	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm Inci	mm Inci					
A75050CN1290	02786307	Standard type A	RB 75050	64,0 2.520	86,0 3.386	63,0 2.480	55,0 2.165	0,28 0.620	90	CN...1204...
A75060CN1290	02786308	Standard type A	RB 75060	85,0 3.346	115,0 4.528	68,0 2.677	69,5 2.736	0,58 1.280	90	CN...1204...
A75065CN1290	02786309	Standard type A	RB 75060	114,0 4.488	144,0 5.669	68,0 2.677	99,5 3.917	0,98 2.160	90	CN...1204...
A75070CN1290	02786310	Standard type A	RB 75070	114,0 4.488	160,0 6.299	85,0 3.346	95,0 3.740	1,25 2.760	90	CN...1204...
A75075CN1290	02786311	Standard type A	RB 75070	159,0 6.260	205,0 8.071	85,0 3.346	140,0 5.512	2,03 4.480	90	CN...1204...

## Piese de schimb

Pentru dimensiunea plăcuței	Șurub nicovală	Set clemă	Nicovală	Cheie (tip T)
CN...1204...	 CSC6312-T15P	 CD12-S12	 UCN120612	 DOUBLE-T

Pentru plăcuțe de degroșare recomandate, vezi pag. 646



## Instrucțiuni Condiții de prelucrare recomandate

### Puterea mașinii:

Având în vedere că degroșarea necesită putere mare, vă recomandăm să verificați dacă mașina este potrivită. Alezarea asimetrică este o soluție pentru reducerea necesarului de putere, avansul fiind divizat la 2 pentru aceeași adâncime de tăiere, comparativ cu cea simetrică.

Performanțe optime se obțin cu răcire internă (regimuri de așchiere mari, finisare superioară a suprafeței, evacuare mai bună a așchiilor, viață mai lungă a plăcuței).

Pentru instrucțiunile de utilizare detaliate, verificați instrucțiunile de utilizare livrate împreună cu pachetul capului de alezat sau cu barele Steadyline®. Aceste instrucțiuni pot fi descărcate de pe [www.secotools.com](http://www.secotools.com)

### Vitezele maxime pentru capetele de alezare de degroșare

Cap	Capacitate Ø mm	Capacitate Ø inci	RPM max.	Viteza max de așchiere implicită $v_c$ la Cap. min. m/ min (feet/min)	Viteza max de așchiere implicită $v_c$ la Cap. max. m/ min (feet/min)
Capete de alezare de degroșare (cu două portplăcuțe identice reglate simetric), cu conexiune Graflex®					
A75000	18-24	0.709-0.945	15000	848 (2782)	1131 (3711)
A75010	23-31	0.906-1.220	12000	867 (2844)	1169 (3835)
A75020	30-40	1.181-1.575	9500	895 (2936)	1194 (3917)
A75030	39-51	1.535-2.008	7500	919 (3015)	1202 (3944)
A75040	50-65	1.969-2.559	5700	895 (2936)	1164 (3819)
A75050	64-86	2.520-3.386	4500	905 (2969)	1216 (3990)
A75060	85-115	3.346-4.528	3500	935 (3068)	1264 (4147)
A75060	114-144	4.488-5.669	2700	967 (3173)	1221 (4006)
A75070	114-160	4.488-6.299	2500	895 (2936)	1257 (4124)
A75070	159-205	6.260-8.071	2000	999 (3278)	1288 (4226)
Capete de alezare de degroșare (cu două portplăcuțe identice reglate simetric), cu conexiune Seco-Capto™					
C3-391.0750-30	39-51	1.535-2.008	7500	919 (3015)	1202 (3944)
C4-391.0750-40	50-65	1.969-2.559	5700	895 (2936)	1164 (3819)
C5-391.0750-50	64-86	2.520-3.386	4500	905 (2969)	1216 (3990)
C6-391.0750-60	85-115	3.346-4.528	3500	935 (3068)	1264 (4147)
C6-391.0750-60	114-144	4.488-5.669	2700	967 (3173)	1221 (4006)
C8-391.0750-70	114-160	4.488-6.299	2500	895 (2936)	1257 (4124)
C8-391.0750-70	159-205	6.260-8.071	2000	999 (3278)	1288 (4226)

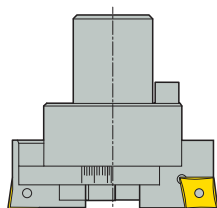
**Notă:** Vitezele maxime depind de designul mecanic al capului de alezat și de calitatea echilibrării. Vitezele dintre aceste limite trebuie alese în funcție de alte condiții de prelucrare, ex.: materialul semifabricatului, muchia de așchiere (sucle și plăcuțe), Lungimea sistemului de scule, arborele mașinii. Pentru viteze de aprox. 8000 RPM sau mai mult, arborii și intermediarii trebuie să fie fin echilibrați.

## Instrucțiuni de depanare

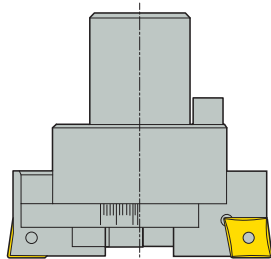
Problemă	Cauză posibilă	Soluție
Control slab al așchiei	Rata avansului prea mică	Măriți avansul
	Adâncime de tăiere prea mare	Utilizați metoda asimetrică
Șocuri și vibrații	Viteză prea mare	Reduceți viteza, nu avansul Scurtează scula pentru a crește rigiditatea
	Raport L/D extrem	Mărește OD arborelui și prinderilor intermediare
		Utilizați o bară Steadyline
		Utilizează carbură sau metal greu pentru extensii
	Raza plăcuței prea mare	Utilizați o plăcuță cu rază mai mică.
	Piesă de lucru instabilă	Îmbunătățește fixarea și suportul de prindere
	Unghiul de atac $\kappa$ este 80°	$\Sigma\chi\eta\mu\beta\Box\chi\upsilon\kappa=90^\circ$ , plăcuțe tip CC
Ciupirea sau spargerea plăcuței	Plăcuță aleasă greșit	Schimbă cu o calitate mai rezistentă a plăcuței Utilizează o rază mai mare dacă este posibil
	Așchiere cu întreruperi severe	Micșorează viteza, mărește avansul
	Așchii sunt împachetate și re-tăiate	Verifică diferența între diametrul găurii și al barei de alezat Îmbunătățește controlul așchiilor, mărește avansul
Viață scurtă a sculei	Plăcuță aleasă greșit	Schimbă cu o calitate mai rezistentă la uzură
	Viteza de așchiere prea mare	Reduceți viteza
	Ciupituri pe plăcuță	Verifică adâncimea de așchiere și avansul
	Presiune prea mică a lichidului de răcire	Creșteți presiunea lichidului de răcire
Așchiile nu sunt evacuate	Bara de alezare prea mare	Utilizați capete mai mici cu port-plăcuțe cu extensie dacă este posibil
	Adâncime de tăiere prea mare	Utilizați metoda asimetrică; de preferat plăcuțe CC.. în loc de CN.. (mai ales la utilizarea capetelor de alezat cu diametre mici).
	Spațiu neadecvat sub alezaj	Reglați piesa mai sus pe masa de lucru
	Control slab al așchiei	Vezi mai sus
Putere mică a mașinii	Rata avansului prea mare	Reduceți rata avansului (nu mai puțin de 25% din raza plăcuței)
	Adâncime de tăiere prea mare	Utilizați metoda asimetrică
	Putere mică a mașinii	RPM în zona de cuplu mic al arborelui: mărește viteza
		RPM în zona de schimbare a vitezelor: reglați RPM
		Utilizează plăcuțe cu unghi mai mare de degajare (HSS în cazuri extreme)
Reduceți adâncimea de tăiere		
Bavuri excesive la ieșirea găurii	Rata avansului prea mare	Reduceți avansul
	Port-plăcuță tip CC 90°	Utilizează port-plăcuță pătrată 80°
	Forțe de așchiere prea mari	Reduceți adâncimea de tăiere Reduceți raza plăcuței

RB 610 Capete de alezare pentru degroșare – Vedere generală

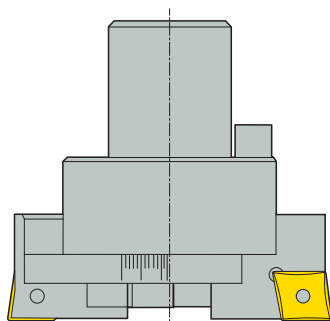
Graflex® conexiune



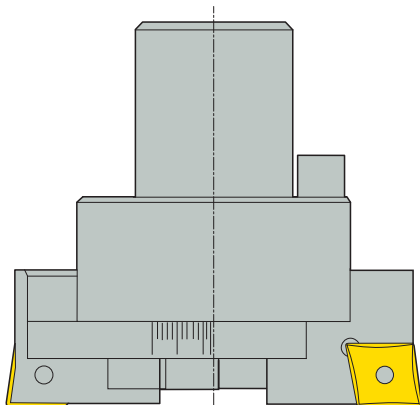
Ø 39–51 mm (Ø 1.535–2.008")



Ø 50–65 mm (Ø 1.969–2.559")

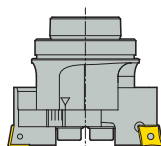


Ø 64–86 mm (Ø 2.520–3.386")

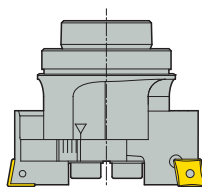


Ø 85–115 mm (Ø 3.346–4.528")

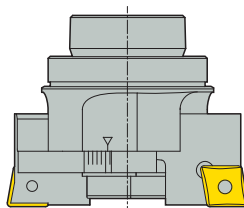
GL conexiune



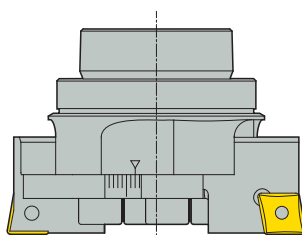
Ø 28–37 mm (Ø 1.102–1.457")



Ø 36–46 mm (Ø 1.417–1.811")

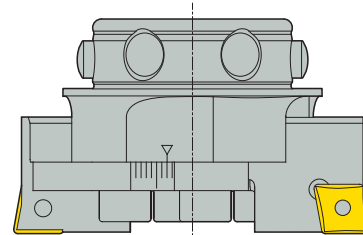


Ø 45–56 mm (Ø 1.772–2.205")

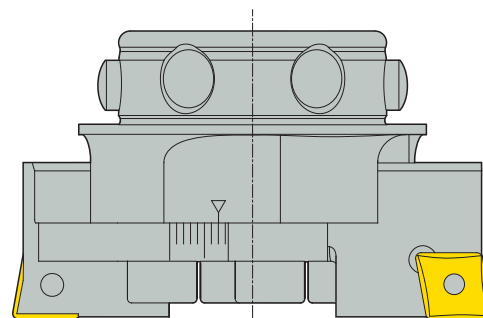


Ø 55–69 mm (Ø 2.165–2.717")

BA conexiune



Ø 66–88 mm (Ø 2.598–3.465")



Ø 86–116 mm (Ø 3.386–4.567")

## Capete de alezare de degroșare RB 610 - Ghid

### Caracteristici

- Un ansamblu de cap de alezare de degroșare este o combinație de 1 corp (cap) și 2 suporturi de plăcuță
- Atingerea preciziei geometrice a găurilor începând cu găuri turnate, tăiate cu flacăra sau perorate
- Minimizarea dezechilibrului, grație conceptului simetric

### Compact

- Corp scurt pentru mărirea rigidității ansamblului de alezare și pentru a permite cel mai bun efect de amortizare atunci când se utilizează barele de strunjire și de alezare Steadyline®
- Greutate redusă pentru a permite o schimbare rapidă a sculei și o accelerare ușoară a arborelui

### Reglare rapidă și intuitivă

- Fiecare portplăcuță are un mecanism de reglare care permite setarea rapidă și ușoară a diametrului, atunci când se utilizează un preseter
- Scala gradată arată poziția grosieră a portplăcuțelor

### Port-plăcuțe

- Portplăcuțele A610...CC... au un unghi de atac de 90° pentru plăcuțele rombice, 0° unghiul de degajare și 0° unghiul de înclinare
- Portplăcuțele se potrivesc pe ambele tipuri de capete EPB 610 Graflex® și RB 610 GL

### Productivitate

- Rigiditate mare datorită instalării strânse a suporturilor de plăcuță în corpul capului, precum și datorită șuruburilor de prindere mari
- Posibilitate de a obține o adâncime de așchiere ap de până la jumătate din lățimea plăcuței, maximizând rata de îndepărtare a materialului și permițând o exploatare totală a plăcuțelor
- Alezare alternantă cu ajutorul unei garnituri de reglare (care face parte din pachetul de livrare al capului) pentru decalarea unui suport de plăcuță pentru a mări adâncimea radială de așchiere sau pentru a o diviza
- Livrare a agentului de răcire complet direcționată către muchiile așchietoare

### Gama de produse

- Capetele de alezare de degroșare RB 610 sunt disponibile cu conexiune Graflex® pe partea utilajului, pentru operațiuni de alezat convenționale de console de până la 6xD,
- capetele de alezare de degroșare RB 610 cu conexiuni GL și BA pe partea utilajului sunt concepute pentru console mai lungi cu ansambluri de amortizare a vibrațiilor Steadyline®.

### RB 610 Graflex®



- Graflex®: 4 capete de alezare de degroșare compacte pentru Ø 39-115 mm (Ø 1,535-4,528")
- Sistemul modular Graflex® permite alcătuirea de ansambluri de alezare optime din adaptoare Graflex®, module intermediare și capete de alezare

### RB 610 GL și BA, pentru barele antivibrații Steadyline®



GL



BA

- GL: 4 capete de alezare de degroșare scurte și compacte, pentru diametre 28-69 mm (Ø 1,102-2,717")
- BA: 2 capete de alezare de degroșare scurte și compacte, pentru diametru 66-116 mm (Ø 2,598-4,567")
- Adaptate în special barelor de strunjire și de alezare Steadyline®. Performanțele de alezare, atunci când se utilizează bare lungi Steadyline®, sunt similare cu ansamblurile mai scurte fără amortizare (<6xD).

## Capete de alezare de degroșare RB 610 - Ghid

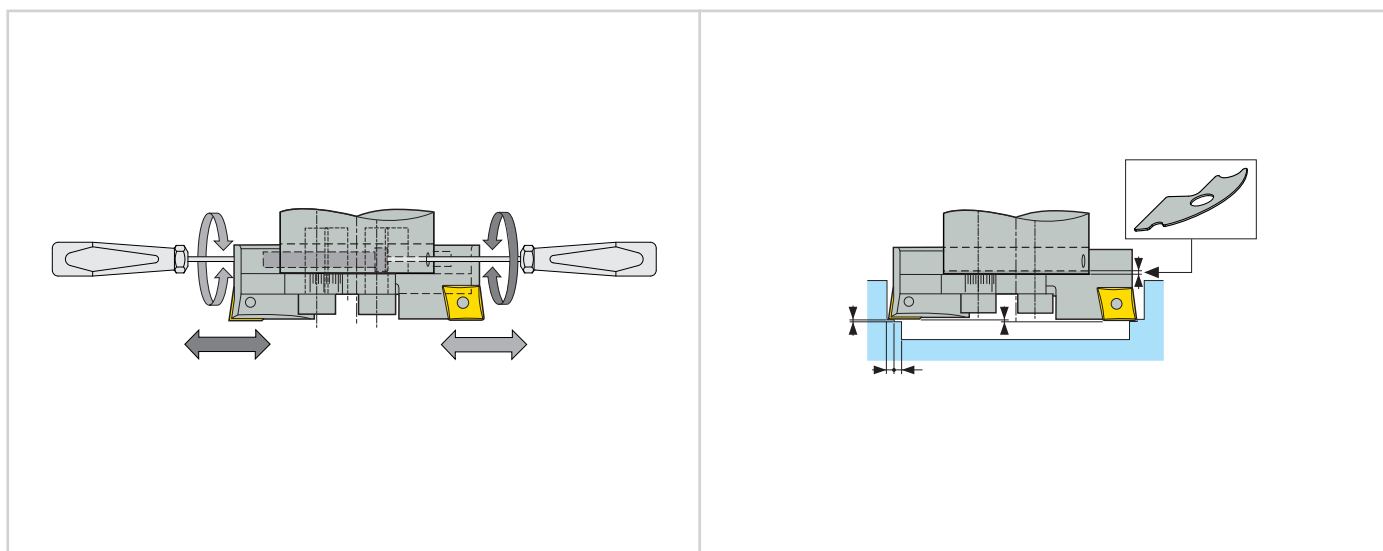
### Setarea alezării simetrice:

Alezare simetrică înseamnă că ambele muchii de așchiere au același diametru și aceeași înălțime.

### Setarea alezării alternante:

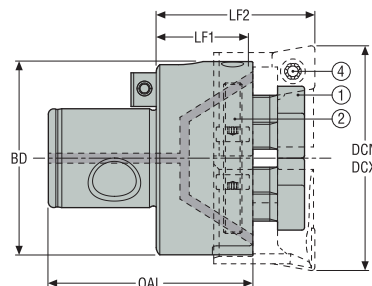
Alezare asimetrică înseamnă că o muchie de așchiere este decalată ca și operație de așchiere la un diametru mai mic decât a doua muchie reglată la diametrul de executat. Necesită un distanțier (inclus în pachet) montat între corpul capului de alezat și una dintre portplăcuțe pentru a obține o decalare axială (+), vezi tabelul de mai jos.

Distanțier Reper. nr.	Grosimea (mm)	Grosimea (inci)
AU6101003	0,2	0.008
AU6103003	0,4	0.016
AU6104003	0,5	0.020
AU6105003	0,6	0.024
AU6106003	0,6	0.024



# RB610

Graflex®



- Este posibilă alezare simetrică sau asimetrică
- Mecanism individual de reglare a portplăcuței
- Lichid de răcire prin interior dirjat spre muchia de așchiere

1. Șurub de prindere și cheie de prindere
- 2 & 4. Cheia pentru reglarea diametrului și pentru prinderea șurubului plăcuței

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat		Capacitatea DCN-DCX Ø	OAL	LF1	LF2	BD	Greutate	RPM max.*
			mm Inci	mm Inci							
A61030	02904453	G3	39,0 1.535	51,0 2.008	43,5 1.713	23,5 0.925	36,4 1.433	34,0 1.339	0,18 0.400	7500	
A61040	02904454	G4	50,0 1.969	65,0 2.559	45,5 1.791	21,5 0.846	35,3 1.390	43,0 1.693	0,27 0.600	5700	
A61050	02904455	G5	64,0 2.520	86,0 3.386	55,0 2.165	25,0 0.984	42,3 1.665	54,0 2.126	0,54 1.190	4500	
A61060	02904457	G6	85,0 3.346	115,0 4.528	69,0 2.717	29,0 1.142	47,8 1.882	63,0 2.480	0,93 2.050	3500	

Portplăcuțele se vor comanda separat, vezi pag. 575

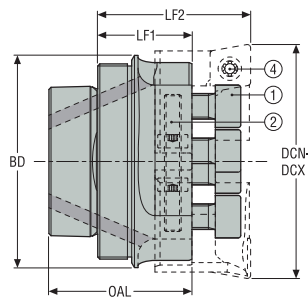
\* Pentru turațiile maxime RPM, vezi pagina de Instrucțiuni. Note, weight is without insert holder

## Piese de schimb

Pentru cap	Șurub ansamblu	Cheie clemă	Cheie (tip T)	Nicovală, alezare decalată	Cep
A61030	950DC0616	03HL05	DOUBLE-T	AU6103003	90M31
A61040	950D0616	03HL05	DOUBLE-T	AU6104003	90M41
A61050	950D0820	03HL06	DOUBLE-T	AU6105003	90M51
A61060	950D0822	03HL06	DOUBLE-T	AU6106003	90M61

## RB610 Compact

GL



- Șurub de prindere și cheie de prindere
- 2 & 4. Cheia pentru reglarea diametrului și pentru prinderea șurubului plăcuței

- Concepute pentru barele de strunjire și alezare GL25, GL32, GL40 și GL50 Steadyline®
- Este posibilă alezare simetrică sau asimetrică
- Mecanism individual de reglare a portplăcuței
- Lichid de răcire prin interior dirijat spre muchia de așchiere

Reper Nr.	Număr reper	Od strony obrabiarki Mărime GL	Spre semifabricat		OAL	LF1	LF2	BD	Greutate	RPM max.*
			Capacitatea DCN-DCX Ø							
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
GL25-RB610-10	03307854	GL25	28,0 1.102	37,0 1.457	21,7 0.854	16,2 0.638	25,0 0.984	25,0 0.984	0,1 0.220	9500
GL32-0610-20	02904458	GL32	36,0 1.417	46,0 1.811	27,6 1.087	21,1 0.831	32,0 1.260	32,0 1.260	0,1 0.220	7500
GL40-0610-30	02904459	GL40	45,0 1.772	56,0 2.205	31,6 1.244	22,1 0.870	35,0 1.378	40,0 1.575	0,2 0.440	5700
GL50-0610-40	02904460	GL50	55,0 2.165	69,0 2.717	33,7 1.327	22,2 0.874	36,0 1.417	50,0 1.969	0,3 0.660	4500

Portplăcuțele se vor comanda separat, vezi pag. 575

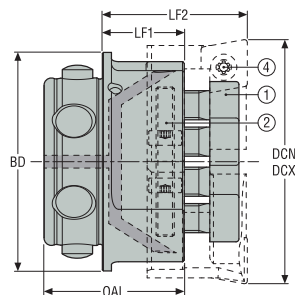
\* Pentru turațiile maxime RPM, vezi pagina de Instrucțiuni. Note, weight is without insert holder

### Piese de schimb

Pentru cap	Șurub ansamblu	Cheie clemă	Cheie plăcuță	Cheie (tip T)	Nicovală, alezare decalată
GL25-0610-10	950D0410	03HL03	–	–	AU6101003
GL32-0610-20	950DC0412	03HL03	H4B-T07P	DOUBLE-T	AU6102003
GL40-0610-30	950DC0616	03HL05	–	DOUBLE-T	AU6103003
GL50-0610-40	950D0616	03HL05	–	DOUBLE-T	AU6104003

# RB610

BA



- Concepute pentru barele de strunjire și alezare BA60 și BA80 Steadyline®
- Este posibilă alezare simetrică sau asimetrică
- Mecanism individual de reglare a portplăcuței
- Lichid de răcire prin interior dirijat spre muchia de așchiere

1. Șurub de prindere și cheie de prindere
- 2 & 4. Cheia pentru reglarea diametrului și pentru prinderea șurubului plăcuței

Reper Nr.	Număr reper	Od strony obrabiarki Mărime BA	Spre semifabricat Capacitatea		OAL	LF1	LF2	BD	Greutate	RPM max.*
			DCN-DCX Ø	DCN-DCX Ø						
			mm	mm	mm	mm	mm	mm	kg	
			Inci	Inci	Inci	Inci	Inci	Inci	lbs	
BA060-RB610-50	03204092	BA060	66,0 2.598	88,0 3.465	38,5 1.516	22,5 0.886	39,8 1.567	60,0 2.362	0,8 1.760	4000
BA080-RB610-60	03204093	BA080	86,0 3.386	116,0 4.567	44,5 1.752	22,5 0.886	39,8 1.567	80,0 3.150	1,1 2.430	3000

Portplăcuțele se vor comanda separat, vezi pag. 575

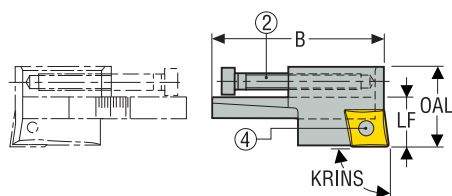
\* Pentru turațiile maxime RPM, vezi pagina de Instrucțiuni. Note, weight is without insert holder

## Piese de schimb

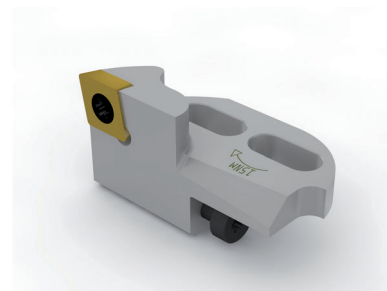
Pentru cap	Cheie clemă	Șurub clemă	Cheie (tip T)	Nicovală, alezare decalată
BA060-RB610-50	03HL06	950D0820	DOUBLE-T	AU6105003
BA080-RB610-60	03HL06	950D0822	DOUBLE-T	AU6106003



Insert holders




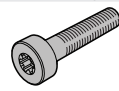
- 2. Șurub de reglare
- 4. Șurub plăcuță



- Se potrivesc la capete de alezare RB 610 cu conexiune Graflex®, BA sau GL

Reper Nr.	Număr reper	Pentru cap	Spre semifabricat	Capacitatea DCN-DCX Ø	l <sub>1</sub>	LF	B	Greutate
			mm	mm	mm	mm	mm	kg
			Inci	Inci	Inci	Inci	Inci	lbs
A61010CC0690	03307856	RB 61010	28,0 1.102	37,0 1.457	-	15,1 0.594	21,75 0.856	0,1 0.220
A61020CC0690	02971268	RB 61020	36,0 1.417	46,0 1.811	10,9 0.429	10,9 0.429	26,0 1.024	0,1 0.220
A61030CC0990	02904461	RB 61030	39,0 1.535	56,0 2.205	12,9 0.508	12,9 0.508	33,0 1.299	0,1 0.220
A61040CC0990	02904462	RB 61040	50,0 1.969	69,0 2.717	13,8 0.543	13,8 0.543	43,8 1.724	0,1 0.220
A61050CC1290	02904463	RB 61050	64,0 2.520	86,0 3.386	17,3 0.681	17,3 0.681	57,4 2.260	0,2 0.440
A61060CC1290	02904464	RB 61060	85,0 3.346	115,0 4.528	18,8 0.740	18,8 0.740	75,0 2.953	0,3 0.660

Piese de schimb

Pentru portplăcuță	Șurub plăcuță	Șurub de reglare
		
A61010CC0690	C02504-T07P	-
A61020CC0690	C02504-T07P	19A61020
A61030CC0990	C04008-T15P	19A61030
A61040CC0990	C04008-T15P	19A61040
A61050CC1290	C05012-T15P	19A61050
A61060CC1290	C05012-T15P	19A61060

Pentru plăcuțe de degroșare recomandate, vezi pag. 646  
Notă: În pachetul de livrare al capului RB 610 se găsește o cheie pentru șurubul plăcuței.

## Capete de alezare de degroșare RB 610 - Instrucțiuni

Cuplu de strângere recomandat. Avansul maxim per rotație la alezare alternantă.

Capete de alezare de RB 610 - Dimensiuni	30	40	50	60
Cuplul de strângere a șuruburilor de blocare pentru prinderea suporturilor de plăcuță (Nm)	2 x 25	4 x 25	4 x 40	4 x 40
Rata max. a avansului la alezare alternantă mm/rot ( <i>in/rot</i> )	0,4 (0.016)	0,5 (0.020)	0,6 (0.024)	0,6 (0.024)

**Condiții de prelucrare recomandate**  
Puterea capului de alezare:

Având în vedere că degroșarea necesită putere mare, vă recomandăm să verificați dacă mașina este potrivită. Alezarea asimetrică este o soluție pentru reducerea necesarului de putere, avansul fiind divizat la 2 pentru aceeași adâncime de tăiere, comparativ cu cea simetrică. Performanțe optime se obțin cu răcire internă (regimuri de așchiere mari, finisare superioară a suprafeței, evacuare mai bună a așchilor, viață mai lungă a plăcuței).

Pentru instrucțiunile de utilizare detaliate, consultați instrucțiunile de utilizare livrate împreună cu pachetul capetelor de alezare sau cu barele Steadyline®. Aceste instrucțiuni pot fi descărcate de pe [www.secotools.com](http://www.secotools.com)

**Viteza maximă pentru capetele de degroșare RB 610**

**NOTĂ!** Vitezele maxime arătate în pagina de prezentare a capetelor de alezare sunt condiționate de conceptul mecanic al capului și de calitatea echilibrării.

Vitezele cuprinse în intervalul recomandat vor fi alese ținând cont de toate condițiile de prelucrare, ex.: materialul semifabricatului, muchia de așchiere, lungimea sculei, arborele mașinii.

În cazul operațiilor de alezare cu barele Steadyline®, aveți grijă să nu depășiți RPM maxim al barei. Vedeți instrucțiunile de utilizare livrate împreună cu barele Steadyline® pentru strunjire și alezare.



## Alezare de finisare

Acoperind o gamă largă de dimensiuni de găuri și materiale, familiile de produse Seco pentru alezare de precizie permit reglări de precizie până la microni, realizează finisări de suprafețe de  $Ra < 1$  (RMS 44 micro/inci) și oferă alezaje în toleranțe IT6. Cu o axare constantă pe precizie și rigiditate, aceste produse facilitează respectarea chiar și a celor mai stricte specificații de piese. Soluțiile de amortizare a vibrațiilor Steadyline™ completează gama, pentru a oferi niveluri și mai mari de stabilitate pentru prelucrarea cavităților adânci, în care sunt necesare console de scule lungi.

- Capetele de alezare de precizie tip Axiabore FB 760 sunt concepute pentru precizie și finisare de suprafețe pe diametre mici
- Capetele de alezare de precizie radiale FB 620/780/790 sunt concepute pentru a oferi cele mai bune geometrii de alezaj pe diametre mai mari (până la 205 mm)

## Vedere generală



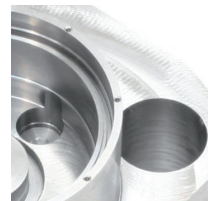
Alezare exterioră



Canelare

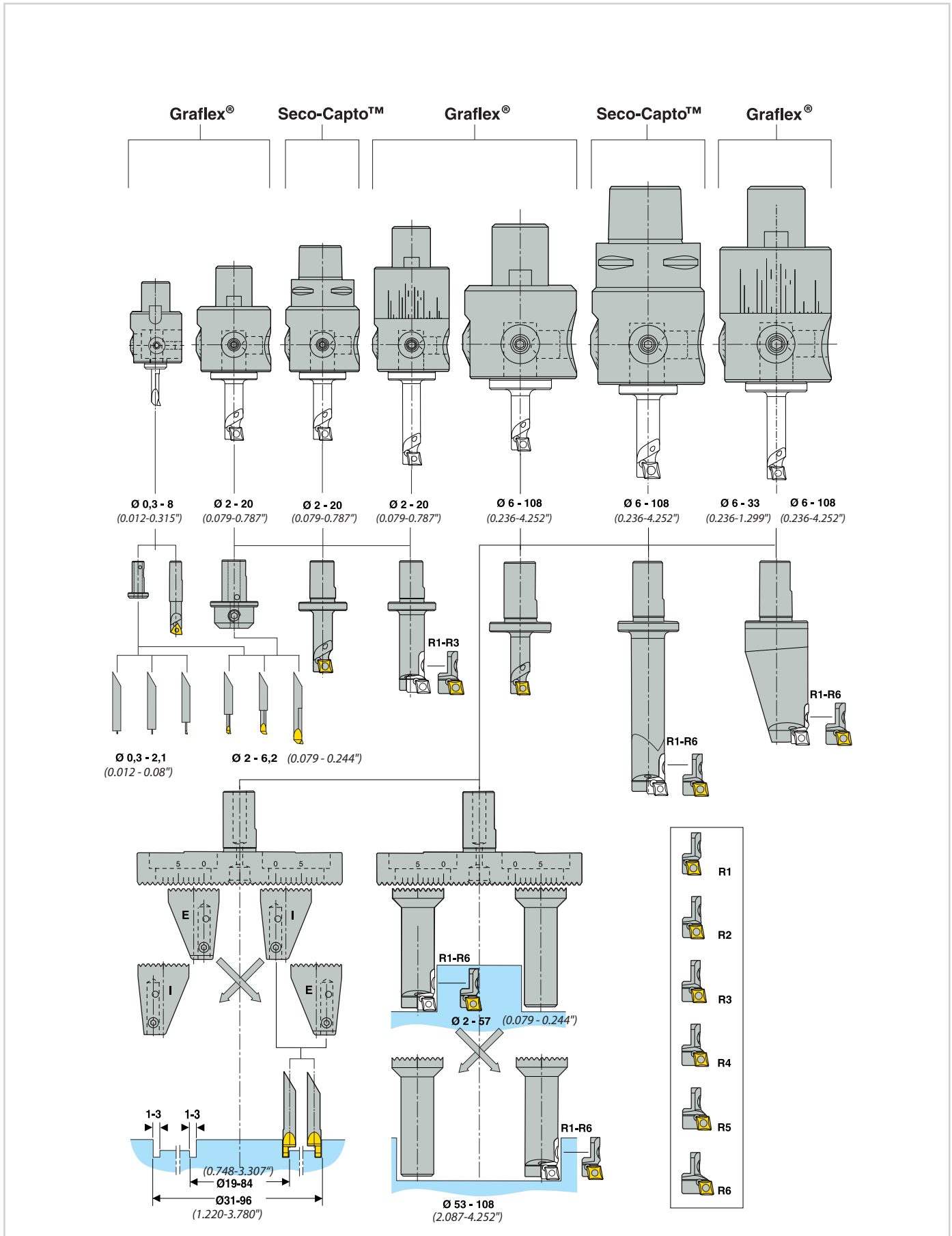


Alezare cu aşchiere intermitentă  
(intreruperi)



Alezare cu alezor reglabil

Vedere generală

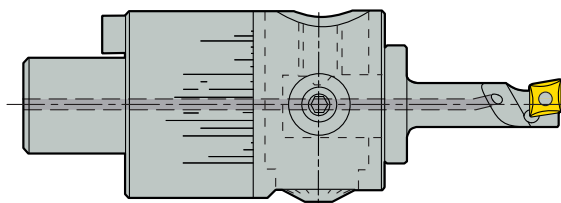


## Capete de alezare de precizie tip Axiabore™ pentru diametru de alezaj 0,3-108 mm (0,012-4,252")

Un cap tip Axiabore™ este un ansamblu compus dintr-un corp (cap) și o sculă.

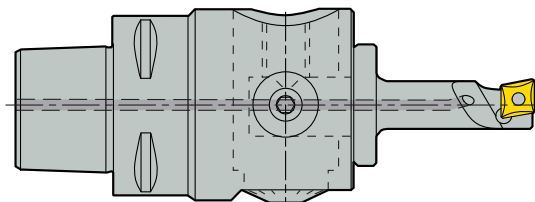
Selecția capului tip Axiabore™	Capacitate Ø mm	Capacitate Ø inci	HSM/ viteze maxime	Geometria găurii	Cost efectiv	Multifuncțional
Nanobore™ A760 01	0,3-8	0.012-0.315"	30000 RPM	■ ■	■ ■	
Axiabore™ A760 02	2-20	0.079-0.787"	12000 RPM	■	■ ■	
Axiabore™ Plus - A760 03	6-108	0.236-4.252"	8000* RPM sau 1000 m/min	■	■ ■ ■	■ ■ ■
Axiabore™ Plus C5-391.0760-03	6-108	0.236-4.252"	8000* RPM	■	■ ■ ■	■ ■ ■
Axialibrabore™ Plus - A760 13	6-33	0.236-1.299"	20000 RPM sau 1500 m/min	■ ■	■	

### Capetele tip Axiabore™ au conexiune Graflex® sau Seco-Capto™: 5 capete de alezare de precizie Axiabore™ FB 760 cu conexiune Graflex® pentru alezaje de diametru 0,3-108 mm (0,012-4,252")



Nanobore™ A760 01  
Axiabore™ A760 02  
Axialibrabore™ A760 12  
Axiabore™ Plus - A760 03  
Axialibrabore™ Plus - A760 13

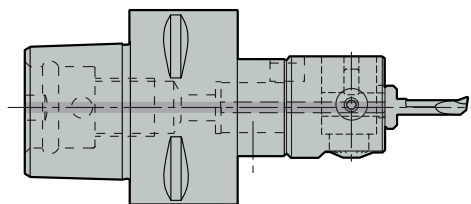
### 2 capete de alezare de precizie Axiabore™ FB 760 cu conexiune Seco-Capto™ pentru alezaje: Ø 2-108 mm (0,079-4,252")



Axiabore™ C3-391.0760-02  
Axiabore™ Plus- C5-391.0760-03

**NOTĂ!** Alezajul minim al celui mai mic cap de alezare de precizie Seco-Capto™ este Ø 2 mm (0,079") cu cea mai mică conexiune Seco-Capto™ C3 disponibilă. Pentru Ø 0,3-8 mm (0,012-0,315") utilizați capetele de alezat Nanobore™ cu conexiunea G2 împreună cu adaptorul Seco-Capto™/Graflex® corespunzător.

### Adaptor Seco-Capto™ și cap Graflex®: Ø 0,3-8 mm (0,012-0,315")



Adaptoare și extensii modulare Graflex® și Seco-Capto™: consultați catalogul de port-scule.

**NOTĂ!** Caracteristici, instrucțiuni (procedura de instalare a sculei, setarea diametrului, procedura de asamblare MPA, viteze maxime, viteze de așchiere recomandate, depanare), sculele și suporturile de plăcuță adecvate sunt similare pentru ambele tipuri de capete de alezare de precizie 760 cu capacitate de alezare similară, indiferent de tipul de conexiune.

## Scule pentru alezare

**Notă!** În pagina produsului, se precizează exact ce sculă se potrivește cu fiecare cap.

**Scule de alezat, coadă din carbură solidă** Ø 4 mm (Ø 0,1574") pentru cele mai mici diametre 0,3-6,2 mm (Ø 0,012-0,244"), unghi de avans 98°. Este necesară o bucsă de reducere pentru a instala capete Nanobore™ și Axia(libra)bore™. Sculele au capătul din spate în unghi pentru orientarea muchiilor de așchiere conform ISO.

**Bare de alezare, cozi tip plăcuță** Ø 6, 12 sau 16 mm (Ø 0,236, 0,472, 0,630") pentru Ø 6-13 mm (Ø 0,236-0,512"), tip „oțel” pentru scule scurte, tip „carbură” pentru scule lungi. Pentru plăcuțe WB..0301.. sau CC..0602.. și unghi de avans de 90°. Fixare directă în capul de alezat. Aplatizarea de blocare asigură o orientare a muchiei așchietoare conform ISO.

## Adaptoare cu utilizare multiplă (MPA)

MPA pentru alezare și alezare exterioară, precum și pentru canelare cu capetele Axiabore™ Plus. MPA și sculele au o interfață zimțată, care asigură trepte precise de orientare și poziționare de 2,5 mm (0,098") pe diametru. Sunt incluse duzele pentru direcționarea lichidului de răcire.

Alege componentele pentru a obține o sculă tip MPA din tabelul de scule MPA. Vezi detaliile de asamblare în capitoul cu instrucțiuni.

### Reglarea unui ansamblu pentru Alezare sau alezare exterioară.

Ambele ansambluri de alezare și de alezare exterioară utilizează aceeași coadă echipată cu o port-plăcuță și o contragreutate. Ansamblul de alezare: Alege port-plăcuța necesară pentru a fi asamblată în coada pentru alezare/alezare exterioară, utilizând tabelul de selecție 'Alezare cu MPA' (vezi paginile următoare).

**Bare de alezare**, modulare, alcătuite dintr-o „coadă” și un „suport de plăcuță” pentru diametre 13-63 mm (Ø 0,512-2,480"). Diametru coadă 12 sau 16 mm (Ø 0,472, 0,630"), „oțel” pentru scurte, „carbură” pentru lungi și „ușoare/aluminiu” pentru cele mai mari diametre. Fixare directă în capul de alezat.

Șase port-scule pentru plăcuțele CC..0602.. cu unghi de atac de 90°, compatibil cu toate cozile pentru a obține o capacitate mare de alezare cu cozi normale.

Ansamblul de alezare exterioară: Alege port-plăcuța necesară pentru a fi asamblată în coada pentru alezare/alezare exterioară, utilizând tabelul de selecție 'Alezarea exterioară cu MPA' (vezi paginile următoare). Vezi detaliile de asamblare în capitoul cu instrucțiuni.

### Alcătuirea unui ansamblu de canelare

Un ansamblu de canelare necesită:

- O pereche de port-scule pentru scule de canelat (una E = „externă” și una I = „internă”)
- O sculă de canelat „spre cep” sau „spre alezaj”. Când canalul nu este spre un perete de cep sau spre un perete de alezaj, ambele tipuri de scule sunt adecvate. Consultați tabelele de selecție „Sculă de canelat pentru canelare cu MPA”

## Caracteristici

### Cap Nanobore™, nr. de piesă A76001



**Cap foarte mic pentru alezare de precizie Ø 0,3-8 mm (Ø 0,012-0,315"):**

Diametru exterior 25 mm (0,984"), lungime 25 mm (0,984"), cu conexiune Graflex® mărime G2, instalare sculă Ø 6 mm (Ø 0,236"). Viteze de funcționare de până la 30.000 rotații pe minut permit prelucrarea performantă a unor diametre foarte mici.

Bucșa de reducere 6-4 mm (0,236-0,157") cu aptlizare de orientare și pin pentru instalarea de scule de alezat solide face parte din pachetul de livrare al capului.

### Cap Axiabore™, nr. de piesă A76002



**Capete mici pentru alezare de precizie Ø 2-20 mm (Ø 0,079-0,787"):**

Diametru exterior 36,5 mm (1,401"), lungime 32 mm (1,260"), cu conexiune Graflex® mărimea G3 și conexiune Seco-Capto™ mărimea C3, instalare sculă Ø 12 mm (Ø 0,472"). Aceste mărimi de capete sunt optimizate pentru alezaje greu accesibile.

Bucșa de reducere 12-4 mm (0,472-0,157") cu aptlizare de orientare și pin pentru instalarea de scule de alezat solide face parte din pachetul de livrare al capului.

**NOTĂ!** Pot fi instalate și unelte mai mici de la Nanobore™ 0,3-2,1 mm (0,012-0,083"), dar viteza de prelucrare va fi limitată la 12000 de rotații pe minut: Sunt preferate capetele Nanobore®.

### Axiabore™ Plus - cap, nr. de piesă A76003 și C5-391.0760-03



**Capete multifuncționale pentru alezare de precizie Ø 6-108 mm (Ø 0,236-4,252"), teșire a muchilor OD Ø 2-57 mm (Ø 0,079-2,244") și canelare Ø 19-96 mm (Ø 0,748-3,780"):**

Diametru exterior 54 mm (Ø 2,126"), lungime 45 mm (Ø 1,772"), cu conexiune Graflex® mărimea 5 și conexiune Seco-Capto™ mărimea 5, instalare sculă Ø 16 mm (Ø 0,630").

Scule adecvate: toate sculele cu diametru de coadă 16 mm (Ø 0,630"), pentru instalare directă în capete.

Acest cap a fost conceput și pentru echiparea cu MPA (adaptor cu utilizare multiplă), pentru alezarea fină a diametrelor mari, alezare exterioară și canelare.

### Axialibrabore™ Plus - cap, nr. de piesă A76013



**Cap echilibrabil pentru alezare de precizie Ø 6-33 mm (Ø 0,236-1,299"):**

Aceleași caracteristici ca și capul - Axiabore™ Plus - dar cu echilibrare de precizie, lungime a corpului 65 mm (2,559").

Cu conexiune Graflex® mărimea G5.

Capetele fin echilibrate permit viteze mari până la 20 000 RPM sau 1500 m/min (oricare criteriu este îndeplinit primul, fără a-l depăși pe al doilea), geometria găurii îmbunătățită cu o reducere a încărcării arborelui mașinii.

Echilibrarea 'LibraOne' se execută prin reglarea inelului de echilibrare gradat în linie cu marcajul de pe capul de alezare (în conformitate cu codul de echilibrare al sculei folosite și a diametrului de alezat). Nu necesită tabel de valori.

Echilibrarea de precizie este posibilă doar pentru cele mai mici diametre de scule de alezat 6-33 mm (0,236-1,299").

**NOTĂ!** La utilizarea unei scule „Alu” sau „MPA” mai mare de la - Axiabore™ Plus - în capetele - Axialibrabore™

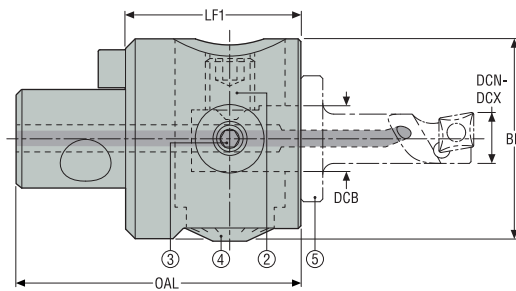
Plus - reglarea de precizie nu este posibilă, iar inelul de echilibrare trebuie setat la poziția de pre-echilibrare a capului (în funcție de operația dorită, consultați capitolul Instrucțiuni).

Viteza maximă va fi cea de la - Axiabore™ Plus.



## FB 760 – Capete tip Axiabore™, fără echilibrare

Graflex®



2. Șurub de asamblare
3. Șurub de blocare
4. Șurub micrometric de reglaj
5. Sculă



- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)
- Axiabore™ Plus – permite alezarea, alezarea exterioară și canelare axială

Reper Nr.	Număr reper	Od stroy obrabirki Mărime Graflex	Spre semifabricat		*	OAL	LF1	BD	DCB	Greutate	Viteza de lucru max**		***
			Capacitatea DCN-DCX Ø	Capacitatea DCN-DCX Ø							RPM max.**	Max. m/min**	
			mm Inci	mm Inci		mm Inci	mm Inci	mm Inci	mm Inci	kg lbs			
A76001	02462575	G2	0,3 0.012	8,0 0.315	-	41,0 1.614	25,0 0.984	25,0 0.984	6,0 0.236	0,1 0.220	30000	1500,0	-
A76002	02594930	G3	2,0 0.079	20,0 0.787	-	52,0 2.047	32,0 1.260	36,5 1.437	12,0 0.472	0,29 0.640	12000	1500,0	-
A76003	02594935	G5	6,0 0.236	108,0 4.252	*	75,0 2.953	45,0 1.772	54,0 2.126	16,0 0.630	0,82 1.810	8000	1000,0	***

Note, weight is without insert holder

Pentru scule, vezi pag. 586-588

\*Capacități - Axiabore™ Plus - cap de alezat 6 la 108 mm, alezare exterioară 2 la 57 mm, canelare 19 la 96 mm (0.748-3.780").

\*\*Viteza maximă, oricare este atinsă prima fără a se depăși cea de a doua.

\*\*\*Max 5000 RPM la folosirea MPA.

### Piese de schimb

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare	Bucă reducere	Sealing Screws	Cep
A76001	-	DOUBLE-T	H4B-H2.0	19M4001A	05A7600604	950A0406	90M21
A76002	AU7601212	-	03M03C	19A71030	05A7601204	-	90M3A
A76003	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	-	-	90M5A

### Accesorii

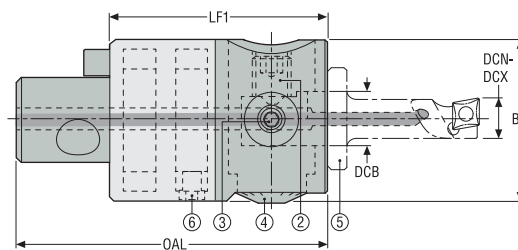
Pentru cap	Lupă	Cutie stocare	Cheie dinamometrică 1	Cheie dinamometrică 2
A76001	935L01	-	-	H00-2009
A76002	-	42M06	-	H00-3030
A76003	-	42M07	H00T-4060	Accesorii, se vor comanda separat

Cheia dinamometrică 1 = pentru șuruburile de blocare a inelului de echilibrare

Cheia dinamometrică 2 = pentru șuruburile de blocare și asamblare

## FB 760 – Capete tip Axiabore™, echilibrabile

Graflex®



- Sistem de echilibrare interior LibraOne bazat pe un singur inel de reglare a echilibrării
- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)

2. Șurub de asamblare
3. Șurub de blocare 1
4. Șurub micrometric de reglaj
5. Sculă
6. Șurub de blocare 2

Reper Nr.	Număr reper	Od strony obrabiarki Mărime Graflex	Spre semifabricat		*	OAL	LF1	BD	DCB	Greutate	Viteza de lucru max**	
			Capacitatea DCN-DCX Ø								RPM max.**	Max. m/min**
			mm Inci	mm Inci		mm Inci	mm Inci	mm Inci	mm Inci	kg lbs		
A76013	02594943	G5	6,0 0.236	33,0 1.299	*	95,0 3.740	65,0 2.559	54,0 2.126	16,0 0.630	1,16 2.560	20000	1500,0

Note, weight is without insert holder  
Pentru scule, vezi pag. 586-588

\*Capacități - Capete Axiabore™ Plus, cu echilibrare.

\*\*Viteza maximă, oricare este atinsă prima fără a se depăși cea de a doua.

### Piese de schimb

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare 1	Șurub de blocare 2	Cep
A76013	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	AU7601318	90M5A1

### Accesorii

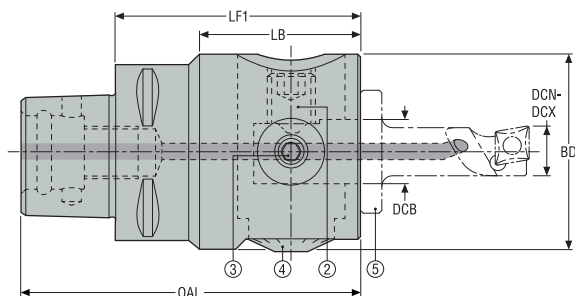
Pentru cap	Cutie stocare	Cheie dinamometrică 1	Cheie dinamometrică 2
A76013	42M07	H00-4020-60	H00T-4060

Cheia dinamometrică 1 = pentru șuruburile de blocare a inelului de echilibrare  
Cheia dinamometrică 2 = pentru șuruburile de blocare și asamblare

Accesorii, se vor comanda separat

## FB 760 – Capete tip Axiabore™

Seco-Capto™



2. Șurub de asamblare
3. Clamp
4. Șurub micrometric de reglaj
5. Sculă



- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)
- Axiabore™ Plus – permite alezarea, alezarea exterioară și canelare axială

Reper Nr.	Număr reper	Spre mașină	Spre semifabricat		*	OAL	LF1	LB	BD	DCB	Greutate	Viteza de lucru max**	
			Capacitatea DCN-DCX	Ø								mm	mm
			mm	mm		mm	mm	mm	mm	mm	kg		
			Inci	Inci		Inci	Inci	Inci	Inci	Inci	lbs		
C5-391.0760-03	02822777	C5	6,0	108,0	*	95,0	65,0	44,0	54,0	16,0	1,12	8000	1500,0
			0.236	4.252		3.740	2.559	1.732	2.126	0.630	2.470		

Note, weight is without insert holder

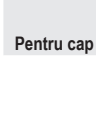





Pentru scule, vezi pag. 586-588

\*Max 5000 RPM la folosirea MPA.

\*\*Capacități - Axiabore™ Plus - cap de alezat 6 la 108 mm, alezare exterioară 2 la 57 mm, canelare 19 la 96 mm (0.748-3.780") .

### Piese de schimb

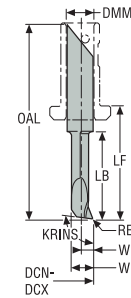
### Accesorii

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare	Cheie dinamometrică 2
					
C5-...-03	AU7601312	DOUBLE-T	H6B-H4.0L	19A71008125	H00-3030

Cheia dinamometrică 2 = pentru șuruburile de blocare și asamblare

Accesorii, se vor comanda separat

## Scule de alezare, carbură solidă, pentru capetele FB 760



- KRINS 98°
- Orientarea muchiilor de aşchiere ISO
- Răcire de-a lungul sculei

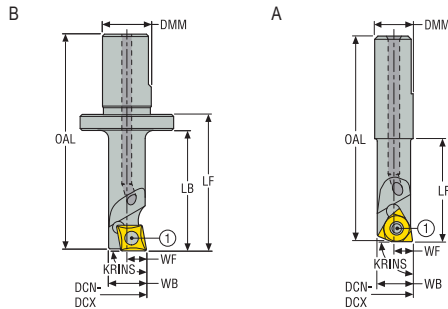
Reper Nr.	Număr reper	Pentru portsculă*	Pentru cap	Capacitatea DCN-DCX		OAL	LB	LF	DMM	WB	WF	RE	Regimuri de aşchiere recoma-	Regimuri de aşchiere recoma-	Greutate	Cod echilibrare
				date** a <sub>p</sub>	date** f											
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg	
				Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	lbs	
A761402	02462579	Solid carbide	FB 76001	0,3 0.012	0,6 0.024	30,7 1.209	1,2 0.047	15,5 0.610	4,0 0.157	0,25 0.010	0,1 0.004	0,0 -	0,02 0.001	0,01 0	0,01 0.020	-
A761412	02462581	Solid carbide	FB 76001	0,5 0.020	1,1 0.043	30,7 1.209	2,0 0.079	15,5 0.610	4,0 0.157	0,45 0.018	0,2 0.008	0,0 -	0,02 0.001	0,01 0	0,01 0.020	-
A761422	02462583	Solid carbide	FB 76001	1,0 0.039	2,1 0.083	30,7 1.209	5,0 0.197	15,5 0.610	4,0 0.157	0,95 0.037	0,45 0.018	0,1 0.004	0,03 0.001	0,02 0.001	0,01 0.020	-
A761432	02462584	Solid carbide	FB 76001/02/12	2,0 0.079	3,2 0.126	30,7 1.209	8,0 0.315	15,5 0.610	4,0 0.157	1,8 0.071	0,88 0.035	0,1 0.004	0,05 0.002	0,02 0.001	0,01 0.020	E13
A761442	02462586	Solid carbide	FB 76001/02/12	3,0 0.118	4,7 0.185	30,7 1.209	10,0 0.394	15,5 0.610	4,0 0.157	2,75 0.108	1,35 0.053	0,15 0.006	0,06 0.002	0,03 0.001	0,01 0.020	E14
A761452	02462587	Solid carbide	FB 76001/02/12	4,5 0.177	6,2 0.244	35,7 1.406	15,0 0.591	20,5 0.807	4,0 0.157	3,95 0.156	1,95 0.077	0,15 0.006	0,08 0.003	0,03 0.001	0,01 0.020	E15

\*Aceste scule cu diametrul cozii de 4 mm necesită o reducție, livrată împreună cu capetele de alezare sau pachetele potrivite.

\*\*Pentru regimurile de aşchiere, vezi pag. 650-653

\*\*\*+0,1 mm capacitate complementară posibilă.

## Bare de alezare, tip cu plăcuțe, pentru capete FB 760



1 = Șurubul plăcuței



- Orientarea muchiilor de așchiere ISO
- Răcire internă
- Doar două mărimi de plăcuțe pentru toate sculele.
- Tool material \* = Steel, indexable insert type
- Tool material \*\* = Carbide, indexable insert type
- KRINS 90°

Reper Nr.	Număr reper	Pentru portsculă	Pentru cap	** Capacitatea DCN-DCX Ø		OAL	LB	LF	DMM	WB	WF	Greutate	Varianta	Mărimea plăcuței potrivite	Cod echilibrare
				mm Inci	mm Inci										
A762001	02462590	*	FB 76001	6,0 0.236	8,0 0.315	31,7 1.248	0,0 0.000	16,0 0.630	6,0 0.236	5,5 0.217	2,9 0.114	0,01 0.020	A	WB..0301..	-
A762002	02594947	*	FB 76002/12	6,0 0.236	8,0 0.315	39,7 1.563	16,0 0.630	20,0 0.787	12,0 0.472	5,5 0.217	2,9 0.114	0,03 0.070	B	WB..0301..	S21
A762003	02594967	*	FB 76003/13	6,0 0.236	8,0 0.315	50,2 1.976	16,0 0.630	21,0 0.827	16,0 0.630	5,5 0.217	2,9 0.114	0,07 0.150	B	WB..0301..	S31
A763002	02594948	*	FB 76002/12	8,0 0.315	10,0 0.394	45,7 1.799	22,0 0.866	26,0 1.024	12,0 0.472	7,4 0.291	3,9 0.154	0,04 0.090	B	WB..0301..	S22
A763003	02594968	*	FB 76003/13	8,0 0.315	10,0 0.394	56,2 2.213	22,0 0.866	27,0 1.063	16,0 0.630	7,4 0.291	3,9 0.154	0,08 0.180	B	WB..0301..	S32
A765002	02594957	*	FB 76002/12	10,0 0.394	13,0 0.512	53,5 2.106	30,0 1.181	34,0 1.339	12,0 0.472	9,35 0.368	4,8 0.189	0,04 0.090	B	CC..0602..	S23
A765003	02594969	*	FB 76003/13	10,0 0.394	13,0 0.512	64,0 2.520	30,0 1.181	35,0 1.378	16,0 0.630	9,35 0.368	4,8 0.189	0,08 0.180	B	CC..0602..	S33
A762201	02462591	**	FB 76001	6,0 0.236	8,0 0.315	41,7 1.642	0,0 0.000	26,0 1.024	6,0 0.236	5,5 0.217	2,9 0.114	0,02 0.040	A	WB..0301..	-
A762202	02594958	**	FB 76002/12	6,0 0.236	8,0 0.315	50,7 1.996	27,0 1.063	31,0 1.220	12,0 0.472	5,5 0.217	2,9 0.114	0,06 0.130	B	WB..0301..	E21
A762203	02594970	**	FB 76003/13	6,0 0.236	8,0 0.315	61,2 2.409	27,0 1.063	32,0 1.260	16,0 0.630	5,5 0.217	2,9 0.114	0,13 0.290	B	WB..0301..	E31
A763202	02594961	**	FB 76002/12	8,0 0.315	10,0 0.394	60,7 2.390	37,0 1.457	41,0 1.614	12,0 0.472	7,4 0.291	3,9 0.154	0,07 0.150	B	WB..0301..	E22
A763203	02594971	**	FB 76003/13	8,0 0.315	10,0 0.394	71,2 2.803	37,0 1.457	42,0 1.654	16,0 0.630	7,4 0.291	3,9 0.154	0,14 0.310	B	WB..0301..	E32
A765202	02594962	**	FB 76002/12	10,0 0.394	13,0 0.512	78,5 3.091	55,0 2.165	59,0 2.323	12,0 0.472	9,35 0.368	4,8 0.189	0,09 0.200	B	CC..0602..	E23
A765203	02594972	**	FB 76003/13	10,0 0.394	13,0 0.512	89,0 3.504	55,0 2.165	60,0 2.362	16,0 0.630	9,35 0.368	4,8 0.189	0,17 0.370	B	CC..0602..	E33

### Piese de schimb

Pentru dimensiunea plăcuței

Șurub plăcuță



WB...0301..

C02035-T06P

CC...0602..

C02504-T07P

### Accesorii

Cheie plăcuță



H4B-T06P

H4B-T07P

Cheie (tip T)



DOUBLE-T

DOUBLE-T

\*\*+0,2 mm capacitate complementară posibilă.

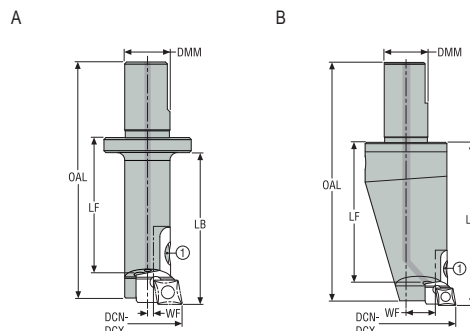
Accesorii, se vor comanda separat

## Cozi de alezare, pentru barele modulare de finisare, pentru capete FB 760

Introducere



- Se pot obține mai multe capacități cu ajutorul port-plăcuțelor interschimbabile.
- Tipuri de cozi din 'oțel' pentru bari scurte, din 'carbură' pentru bari lungi, și din 'aluminiu' pentru bari largi.
- Răcire internă



1 = Șurub de blocare

Găuire

Reper Nr.	Număr reper	Coadă modulară de alezare tip Pentru cap		** Capacitatea DCN-DCX Ø		OAL	LB	LF	DMM	WF	Greutate	Varianta	***
				mm Inci	mm Inci								
A760S20	02594963	Oțel	FB 76002/12	13,0 0.512	20,0 0.787	62,5 2.461	40,0 1.575	34,0 1.339	12,0 0.472	1,4 0.055	0,06 0.130	A	
A760S30	02594973	Oțel	FB 76003/13	13,0 0.512	18,0 0.709	73,0 2.874	40,0 1.575	35,0 1.378	16,0 0.630	1,4 0.055	0,1 0.220	A	
A760S31	02594974	Oțel	FB 76003/13	18,0 0.709	33,0 1.299	83,0 3.268	50,0 1.969	45,0 1.772	16,0 0.630	3,9 0.154	0,13 0.290	A	
A760E20	02594964	Carbură	FB 76002/12	13,0 0.512	20,0 0.787	82,5 3.248	60,0 2.362	54,0 2.126	12,0 0.472	1,4 0.055	0,2 0.440	A	
A760E30	02594965	Carbură	FB 76003/13	13,0 0.512	18,0 0.709	103,0 4.055	70,0 2.756	65,0 2.559	16,0 0.630	1,4 0.055	0,21 0.460	A	
A760E31	02594966	Carbură	FB 76003/13	18,0 0.709	33,0 1.299	113,0 4.449	80,0 3.150	75,0 2.953	16,0 0.630	3,9 0.154	0,3 0.660	A	
A760A32	02594977	Aluminium	FB 76003/13	33,0 1.299	48,0 1.890	88,0 3.465	60,0 2.362	50,0 1.969	16,0 0.630	11,5 0.453	0,14 0.310	B	***
A760A33	02594978	Aluminium	FB 76003/13	48,0 1.890	63,0 2.480	108,0 4.252	80,0 3.150	70,0 2.756	16,0 0.630	19,0 0.748	0,34 0.750	B	***

Alezare

### Piese de schimb

Pentru cap	Șurub de blocare
A76002/12	C04008-T15P
A76003/13	C04008-T15P
A76003	C04008-T15P

### Accesorii

Cheie (tip T)
DOUBLE-T
DOUBLE-T
DOUBLE-T

\*\*+0,2 mm capacitate complementară posibilă.

\*\*\* La utilizarea A760 13, nu este posibilă echilibrarea fină.

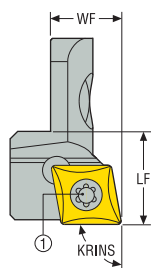
Alegeți coada dorită și combinația de port-scule utilizând tabelul de la pag.590.

Weight without insert holder.

Accesorii, se vor comanda separat

Anexă

## Portplăcuțe, pentru barele de alezare de finisare modulare, pentru capete FB 760



1 = Șurub plăcuță



- O singură mărime potrivită pentru toate cozile de alezare (și alezare exterioră).
- O singură dimensiune de plăcuță pentru toate port-plăcuțele.

Reper Nr.	Număr reper	LF		WF*		Greutate	Mărimea plăcuței potrivite	KRINS°
		mm	Inci	mm	Inci			
A765R1	02594979	10,0	0.394	4,95	0.195	0,01 0.020	CC..0602..	90
A765R2	02594983	10,0	0.394	6,2	0.244	0,01 0.020	CC..0602..	90
A765R3	02594984	10,0	0.394	7,45	0.293	0,01 0.020	CC..0602..	90
A765R4	02594987	10,0	0.394	8,7	0.343	0,01 0.020	CC..0602..	90
A765R5	02594989	10,0	0.394	9,97	0.393	0,01 0.020	CC..0602..	90
A765R6	02594990	10,0	0.394	11,2	0.441	0,01 0.020	CC..0602..	90

### Piese de schimb

Pentru dimensiunea plăcuței

Șurub plăcuță



CC...0602...

C02504-T07P

### Accesorii

Cheie plăcuță



H4B-T07P

Cheie (tip T)



DOUBLE-T

\*WF când este combinat cu plăcuțe tip CC..060204.

Selecționați combinațiile de cozi și portplăcuțe utilizând tabelul de la pag. 590.

Accesorii, se vor comanda separat

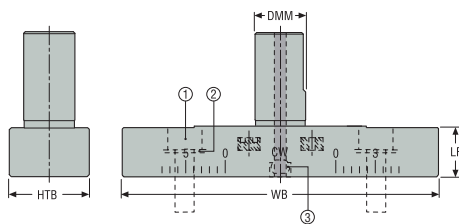
Tabel de selecție:  
Scule de alezare și portplăcuțe potrivite pentru capetele FB 760

Pentru cap	Capacitatea de alezare DCN-DCX		Lungimea de alezare LB		Reper Nr.		DMM	Mărimea plăcuței potrivite	Sculă tip		
	Ø mm	inci	mm	inci	Alezare cu alezor reglabil sculă	Portplăcuță					
A760 01	0,3-0,6	0.012-0.024	1,2	0.047	A761402	-	4	0.157	-	Carbură solidă	
	0,5-1,1	0.020-0.043	2	0.078	A761412	-	4	0.157	-	Carbură solidă	
	1-2,1	0.039-0.083	-	-	A761422	-	4	0.157	-	Carbură solidă	
	2-3,2	0.079-0.126	8	0.315	A761432	-	4	0.157	-	Carbură solidă	
	3-4,7	0.118-0.185	10	0.394	A761442	-	4	0.157	-	Carbură solidă	
	4,5-6,2	0.177-0.244	15	0.591	A761452	-	4	0.157	-	Carbură solidă	
	6-8	0.236-0.315	16	0.630	A762001	-	6	0.236	WB..0301..	Oțel, Plăcuțe amovibile tip	
	6-8	0.236-0.315	26	1.024	A762201	-	6	0.236	WB..0301..	Carbură, Plăcuțe amovibile tip	
A760 02/ A760 12	2-3,2	0.079-0.126	8	0.315	A761432	-	4	0.157	-	Carbură solidă	
	3-4,7	0.118-0.185	10	0.394	A761442	-	4	0.157	-	Carbură solidă	
	4,5-6,2	0.177-0.244	15	0.591	A761452	-	4	0.157	-	Carbură solidă	
	6-8	0.236-0.315	16	0.630	A762002	-	12	0.472	WB..0301..	Oțel, Plăcuțe amovibile tip	
	6-8	0.236-0.315	27	1.063	A762202	-	12	0.472	WB..0301..	Carbură, Plăcuțe amovibile tip	
	8-10	0.315-0.394	22	0.866	A763002	-	12	0.472	WB..0301..	Oțel, Plăcuțe amovibile tip	
	8-10	0.315-0.394	37	1.457	A763202	-	12	0.472	WB..0301..	Carbură, Plăcuțe amovibile tip	
	10-13	0.394-0.512	30	1.181	A765002	-	12	0.472	CC..0602..	Oțel, Plăcuțe amovibile tip	
	10-13	0.394-0.512	55	2.165	A765202	-	12	0.472	CC..0602..	Carbură, Plăcuțe amovibile tip	
	13-15,5	0.512-0.610	40	1.575	A760S20	A765R1	12	0.472	CC..0602..	Oțel coadă cu portplăcuță	
	13-15,5	0.512-0.610	60	2.362	A760E20	A765R1	12	0.472	CC..0602..	Carbură coadă cu portplăcuță	
	15,5-18	0.610-0.709	40	1.575	A760S20	A765R2	12	0.472	CC..0602..	Oțel coadă cu portplăcuță	
	15,5-18	0.610-0.709	60	2.362	A760E20	A765R2	12	0.472	CC..0602..	Carbură coadă cu portplăcuță	
	18-20	0.709-0.787	40	1.575	A760S20	A765R3	12	0.472	CC..0602..	Oțel coadă cu portplăcuță	
	18-20	0.709-0.787	60	2.362	A760E20	A765R3	12	0.472	CC..0602..	Carbură coadă cu portplăcuță	
	A760 03/ A760 13	6-8	0.236-0.315	16	0.630	A762003	-	16	0.630	WB..0301..	Oțel, Plăcuțe amovibile tip
		6-8	0.236-0.315	32	1.260	A762203	-	16	0.630	WB..0301..	Carbură, Plăcuțe amovibile tip
		8-10	0.315-0.394	22	0.866	A763003	-	16	0.630	WB..0301..	Oțel, Plăcuțe amovibile tip
8-10		0.315-0.394	37	1.457	A763203	-	16	0.630	WB..0301..	Carbură, Plăcuțe amovibile tip	
10-13		0.394-0.512	30	1.181	A765003	-	16	0.630	CC..0602..	Oțel, Plăcuțe amovibile tip	
10-13		0.394-0.512	55	2.165	A765203	-	16	0.630	CC..0602..	Carbură, Plăcuțe amovibile tip	
13-15,5		0.512-0.610	40	1.575	A760S30	A765R1	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
13-15,5		0.512-0.610	70	2.756	A760E30	A765R1	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
15,5-18		0.610-0.709	40	1.575	A760S30	A765R2	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
15,5-18		0.610-0.709	70	2.756	A760E30	A765R2	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
18-20,5		0.709-0.807	50	1.969	A760S31	A765R1	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
18-20,5		0.709-0.807	80	3.150	A760E31	A765R1	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
20,5-23		0.807-0.906	50	1.969	A760S31	A765R2	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
20,5-23		0.807-0.906	80	3.150	A760E31	A765R2	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
23-25,5		0.906-1.00	50	1.969	A760S31	A765R3	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
23-25,5		0.906-1.00	80	3.150	A760E31	A765R3	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
25,5-28		1.004-1.102	50	1.969	A760S31	A765R4	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
25,5-28		1.004-1.102	80	3.150	A760E31	A765R4	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
28-30,5		1.102-1.201	50	1.969	A760S31	A765R5	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
28-30,5		1.102-1.201	80	3.150	A760E31	A765R5	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
30,5-33		1.201-1.299	50	1.969	A760S31	A765R6	16	0.630	CC..0602..	Oțel coadă cu portplăcuță	
30,5-33		1.201-1.299	80	3.150	A760E31	A765R6	16	0.630	CC..0602..	Carbură coadă cu portplăcuță	
33-35,5*		1.299-1.398*	60	2.362	A760A32	A765R1	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
35,5-38*		1.299-1.496*	60	2.362	A760A32	A765R2	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
38-40,5*		1.496-1.594*	60	2.362	A760A32	A765R3	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
40,5-43*		1.594-1.693*	60	2.362	A760A32	A765R4	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
43-45,5*		1.693-1.791*	60	2.362	A760A32	A765R5	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
45,5-48*		1.791-1.890*	60	2.362	A760A32	A765R6	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
48-50,5*		1.890-1.988*	80	3.150	A760A33	A765R1	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
50,5-53*		1.988-2.087*	80	3.150	A760A33	A765R2	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță	
53-55,5*	2.087-2.185*	80	3.150	A760A33	A765R3	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță		
55,5-58*	2.185-2.283*	80	3.150	A760A33	A765R4	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță		
58-60,5*	2.283-2.382*	80	3.150	A760A33	A765R5	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță		
60,5-63*	2.382-2.480*	80	3.150	A760A33	A765R6	16	0.630	CC..0602..	Coadă de aluminiu cu portplăcuță		

Pentru diametre mai mari, vezi secțiunea adaptorului multifuncțional (MPA).  
\* Atunci când se utilizează împreună cu A760 13, nu este posibilă echilibrarea fină.



## Adaptor multifuncțional (MPA), pentru capete FB 760



1. Șurub de asamblare
2. Șaibă
3. Duză ajustabilă



- Potrivită doar pentru capete Axiabore® Plus\*.
- Conceput să țină o coadă și o contragreutate (pentru alezare sau alezare exterioră) sau două port-scule de canelat (pentru canelare)
- Răcire internă cu duză reglabilă (3)

Număr reper	Reper Nr.	Capacitatea DCN-DCX Ø						HTB	LF	DMM	WB	Greutate
		Pentru alezaj		Pentru strunjire exterioră		Pentru canelare						
		mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs
02595014	BDA16BS25100	53,0 2.087	108,0 4.252	2,0 0.079	57,0 2.244	31,0 1.220	96,0 3.780	25,0 0.984	16,0 0.630	16,0 0.630	100,0 3.937	0,28 0.620

### Piese de schimb

Pentru	Șurub ansamblu	Șaibă
BDA16BS25100	950D0618	940ZC06

### Accesorii

Cheie clemă
03HL05

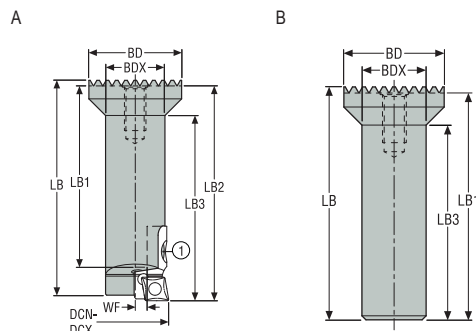
\*Atunci când se utilizează un cap - Axiabore™ Plus - A760 13, echilibrarea fină nu este posibilă, vezi pag. 582  
 Selectați componentele necesare pentru realizarea ansamblului de alezare, alezare exterioră sau canelare, folosind pag. 595-606

Accesorii, se vor comanda separat

## Coadă și contragreutate, pentru alezare și alezare exterioră cu MPA, pentru capete FB 760



- Pentru montarea în MPA.
- Coadă poate fi folosită pentru alezare sau alezare exterioră
- Necesită aceleași port-plăcuțe ca și cozile modulare pentru alezare



1. Șurub de asamblare

Număr reper	Reper Nr.	Varianta	** Capacitatea DCN-DCX Ø				LB	LB1	LB2	LB3	WF	BDX	BD	Greutate	Varianta
			Pentru alezaj		Pentru strunjire exterioră										
			mm Inci	mm Inci	mm Inci	mm Inci									
02595019	BAS25MH1660	Coadă*	53,0 2.087	108,0 4.252	2,0 0.079	57,0 2.244	58,5 2.303	48,5 1.909	58,5 2.303	50,0 1.969	4,0 0.157	16,0 0.630	25,0 0.984	0,1 0.220	A
02595016	BAS25CW1660	Contragreutate	53,0 2.087	108,0 4.252	2,0 0.079	57,0 2.244	58,0 2.283	56,6 2.228	-	48,5 1.909	-	16,0 0.630	25,0 0.984	0,11 0.240	B

### Piese de schimb

Pentru	Șurub ansamblu
BAS25MH1660	C04008-T15P
BAS25CW1660	-

### Accesorii

Pentru	Cheie (tip T)
BAS25MH1660	DOUBLE-T
BAS25CW1660	-

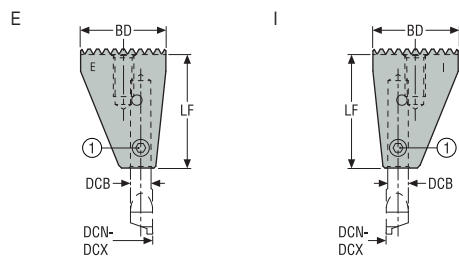
\*Port-plăcuțele se comandă separat, vezi pag. . 589

\*\* Capacitățile de alezare și alezare exterioră depind de portplăcuța aleasă

și de poziție de reglare a cozilor utilizând "Tabel de selecție pentru portplăcuțele pentru alezare și alezare exterioră" la pag. 595-606

Accesorii, se vor comanda separat

## Portscule pentru canelare, pentru canelare frontală cu MPA, pentru capetele FB 760



1. Șurub de blocare



- Pentru montarea în MPA.
- O port-sculă pentru canelare se poate utiliza pentru a ține o sculă de canelare sau poate fi folosită ca și contragreutate.

Număr reper	Reper Nr.	Varianta	* Capacitatea DCN-DCX ∅		DCB	LF	BD	Greutate	Varianta
			mm	mm					
02595021	BAS25FGI35	Grooving tool holder I (internal)*	19,0 0.748	76,0 2.992	6,0 0.236	35,0 1.378	25,0 0.984	0,1 0.220	I (Internal)
02595020	BAS25FGE35	Grooving tool holder E (external)*	39,0 1.535	96,0 3.780	6,0 0.236	35,0 1.378	25,0 0.984	0,1 0.220	E (External)

### Piese de schimb

Pentru	[Locking screw] Șurub de blocare
BAS25FGI35	950L0607T15P
BAS25FGE35	950L0607T15P



### Accesorii

Cheie (tip T)
DOUBLE-T
DOUBLE-T



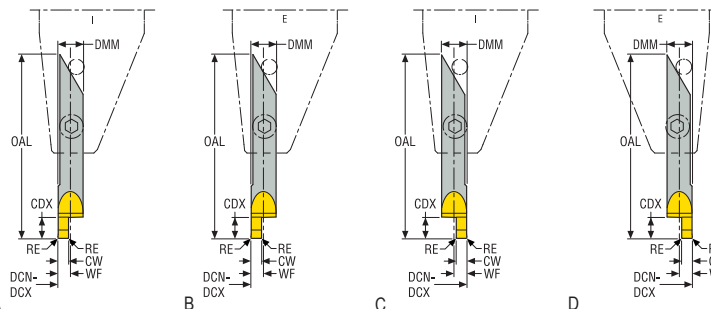
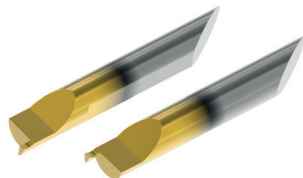
\*Sculele de canelare se vor comanda separat, vezi pag. 594

\* Capacitățile de canelare depind de scula aleasă pentru canelare, de poziție de reglare și de orientarea portsculei de canelare, utilizând "Tabel de selecție a sculelor pentru canelare spre dorn (sau spre alezaj)" la pag. 595-606

Accesorii, se vor comanda separat

## Scule de canelat

pentru capete FB 760



• Se poate utiliza atât pentru canelare interioară cât și exterioară, în funcție de capacitate. A

* Capacitatea DCN-DCX Ø																	
Număr reper	Reper Nr.	Varianta	Varianta A		Varianta B		Varianta C		Varianta D		OAL	CW	RE	DMM	WF	Adâncimea maximă **	Greutate
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci							
02595028	AFG0629101582	Against spigot	19,0 0.748	64,0 2.520	39,0 1.535	84,0 3.307	-	-	-	-	42,0 1.654	1,0 0.039	0,15 0.006	6,0 0.236	2,95 0.116	2,0 0.079	0,07 0.150
02595029	AFG0629151582	Against spigot	19,0 0.748	64,0 2.520	39,0 1.535	84,0 3.307	-	-	-	-	42,0 1.654	1,5 0.059	0,15 0.006	6,0 0.236	2,95 0.116	3,0 0.118	0,07 0.150
02595031	AFG0629201582	Against spigot	19,0 0.748	64,0 2.520	39,0 1.535	84,0 3.307	-	-	-	-	42,0 1.654	2,0 0.079	0,15 0.006	6,0 0.236	2,95 0.116	5,0 0.197	0,07 0.150
02595032	AFG0629251582	Against spigot	19,0 0.748	64,0 2.520	39,0 1.535	84,0 3.307	-	-	-	-	42,0 1.654	2,5 0.098	0,15 0.006	6,0 0.236	2,95 0.116	5,0 0.197	0,07 0.150
02595033	AFG0629301582	Against spigot	19,0 0.748	64,0 2.520	39,0 1.535	84,0 3.307	-	-	-	-	42,0 1.654	3,0 0.118	0,15 0.006	6,0 0.236	2,95 0.116	6,0 0.236	0,07 0.150
02595022	AFG0629101581	Against bore	-	-	-	-	31,0 1.220	76,0 2.992	51,0 2.008	96,0 3.780	42,0 1.654	1,0 0.039	0,15 0.006	6,0 0.236	2,95 0.116	2,0 0.079	0,02 0.040
02595023	AFG0629151581	Against bore	-	-	-	-	31,0 1.220	76,0 2.992	51,0 2.008	96,0 3.780	42,0 1.654	1,5 0.059	0,15 0.006	6,0 0.236	2,95 0.116	3,0 0.118	0,07 0.150
02595024	AFG0629201581	Against bore	-	-	-	-	31,0 1.220	76,0 2.992	51,0 2.008	96,0 3.780	42,0 1.654	2,0 0.079	0,15 0.006	6,0 0.236	2,95 0.116	4,0 0.157	0,07 0.150
02595026	AFG0629251581	Against bore	-	-	-	-	31,0 1.220	76,0 2.992	51,0 2.008	96,0 3.780	42,0 1.654	2,5 0.098	0,15 0.006	6,0 0.236	2,95 0.116	5,0 0.197	0,07 0.150
02595027	AFG0629301581	Against bore	-	-	-	-	31,0 1.220	76,0 2.992	51,0 2.008	96,0 3.780	42,0 1.654	3,0 0.118	0,15 0.006	6,0 0.236	2,95 0.116	6,0 0.236	0,07 0.150

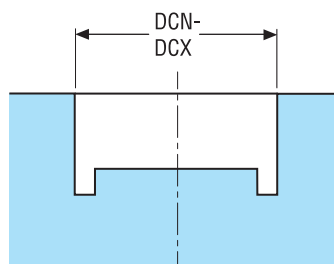
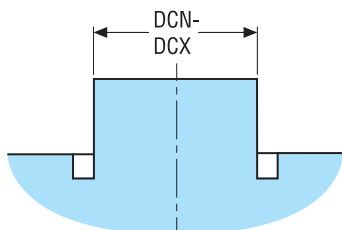
\* Capacitățile de canelare depind de scula aleasă pentru canelare, de poziție de reglare și de orientarea portsculei de canelare, utilizând "Tabel de selecție a sculelor pentru canelare spre dorn (sau spre alezaj)" la pag. 595-606

\*\* Adâncimea maximă de canelare CDX

### Piese de schimb

cule de canelat - contra spigot-

Scule de canelat - against bore-



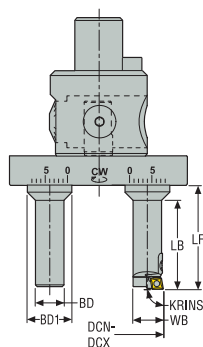
Tabel de selecție:  
Scule de alezare și portplăcuțe potrivite pentru capetele FB 760, Metric

	Capacitatea DCN-DCX Ø mm*	Portplăcuță Descriere	Poziția cozii	Dimensiunea în mm					Unghiul de atac KRINS°	Mărimea plăcuței potrivite
				BD	BD1	LF	LB	WB		
	53-55,5	A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
	55,5-58	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
	58-60,5	A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	0	16	25	58,5	50	19,5	90°	CC..0602..
	60,5-63	A765 R2	1	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	0	16	25	58,5	50	20,7	90°	CC..0602..
	63-65,5	A765 R1	2	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	1	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
	65,5-68	A765 R2	2	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	1	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	0	16	25	58,5	50	23,3	90°	CC..0602..
	68-70,5	A765 R1	3	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	2	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	1	16	25	58,5	50	22	90°	CC..0602..
	70,5-73	A765 R2	3	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	2	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
	73-75,5	A765 R1	4	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	3	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	2	16	25	58,5	50	22	90°	CC..0602..
	75,5-78	A765 R2	4	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	3	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	2	16	25	58,5	50	23,2	90°	CC..0602..
	78-80,5	A765 R1	5	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	4	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	3	16	25	58,5	50	22	90°	CC..0602..
	80,5-83	A765 R2	5	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	4	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	3	16	25	58,5	50	23,2	90°	CC..0602..
	83-85,5	A765 R1	6	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	5	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	4	16	25	58,5	50	22	90°	CC..0602..
	85,5-88	A765 R2	6	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	5	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	4	16	25	58,5	50	23,2	90°	CC..0602..
	88-90,5	A765 R1	7	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	6	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	5	16	25	58,5	50	22	90°	CC..0602..
	90,5-93	A765 R2	7	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	6	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	5	16	25	58,5	50	23,2	90°	CC..0602..
	93-95,5	A765 R1	8	16	25	58,5	50	17	90°	CC..0602..
		A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
	95,5-98	A765 R2	8	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R4	7	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R6	6	16	25	58,5	50	23,2	90°	CC..0602..
	98-100,5	A765 R3	8	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	7	16	25	58,5	50	22	90°	CC..0602..
		A765 R1	8	16	25	58,5	50	17	90°	CC..0602..
	100,5-103	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
		A765 R1	8	16	25	58,5	50	17	90°	CC..0602..
	103-105,5	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
	105,5-108	A765 R6	8	16	25	58,5	50	23,2	90°	CC..0602..

Alege o portplăcuță potrivită și ai grijă de poziția cozii în MPA pentru a obține dimensiunea de alezare dorită.

Notă: Un ansamblu de alezare necesită:

- un cap - Axiabore™ Plus - (A760 03)
- un MPA (BDA16BS25100)
- o coadă (BAS25MH1660)
- o contragreutate (BAS25CW1660).
- o portplăcuță (A765R), se va selecta din tabel
- o plăcuță

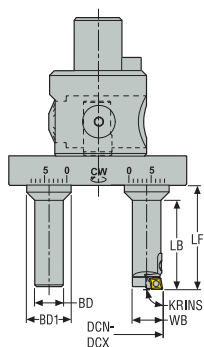


\* +0,2 mm (0.008") capacitate complementară posibilă.  
Descrierea detaliată a portplăcuțelor, vezi pag. 589

**Tabel de selecție:**  
**Scule de alezare și portplăcuțe potrivite pentru capetele FB 760, inci**

	Capacitate DCN-DCX Ø inci*	Portplăcuță Descriere	Poziția cozii	Dimensiunea în inci					Unghiul de atac KRINS°	Mărima plăcuței potrivite
				BD	BD1	LF	LB	WB		
	2.087-2.185	A765 R1	0	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
	2.185-2.283	A765 R2	0	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	2.283-2.382	A765 R1	1	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	0	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	2.382-2.480	A765 R2	1	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R4	0	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
	2.480-2.579	A765 R1	2	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	1	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	2.579-2.677	A765 R5	0	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R2	2	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	2.677-2.776	A765 R4	1	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R6	0	0.630	0.984	2.303	1.969	0.917	90°	CC..0602..
	2.776-2.874	A765 R1	3	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	2	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	2.874-2.972	A765 R5	1	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R2	3	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	2.972-3.071	A765 R4	3	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R6	2	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	3.071-3.169	A765 R1	5	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	4	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	3.169-3.268	A765 R5	3	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R2	5	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	3.268-3.366	A765 R4	4	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R6	3	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	3.366-3.465	A765 R1	6	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	5	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	3.465-3.563	A765 R5	4	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R2	6	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	3.563-3.661	A765 R4	5	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R6	4	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	3.661-3.760	A765 R1	7	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	6	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	3.760-3.858	A765 R5	5	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R2	7	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	3.858-3.957	A765 R4	6	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R6	5	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	3.957-4.055	A765 R1	8	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R3	7	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	4.055-4.154	A765 R5	6	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R2	8	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	4.154-4.252	A765 R4	7	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R6	6	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..

Alege o portplăcuță potrivită și ai grijă de poziția cozii în MPA pentru a obține dimensiunea de alezare dorită.  
Notă: Un ansamblu de alezare necesită:  
- un cap - Axiabore™ Plus - (A760 03)  
- un MPA (BDA16BS25100)  
- o coadă (BAS25MH1660)  
- o contragreutate (BAS25CW1660).  
- o portplăcuțar (A765R.), se va selecta din tabel  
- o plăcuță



\* +0,2 mm (0.008") capacitate complementară posibilă.  
Descrierea detaliată a portplăcuțelor, vezi pag. 589

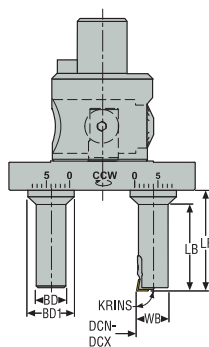
## Tabel de selecție: Portplăcuțe pentru alezarea exterioară cu MPA, pentru capetele FB 760, Metric

	Capacitatea DCN-DCX Ø mm*	Portplăcuță Descriere	Poziția cozii	Dimensiunea în mm					Unghiul de atac KRINS°	Mărimea plăcuței potrivite
				BD	BD1	LF	LB	WB		
	2-4,5	A765 R6	0	16	25	58,5	50	23,2	90°	CC..0602..
	4,5-7	A765 R5	0	16	25	58,5	50	22	90°	CC..0602..
	7-9,5	A765 R6	1	16	25	58,5	50	23,2	90°	CC..0602..
		A765 R4	0	16	25	58,5	50	20,7	90°	CC..0602..
	9,5-12	A765 R5	1	16	25	58,5	50	22	90°	CC..0602..
		A765 R3	0	16	25	58,5	50	19,5	90°	CC..0602..
	12-14,5	A765 R6	2	16	25	58,5	50	23,2	90°	CC..0602..
		A765 R4	1	16	25	58,5	50	20,7	90°	CC..0602..
	14,5-17	A765 R2	0	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R5	2	16	25	58,5	50	22	90°	CC..0602..
	17-19,5	A765 R3	1	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R1	0	16	25	58,5	50	17	90°	CC..0602..
	19,5-22	A765 R6	3	16	25	58,5	50	23,2	90°	CC..0602..
		A765 R4	2	16	25	58,5	50	20,7	90°	CC..0602..
	22-24,5	A765 R2	1	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R5	3	16	25	58,5	50	22	90°	CC..0602..
	24,5-27	A765 R3	2	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R1	1	16	25	58,5	50	17	90°	CC..0602..
	27-29,5	A765 R6	4	16	25	58,5	50	23,2	90°	CC..0602..
		A765 R4	3	16	25	58,5	50	20,7	90°	CC..0602..
	29,5-32	A765 R2	2	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R5	4	16	25	58,5	50	22	90°	CC..0602..
	32-34,5	A765 R3	3	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R1	2	16	25	58,5	50	17	90°	CC..0602..
	34,5-37	A765 R6	5	16	25	58,5	50	23,2	90°	CC..0602..
		A765 R4	4	16	25	58,5	50	20,7	90°	CC..0602..
	37-39,5	A765 R2	3	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R5	5	16	25	58,5	50	22	90°	CC..0602..
	39,5-42	A765 R3	4	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R1	3	16	25	58,5	50	17	90°	CC..0602..
	42-44,5	A765 R6	6	16	25	58,5	50	23,2	90°	CC..0602..
		A765 R4	5	16	25	58,5	50	20,7	90°	CC..0602..
	44,5-47	A765 R2	4	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R5	6	16	25	58,5	50	22	90°	CC..0602..
	47-49,5	A765 R3	7	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R1	6	16	25	58,5	50	17	90°	CC..0602..
	49,5-52	A765 R4	8	16	25	58,5	50	20,7	90°	CC..0602..
		A765 R2	7	16	25	58,5	50	18,2	90°	CC..0602..
	52-54,5	A765 R3	8	16	25	58,5	50	19,5	90°	CC..0602..
		A765 R1	7	16	25	58,5	50	17	90°	CC..0602..
	54,5-57	A765 R2	8	16	25	58,5	50	18,2	90°	CC..0602..
		A765 R1	8	16	25	58,5	50	17	90°	CC..0602..

Alege o portplăcuță potrivită și ai grijă de poziția cozii în MPA pentru a obține dimensiunea de alezare dorită.

Notă: Un ansamblu de alezare necesită:

- un cap - Axiabore™ Plus - (A760 03)
- un MPA (BDA16BS25100)
- o coadă (BAS25MH1660)
- o contragreutate (BAS25CW1660).
- o portplăcuță (A765R), se va selecta din tabel
- o plăcuță



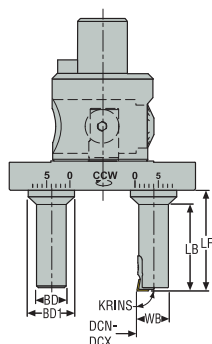
\* +0,2 mm (0.008") capacitate complementară posibilă.

Descrierea detaliată a portplăcuțelor, vezi pag. 589

Tabel de selecție:  
Portplăcuțe pentru alezarea exterioră cu MPA, pentru capetele FB 760, inci

	Capacitate DCN-DCX Ø inci*	Portplăcuță Descriere	Poziția cozii	Dimensiunea în inci					Unghiul de atac KRINS°	Mărima plăcuței potrivite
				BD	BD1	LF	LB	WB		
	0.079-0.177	A765 R6	0	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	0.177-0.276	A765 R5	0	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	0.276-0.374	A765 R6	1	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
		A765 R4	0	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
	0.374-0.472	A765 R5	1	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
		A765 R3	0	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R6	2	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	0.472-0.571	A765 R4	1	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	0	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	2	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	0.571-0.669	A765 R3	1	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	0	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R6	3	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	0.669-0.768	A765 R4	2	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	1	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	3	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	0.768-0.866	A765 R3	2	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	1	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R6	4	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	0.866-0.965	A765 R4	3	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	2	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	4	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	0.965-1.063	A765 R3	3	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	2	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R6	5	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	1.063-1.161	A765 R4	4	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	3	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	5	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	1.161-1.260	A765 R3	4	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	3	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R6	6	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	1.260-1.358	A765 R4	5	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	4	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	6	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	1.358-1.457	A765 R3	5	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	4	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R6	7	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	1.457-1.555	A765 R4	6	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	5	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	7	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	1.555-1.654	A765 R3	6	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	5	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R6	8	0.630	0.984	2.303	1.969	0.913	90°	CC..0602..
	1.654-1.654	A765 R4	7	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
		A765 R2	6	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R5	8	0.630	0.984	2.303	1.969	0.866	90°	CC..0602..
	1.654-1.850	A765 R3	7	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
		A765 R1	6	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R4	8	0.630	0.984	2.303	1.969	0.815	90°	CC..0602..
	1.850-1.949	A765 R2	7	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
		A765 R3	8	0.630	0.984	2.303	1.969	0.768	90°	CC..0602..
	1.949-2.047	A765 R1	7	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..
		A765 R2	8	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	2.047-2.146	A765 R2	8	0.630	0.984	2.303	1.969	0.717	90°	CC..0602..
	2.146-2.244	A765 R1	8	0.630	0.984	2.303	1.969	0.669	90°	CC..0602..

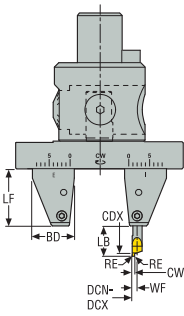
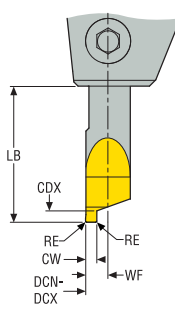
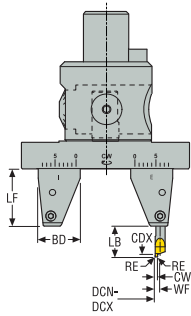
Alege o portplăcuță potrivită și ai grijă de poziția cozii în MPA pentru a obține dimensiunea de alezare dorită.  
Notă: Un ansamblu de alezare necesită:  
- un cap - Axiabore™ Plus - (A760 03)  
- un MPA (BDA16BS25100)  
- o coadă (BAS25MH1660)  
- o contragreutate (BAS25CW1660).  
- o portplăcuțar (A765R.), se va selecta din tabel  
- o plăcuță



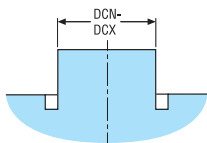
\* +0,2 mm (0.008") capacitate complementară posibilă.  
Descrierea detaliată a portplăcuțelor, vezi pag. 589



Tabel de selecție:  
Sculă de canelare -spre dorn- pentru canelare cu MPA, pentru capetele FB 760, Metric

	Capacitatea DCN-DCX Ø mm*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în mm						Adâncimea maximă de canelare CDX
					BD	CW	LF	LB	WF	RE	
<p>Cutie de asamblare 1</p>  <p>Cutie de asamblare 2</p>  	19-24	AFG0629 10 1582	0-I	1	25	1	34	18	2,95	0,15	2,0
	24-29		1-I	1	25	1	34	18	2,95	0,15	2,0
	29-34		2-I	1	25	1	34	18	2,95	0,15	2,0
	34-39		3-I	1	25	1	34	18	2,95	0,15	2,0
	39-44		0-E / 4-I	1/2	25	1	34	18	2,95	0,15	2,0
	44-49		1-E / 5-I	1/2	25	1	34	18	2,95	0,15	2,0
	49-54		2-E / 6-I	1/2	25	1	34	18	2,95	0,15	2,0
	54-59		3-E / 7-I	1/2	25	1	34	18	2,95	0,15	2,0
	59-64		4-E / 8-I	1/2	25	1	34	18	2,95	0,15	2,0
	64-69		5-E	2	25	1	34	18	2,95	0,15	2,0
	69-74		6-E	2	25	1	34	18	2,95	0,15	2,0
	74-79		7-E	2	25	1	34	18	2,95	0,15	2,0
	79-84		8-E	2	25	1	34	18	2,95	0,15	2,0
	19-24		0-I	1	25	1,5	34	18	2,95	0,15	3,0
	24-29		1-I	1	25	1,5	34	18	2,95	0,15	3,0
	29-34		2-I	1	25	1,5	34	18	2,95	0,15	3,0
34-39	3-I	1	25	1,5	34	18	2,95	0,15	3,0		
39-44	0-E / 4-I	1/2	25	1,5	34	18	2,95	0,15	3,0		
44-49	1-E / 5-I	1/2	25	1,5	34	18	2,95	0,15	3,0		
49-54	2-E / 6-I	1/2	25	1,5	34	18	2,95	0,15	3,0		
54-59	3-E / 7-I	1/2	25	1,5	34	18	2,95	0,15	3,0		
59-64	4-E / 8-I	1/2	25	1,5	34	18	2,95	0,15	3,0		
64-69	5-E	2	25	1,5	34	18	2,95	0,15	3,0		
69-74	6-E	2	25	1,5	34	18	2,95	0,15	3,0		
74-79	7-E	2	25	1,5	34	18	2,95	0,15	3,0		
79-84	8-E	2	25	1,5	34	18	2,95	0,15	3,0		
19-24	0-I	1	25	2	34	18	2,95	0,15	4,0		
24-29	1-I	1	25	2	34	18	2,95	0,15	4,0		
29-34	2-I	1	25	2	34	18	2,95	0,15	4,0		
34-39	3-I	1	25	2	34	18	2,95	0,15	4,0		
39-44	0-E / 4-I	1/2	25	2	34	18	2,95	0,15	4,0		
44-49	1-E / 5-I	1/2	25	2	34	18	2,95	0,15	4,0		
49-54	2-E / 6-I	1/2	25	2	34	18	2,95	0,15	4,0		
54-59	3-E / 7-I	1/2	25	2	34	18	2,95	0,15	4,0		
59-64	4-E / 8-I	1/2	25	2	34	18	2,95	0,15	4,0		
64-69	5-E	2	25	2	34	18	2,95	0,15	4,0		
69-74	6-E	2	25	2	34	18	2,95	0,15	4,0		
74-79	7-E	2	25	2	34	18	2,95	0,15	4,0		
79-84	8-E	2	25	2	34	18	2,95	0,15	4,0		

Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.



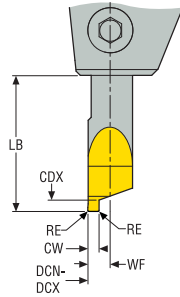
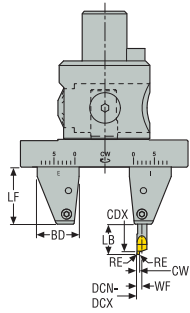
Notă : Un ansamblu de canelare -spre dorn- necesită:

- un cap - Axiabore™ Plus - (A760 03)
- un MPA (BDA16BS25100)
- o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel)
- o sculă de canelare -spre dorn- (AFG...82) aleasă din tabel, în funcție de lățimea și diametrul canalului.

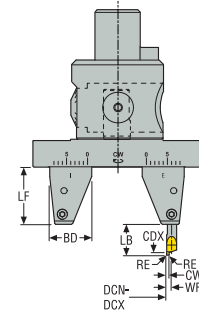
\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

Tabel de selecție:  
Sculă de canelare -spre dorn- pentru canelare cu MPA, pentru capetele FB 760, inci

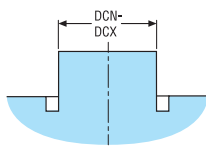
Cutie de asamblare 1



Cutie de asamblare 2



	Capacitate DCN-DCX Ø inci*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea in inci						Adâncimea maximă de canelare CDX
					BD	CW	LF	LB	WF	RE	
Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.	0.748-0.945	AFG0629 10 1582	0-I	1	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	0.945-1.142		1-I	1	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.142-1.339		2-I	1	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.339-1.535		3-I	1	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.535-1.732		0-E / 4-I	1/2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.732-1.929		1-E / 5-I	1/2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.929-2.126		2-E / 6-I	1/2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.126-2.323		3-E / 7-I	1/2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.323-2.520		4-E / 8-I	1/2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.520-2.717		5-E	2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.717-2.913		6-E	2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.913-3.110		7-E	2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	3.110-3.307		8-E	2	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	0.748-0.945		0-I	1	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	0.945-1.142		1-I	1	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
1.142-1.339	2-I	1	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
1.339-1.535	3-I	1	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
1.535-1.732	0-E / 4-I	1/2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
1.732-1.929	1-E / 5-I	1/2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
1.929-2.126	2-E / 6-I	1/2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
2.126-2.323	3-E / 7-I	1/2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
2.323-2.520	4-E / 8-I	1/2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
2.520-2.717	5-E	2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
2.717-2.913	6-E	2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
2.913-3.110	7-E	2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
3.110-3.307	8-E	2	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
0.748-0.945	0-I	1	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
0.945-1.142	1-I	1	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
1.142-1.339	2-I	1	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
1.339-1.535	3-I	1	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
1.535-1.732	0-E / 4-I	1/2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
1.732-1.929	1-E / 5-I	1/2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
1.929-2.126	2-E / 6-I	1/2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
2.126-2.323	3-E / 7-I	1/2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
2.323-2.520	4-E / 8-I	1/2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
2.520-2.717	5-E	2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
2.717-2.913	6-E	2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
2.913-3.110	7-E	2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
3.110-3.307	8-E	2	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		

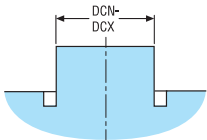


Notă : Un ansamblu de canelare -spre dorn- necesită:

- un cap - Axiabore™ Plus - (A760 03)
- un MPA (BDA16BS25100)
- o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel)
- o sculă de canelare -spre dorn- (AFG...82) aleasă din tabel, în funcție de lățimea și diametrul canalului.

\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

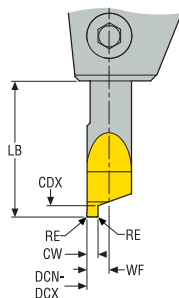
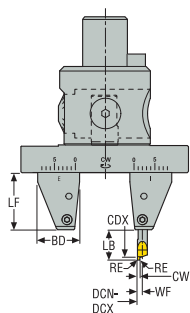
Tabel de selecție:  
Sculă de canelare -spre dorn- pentru canelare cu MPA, pentru capetele FB 760, Metric

	Capacitatea DCN-DCX Ø mm*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în mm						Adâncimea maximă de canelare CDX		
					BD	CW	LF	LB	WF	RE			
<p>Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.</p> 	19-24	AFG0629 25 1582	0-I	1	25	2,5	34	18	2,95	0,15	5,0		
	24-29		1-I	1	25	2,5	34	18	2,95	0,15	5,0		
	29-34		2-I	1	25	2,5	34	18	2,95	0,15	5,0		
	34-39		3-I	1	25	2,5	34	18	2,95	0,15	5,0		
	39-44		0-E / 4-I	1/2	25	2,5	34	18	2,95	0,15	5,0		
	44-49		1-E / 5-I	1/2	25	2,5	34	18	2,95	0,15	5,0		
	49-54		2-E / 6-I	1/2	25	2,5	34	18	2,95	0,15	5,0		
	54-59		3-E / 7-I	1/2	25	2,5	34	18	2,95	0,15	5,0		
	59-64		4-E / 8-I	1/2	25	2,5	34	18	2,95	0,15	5,0		
	64-69		5-E	2	25	2,5	34	18	2,95	0,15	5,0		
	69-74		6-E	2	25	2,5	34	18	2,95	0,15	5,0		
	74-79		7-E	2	25	2,5	34	18	2,95	0,15	5,0		
	79-84		8-E	2	25	2,5	34	18	2,95	0,15	5,0		
	<p>Notă : Un ansamblu de canelare -spre dorn- necesită:</p> <ul style="list-style-type: none"> <li>• un cap - Axiabore™ Plus - (A760 03)</li> <li>• un MPA (BDA16BS25100)</li> <li>• o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel)</li> <li>• o sculă de canelare -spre dorn- (AFG...82) aleasă din tabel, în funcție de lățimea și diametrul canalului.</li> </ul>		19-24	AFG0629 30 1582	0-I	1	25	3	34	18	2,95	0,15	6,0
			24-29		1-I	1	25	3	34	18	2,95	0,15	6,0
			29-34		2-I	1	25	3	34	18	2,95	0,15	6,0
34-39		3-I	1		25	3	34	18	2,95	0,15	6,0		
39-44		0-E / 4-I	1/2		25	3	34	18	2,95	0,15	6,0		
44-49		1-E / 5-I	1/2		25	3	34	18	2,95	0,15	6,0		
49-54		2-E / 6-I	1/2		25	3	34	18	2,95	0,15	6,0		
54-59		3-E / 7-I	1/2		25	3	34	18	2,95	0,15	6,0		
59-64		4-E / 8-I	1/2		25	3	34	18	2,95	0,15	6,0		
64-69		5-E	2		25	3	34	18	2,95	0,15	6,0		
69-74		6-E	2		25	3	34	18	2,95	0,15	6,0		
74-79		7-E	2		25	3	34	18	2,95	0,15	6,0		
79-84		8-E	2		25	3	34	18	2,95	0,15	6,0		

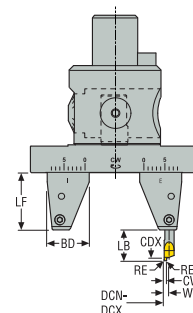
\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

Tabel de selecție:  
Sculă de canelare -spre dorn- pentru canelare cu MPA, pentru capetele FB 760, inci

Cutie de asamblare 1



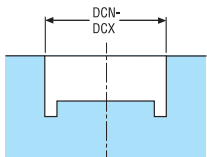
Cutie de asamblare 2



	Capacitate DCN-DCX Ø inci*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în inci						Adâncimea maximă de canelare CDX		
					BD	CW	LF	LB	WF	RE			
Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.	0.748-0.945	AFG0629 25 1582	0-I	1	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	0.945-1.142		1-I	1	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	1.142-1.339		2-I	1	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	1.339-1.535		3-I	1	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	1.535-1.732		0-E / 4-I	1/2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	1.732-1.929		1-E / 5-I	1/2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	1.929-2.126		2-E / 6-I	1/2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	2.126-2.323		3-E / 7-I	1/2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	2.323-2.520		4-E / 8-I	1/2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	2.520-2.717		5-E	2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	2.717-2.913		6-E	2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	2.913-3.110		7-E	2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	3.110-3.307		8-E	2	0.984	0.0984	1.339	0.709	0.116	0.006	0.197		
	Notă : Un ansamblu de canelare -spre dorn- necesită: • un cap - Axiabore™ Plus - (A760 03) • un MPA (BDA16BS25100) • o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel) • o sculă de canelare -spre dorn- (AFG...82) aleasă din tabel, în funcție de lățimea și diametrul canalului.		0.748-0.945	AFG0629 30 1582	0-I	1	0.984	0.1181	1.339	0.709	0.116	0.006	0.236
			0.945-1.142		1-I	1	0.984	0.1181	1.339	0.709	0.116	0.006	0.236
1.142-1.339		2-I	1		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
1.339-1.535		3-I	1		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
1.535-1.732		0-E / 4-I	1/2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
1.732-1.929		1-E / 5-I	1/2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
1.929-2.126		2-E / 6-I	1/2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
2.126-2.323		3-E / 7-I	1/2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
2.323-2.520		4-E / 8-I	1/2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
2.520-2.717		5-E	2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
2.717-2.913		6-E	2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
2.913-3.110		7-E	2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		
3.110-3.307		8-E	2		0.984	0.1181	1.339	0.709	0.116	0.006	0.236		

\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

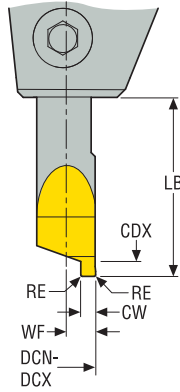
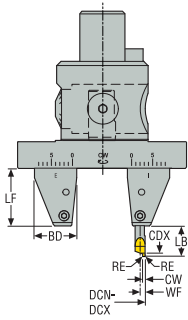
Tabel de selecție:  
Scule de canelat - către pi - pentru alezare cu MPA, pentru capete FB 760, Metric

	Capacitatea DCN-DCX Ø mm*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în mm						Adâncimea maximă de canelare CDX
					BD	CW	LF	LB	WF	RE	
<p>Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.</p> 	31-36	AFG0629 10 1581	0-I	3	25	1	34	18	2,95	0,15	2,0
	36-41		1-I	3	25	1	34	18	2,95	0,15	2,0
	41-46		2-I	3	25	1	34	18	2,95	0,15	2,0
	46-51		3-I	3	25	1	34	18	2,95	0,15	2,0
	51-56		0-E / 4-I	3/4	25	1	34	18	2,95	0,15	2,0
	56-61		1-E / 5-I	3/4	25	1	34	18	2,95	0,15	2,0
	61-66		2-E / 6-I	3/4	25	1	34	18	2,95	0,15	2,0
	66-71		3-E / 7-I	3/4	25	1	34	18	2,95	0,15	2,0
	71-76		4-E / 8-I	3/4	25	1	34	18	2,95	0,15	2,0
	76-81		5-E	4	25	1	34	18	2,95	0,15	2,0
	81-86		6-E	4	25	1	34	18	2,95	0,15	2,0
	86-91		7-E	4	25	1	34	18	2,95	0,15	2,0
	91-96		8-E	4	25	1	34	18	2,95	0,15	2,0
	31-36		0-I	3	25	1,5	34	18	2,95	0,15	3,0
	39-41		1-I	3	25	1,5	34	18	2,95	0,15	3,0
	41-46		2-I	3	25	1,5	34	18	2,95	0,15	3,0
46-51	3-I	3	25	1,5	34	18	2,95	0,15	3,0		
51-56	0-E / 4-I	3/4	25	1,5	34	18	2,95	0,15	3,0		
56-61	1-E / 5-I	3/4	25	1,5	34	18	2,95	0,15	3,0		
61-66	2-E / 6-I	3/4	25	1,5	34	18	2,95	0,15	3,0		
66-71	3-E / 7-I	3/4	25	1,5	34	18	2,95	0,15	3,0		
71-76	4-E / 8-I	3/4	25	1,5	34	18	2,95	0,15	3,0		
76-81	5-E	4	25	1,5	34	18	2,95	0,15	3,0		
81-86	6-E	4	25	1,5	34	18	2,95	0,15	3,0		
86-91	7-E	4	25	1,5	34	18	2,95	0,15	3,0		
91-96	8-E	4	25	1,5	34	18	2,95	0,15	3,0		
31-36	0-I	3	25	2	34	18	2,95	0,15	4,0		
39-41	1-I	3	25	2	34	18	2,95	0,15	4,0		
41-46	2-I	3	25	2	34	18	2,95	0,15	4,0		
46-51	3-I	3	25	2	34	18	2,95	0,15	4,0		
51-56	0-E / 4-I	3/4	25	2	34	18	2,95	0,15	4,0		
56-61	1-E / 5-I	3/4	25	2	34	18	2,95	0,15	4,0		
61-66	2-E / 6-I	3/4	25	2	34	18	2,95	0,15	4,0		
66-71	3-E / 7-I	3/4	25	2	34	18	2,95	0,15	4,0		
71-76	4-E / 8-I	3/4	25	2	34	18	2,95	0,15	4,0		
76-81	5-E	4	25	2	34	18	2,95	0,15	4,0		
81-86	6-E	4	25	2	34	18	2,95	0,15	4,0		
86-91	7-E	4	25	2	34	18	2,95	0,15	4,0		
91-96	8-E	4	25	2	34	18	2,95	0,15	4,0		

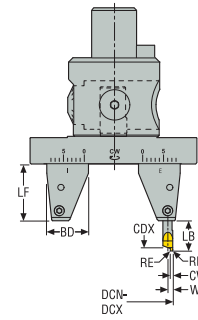
\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

Tabel de selecție:  
Scule de canelat - către pi - pentru alezare cu MPA, pentru capete FB 760, inci

Cutie de asamblare 3



Cutie de asamblare 4



	Capacitate DCN-DCX Ø inci*	Sculă de alezare spre dornul Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în inci						Adâncimea maximă de canelare CDX
					BD	CW	LF	LB	WF	RE	
Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.	1.220-1.417	AFG0629 10 1581	0-I	3	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.417-1.614		1-I	3	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.614-1.811		2-I	3	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	1.811-2.008		3-I	3	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.008-2.205		0-E / 4-I	3/4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.205-2.402		1-E / 5-I	3/4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.402-2.598		2-E / 6-I	3/4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.598-2.795		3-E / 7-I	3/4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.795-2.992		4-E / 8-I	3/4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
	2.992-3.189		5-E	4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079
3.189-3.386	6-E	4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079		
3.386-3.583	7-E	4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079		
3.583-3.780	8-E	4	0.984	0.0394	1.339	0.709	0.116	0.006	0.079		
Notă : Un ansamblu de canelare -spre alezaj- necesită: • un cap - Axiabore™ Plus - (A760 03) • un MPA (BDA16BS25100) • o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel) • o sculă de canelare -spre alezaj- (AFG...81) aleasă din tabel, în funcție de lățimea și diametrul canalului.	1.220-1.417	AFG0629 15 1581	0-I	3	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	1.417-1.614		1-I	3	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	1.614-1.811		2-I	3	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	1.811-2.008		3-I	3	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	2.008-2.205		0-E / 4-I	3/4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	2.205-2.402		1-E / 5-I	3/4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	2.402-2.598		2-E / 6-I	3/4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	2.598-2.795		3-E / 7-I	3/4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	2.795-2.992		4-E / 8-I	3/4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
	2.992-3.189		5-E	4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118
3.189-3.386	6-E	4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
3.386-3.583	7-E	4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
3.583-3.780	8-E	4	0.984	0.0591	1.339	0.709	0.116	0.006	0.118		
	1.220-1.417	AFG0629 20 1581	0-I	3	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	1.417-1.614		1-I	3	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	1.614-1.811		2-I	3	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	1.811-2.008		3-I	3	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	2.008-2.205		0-E / 4-I	3/4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	2.205-2.402		1-E / 5-I	3/4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	2.402-2.598		2-E / 6-I	3/4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	2.598-2.795		3-E / 7-I	3/4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	2.795-2.992		4-E / 8-I	3/4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
	2.992-3.189		5-E	4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157
3.189-3.386	6-E	4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
3.386-3.583	7-E	4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		
3.583-3.780	8-E	4	0.984	0.0787	1.339	0.709	0.116	0.006	0.157		

\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

Tabel de selecție:  
Scule de canelat - către pi - pentru alezare cu MPA, pentru capete FB 760, Metric

**Cutie de asamblare 3**

**Cutie de asamblare 4**

	Capacitatea DCN-DCX Ø mm*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în mm						Adâncimea maximă de canelare CDX
					BD	CW	LF	LB	WF	RE	
<p>Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.</p>	31-36	AFG0629 25 1581	0-I	3	25	2,5	34	18	2,95	0,15	5,0
	36-41		1-I	3	25	2,5	34	18	2,95	0,15	5,0
	41-46		2-I	3	25	2,5	34	18	2,95	0,15	5,0
	46-51		3-I	3	25	2,5	34	18	2,95	0,15	5,0
	51-56		0-E / 4-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	56-61		1-E / 5-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	61-66		2-E / 6-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	66-71		3-E / 7-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	71-76		4-E / 8-I	3/4	25	2,5	34	18	2,95	0,15	5,0
	76-81		5-E	4	25	2,5	34	18	2,95	0,15	5,0
	81-86		6-E	4	25	2,5	34	18	2,95	0,15	5,0
	86-91		7-E	4	25	2,5	34	18	2,95	0,15	5,0
	91-96		8-E	4	25	2,5	34	18	2,95	0,15	5,0
	31-36		0-I	3	25	3	34	18	2,95	0,15	6,0
	39-41		1-I	3	25	3	34	18	2,95	0,15	6,0
	41-46		2-I	3	25	3	34	18	2,95	0,15	6,0
	46-51		3-I	3	25	3	34	18	2,95	0,15	6,0
	51-56		0-E / 4-I	3/4	25	3	34	18	2,95	0,15	6,0
	56-61		1-E / 5-I	3/4	25	3	34	18	2,95	0,15	6,0
61-66	2-E / 6-I	3/4	25	3	34	18	2,95	0,15	6,0		
66-71	3-E / 7-I	3/4	25	3	34	18	2,95	0,15	6,0		
71-76	4-E / 8-I	3/4	25	3	34	18	2,95	0,15	6,0		
76-81	5-E	4	25	3	34	18	2,95	0,15	6,0		
81-86	6-E	4	25	3	34	18	2,95	0,15	6,0		
86-91	7-E	4	25	3	34	18	2,95	0,15	6,0		
91-96	8-E	4	25	3	34	18	2,95	0,15	6,0		

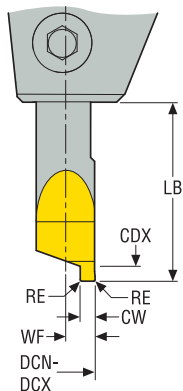
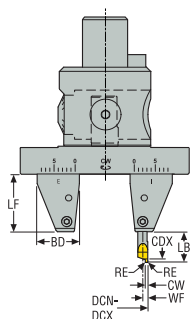
Notă : Un ansamblu de canelare -spre alezaj- necesită:

- un cap - Axiabore™ Plus - (A760 03)
- un MPA (BDA16BS25100)
- o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel)
- o sculă de canelare -spre alezaj- (AFG...81) aleasă din tabel, în funcție de lățimea și diametrul canalului.

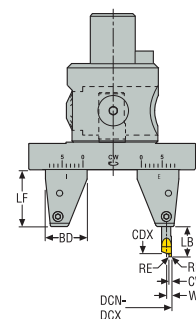
\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt **îngroșate**.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594

Tabel de selecție:  
Scule de canelat - către pi - pentru alezare cu MPA, pentru capete FB 760, inci

Cutie de asamblare 3



Cutie de asamblare 4



	Capacitate DCN-DCX Ø inci*	Sculă de alezare spre dorn Descriere	Poziția sculei de canelare**	Varianta	Dimensiunea în inci						Adâncimea maximă de canelare CDX
					BD	CW	LF	LB	WF	RE	
Alege scula de canelare potrivită și ai grijă de poziția portsculei de canelare în MPA pentru a obține canalul dorit.	1.220-1.417	AFG0629 25 1581	0-I	3	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	1.417-1.614		1-I	3	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	1.614-1.811		2-I	3	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	1.811-2.008		3-I	3	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	2.008-2.205		0-E / 4-I	3/4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	2.205-2.402		1-E / 5-I	3/4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	2.402-2.598		2-E / 6-I	3/4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	2.598-2.795		3-E / 7-I	3/4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	2.795-2.992		4-E / 8-I	3/4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	2.992-3.189		5-E	4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	3.189-3.386		6-E	4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	3.386-3.583		7-E	4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	3.583-3.780		8-E	4	0.984	0.0984	1.339	0.709	0.116	0.006	0.197
	Notă : Un ansamblu de canelare -spre alezaj- necesită: <ul style="list-style-type: none"> <li>• un cap - Axiabore™ Plus - (A760 03)</li> <li>• un MPA (BDA16BS25100)</li> <li>• o portsculă de canelare I (poziția internă) și una E (poziția externă) (BAS25FGI35 și BAS25FGE35) atât pentru a prinde o sculă de canelare cât și pentru a acționa ca o contragreutate (vezi poziția de reglare în tabel)</li> <li>• o sculă de canelare -spre alezaj- (AFG...81) aleasă din tabel, în funcție de lățimea și diametrul canalului.</li> </ul>		1.220-1.417	AFG0629 30 1581	0-I	3	0.984	0.1181	1.339	0.709	0.116
1.417-1.614		1-I	3		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
1.614-1.811		2-I	3		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
1.811-2.008		3-I	3		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
2.008-2.205		0-E / 4-I	3/4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
2.205-2.402		1-E / 5-I	3/4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
2.402-2.598		2-E / 6-I	3/4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
2.598-2.795		3-E / 7-I	3/4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
2.795-2.992		4-E / 8-I	3/4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
2.992-3.189		5-E	4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
3.189-3.386		6-E	4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
3.386-3.583		7-E	4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236
3.583-3.780		8-E	4		0.984	0.1181	1.339	0.709	0.116	0.006	0.236

\* +0,2 mm (0.008") capacitate complementară posibilă. \*\* Valorile recomandate sunt îngroșate.  
Descriere detaliată a sculelor pentru canelare, vezi pag. 594



## Instrucțiuni Viteze maxime pentru capetele tip Axiabore™

Pentru mai multe informații vă rog să consultați instrucțiunile de operare livrate împreună cu capetele de alezat și cu barele GL.

Cap	Capacitate Ø mm (inci)	Max. RPM cu scula (RPM)	Max. RPM cu MPA (RPM)	Viteza maximă de aşchiere v <sub>c</sub> la Cap. min. m/min (feet/min)	Viteza maximă de aşchiere v <sub>c</sub> la Cap. max. m/min (feet/min)
Axiabore™ tip cu Graflex® conexiune					
A76001	0,3-8 (0.0118-0.315)	30000	–	28* (92*)	754* (2474*)
A76002	2-20 (0.0787-0.787)	12000	–	75* (246*)	754* (2474*)
A76003	6-108 (0.236-4.25)	8000**	5000	151* (495*)	1000*** (3281***)
A76013	6-33 (0.236-1.30)	20000**	5000	377* (1237*)	1500*** (4921***)
Axiabore™ tip cu Seco-Capto™ conexiune					
C5-391.0760-03	6-108 (0.236-4.25)	8000*	5000	151* (495*)	1000** (3281**)

**Notă:** Vitezele maxime depind de designul mecanic al capului de alezat și de calitatea echilibrării. Vitezele dintre aceste limite trebuie alese în funcție de alte condiții de prelucrare, ex.: materialul semifabricatului, muchia de aşchiere (scule și plăcuțe), Lungimea sistemului de scule, arborele mașinii. Pentru viteze de aprox. 8000 RPM sau mai mult, arborii și intermediarii trebuie să fie fin echilibrați. Utilizarea capetelor echilibrate și a portsculelor echilibrate fin măresc durata de viață a sculelor și îmbunătățesc performanțele alezării chiar și la viteze mici.

\* Viteza de aşchiere max. sugerată cu max. RPM.

\*\* Nu poate fi atinsă cu toate sculele, vezi\*\*\*.

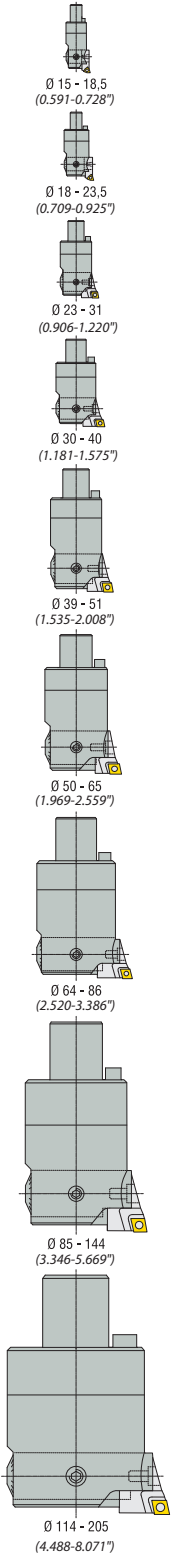
\*\*\* Nu se va depăși viteza maximă de aşchiere

## Instrucțiuni de depanare (valabile și pentru capetele de alezare de precizie tip radial)

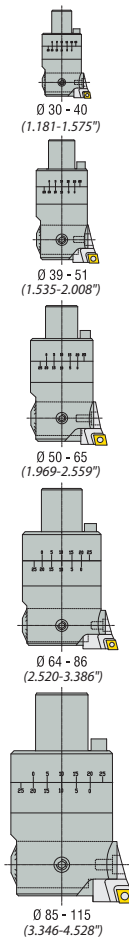
Poziția	Cauză posibilă	Soluție	
Viață scurtă a sculei	Calitate greșită a plăcuței	Schimbă cu o calitate mai rezistentă la uzură	
	Viteza de aşchiere prea mare	Reduceți viteza de aşchiere.	
	Adâncime de tăiere prea mare	Reduceți adâncimea de tăiere	
Șocuri și vibrații	Viteza de aşchiere prea mare	Reduceți viteza de aşchiere.	
	Raport L/D extrem	Scurtează scula pentru a crește rigiditatea	
		Utilizează scule de alezat mai puternice	
		Utilizați o bară Steadyline	
Plăcuță aleasă greșit	Micșorează raza vârfului plăcuței Utilizează plăcuțe cu geometrie rotundă		
Toleranță a diametrului găurii și repetabilitate slabe	Adaos de prelucrare incorect	Modifică diametrul de pre-găurire	
	Schimbare imprecisă a sculei	Coadă uzată sau defectă: de înlocuit Curăță arborele și coada sculei	
	Variația adaosului de prelucrare	Adaugă o etapă de semifinisare a alezajului	
Circularitate slabă	Stabilitate redusă a arborelui	Utilizează plăcuțe cu geometrie mai ascuțită	
		Dezechilibrare pronunțată a sculei de alezare	Verifică bătaia radială a arborelui Treceți la capul de alezare LIBRAFLEX® Verifică reglarea inelului de echilibrare Reduceți viteza
		Forțe de aşchiere ridicate	Verifică adaosul de prelucrare și avansul
		Prindere slabă a semifabricatului	Verifică prinderea uniformă a semifabricatului
	Semifabricat asimetric	Reduceți forțele de tăiere, treci la plăcuțe rotunde Măriți viteza de tăiere, reduceți avansul	
	Toleranță slabă a poziționării	Găurile originale nealiniate	Adaugă o etapă de semifinisare a alezajului
Adâncime de tăiere prea mare		Micșorează adâncimea de tăiere, execută două treceri	
Finisare slabă a suprafeței	Raza plăcuței greșită	Utilizează o raza a plăcuței mai mare	
	Rata avansului prea mare	Reduceți avansul max. 30% din raza vârfului plăcuței	
	Control slab al aşchiei	Utilizează răcirea prin interior Utilizează plăcuțe cu unghi mai mare de degajare (HSS în cazuri extreme) Verifică adâncimea de tăiere	
Gaură conică	Uzura prematură a sculei	Schimbă cu o calitate mai rezistentă la uzură	
		Modificați viteza de aşchiere.	
		Măriți debitul agentului de răcire	

Vedere generală

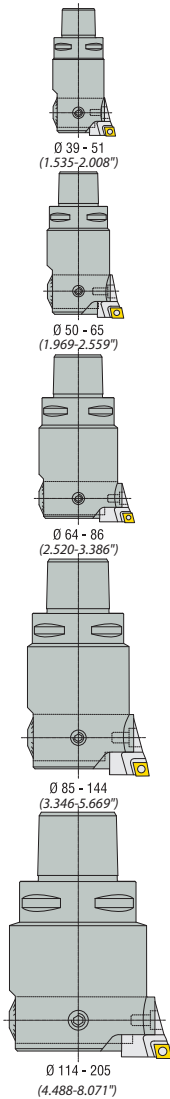
Graflex®



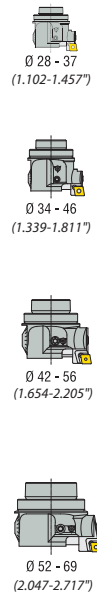
Graflex® balaceable



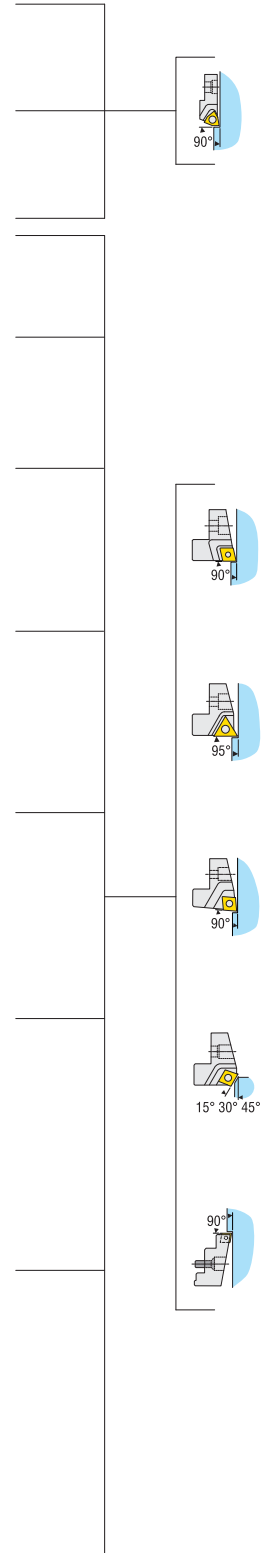
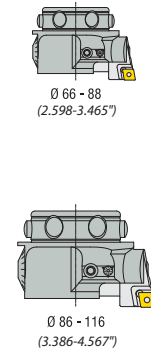
Seco-Capto™



GL conexiune



BA conexiune



Introducere

Găurire

Alezare

Alezare adâncă

Anexă

## Capete de alezare de precizie – ghid

## Caracteristici

Un cap de alezare fină este un ansamblu compus dintr-un corp și o plăcuță. Caracteristicile capetelor de finisare FB 620, FB 780 și FB 790 radiale:

## Gama de produse

Seco oferă o gama variată de capete de alezat radiale pentru finiițe care se potrivesc nevoilor dumneavoastră:

## Capete de alezare de precizie, radiale FB 620, FB 780 și FB 790



- Reglarea micrometrică: Mecanism de setare a suportului de plăcuță cu șurub de reglare micrometric, 1 treaptă = 0,01 mm (0,0004") în diametru și un vernier, cu rezoluția de 2,5 μm (98,4 μin) în diametru
- Precizia mecanismului garantează precizie repetabilă
- Orientarea unghiulară a muchiei așchietoare conform DIN 69871/ISO 7388 pentru SA și ISO 12164 pentru HSK
- Lichid de răcire prin interior direcționat către muchia așchietoare
- Capetele de alezare FB 780 și FB 620 sunt pre-echilibrate pentru setarea mediană de diametru. FB 790 sunt echilibrate, pentru optimizarea performanței

**Notă:** Caracteristici, Instrucțiuni (procedura de montare a sculei, reglarea diametrului, instrucțiuni pentru alezarea inversă, depanare condiție recomandate, viteze maxime), port-plăcuțe și plăcuțele potrivite sunt similare pentru toate tipuri de capete de alezare FB 620, FB 780 și FB 790 la aceeași mărime, indiferent de tipul conexiunii.

## Capete de finisare FB 620, tip radial, pentru barele antivibrație Steadyline®



GL



BA

- 4 capete de alezare de precizie cu conexiune GL pe partea utilajului pentru alezare de precizie Ø 27-69 mm (Ø 1,102-2,717")
- 2 capete de alezare de precizie cu conexiune BA pe partea utilajului pentru alezare de precizie Ø 66-116 mm (Ø 2,598-4,567")

Designul lor compact permite atingerea performanțelor maxime atunci când se utilizează împreună cu barele de strunjire și alezare Steadyline® GL.

## Capete de alezare de finisare FB 780, tip radial

**9 capete de alezare de precizie cu conexiune Graflex® pe partea utilajului** pentru alezare de precizie  $\varnothing$  15-205 mm ( $\varnothing$  0,591-8,071") utilizând suporturi de plăcuță instalate radial.

**5 capete de alezare de precizie cu conexiune Seco-Capto™ pe partea utilajului** pentru alezare de precizie  $\varnothing$  39-205 mm ( $\varnothing$  1,535-8,071").

**Adaptor Seco-Capto™ și cap Graflex®:**  $\varnothing$  15-40 mm ( $\varnothing$  0,591-1,575").

**Notă:** Alezajul minim al celui mai mic cap de alezare de precizie Seco-Capto™ este  $\varnothing$  39 mm ( $\varnothing$  1,535") cu cea mai mică conexiune Seco-Capto™ C3 disponibilă. Pentru  $\varnothing$  15-40 mm ( $\varnothing$  0,591-1,575"), utilizați capete de alezare Graflex® cu mărimi de conexiune între G0 și G2 în combinație cu adaptorul Seco-Capto™/Graflex® adecvat. Acest lucru oferă și modularitate atunci când se utilizează extensii Graflex® suplimentare.

**Notă:** Caracteristici, Instrucțiuni (procedura de montare a sculei, reglarea diametrului, instrucțiuni pentru alezarea inversă, depanare, condiție recomandate, viteze maxime), port-plăcuțe și plăcuțele potrivite sunt similare pentru ambele tipuri de capete de alezare FB 780 la aceeași mărime, indiferent de tipul conexiunii.

## Capetele de alezare echilibrabile pentru finisaj FB 790, tipul radial

**5 capete de alezare „Libraflex®” echilibrabile cu conexiune Graflex® pe partea utilajului** pentru alezare de precizie  $\varnothing$  30-115 mm ( $\varnothing$  1,181-4,528"), la viteze ridicate, până la 1500 m/min (4921 ft/min), utilizând suporturi de plăcuță instalate radial.

Echilibrarea reduce solicitarea arborelui, permite optimizarea parametrilor de aşchiere, și se obține o calitate mai ridicată a prelucrării chiar și la viteze normale.

Echilibrare prin reglarea ambelor inele conform cu diametrul de alezat (nu necesită tabel de valori).



## Caracteristici

### Suporturi de plăcuță

Un cap de alezare de precizie de tip radial este un ansamblu compus dintr-un corp (cap) și un suport de plăcuță.

Gama largă de port-plăcuțe pentru alezare fină, șanfenare și alezare inversă este potrivită cu toate capetele de finisare FB 620, FB 780 și FB 790, tip radial.

### Suporturi de plăcuță pentru alezare de precizie

FBIH 782: unghi de avans  $90^\circ$  pentru plăcuțe WB  
 FBIH 724: unghi de avans  $90^\circ$  pentru plăcuțe TC  
 FBIH 725: unghi de avans  $90^\circ$  pentru plăcuțe CC  
 FBIH 726: unghi de avans  $95^\circ$  pentru plăcuțe CC

**Notă:** Unghiul de atac de  $95^\circ$  al port-plăcuței se utilizează pentru a evita contactul feței la alezarea peste un umăr.

### Suporturi de plăcuță de șanfenare, $\varnothing$ 23 până la 160 mm ( $\varnothing$ 0,906-6,299")

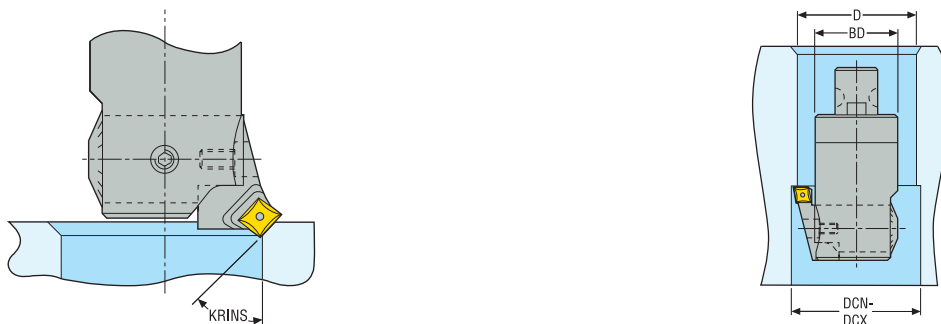
FBIH 729: disponibile cu un unghi de avans de  $15^\circ$ ,  $30^\circ$  sau  $45^\circ$  pentru plăcuțe CC.

Libraflex® se poate echilibra și la echiparea cu port-plăcuțe de șanfenare.

### Suporturi de plăcuță pentru alezare inversă, $\varnothing$ 26,5 până la 164 mm ( $\varnothing$ 1,043-6,457")

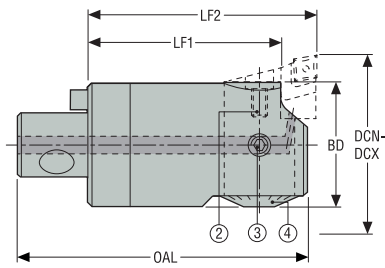
FBIH A789: unghi de avans  $90^\circ$  pentru plăcuțe WB și CC.

Echilibrarea de precizie a Libraflex® nu este posibilă cu port-plăcuțe de alezare inversă. În acest caz, cea mai mare echilibrare se obține atunci când ambele inele de echilibrare sunt reglate la cea mai mare gradajie.



FB780

Graflex®



- 2. Șurub de asamblare
- 3. Șurub de blocare
- 4. Șurub micrometric de reglaj



- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)

Număr reper	Reper Nr.	Od stromy obrabiarki Mărire Graflex	Spre semifabricat Capacitatea		OAL	LF1	LF2	BD	Greutate	Mărimea port-plăcuței
			DCN-DCX Ø	DCN-DCX Ø						
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
00056632	A78008	G0	15,0 0.591	18,5 0.728	44,0 1.732	27,5 1.083	35,0 1.378	14,0 0.551	0,1 0.220	09
00056633	A78009	G0	18,0 0.709	23,5 0.925	44,0 1.732	27,5 1.083	35,0 1.378	17,0 0.669	0,1 0.220	09
00072991	A78010	G1	23,0 0.906	31,0 1.220	51,5 2.028	32,5 1.280	40,0 1.575	21,5 0.846	0,11 0.240	10
00072992	A78020	G2	30,0 1.181	40,0 1.575	59,5 2.343	37,5 1.476	45,0 1.772	27,0 1.063	0,22 0.490	20
00072993	A78030	G3	39,0 1.535	51,0 2.008	82,0 3.228	54,5 2.146	65,0 2.559	35,0 1.378	0,5 1.100	30
00072995	A78040	G4	50,0 1.969	65,0 2.559	93,0 3.661	61,5 2.421	72,0 2.835	43,0 1.693	0,8 1.760	40
00072996	A78050	G5	64,0 2.520	86,0 3.386	109,0 4.291	71,5 2.815	82,0 3.228	54,0 2.126	1,49 3.280	50
00056551	A78060	G6	85,0 3.346	144,0 5.669	140,0 5.512	88,5 3.484	105,0 4.134	70,0 2.756	3,1 6.830	60/65
00056552	A78070	G7	114,0 4.488	205,0 8.071	160,0 6.299	98,5 3.878	115,0 4.528	95,0 3.740	6,3 13.890	70/75

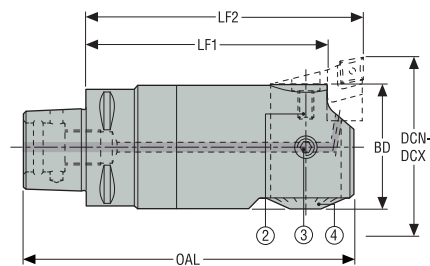
Portplăcuțele se vor comanda separat, vezi pag. 618, 619-621  
Note, weight is without insert holder

Piese de schimb

Pentru	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare	Cep
A78008	960D30050S	DOUBLE-T	H4B-H2.0	19A7100403	90M01
A78009	LBHF0306R	DOUBLE-T	H4B-H2.0	19A71000	90M0
A78010	19TB0305	DOUBLE-T	H4B-H2.0	19A71000	90M1
A78020	19TB0305	H4B-H2.0	-	950L0406	90M2
A78030	19TB04075	-	03M03C	950L0608	90M3
A78040	19TB04075	-	03M03C	950L0612	90M4
A78050	950D0410	-	03M03C	950L0616	90M5
A78060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	90M6
A78070	950D0616	DOUBLE-T	H6B-H5.0L	950L1030	90M7

## FB780

Seco-Capto™



- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)

2. Șurub de asamblare
3. Șurub de blocare
4. Șurub micrometric de reglaj

Reper Nr.	Număr reper	Spre mașină	Spre semifabricat		OAL	LF1	LF2	BD	Greutate	Mărimea port-plăcuței
			Capacitatea DCN-DCX Ø	Capacitatea DCN-DCX Ø						
			mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	mm <i>Inci</i>	kg <i>lbs</i>	
C3-391.0780-30	02809740	C3	39,0 1.535	51,0 2.008	86,0 3.386	59,5 2.343	70,0 2.756	35,0 1.378	0,48 1.060	30
C4-391.0780-40	02809742	C4	50,0 1.969	65,0 2.559	103,0 4.055	71,5 2.815	82,0 3.228	43,0 1.693	0,89 1.960	40
C5-391.0780-50	02809744	C5	64,0 2.520	86,0 3.386	119,0 4.685	81,5 3.209	92,0 3.622	54,0 2.126	1,62 3.570	50
C6-391.0780-60	02809745	C6	85,0 3.346	144,0 5.669	150,0 5.906	100,5 3.957	117,0 4.606	70,0 2.756	3,3 7.280	60
C8-391.0780-70	02809747	C8	114,0 4.488	205,0 8.071	181,0 7.126	121,5 4.783	138,0 5.433	95,0 3.740	7,15 15.760	70

Portplăcuțele se vor comanda separat, vezi pag. 618, 619-621  
Note, weight is without insert holder

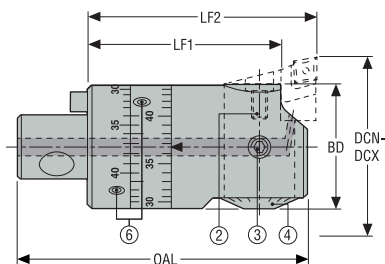
### Piese de schimb

Pentru	Șurub ansamblu	Cheie (steag)	Cheie (tip T)	Cheie	Șurub de blocare
C3-391.0780-30	19TB04075	03M03C	-	-	950L0608
C4-391.0780-40	19TB04075	03M03C	-	-	950L0612
C5-391.0780-50	950D0410	03M03C	-	-	950L0616
C6-391.0780-60	950D0612	-	DOUBLE-T	H6B-H5.0L	950L0616
C8-391.0780-70	950D0616	-	DOUBLE-T	H6B-H5.0L	950L1030



## FB780 Libraflex® balanceable

Graflex®



- 2. Șurub de asamblare
- 3. Șurub de blocare 1
- 4. Șurub micrometric de reglaj
- 6. Șurub de blocare 2

- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)
- Echilibrare prin reglarea ambelor inele conform cu diametrul de alezat.
- Pentru viteze de așchiere  $v_c$  până la 1 495 m/min sau peste, vezi pag. 622

Număr reper	Reper Nr.	Od stroy obrabiarki Mărime Graflex	Spre semifabricat		OAL	LF1	LF2	BD	Greutate	Mărimea port-plăcuței
			Capacitatea DCN-DCX Ø	Capacitatea DCN-DCX Ø						
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
00055932	A79020	G2	30,0 1.181	40,0 1.575	59,5 2.343	37,5 1.476	45,0 1.772	27,0 1.063	0,19 0.420	20
00056005	A79030	G3	39,0 1.535	51,0 2.008	82,0 3.228	54,5 2.146	65,0 2.559	35,0 1.378	0,45 0.990	30
00056006	A79040	G4	50,0 1.969	65,0 2.559	93,0 3.661	61,5 2.421	72,0 2.835	43,0 1.693	0,78 1.720	40
00056007	A79050	G5	64,0 2.520	86,0 3.386	109,0 4.291	71,5 2.815	82,0 3.228	54,0 2.126	1,42 3.130	50
00001451	A79060	G6	85,0 3.346	115,0 4.528	140,0 5.512	88,5 3.484	105,0 4.134	70,0 2.756	2,87 6.330	60

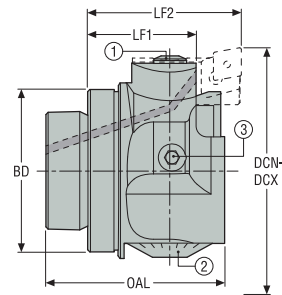
Portplăcuțele se vor comanda separat, vezi pag. 618, 619-621  
Note, weight is without insert holder

### Piese de schimb

Pentru cap	Șurub ansamblu	Cheie (tip T)	Cheie	Șurub de blocare 1	Șurub de blocare 2	Cep
A79020	19TB0305	DOUBLE-T	H4B-H2.0	950L0406	960D30045S	90M2
A79030	19TB04075	-	03M03C	950L0608	AU7901030	90M3
A79040	19TB04075	-	03M03C	950L0612	AU7901040	90M4
A79050	950D0410	-	03M03C	950L0616	AU7901050	90M51
A79060	950D0612	DOUBLE-T	H6B-H5.0L	950L1016	AU7901060	90M6

## FB 620 GL - Capete pentru alezare de finisare, compacte, cu conexiune GL

GL



- Concepute pentru barele de strunjire și alezare GL25, GL32, GL40 și GL50 Steadylite®
- Lichid de răcire prin interior dirijat spre muchia de așchiere
- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)

1. Șurub de asamblare
2. Șurub micrometric de reglaj
3. Șurub de blocare

Reper Nr.	Număr reper	Od strony obrabiarki Mărime GL	Spre semifabricat Capacitatea		OAL	LF1	LF2	BD	Greutate	RPM max.**
			DCN-DCX Ø							
			mm	mm	mm	mm	mm	kg		
			Inci	Inci	Inci	Inci	Inci	lbs		
GL25-FB620-10	03307855	GL25	27,0 1.063	35,0 1.378	29,5 1.161	17,7 0.697	28,0 1.102	25,0 0.984	0,1 0.220	9000
GL32-0620-20	02904469	GL32	34,0 1.339	46,0 1.811	35,2 1.386	23,75 0.935	32,1 1.264	32,0 1.260	0,13 0.290	7000
GL40-0620-30	02904470	GL40	42,0 1.654	56,0 2.205	40,7 1.602	24,75 0.974	35,1 1.382	40,0 1.575	0,22 0.490	5600
GL50-0620-40	02904471	GL50	52,0 2.047	69,0 2.717	43,7 1.720	25,75 1.014	36,1 1.421	50,0 1.969	0,32 0.710	4800

Portplăcuțele se vor comanda separat, vezi pag. 618, 619-621

\*\* Pentru turațiile maxime RPM, vezi pagina de Instrucțiuni.

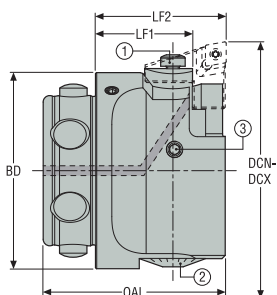
Note, weight is without insert holder

### Piese de schimb

Pentru cap	Șurub ansamblu	Cheie clemă	Cheie (tip T)	Șurub de blocare
GL25-FB620-10	19TB0305	H2.0-2D	–	19A71000
GL32-FB620-20	19TB0305	H4B-H2.0	DOUBLE-T	950L0406
GL40-FB620-30	19TB04075	03M03C	–	950L0608
GL50-FB620-40	19TB04075	03M03C	–	950L0608

## FB 620 BA - Capete pentru alezare de finisare, cu conexiune BA

BA



1. Șurub de asamblare
2. Șurub micrometric de reglaj
3. Șurub de blocare



- Concepute pentru barele de strunjire și alezare BA60 și BA80 Steadyline®
- Lichid de răcire prin interior dirijat spre muchia de așchiere
- Cu reglare micrometrică (increment 0,01 mm și vernier 2,5 μm, pe diametru)

Reper Nr.	Număr reper	Od stromy obrabiarki Mărime BA	Spre semifabricat		OAL	LF1	LF2	BD	Greutate	RPM max.**
			Capacitatea DCN-DCX Ø							
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	
BA060-FB620-50	03204094	BA060	65,0 2.559	87,0 3.425	55,7 2.193	29,7 1.169	40,0 1.575	60,0 2.362	0,7 1.540	4000
BA080-FB620-60	03204095	BA080	85,0 3.346	115,0 4.528	58,2 2.291	26,7 1.051	41,2 1.622	80,0 3.150	1,1 2.430	3000

Portplăcuțele se vor comanda separat, vezi pag. 576

\*\* Pentru turațiile maxime RPM, vezi pagina de Instrucțiuni.

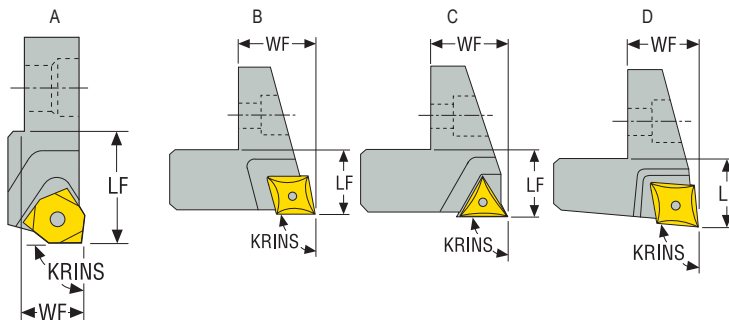
Note, weight is without insert holder

### Piese de schimb

Pentru cap	Șurub ansamblu	Cheie (steag)	Cheie (tip T)	Cheie	Șurub de blocare
BA060-FB620-50	19TB04075	03M03C	-	-	950L0608
BA080-FB620-60	950D0514	-	DOUBLE-T	H6B-H5.0L	950L0608

## Portplăcuță

pentru capetele de alezare de finisare FB 620/ 780/ 790

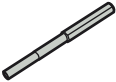




- Potrivite pentru capetele de alezare radiale FB 620/ 780/ 790
- \*\*Echilibrarea precisă a capetelor FB A790 nu este posibilă la utilizare port-plăcuțelor mari.

Reper Nr.	Număr reper	Pas	Capacitatea DCN-DCX Ø		LF	WF	Greutate	Pentru cap	KRINS°	**	Mărimea port-plăcuței	Mărimea plăcuței potrivite	Varianta
			mm Inci	mm Inci									
A78209	00056634	90° pentru plăcuțe WB	15,0 0.591	23,5 0.925	7,2 0.283	4,0 0.157	0,01 0.020	FB 78008 / FB 78009	90	-	09	WB...0301...	A
A72510	00056580	90° pentru plăcuțe CC	23,0 0.906	31,0 1.220	10,3 0.406	4,5 0.177	0,01 0.020	FB 78010 / FB62010	90	-	10	CC...0602...	B
A72520	00056581	90° pentru plăcuțe CC	30,0 1.181	46,0 1.811	8,3 0.327	5,0 0.197	0,02 0.040	FB 78020 / FB 79020 / FB 62020	90	-	20	CC...0602...	B
A72530	00056582	90° pentru plăcuțe CC	39,0 1.535	56,0 2.205	10,3 0.406	8,0 0.315	0,02 0.040	FB 78030 / FB 79030 / FB 62030	90	-	30	CC...0602...	B
A72540	00056583	90° pentru plăcuțe CC	50,0 1.969	69,0 2.717	10,3 0.406	9,5 0.374	0,02 0.040	FB 78040 / FB 79040 / FB 62040	90	-	40	CC...0602...	B
A72550	00056584	90° pentru plăcuțe CC	64,0 2.520	86,0 3.386	10,3 0.406	12,5 0.492	0,02 0.040	FB 78050 / FB 79050 / FB 62050	90	-	50	CC...0602...	B
A7256A	02689978	90° pentru plăcuțe CC	85,0 3.346	115,0 4.528	14,5 0.571	18,5 0.728	0,05 0.110	BA080-FB620-60	90	-	6A	CC...09T3...	B
A72560	00056585	90° pentru plăcuțe CC	85,0 3.346	115,0 4.528	16,5 0.650	18,9 0.744	0,08 0.180	FB 78060 / FB 79060 / FB 731S500	90	-	60	CC...09T3...	B
A72565	00056587	90° pentru plăcuțe CC	114,0 4.488	144,0 5.669	16,5 0.650	33,7 1.327	0,09 0.200	FB 78060 / FB 79060 / FB 731S500	90	**	65	CC...09T3...	B
A72570	00056588	90° pentru plăcuțe CC	114,0 4.488	160,0 6.299	16,5 0.650	18,9 0.744	0,09 0.200	FB 78070	90	-	70	CC...09T3...	B
A72575	00056589	90° pentru plăcuțe CC	159,0 6.260	205,0 8.071	16,5 0.650	41,7 1.642	0,12 0.260	FB 78070	90	-	75	CC...09T3...	B
A72430	00056572	90° pentru plăcuțe TC	39,0 1.535	56,0 2.205	10,3 0.406	7,9 0.311	0,01 0.020	FB 78030 / FB 79030 / FB 62030	90	-	30	TC...1102...	C
A72440	00056573	90° pentru plăcuțe TC	50,0 1.969	69,0 2.717	10,3 0.406	9,4 0.370	0,02 0.040	FB 78040 / FB 79040 / FB 62040	90	-	40	TC...1102...	C
A72450	00056574	90° pentru plăcuțe TC	64,0 2.520	86,0 3.386	10,3 0.406	12,4 0.488	0,02 0.040	FB 78050 / FB 79050 / FB 62050	90	-	50	TC...1102...	C
A72460	00056575	90° pentru plăcuțe TC	85,0 3.346	115,0 4.528	16,3 0.642	18,9 0.744	0,08 0.180	FB 78060 / FB 79060 / FB 731S500	90	-	60	TC...1102...	C
A72465	00056577	90° pentru plăcuțe TC	114,0 4.488	144,0 5.669	16,5 0.650	33,7 1.327	0,09 0.200	FB 78060 / FB 79060 / FB 731S500	90	**	65	TC...1102...	C
A72470	00056578	90° pentru plăcuțe TC	114,0 4.488	160,0 6.299	16,3 0.642	18,9 0.744	0,1 0.220	FB 78070	90	-	70	TC...1102...	C
A72475	00056579	90° pentru plăcuțe TC	159,0 6.260	205,0 8.071	16,5 0.650	41,7 1.642	0,13 0.290	FB 78070	90	-	75	TC...1102...	C
A72610	00056590	95° pentru plăcuțe CC	23,0 0.906	31,0 1.220	10,3 0.406	4,5 0.177	0,01 0.020	FB 78010	95	-	10	CC...0602...	D
A72620	00056591	95° pentru plăcuțe CC	30,0 1.181	46,0 1.811	8,3 0.327	5,0 0.197	0,01 0.020	FB 78020 / FB 79020 / FB 62020	95	-	20	CC...0602...	D
A72630	00056592	95° pentru plăcuțe CC	39,0 1.535	56,0 2.205	10,3 0.406	8,0 0.315	0,01 0.020	FB 78030 / FB 79030 / FB 62030	95	-	30	CC...0602...	D
A72640	00056593	95° pentru plăcuțe CC	50,0 1.969	69,0 2.717	10,3 0.406	9,5 0.374	0,02 0.040	FB 78040 / FB 79040 / FB 62040	95	-	40	CC...0602...	D

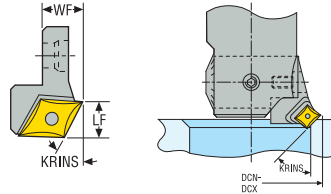
Reper Nr.	Număr reper	Pas	Capacitatea DCN-DCX $\varnothing$		LF	WF	Greutate	Pentru cap	KRINS°	**	Mărimea port-plăcuței	Mărimea plăcuței potrivite	Varianta
			mm Inci	mm Inci									
A72650	00056594	95° pentru plăcuțe CC	64,0 2.520	86,0 3.386	10,3 0.406	12,5 0.492	0,02 0.040	FB 78050 / FB 79050 / FB 62050	95	–	50	CC...0602...	D
A72660	00056595	95° pentru plăcuțe CC	85,0 3.346	115,0 4.528	16,5 0.650	18,9 0.744	0,07 0.150	FB 78060 / FB 79060 / FB 731S500	95	–	60	CC...09T3...	D
A72665	00056597	95° pentru plăcuțe CC	114,0 4.488	144,0 5.669	16,5 0.650	33,7 1.327	0,09 0.200	FB 78060 / FB 79060 / FB 731S500	95	**	65	CC...09T3...	D
A72670	00056598	95° pentru plăcuțe CC	114,0 4.488	160,0 6.299	16,5 0.650	18,9 0.744	0,09 0.200	FB 78070	95	–	70	CC...09T3...	D
A72675	00056599	95° pentru plăcuțe CC	159,0 6.260	205,0 8.071	16,5 0.650	41,7 1.642	0,12 0.260	FB 78070	95	–	75	CC...09T3...	D

## Piese de schimb

Pentru dimensiunea plăcuței	Cheie plăcuță	Șurub plăcuță	Cheie (tip T)
WB...0301...	H4B-T06P 	C02035-T06P 	DOUBLE-T 
CC...0602...	H4B-T07P	C02504-T07P	DOUBLE-T
CC...09T3...	H4B-T15P	C04008-T15P	DOUBLE-T
TC...1102...	H4B-T07P	C02504-T07P	DOUBLE-T

## Port-plăcuțe pentru șanfenare

pentru capetele de alezare de finisare FB 620/ 780/ 790



- Potrivite pentru capetele de alezare radiale FB 620/ 780/ 790

Număr reper	Reper Nr.	Pentru cap	Mărimea port-plăcuței	Capacitatea DCN-DCX Ø		LF	WF	Greutate	KRINS°	Mărimea plăcuței potrivite
				mm Inci	mm Inci					
00086885	A72910CC0630	FB 78010	10	23,0 0.906	31,0 1.220	10,8 0.425	4,5 0.177	0,01 0.020	30	CC...0602...
00086888	A72920CC0630	FB 78020 / FB 79020/ GL32-0620-20	20	30,0 1.181	36,0 1.417	10,0 0.394	4,9 0.193	0,01 0.020	30	CC...0602...
00086891	A72930CC0630	FB 78030 / FB 79030 / FB 62030	30	39,0 1.535	56,0 2.205	10,5 0.413	8,1 0.319	0,01 0.020	30	CC...0602...
00086894	A72940CC0630	FB 78040 / FB 79040 / FB 62040	40	50,0 1.969	69,0 2.717	10,5 0.413	9,5 0.374	0,02 0.040	30	CC...0602...
00086897	A72950CC0630	FB 78050 / FB 79050	50	64,0 2.520	86,0 3.386	10,5 0.413	12,5 0.492	0,02 0.040	30	CC...0602...
00086900	A72960CC0930	FB 78060 / FB 79060 / A731S500	60	85,0 3.346	115,0 4.528	16,5 0.650	19,1 0.752	0,08 0.180	30	CC...09T3...
00086903	A72970CC0930	FB 78070	70	114,0 4.488	160,0 6.299	16,4 0.646	18,8 0.740	0,09 0.200	30	CC...09T3...
00086886	A72910CC0645	FB 78010	10	23,0 0.906	31,0 1.220	11,5 0.453	4,5 0.177	0,01 0.020	45	CC...0602...
00086889	A72920CC0645	FB 78020 / FB 79020 / FB 62020	20	30,0 1.181	46,0 1.811	10,0 0.394	5,0 0.197	0,01 0.020	45	CC...0602...
00086892	A72930CC0645	FB 78030 / FB 79030 / FB 62030	30	39,0 1.535	56,0 2.205	10,5 0.413	8,1 0.319	0,01 0.020	45	CC...0602...
00086895	A72940CC0645	FB 78040 / FB 79040 / FB 62040	40	50,0 1.969	69,0 2.717	10,5 0.413	9,5 0.374	0,02 0.040	45	CC...0602...
00086898	A72950CC0645	FB 78050 / FB 79050	50	64,0 2.520	86,0 3.386	10,3 0.406	12,4 0.488	0,02 0.040	45	CC...0602...
00086901	A72960CC0945	FB 78060 / FB 79060 / A731S500	60	85,0 3.346	115,0 4.528	16,5 0.650	19,1 0.752	0,07 0.150	45	CC...09T3...
00086904	A72970CC0945	FB 78070	70	114,0 4.488	160,0 6.299	16,4 0.646	18,8 0.740	0,09 0.200	45	CC...09T3...

Pentru șuruburi plăcuță și chei plăcuță de schimb, vezi pag. 654

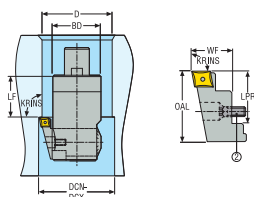
\*\*Pentru capacitățile DC de alezare cu barele Bridge și cu barele Jumbo Bridge, vezi pag. 630

### Piese de schimb

Pentru dimensiunea plăcuței	Cheie plăcuță	Șurub plăcuță	Cheie (tip T)
CC...0602...	H4B-T07P	C02504-T07P	DOUBLE-T
CC...09T3...	H4B-T15P	C04008-T15P	DOUBLE-T

## Port-plăcuțe pentru alezare inversă de finisare

pentru capetele de alezare de finisare FB 620/ 780/ 790



- Potrivite pentru capetele de alezare radiale FB 620/ 780/ 790
- Echilibrarea precisă a capetelor FB 790 nu este posibilă la utilizare port-plăcuțelor pentru alezare inversă
- KRINS 90°
- Mărimea plăcuței potrivite: CC...0602...

Reper Nr.	Număr reper	Pentru cap	Capacitate de alezare inversă DCN-DCX Ø		LF	BD	OAL	LPR	WF	Greutate
			mm	(Inci)						
A789X10CC0690	00086907	A78010	39,5-47,5	(1.555-1.870)	16,5 (0.650)	21,5 (0.846)	30,5 (1.201)	16,0 (0.630)	12,8 (0.504)	0,01 (0.020)
		A78020 & A79020	46-56	(1.811-2.205)	21,5 (0.846)	27 (1.063)				
		GL32-0620-20	49,7-61,7	(1.957-2.429)	7,75 (0.305)	32 (1.260)				
A789X30CC0690	00086910	A78030 & A79030	53-65	(2.087-2.559)	32 (1.260)	35 (1.378)	30,0 (1.181)	23,0 (0.906)	15,0 (0.591)	0,03 (0.070)
		A78040 & A79040	61-76	(2.402-2.992)	39 (1.535)	43 (1.693)				
		A78050 & A79050	69-91	(2.717-3.583)	49 (1.929)	54 (2.126)				
		GL40-0620-30	57,6-70,2	(2.268-2.764)	1,75 (0.069)	40 (1.575)				
		GL50-0620-40	67,6-80,2	(2.661-3.157)	2,75 (0.108)	50 (1.969)				
A789X60CC0690	00086909	A78060 & A79060 A731S500	89-119 *	(3.504-4.685 *)	50 (1.969)	70 (1.969)	50,0 (1.969)	38,5 (1.516)	21,0 (0.827)	0,09 (0.200)
A789X70CC0690	00086911	A78070	118-164	(4.646-6.457)	60 (2.362)	95 (2.362)	50,0 (1.969)	38,5 (1.516)	21,0 (0.827)	0,1 (0.220)

\*Pentru capacitățile DC de alezare inversă cu barele Bridge și cu barele Jumbo Bridge, vezi pag. 634

Pentru șuruburi plăcuță și chei plăcuță de schimb, vezi pag. 654

În pachetul de livrare al port-plăcuțelor pentru alezare inversă se găsește un șurub specific de prindere al port-plăcuței, care va înlocui șurubul standard livrat cu capetele de alezare.

DCN/DCX mini = D+BD / 2 + 0,5 mm (0.02") Ø 39,5 – 47,5 (1.555" – 1.870")

DCB/DCX mini = D+BD / 2 + 1 mm (0.039") Ø 46 – 64 (1.811" – 2.520")

### Piese de schimb

Pentru	Șurub ansamblu	Șurub plăcuță	Cheie (tip T)	Cheie
A789X10CC0690	950F0308	C02504-T07P	DOUBLE-T	H4B-T07P
A789X30CC0690	950F0410	C02504-T07P	DOUBLE-T	H4B-T07P
A789X60CC0690	950F0620	C02504-T07P	DOUBLE-T	H4B-T07P
A789X70CC0690	950F0620	C02504-T07P	DOUBLE-T	H4B-T07P

## Capete de alezare de precizie FB 780/ 790 – instrucțiuni

## Condiții de prelucrare recomandate

Pentru mai multe detalii consultați instrucțiunile de utilizare livrate împreună cu capetele de alezare și cu barele GL.

## Viteze maxime pentru capete de alezare de precizie, tip radial

Vitezele maxime indicate în paginile de produs ale capetelor de alezare depind de proiectarea mecanică și calitatea echilibrării capului de alezare. Vitezele cuprinse în intervalul recomandat vor fi alese ținând cont de toate condițiile de prelucrare, ex.: materialul semifabricatului, muchia de așchiere, lungimea sculei, arborele mașinii.

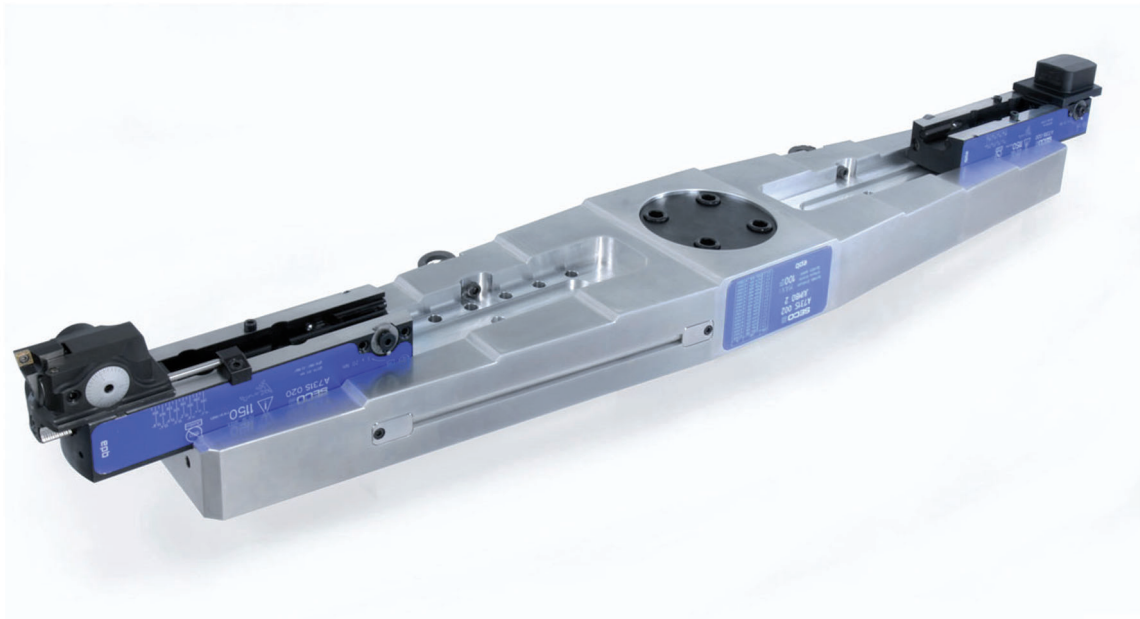
În cazul operațiilor de alezare cu barele Steadyline®, aveți grijă să nu depășiți RPM maxim al barei: vedeți instrucțiunile de utilizare livrate împreună cu barele Steadyline®.

Viteza inferioară max. RPM se folosește la capetele echipate cu port-scule de aalezare sau de șanfenare. La utilizarea suporturilor de plăcuță de alezare inversă în capete tip FB 620, FB 790 sau FB 780, utilizați valoarea max. de rotații pe minut pentru tipul A780 de mărime similară.

Cap	Capacitate Ø mm (inci)	RPM max.	Viteza max de așchiere implicită $v_c$ la Cap. min. m/min (feet/min)	Viteza max de așchiere implicită $v_c$ la Cap. max. m/min (feet/min)
Capete de alezare pentru finii FB 620, cu conexiune GL și BA spre mașină, pentru barele de strunjire și alezare Steadyline®				
GL25-FB620-10	27-35 (1.063-1.378)	9000	760 (2493)	1000 (3281)
GL32-FB620-20	34-46 (1.339-1.811)	7000	748 (2454)	1012 (3320)
GL32-FB620-30	42-56 (1.654-2.205)	5600	739 (2425)	985 (3232)
GL32-FB620-40	52-69 (2.047-2.717)	4800	784 (2572)	1040 (3412)
BA060-FB620-50	66-88 (2.598-3.465)	4000	830 (2723)	1105 (3625)
BA080-FB620-60	86-116 (3.386-4.567)	3000	810 (2657)	1093 (3586)
FB 790 Capete pentru alezare de finisare, echilibrabile, cu Graflex® conexiune				
A79020	30-40 (1.181-1.575)	16000	1508 (4948)	2011 (6598)
A79030	39-51 (1.535-2.008)	12250	1501 (4925)	1963 (6440)
A79040	50-65 (1.969-2.559)	10000	1571 (5154)	2042 (6699)
A79050	64-86 (2.520-3.386)	7500	1508 (4948)	2026 (6647)
A79060	85-115 (3.346-4.528)	5600	1495 (4905)	2023 (6637)
FB 780 Capete pentru alezare de finisare, cu Graflex® conexiune				
A78008	15-18,5 (0.591-0.728)	16000	754 (2474)	930 (3051)
A78009	18-23,5 (0.709-0.925)	13000	735 (2411)	960 (3150)
A78010	23-31 (0.906-1.220)	10000	723 (2372)	974 (3196)
A78020	30-40 (1.181-1.575)	8000	754 (2474)	1005 (3297)
A78030	39-51 (1.535-2.008)	6000	735 (2411)	961 (3153)
A78040	50-65 (1.969-2.559)	5000	785 (2575)	1021 (3350)
A78050	64-86 (2.520-3.386)	3700	744 (2441)	1000 (3281)
A78060	85-115 (3.346-4.528)	2700	721 (2365)	975 (3199)
	114-144 (4.488-5.669)	2200	788 (2585)	995 (3264)
A78070	114-160 (4.488-6.299)	2000	716 (2349)	1005 (3297)
	159-205 (6.260-8.071)	1600	799 (2621)	1030 (3379)
FB 780 Capete pentru alezare de finisare cu Seco-Capto™ conexiune				
C3-391.0780-30	39-51 (1.535-2.008)	6000	735 (2411)	961 (3153)
C4-391.0780-40	50-65 (1.969-2.559)	5000	785 (2575)	1021 (3350)
C5-391.0780-50	64-86 (2.520-3.386)	3700	744 (2441)	1000 (3281)
C6-391.0780-60	85-115 (3.346-4.528)	2700	721 (2365)	975 (3199)
	114-144 (4.488-5.669)	2200	788 (2585)	995 (3264)
C8-391.0780-70	114-160 (4.488-6.299)	2000	716 (2349)	1005 (3297)
	159-205 (6.260-8.071)	1600	799 (2621)	1030 (3379)

**Notă:** Vitezele maxime depind de designul mecanic al capului de alezat și de calitatea echilibrării. Vitezele dintre aceste limite trebuie alese în funcție de alte condiții de prelucrare, ex.: materialul semifabricatului, muchia de așchiere (scule și plăcuțe), Lungimea sistemului de scule, arborele mașinii. Pentru viteze de aprox. 8000 RPM sau mai mult, arborii și intermediarii trebuie să fie fin echilibrați.





## Bridge bar

Seco oferă o gamă completă de traverse de alezat și traverse de alezat mari pentru alezare de diametru mare și operații de țesire a muchiiilor.

- Concepute pentru o flexibilitate maximă, traversele de alezat sunt disponibile într-o varietate mare de diametre ca produse standard, acoperind un interval de diametre de la 204 până la 655 mm (8,03-25,78 inci)
- Traversele de alezat mari Seco sunt fabricate din aluminiu rezistent la efort cu interfețe din oțel și acoperă intervalul de diametre 654-2155 mm (25,75-84,843 inci)

Vedere generală

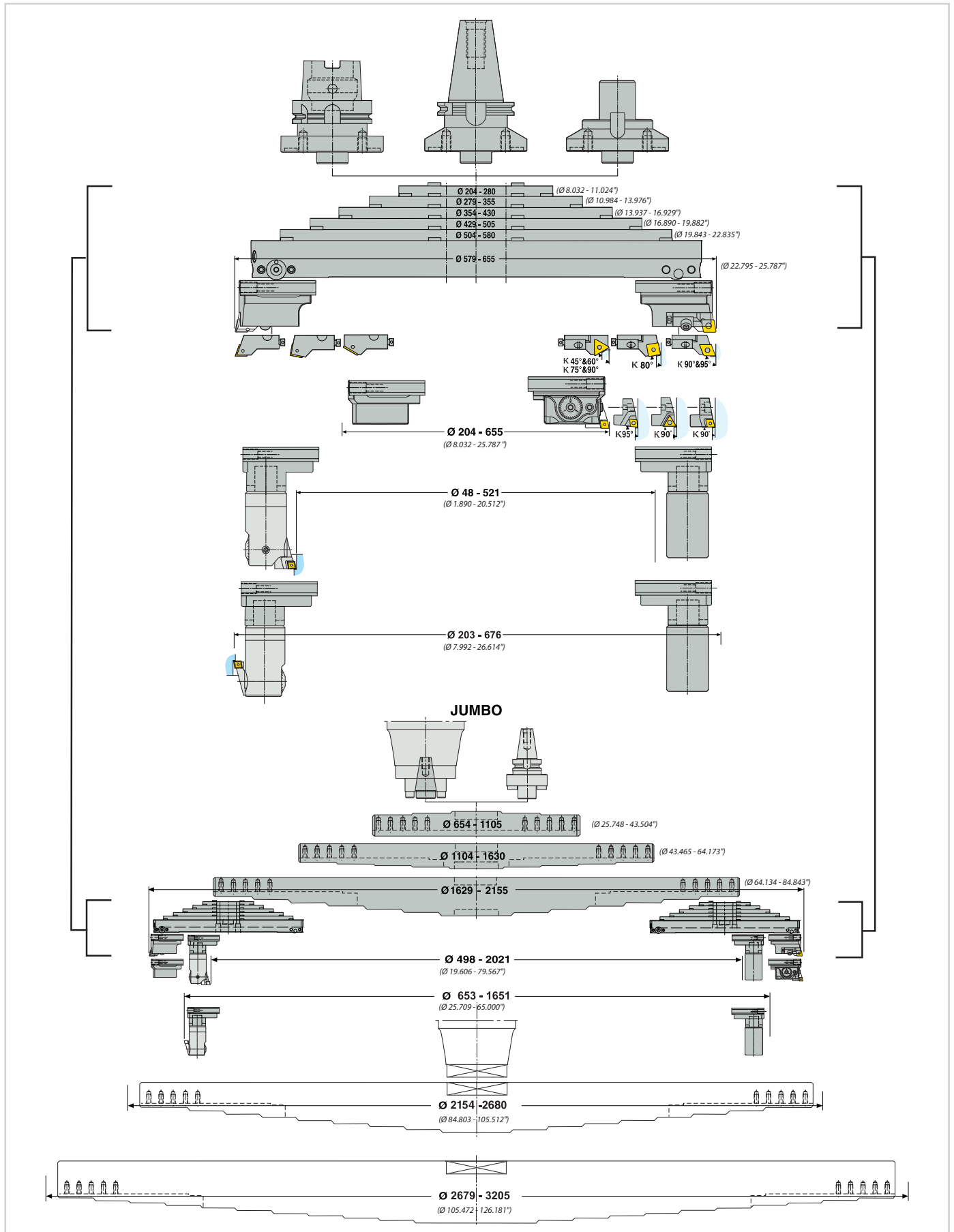
Introducere

Găurire

Alezare

Alezare adâncă

Anexă



## Caracteristici

### 5 traverse de alezat pentru alezare

Ø 654-3205 mm (Ø 25,748-126,181"), de asemenea teșire a muchiiilor OD Ø 498-3071 mm (Ø 19,606-120,906") și alezare inversă Ø 653-3226 mm (Ø 25,709-127,008").

Bare Jumbo Bridge construite din aluminiu rezistent la efort cu prinderi din oțel, sunt concepute pentru a ține două bare Bridge standard în diferite poziții.

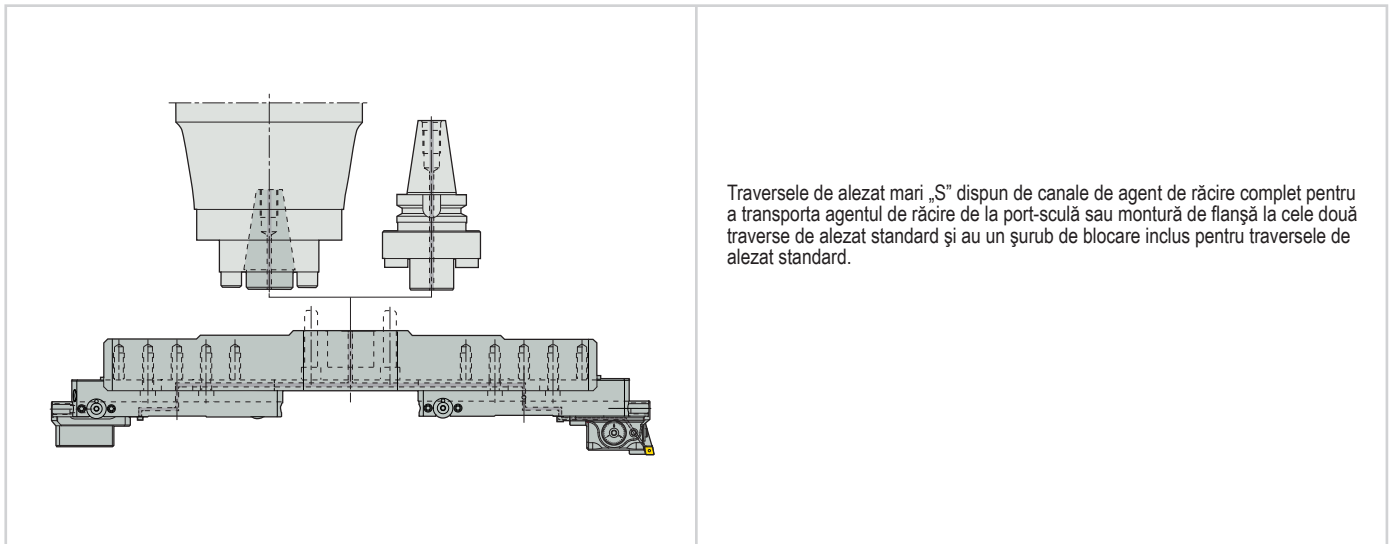
Mărimile A731S001, 002, 003 sunt livrate cu 4 șuruburi de blocare pentru instalare în suport de freză, prindere cu flanșă tip 569, cep Ø 60 mm (Ø 2,362"); sau instalare direct pe capul de alezare al utilajului (DIN 2079/50 partea piesei de prelucrat), utilizând cepul de centrare indicat în accesorii. Barele Jumbo Bridge sunt livrate împreună cu două inele de ridicare.

Mărimile A731S004-...\* și A731S005-...\* sunt disponibile la cerere, cu posibilitate de prindere standard sau specifică arborelui, în funcție de arborele mașinii:

Capacitate Ø mm (inci)	Reper Nr.	Dimensiunile în mm (inci), vezi desenul de la pagina produsului							
		DCB	LF	HTB	LB	CBDP	WB	DCON	Greutate
2154-2680 (84.803-105.512")	A731S004-...*	*	70 (2.75591")	300 (11.811")	160 (6.29921")	*	2140 (84.25197")	*	*
2679-3205 (105.472-126.181")	A731S005-...*	*	110 (4.33071")	400 (15.748")	200 (7.87402")	*	2665 (104.9213")	*	*

\* descrierea și dimensiunile sunt complet dependente de tipul prinderii în arbore.

### Caracteristici principale ale traverselor de alezat mari



**Notă!** Aceste noi traverse de alezat mari „S” pot fixa toate traversele de alezat clasice (cele noi „S” sau cele anterioare): la utilizarea celor anterioare, nu poate fi utilizat șurubul de prindere inclus. Agent de răcire complet către muchia așchietoare este posibil doar la utilizarea traverselor de alezat mari „S” și traverselor de alezat standard „S”. Pentru a menține echilibrul, nu combinați traverse și blocuri de alezat noi și standard anterioare pe aceeași traversă de alezat mare.

## Caracteristici

### 6 traverse de alezat pentru alezare

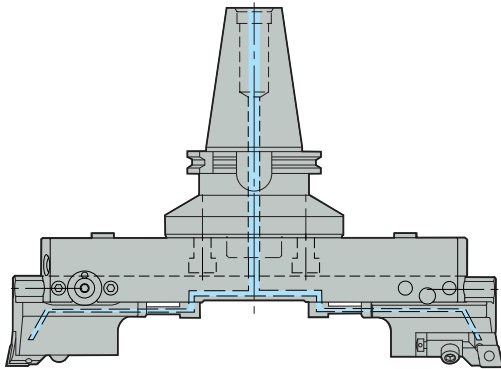
Ø 204-655 mm (Ø 8,032-25,787") de asemenea teșire a muchiiilor OD Ø 48-521 mm  
Ø 1,890-20,512") și alezare inversă.

Traversele de alezat au o conexiune pe partea utilajului Ø 130 mm (Ø 5,118") pentru instalare directă pe arbori pentru traverse de alezat (SA și HSK) sau pe adaptorul Graflex®.

La utilizarea adaptorului Graflex®, sunt posibile extensii, precum și prindere cu flanșă a capului de alezare, a se vedea sistemul modular Graflex®. Poziție unghiulară a traversei de alezat la fiecare 30° pe arbori sau adaptorul Graflex®, pentru depozitare optimizată a magaziei.

Bridge bar poate ține capete de degroșare, finisare, contragreutate sau Graflex®. Capetele de alezare sunt fixate în Bridge bar cu ajutorul a doi cilindri acționați de trei șuruburi de prindere: Un șurub de prindere are un disc opritor, care limitează culisarea capului în limitele de reglare și oprește capul să culiseze afară din Bridge bar. Glisare precisă și fără hopuri a blocului pentru reglare a diametrului 38 mm (Ø 1,496") cursă pe rază, utilizând șurubul de reglare al blocului, care este conectat la pinul de reținere al traversei de alezat.

Răcire interioară, prin Bridge bar și prin cap direcționată spre muchia de tăiere.



Pentru alegerea traverselor de alezat și traverselor de alezat mari, în funcție de diametrul alezării, teșirii muchiiilor sau alezării inverse dorite, consultați tabelele de selecție a traverselor de alezat, paginile 629-634.

Valoare max. de rotații pe minut, consultați paginile 640.

**Notă!** Aceste traverse de alezat (nr. piesă A731S 0\_0) nu pot fixa tipurile anterioare de blocuri de alezat (nr. de piesă A731 \_00 -fără S-).

## Caracteristici

### Bloc de alezare de degroșare

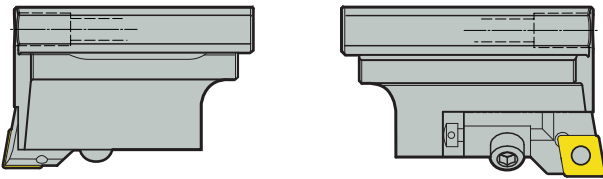
Un cap de alezare larg perechă necesită două blocuri de degroșare, fiecare echipat cu câte un cartuș. Blocurile de degroșare au răcire interioară, direcționată spre muchiile de tăiere.

La utilizarea adaptorului Graflex®, sunt posibile extensii, precum și prindere cu flanșă a capului de alezare, a se vedea sistemul modular Graflex®.

Poziție unghiulară a traversei de alezat la fiecare 30° pe arbori sau adaptorul Graflex®, pentru depozitare optimizată a magaziei.

Bridge bar poate ține capete de degroșare, finisare, contragreutate sau Graflex®.

#### Cartușele



O gamă extinsă de cartușe este disponibilă:

- Cartușe cu unghi de avans de 90°, recomandate în majoritatea aplicațiilor de alezare, pentru un consum de putere mai mic.
- Cartușe cu unghi de avans de 80°, recomandate pentru alezare de găuri străpunse (și șanfrenare), în special în fontă, pentru a evita defectele la ieșire. Consumul de putere este mare.
- Alte cartușe cu interfață de instalare ISO5611/h1 = 16 mm (0,629") sunt, de asemenea, adecvate.

**NOTĂ!** Cele două cartușe se pot regla la același diametru (alezare simetrică) sau se pot așeza decalat (alezare asimetrică). O pană pentru ridicarea cartușului este disponibilă ca accesoriu (Reper Nr. 18LS0316). Proceduri de asamblare și setare, consultați paginile 629-634.

### Blocuri pentru alezare fină și contragreutăți

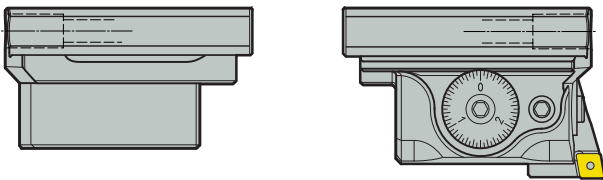
Un cap mare de alezare de finisare necesită un bloc de alezare de finisare echipat cu o portplăcuță și o contragreutate.

Mecanism de setare a diametrului blocului de alezare de precizie cu șurub de setare micrometric (1 treaptă = 5 μm (197 μin) în diametru). Sistemul este protejat și lubrifiat pe viață.

Precizia mecanismului asigură garanția repetabilității. Șurubul de reglare a diametrului este poziționat lateral pentru un acces mai facil.

Blocurile de finisare au răcire interioară, direcționată spre muchiile de așchiere.

#### Adecvate pentru suporturile de plăcuță pentru alezare de precizie A72460, A72560 sau A72660



Suporturile de plăcuță pentru alezare de precizie A72460, A72560 sau A72660 adecvate trebuie comandate separat: sunt la fel precum la capetele de alezare de precizie de tip radial, consultați paginile 618, 619.

Proceduri de asamblare și setare, consultați paginile 629-634.

## Caracteristici

### Blocuri de alezare Graflex®, pentru teșire a muchii OD sau alezare inversă

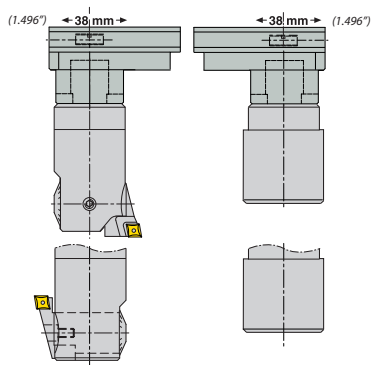
Acest bloc are o conexiune frontală Graflex® mamă mărimea G5.

Orice cap de alezat Graflex®, sculă specială sau modul standard Graflex® mărimea G5 poate fi montat pe o bară Bridge, ex. desenul care arată un ansamblu pentru alezare exterioară sau alezare inversă utilizând două blocuri de alezare Graflex® complete cu un cap de alezare de finisare Graflex® A78050 cu port-plăcută (ex. A72550 pentru alezare exterioară), o port-plăcută (ex. A789X30CC0690) și o contragreutate Graflex® (ex.: Part No. BM050W78050).

Sunt posibile două poziționări ale modului Graflex®, deoarece are șuruburi cu vârf sferic poziționate 2x2 și două știfturi plasate la 180°. Blocurile de degroșare au răcire interioară, direcționată spre muchiile de așchiere.

Proceduri de asamblare și setare, consultați paginile 629-634.

#### Blocuri de alezare Graflex®, pentru teșire a muchii OD sau alezare inversă



Aceste blocuri de alezare (nr. de piesă A731S 400, A731S 500, A731S 600, A731S 40128) se pot instala și în tipul anterior de traverse de alezat (nr. de piesă A731 0\_0 -fără S-).

Se vor utiliza instrucțiunile de montare și RPM max. de la tipul anterior de bare.

Pentru a menține echilibrarea, nu monta blocuri noi și vechi pe același Bridge bar.

**NOTĂ!** Noile blocuri de alezare se potrivesc în vechile tipuri de Bridge bar.

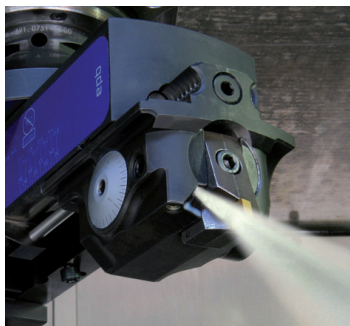
### Sfaturi pentru alegerea accesoriilor pentru agent de răcire complet

#### Degroșare (bară Bridge cu 2 blocuri de alezare de degroșare):

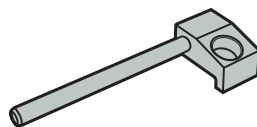
Pentru direcționarea lichidului de răcire către ambele muchii de așchiere, folosiți 2 conectoare (Reper Nr. AU731S00700), montate în Bridge Bar, și 2 seturi de duze de direcționare (Reper Nr. AU731S40700), care se vor monta în fiecare bloc de degroșare. Pentru răcirea normală prin canalele blocului, folosiți 2 conectoare (Reper Nr. AU731S00700), care se vor monta în Bridge bar.

#### Alezare de finisare (bară Bridge cu 1 bloc de alezare de finisare și 1 contragreutate):

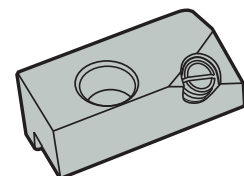
Folosiți 1 conector (Reper Nr. AU731S00700), montat în Bridge Bar înainte de conectarea blocului de finisare. Deoarece blocurile de alezare au o duză pentru alimentarea cu lichid de răcire, direcționarea lichidului este rezolvată. Alezare exterioară (ex. bară Bridge cu 2 blocuri de alezare Graflex® echipate cu un cap de alezare de finisare și o contragreutate): Folosiți 1 conector (Reper Nr. AU731S00700), montat în Bridge Bar înainte de conectarea blocului de Graflex® cu capul de alezare montat. Canalul central de lichid de răcire al blocului de alezare Graflex® va alimenta cu lichid de răcire capul de alezare instalat



Conectorul țevă răcire  
(Reper Nr. AU731S00700)



Set duză pentru direcționarea lichidului  
(Part Nr. AU731S40700)



**NOTĂ!** Presiunea maximă admisă = 70 bari max.

## Alcătuirea ansamblurilor de traversă de alezat

Un ansamblu pentru alezare de degroșare de până la  $\varnothing 655 \text{ mm}$  ( $\varnothing 25,787''$ ) necesită: 1 traversă de alezat (A731S 0\_0) + 2 blocuri de alezare de degroșare (2x A731S 400) cu 2 cartușe\*.

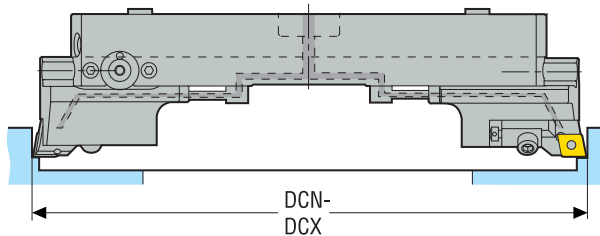


Fig. 1

Un ansamblu pentru alezare de precizie de până la  $\varnothing 655 \text{ mm}$  ( $\varnothing 25,787''$ ) necesită: 1 bară Bridge (A731S 0\_0) + 1 bloc de alezare de finisare (A731S 500) cu 1 port-plăcuță de finisare mărimea 60\*\* + 1 bloc contragreutate (A731S 600).

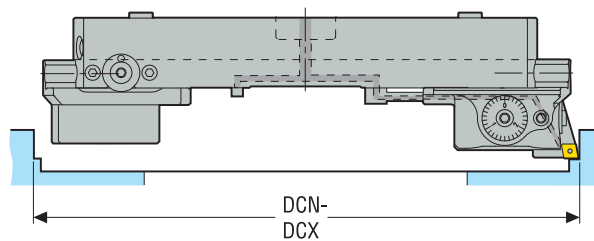


Fig. 2

Un ansamblu pentru alezare de degroșare de până la  $\varnothing 3205 \text{ mm}$  ( $\varnothing 126,181''$ ) necesită: 1 bară Jumbo Bridge (A731S 00\_) + 2 bare Bridge (A731S 0\_0) + 2 blocuri de alezare de degroșare (2x A731S 400) cu 2 cartușe\*.

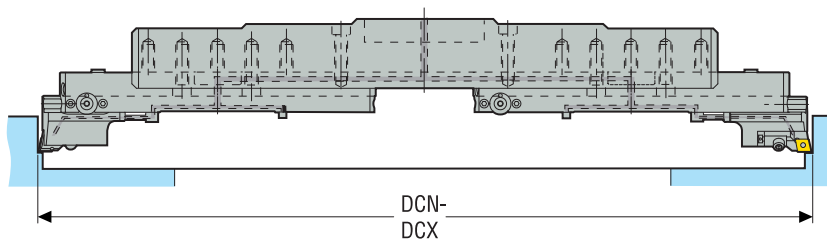


Fig. 3

Un ansamblu pentru alezare de precizie de până la  $\varnothing 3205 \text{ mm}$  ( $\varnothing 126,181''$ ) necesită: 1 bară Jumbo Bridge (A731S 00\_) + 2 bare Bridge (A731S 0\_0) + 1 bloc de alezare de finisare (A731S 500) cu 1 port-plăcuță de finisare mărimea 60\*\* + 1 bloc contragreutate (A731S 600).

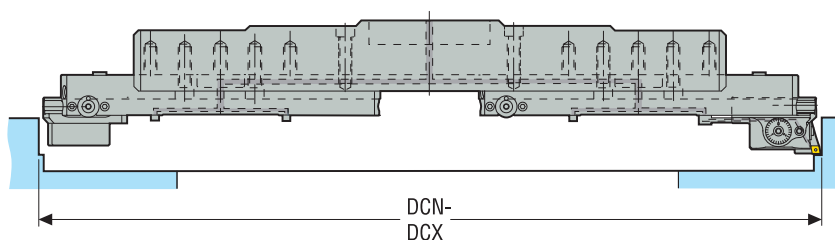


Fig. 4

\* Cartușele trebuie comandate separat.

\*\* Suporturile de plăcuță trebuie comandate separat.

Construirea unui ansamblu Bridge bar pentru alezare:  
Tabel pentru selecția și realizarea barelor Bridge în funcție de diametrul la alezare

Pentru alezare DCN-DCX Ø mm	Pentru alezare DCN-DCX Ø inci	Traverse de alezat Jumbo	Bare de alezat clasice	Pentru alezare de degroșare		Pentru alezare de finisare	
					Fig.		Fig.
204-280	8.031-11.024	-	A731S 010	2x A731S 400 + 2 cartușe	1	A731S 500 + 1 Portplăcuță + A731S 600	2
279-355	10.984-13.976	-	A731S 020				
354-430	13.937-16.929	-	A731S 030				
429-505	16.890-19.882	-	A731S 040				
504-580	(19.843-22.835	-	A731S 050				
579-655	22.795-25.787	-	A731S 060				
654-805	25.748-31.693	A731S 001	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Portplăcuță + A731S 600	4
654-880	25.748-34.646		2x A731S 020				
804-955	31.654-37.598		2x A731S 030				
879-1030	34.606-40.551		2x A731S 040				
1029-1105	40.512-43.504		2x A731S 050				
1104-1255	43.465-49.409	A731S 002	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Portplăcuță + A731S 600	4
1104-1330	43.465-52.362		2x A731S 020				
1179-1405	46.417-55.315		2x A731S 030				
1254-1480	49.370-58.268		2x A731S 040				
1329-1555	52.323-61.220		2x A731S 050				
1404-1630	55.276-64.173		2x A731S 060				
1629-1780	64.134-70.079	A731S 003	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Portplăcuță + A731S 600	4
1629-1855	64.134-73.031		2x A731S 020				
1704-1930	67.087-75.984		2x A731S 030				
1779-2005	70.039-78.937		2x A731S 040				
1854-2080	72.992-81.890		2x A731S 050				
1929-2155	75.945-84.843		2x A731S 060				
2154-2305	84.803-90.748	A731S 004	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Portplăcuță + A731S 600	4
2154-2380	84.803-93.701		2x A731S 020				
2229-2455	87.756-96.654		2x A731S 030				
2304-2530	90.709-99.606		2x A731S 040				
2379-2605	93.661-105.512		2x A731S 050				
2454-2680	96.614-105.512		2x A731S 060				
2679-2830	105.472-111.417	A731S 005	2x A731S 010	2x A731S 400 + 2 cartușe	3	A731S 500 + 1 Portplăcuță + A731S 600	4
2679-2905	105.472-114.370		2x A731S 020				
2754-2980	108.425-117.323		2x A731S 030				
2829-3055	111.378-120.276		2x A731S 040				
2904-3130	114.331-123.228		2x A731S 050				
2979-3205	117.283-126.181		2x A731S 060				



## Construirea unui ansamblu de alezare exterioră Bridge bar:

Un ansamblu pentru teșire a muchii OD de precizie de până la  $\varnothing 521$  mm ( $\varnothing 20,512''$ ) necesită: 1 bară Bridge (A731S 0\_0) + 2 blocuri Graflex® (2x A731S 40128) + ex. 1 cap de alezare de finisare (A780 50) cu 1 port-plăcuță de finisare mărimea 60\* + 1 contragreutate (BM050W78050).

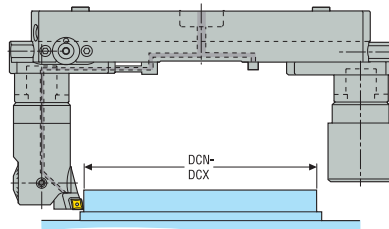


Fig. 1

Un ansamblu pentru alezare de degroșare de până la  $\varnothing 3205$  mm ( $\varnothing 120,906''$ ) necesită: 1 bară Jumbo Bridge (A731S 00\_) + 2 bare Bridge (A731S 0\_0) + 2 blocuri de alezare de degroșare (2x A731S 400) cu 2 cartușe\*.

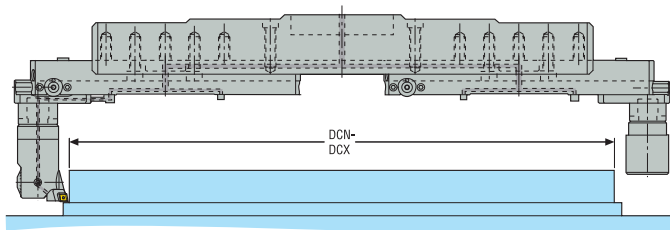


Fig. 2

\* Port-plăcuțele se comandă separat.

Construirea unui ansamblu Bridge bar pentru alezare exterioră:  
Tabel pentru selecția și realizarea barelor Bridge în funcție de diametrul dorit la alezare exterioră

Pentru alezare exterioră DCN-DCX Ø mm	Pentru alezare exterioră DCN-DCX Ø inci	Traverse de alezat Jumbo	Bare de alezat clasice	Strunjire de finisare exterioră	Fig.
48-146	1.890-5.748	–	A731S 010	2x A731S 40128 + 1x A780 50 + 1 Portplăcuță + 1x BM050W78050	1
123-221	4.843-8.701	–	A731S 020		
198-296	7.795-11.654	–	A731S 030		
273-371	10.748-14.606	–	A731S 040		
348-446	13.701-17.559	–	A731S 050		
423-521	16.654-20.512	–	A731S 060		
498-671	19.606-26.417	A731S 001	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Portplăcuță + 1x BM050W78050	2
498-746	19.606-29.370		2x A731S 020		
648-821	25.512-32.323		2x A731S 030		
723-896	28.465-35.276		2x A731S 040		
873-971	34.370-38.228		2x A731S 050		
948-1121	37.323-44.134	A731S 002	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Portplăcuță + 1x BM050W78050	2
948-1196	37.323-47.087		2x A731S 020		
1098-1271	43.228-50.039		2x A731S 030		
1173-1346	46.181-52.992		2x A731S 040		
1323-1421	52.087-55.945		2x A731S 050		
1398-1496	55.039-58.898		2x A731S 060		
1473-1646	57.992-64.803	A731S 003	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Portplăcuță + 1x BM050W78050	2
1473-1721	57.992-67.756		2x A731S 020		
1623-1796	63.898-70.709		2x A731S 030		
1698-1871	66.850-73.661		2x A731S 040		
1848-1946	72.756-76.614		2x A731S 050		
1923-2021	75.709-79.567		2x A731S 060		
1998-2171	78.661-85.472	A731S 004	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Portplăcuță + 1x BM050W78050	2
1998-2246	78.661-88.425		2x A731S 020		
2148-2321	84.567-91.378		2x A731S 030		
2223-2396	87.520-94.331		2x A731S 040		
2373-2471	93.425-97.283		2x A731S 050		
2448-2546	96.378-100.236		2x A731S 060		
2523-2696	99.331-106.142	A731S 005	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 Portplăcuță + 1x BM050W78050	2
2523-2771	99.331-109.094		2x A731S 020		
2973-2846	117.047-112.047		2x A731S 030		
2748-2921	108.189-115.000		2x A731S 040		
2898-2996	114.094-117.953		2x A731S 050		
2973-3071	117.047-120.906		2x A731S 060		

## Construirea unui ansamblu Bridge bar pentru alezare inversă:

Un ansamblu pentru alezare inversă de precizie de până la Ø 676 mm (Ø 26,614") necesită: 1 bară Bridge (A731S 0\_0) + 2 blocuri Graflex® (2x A731S 40128) + ex. 1 cap de alezare de finisare (A780 50) cu 1 port-plăcuță de alezare de finisare inversă mărimea 50\* + 1 contragreutate (BM050W78050).

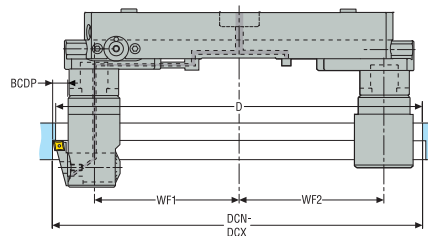


Fig. 1

Un ansamblu pentru alezare inversă de precizie de până la Ø 3226 mm (Ø 127,008") necesită: 1 bară Jumbo Bridge (A731S 00\_) + 2 bare Bridge (A731S 0\_0) + ex. 1 cap de alezare de finisare (A780 50) cu 1 port-plăcuță de finisare inversă mărimea 50\* + 1 contragreutate (BM050W78050).

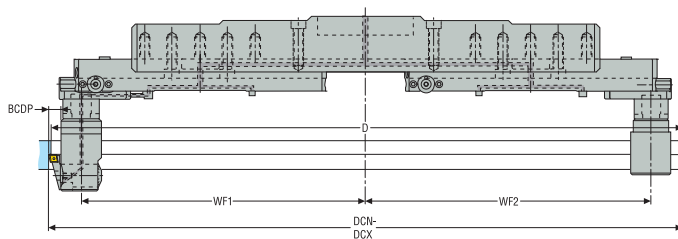


Fig. 2

\* Port-plăcuțele se comandă separat.

### Determinarea diametrului de acces minim (D min)

Condiții de echilibrare:  $WF1 = WF2$

$D_{min} = DC + 5 - BCDP$

BCDP = distanța dintre muchia de așchiere a plăcuțelor și corpul capului de alezat A78050 montat ( $7,5 < BCDP < 18,5$ ).

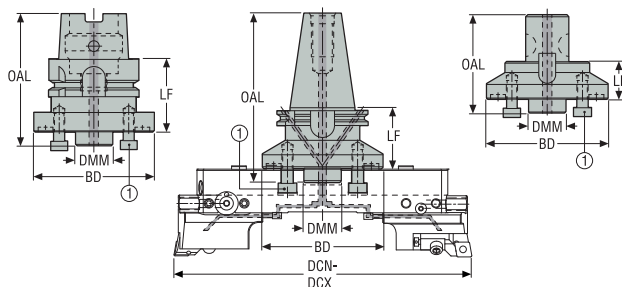
#### Două cazuri extreme:

Capul de alezat A78050 reglat la capacitate minimă:  $D_{min} = DCN - 2,5$   
 Capul de alezat A78050 reglat la capacitate maximă:  $D_{min} = DCX - 13,5$

**Construirea unui ansamblu Bridge bar pentru alezare inversă:  
Tabel pentru selecția și realizarea barelor Bridge în funcție de diametrul dorit la alezare inversă**

Pentru alezare inversă DCN-DCX Ø mm	Pentru alezare inversă DCN-DCX Ø inci	Traverse de alezat Jumbo	Bare de alezat clasice	Pentru finisare alezare inversă	Fig.
203-301	7.992-11.850	-	A731S 010	2x A731S 40128 + 1x A780 50 + 1 portplăcuță pentru alezare inversă + 1x BM050W78050	1
278-376	10.945-14.803	-	A731S 020		
353-451	13.898-17.756	-	A731S 030		
428-526	16.850-20.709	-	A731S 040		
503-601	19.803-23.661	-	A731S 050		
578-676	22.756-26.614	-	A731S 060		
653-826	25.709-32.520	A731S 001	2x A731S 010	2x A731S 40128 + 1x A780 50 + 1 portplăcuță pentru alezare inversă + 1x BM050W78050	2
653-901	25.709-35.472		2x A731S 020		
803-976	31.614-38.425		2x A731S 030		
878-1051	34.567-41.378		2x A731S 040		
1028-1126	40.472-44.331		2x A731S 050		
1103-1276	43.425-50.236		2x A731S 010		
1103-1351	43.425-53.189	A731S 002	2x A731S 020	2x A731S 40128 + 1x A780 50 + 1 portplăcuță pentru alezare inversă + 1x BM050W78050	2
1253-1426	49.331-56.142		2x A731S 030		
1328-1501	52.283-59.094		2x A731S 040		
1478-1576	58.189-62.047		2x A731S 050		
1553-1651	61.142-65.000		2x A731S 060		
1628-1801	64.094-70.906		2x A731S 010		
1628-1876	64.094-73.858	A731S 003	2x A731S 020	2x A731S 40128 + 1x A780 50 + 1 portplăcuță pentru alezare inversă + 1x BM050W78050	2
1778-1951	70.000-76.811		2x A731S 030		
1853-2026	72.953-79.764		2x A731S 040		
2003-2101	78.858-82.717		2x A731S 050		
2078-2176	81.811-85.669		2x A731S 060		
2153-2326	84.764-91.575		2x A731S 010		
2153-2401	84.764-94.528	A731S 004	2x A731S 020	2x A731S 40128 + 1x A780 50 + 1 portplăcuță pentru alezare inversă + 1x BM050W78050	2
2303-2476	90.669-97.480		2x A731S 030		
2378-2551	93.622-100.433		2x A731S 040		
2528-2626	99.528-103.386		2x A731S 050		
2603-2701	102.480-106.339		2x A731S 060		
2678-2851	105.433-112.244		2x A731S 010		
2678-2926	105.433-115.197	A731S 005	2x A731S 020	2x A731S 40128 + 1x A780 50 + 1 portplăcuță pentru alezare inversă + 1x BM050W78050	2
2828-3001	111.339-118.150		2x A731S 030		
2903-3076	114.291-121.102		2x A731S 040		
3053-3151	120.197-124.055		2x A731S 050		
3128-3226	123.150-127.008		2x A731S 060		

## ABB 731 200 – Portscule și adaptori pentru Bridge bars



1. Șurub reglaj



- Port-scule HSK și SA pentru asamblări scurte
- Adaptor Graflex® pentru ansambluri extinse
- Poziție unghiulară a Bridge bar la fiecare 30°
- Livrat împreună cu un inel O de etanșare dom Ø 58x3 mm

Reper Nr.	Număr reper	Machine side connection	Mărime	Spre semifabricat Capacitatea		OAL	LF	BD	DMM	Greutate
				DCN-DCX Ø						
				mm	mm	mm	mm	mm	mm	kg
				Inci	Inci	Inci	Inci	Inci	Inci	lbs
E3471731200	02503392	DIN 69871-ADB	DIN50 ADB	204,0 8.031	655,0 25.787	166,75 6.565	65,0 2.559	130,0 5.118	40,0 1.575	5,74 12.650
E3416731200	02503393	BT JIS B 6339-ADB	BT50 ADB	204,0 8.031	655,0 25.787	166,75 6.565	65,0 2.559	130,0 5.118	40,0 1.575	5,64 12.430
E9306731200	02417268	ISO 12164-1/ DIN 69893-A	HSK-A100	204,0 8.031	655,0 25.787	115,0 4.528	65,0 2.559	130,0 5.118	40,0 1.575	4,72 10.410
A731200	00056616	GRAFLEX	G7	204,0 8.031	655,0 25.787	90,0 3.543	40,0 1.575	130,0 5.118	40,0 1.575	3,78 8.330

### Piese de schimb

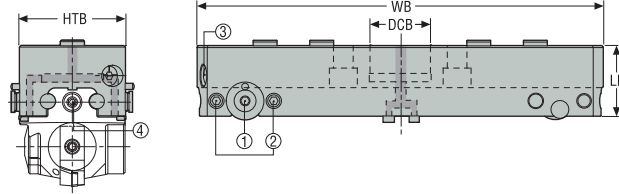
Pentru	Șurub ansamblu	Cheie	Sealing Screws	Cep
E3471731200	950D1230	10SMS795	950A0606	-
E3416731200	950D1230	10SMS795	950A0606	-
E9306731200	950D1230	10SMS795	-	-
A731200	950D1230	10SMS795	-	90M7

### Accesorii

Pentru	Tub răcire	Dop de etanșare	Cheie fixă
E3471731200	-	-	-
E3416731200	-	-	-
E9306731200	20E9306	02E9306	03E9306
A731200	-	-	-

Culplu de strângere 80 Nm. Pentru detaliile aplicațiilor, vezi instrucțiunile de folosire livrate împreună cu Bridge bar și cu blocurile de alezare  
Accesorii, se vor comanda separat

## BB 731S0x0 – Bridge bars



1. Șurub de blocare cu disc opritor
2. Șurub de blocare
3. Pin de reținere
4. Șurubul de reglare a diametrului

- Răcire interioară prin Bridge bar

Reper Nr.	Număr reper	Spre semifabricat	Capacitatea DCN-DCX Ø	HTB	WB	DCB	LF	Greutate
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	
A731S010	02753664	204,0 8.031	280,0 11.024	70,0 2.756	195,0 7.677	40,0 1.575	47,0 1.850	3,43 7.560
A731S020	02753668	279,0 10.984	355,0 13.976	70,0 2.756	269,0 10.591	40,0 1.575	47,0 1.850	4,92 10.850
A731S030	02753670	354,0 13.937	430,0 16.929	70,0 2.756	344,0 13.543	40,0 1.575	47,0 1.850	6,4 14.110
A731S040	02753673	429,0 16.890	505,0 19.882	70,0 2.756	419,0 16.496	40,0 1.575	47,0 1.850	7,9 17.420
A731S050	02753675	504,0 19.843	580,0 22.835	70,0 2.756	494,0 19.449	40,0 1.575	47,0 1.850	10,4 22.930
A731S060	02753677	579,0 22.795	655,0 25.787	70,0 2.756	569,0 22.402	40,0 1.575	47,0 1.850	12,3 27.120

### Piese de schimb

Pentru DCN-DCX	Cheie (tip T)	Cheie	Cheie de blocare	Șurub de blocare
204-655	DOUBLE-T	H6B-H5.0L	03HL05	19A71060

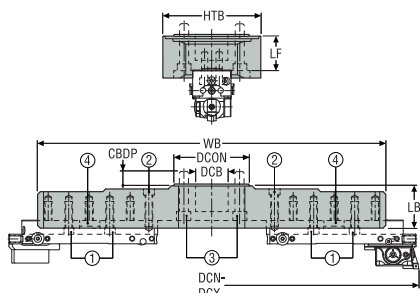
Cuplul de strângere 20 Nm al șurubului de blocare (2) și șurubul de blocare cu disc de oprire (1).\*\*\*

Before diameter setting, make sure retaining pin is engaged. Pentru detaliile aplicațiilor, vezi instrucțiunile de folosire livrate împreună cu Bridge bar și cu blocurile de alezare.

Max RPM, vezi pag. 640 \*Pentru capacitatea de alezare exterioară, vezi Ghidul de la pag. . 631-632

Pentru diametre mai mari, vezi Jumbo Bridge bar la pag. 637

## JBB 731S00 – Bare Jumbo Bridge



1. Șurub de asamblare
2. Șurub de blocare
3. Șurub de fixare
4. Dop de etanșare



- Barele Jumbo Bridge sunt concepute să țină două bare clasice Bridge în diferite poziții
- Lichid de răcire prin barele Jumbo Bridge

Reper Nr.	Număr reper	Spre semifabricat		Capacitatea	HTB	LF	WB	DCON	DCB	CBDP	LB	Greutate	**
		DCN-DCX Ø	mm										
		mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg	
		Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	Inci	lbs	
A731S001	02828506	654,0 25.748	1105,0 43.504	180,0 7.087	63,0 2.480	640,0 25.197	135,0 5.315	60,0 2.362	24,0 0.945	77,0 3.031	20,25 44.640	-	
A731S002	02828516	1104,0 43.465	1630,0 64.173	200,0 7.874	50,0 1.969	1090,0 42.913	135,0 5.315	60,0 2.362	24,0 0.945	80,0 3.150	34,5 76.060	-	
A731S003	02904383	1629,0 64.134	2155,0 84.843	200,0 7.874	50,0 1.969	1615,0 63.583	135,0 5.315	60,0 2.362	24,0 0.945	80,0 3.150	58,0 127.870	**	

Combi-națiile de alezare, alezare exterioară și alezare inversă pentru barele Jumbo și Bridge, vezi pag. Ghid 629-634

\*\*LMărimile mai mari A731S004-... (Ø 2154-2680 mm) și A731S005-... (Ø 2679-3205 mm) disponibile la cerere, vezi pa. Ghid 625

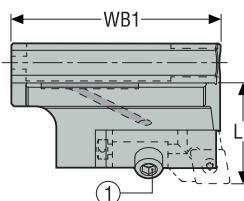
Accesorii, se vor comanda separat

### Piese de schimb

Pentru DCN-DCX	Șurub ansamblu	Șurub de fixare	Șurub levier	Șurub de blocare	Inel O	Dop de etanșare	Pin de centrare
654-1105	950D1240	950D1670	90AS03	950D1250	90JT02	AU731S01100	E447153960
1104-1630	950D1240	950D1680	90AS03	950D1250	90JT02	AU731S01100	E447153960
1629-2155	950D1240	950D16120	90AS03	950D1250	90JT02	AU731S01100	E447153960

Setul de inele de etanșare O conține 6 inele O de etanșare Ø 6 mm (0.236") pentru canalele de răcire și 1inel O de etanșare Ø 60 mm (2.362") pentru alezajul de prindere al barei Jumbo Bridge.

## BBB 731S0xx – for boring blocks and Jumbo bridge bars

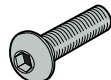







- Pentru montare în Bridge bar.
- Răcire interioară prin blocuri de debrășare, finisare și Graflex.

1. Șurub de asamblare

Număr reper	Reper Nr.	Tiplul blocului de alezare	Spre semifabricat		DCB	BD	WB1	WB2	LF	LF1	HTB	Greutate	Varianta
			Capacitatea DCN-DCX Ø	Capacitatea DCN-DCX Ø									
			mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	mm Inci	kg lbs	-
02753679	A731S400	Rough boring block*	204,0 8.031	2155,0 84.843	-	-	97,0 3.819	-	47,0 1.850	-	70,0 2.756	1,33 2.930	A
02753680	A731S500	Fine boring block**	204,0 8.031	2155,0 84.843	-	-	97,0 3.819	-	47,0 1.850	-	70,0 2.756	1,41 3.110	B
02753682	A731S600	Contragreutate	204,0 8.031	2155,0 84.843	-	-	97,0 3.819	-	-	-	70,0 2.756	1,49 3.280	C
02753687	A731S40128	Graflex size G5***	48,0 1.890	2021,0 79.567	28,0 1.102	50,0 1.969	97,0 3.819	30,0 1.181	38,0 1.496	25,0 0.984	70,0 2.756	0,98 2.160	D

### Piese de schimb

Pentru	Șurub ansamblu	Șurub blocare cilindru	Cheie (tip T)	Cheie	Cheie de blocare	Inel O
A731S400	 950CB0830	 -	 DOUBLE-T	 H6B-H5.0L	 -	 90JT01
A731S500	950D0612	950L1016	DOUBLE-T	H6B-H5.0L	-	90JT01
A731S600	-	-	DOUBLE-T	H6B-H5.0L	-	-
A731S40128	90F5	-	DOUBLE-T	H6B-H5.0L	03H05	90JT01

\* Cartușele se vor comanda separat, vezi pag. 639

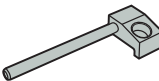
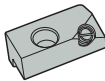
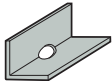
\*\* Portplăcuțele pentru alezare de finisare mărimea 60 se vor comanda separat, vezi pag. 618, 619

\*\*\* Atunci când utilizați capul de alezat A78050, folosiți contragreutatea BM050W78050, vezi Accesoriile de mai jos.

Setul de inele de etanșare O conține 6 inele O de etanșare Ø 6 mm (0.236") pentru canalele de răcire și 1inel O de etanșare Ø 60 mm (2.362") pentru alezajul de prindere al barei Jumbo Bridge.

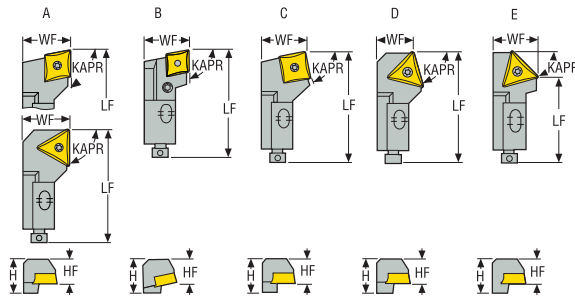
Accesorii, se vor comanda separat

### Accesorii

Pentru	Țeavă de conectare	Set răcire	Corner shim	Contragreutate
A731S400	 AU731S00700	 AU731S40700	 18LS0316	-
A731S500	AU731S00700	-	-	-
A731S600	-	-	-	-
A731S40128	AU731S00700	-	-	BM050W78050



## Cartușe, pentru blocul de alezare de degroșare Bridge bar A731S400



• Pentru montarea în blocuri de degroșare

Reper Nr.	Număr reper	KAPR°	LF	WF	H	HF	Greutate	Mărimea plăcuței potrivite	Varianta
			mm Inci	mm Inci	mm Inci	mm Inci			
SCGCL16CA-16	00039871	90	55,0 2.165	25,0 0.984	20,0 0.787	16,0 0.630	0,2 0.440	CC..16..	A
STGCL16CA-16	00009197	90	63,0 2.480	24,96 0.983	25,0 0.984	16,0 0.630	0,2 0.440	TC..16T3..	A
STGCL16CA-22	02600181	90	55,0 2.165	25,0 0.984	20,0 0.787	16,0 0.630	0,2 0.440	TC..2204..	A
PCGNL16CA-12	02484356	90	63,0 2.480	25,0 0.984	25,0 0.984	16,0 0.630	0,2 0.440	CN..12..	B
SSRCL16CA-15	00039872	75	63,0 2.480	25,0 0.984	20,0 0.787	16,0 0.630	0,2 0.440	SC..15..	C
STRCL16CA-16	00008750	75	63,0 2.480	24,96 0.983	25,0 0.984	16,0 0.630	0,2 0.440	TC..16T3..	D
STRCL16CA-22	02585320	75	63,0 2.480	25,0 0.984	20,0 0.787	16,0 0.630	0,2 0.440	TC..2204..	D
STTCL16CA-16	00009194	60	63,0 2.480	14,96 0.589	25,0 0.984	16,0 0.630	0,2 0.440	TC..16T3..	D
STSCL16CA-16	00009193	45	53,0 2.087	24,96 0.983	25,0 0.984	16,0 0.630	0,2 0.440	TC..16T3..	E

Spare parts for cartridges; see catalog Turning

## Condiții de prelucrare recomandate

Performanțe optime se obțin cu răcire internă (regimuri de așchiere mari, finisare superioară a suprafeței, evacuare mai bună a așchiilor).

Alezarea de degroșare depinde de priorități: pentru avans mare sau rată mare de îndepărtare a materialului se vor regla casetele simetric (cea mai comună metodă, avans dublu față de reglarea asimetrică) sau se reglează asimetric (adâncime de așchiere dublă).

La alezarea de finisare în oțel, în condiții bune de stabilitate, se recomandă utilizarea plăcuțelor Cermet, pentru viteze mari și durată de viață mărită.

Pentru instrucțiunile de utilizare detaliate, verifică instrucțiunile de utilizare livrate împreună cu pachetul capului de alezat sau cu barele Steadyline®. Aceste instrucțiuni pot fi descărcate de pe [www.secotools.com](http://www.secotools.com)

## Depanare

Vezi sfaturi de depanare, în capitolul capete de degroșare pag. 568, sau capitolul capete de finisare pag. 608. Echilibrare prin reglarea ambelor inele conform cu diametrul de alezat (nu necesită tabel de valori).

## Viteza maximă pentru Bridge bar

Datorită dimensiunilor foarte mari ale capetelor de alezare Bridge bar, o turație RPM necorespunzătoare poate duce la producerea unor accidente.

Mai jos sunt prezentate turațiile maxime RPM pentru ansamblurile Bridge bar formate din bare Bridge (Reper Nr. A731S 0\_0) pentru degroșare, pentru finisare și blocuri contragreutate (Reper Nr. A731S \_00) și bare Jumbo Bridge (Reper Nr. A731 00\_). Pentru alte asamblări vă rog să contactați reprezentantul Seco.

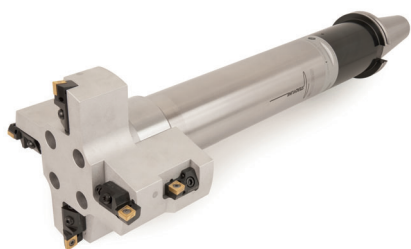
**NOTĂ!** La utilizarea blocurilor de alezare actuale (nr. de piesă A731S 400, A731S 500, A731S 600, A731S 40128) pe traversele de alezat de tip anterior (nr. de piesă A731 0\_0 -fără S-), valoarea maximă de rotații pe minut care trebuie respectată este cea recomandată pentru traversele de alezat de tip anterior. Pentru a menține echilibrul, nu combinați blocuri noi și anterioare pe aceeași traversă de alezat.

Cap bazat pe	Capacitate Ø mm (inci)	RPM max.	Viteza max de așchiere implicită $v_c$ la Cap. min. m/min (feet/min)	Viteza max de așchiere implicită $v_c$ la Cap. max. m/min (feet/min)
Toleranța de fabricație a burghiului				
A731S010	204-280 (8.0315-11.0236")	1600	1025 (3363)	1407 (4616)
A731S020	279-355 (10.9843-13.9764")	1150	1007 (3304)	1282 (4206)
A731S030	354-430 (13.937-16.9291")	900	1000 (3281)	1215 (3986)
A731S040	429-505 (16.8898-19.8819")	750	1010 (3314)	1189 (3901)
A731S050	504-580 (19.8425-22.8346")	650	1029 (3376)	1184 (3885)
A731S060	579-655 (22.7953-25.7874")	550	1000 (3281)	1131 (3711)
Traverse de alezat Jumbo (cu două bare de alezat identice și capete de alezat reglate simetric)				
A731S001	654-1105 (25.748-43.50394")	170	349 (1145)	590 (1936)
A731S002	1104-1630 (43.46457-64.17323")	100	346 (1135)	512 (1680)
A731S003	1629-2155 (64.13386-84.84252")	70	358 (1175)	473 (1552)
A731S004	2154-2680 (84.80315-105.5118")	50	358 (1175)	420 (1378)
A731S005	2679-3205 (105.4724-126.1811")	40	336 (1102)	402 (1319)

**Notă:** Vitezele maxime depind de designul mecanic al capului de alezat și de calitatea echilibrării. Vitezele dintre aceste limite trebuie alese în funcție de alte condiții de prelucrare, ex.: materialul semifabricatului, muchia de așchiere (scule și plăcuțe), Lungimea sistemului de scule, arborele mașinii.

## Soluții personalizate pentru alezare

Seco Tools are o experiență solidă în execuția de soluții de alezare personalizate:



- Soluții antivibrații Steadylite® pentru alezare de degroșare și de precizie,
- Bare de alezat cu mai multe muchii,
- Extensii speciale cu manșoane de ghidare, pentru operațiuni cu consolă lungă,
- Bare combinate pentru operații de găurire, alezare adâncă, șanfenare, alezare, filetare...

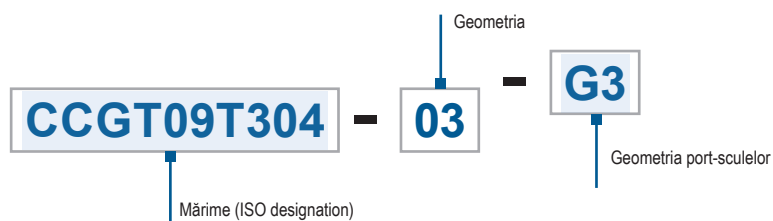
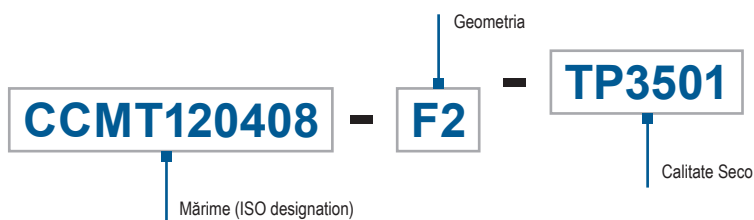
Pentru mai multe informații contactați agentul Seco de pe zona dvs.

## Selectarea unei plăcuțe pentru alezare

Aceasta este o selecție a plăcuțelor din gama Seco, care sunt potrivite pentru alezare. Mărimea selectată a plăcuței este cea potrivită pentru gama de capete de alezare. Plăcuțele pentru degroșare au o mare reziliență pentru a îndepărta mult material și au geometrie pozitivă pentru reducerea cuplului necesar la arbore.

Plăcuțele pentru finisare au geometrii pozitive, muchii ascuțite și rezistente la uzură pentru controlul exact al toleranței, geometriei și finisării suprafeței găurii.

## Codificare, exemple



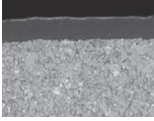
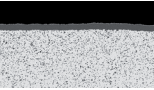
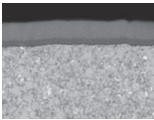
## Calități de plăcuțe pentru alezare - clasificarea ISO a materialului semifabricatului

		P					M				K				N				S				H							
		P01	P10	P20	P30	P40	P50	M01	M10	M20	M30	M40	K01	K10	K20	K30	K40	N01	N10	N20	N30	S01	S10	S20	S30	H01	H10	H20	H30	
CVD	TP1501																													
	TP2501																													
	TP3501																													
	TP200																													
	TP40																													
	TK1501																													
	TK0501																													
PVD	TH1500																													
	25																													
	TS2000																													
	TH1000																													
Neocermet	CP500																													
	26																													
	KX																													
	HX																													
Cermet	03																													
	TP1020																													
	TP1030																													
PCBN	51																													
	CBN10																													
	CBN010																													
	CBN200																													
	81																													
PCD	CBN060K																													
	91																													

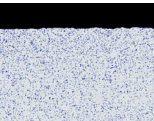

## Calități cu acoperire CVD pentru alezare

TP1501		Tehnologie de acoperire <b>Duratomic®</b> . Calitate cu rezistență foarte mare la căldură și uzură pentru prelucrări generale de strunjire în oțeluri și o soluție de rezervă pentru alte grupe de material.  Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>
TP2501		Tehnologie de acoperire <b>Duratomic®</b> . Calitate cu rezistență mare la uzură cu muchie puternică pentru o gamă largă de aplicații de strunjire în oțel, oțel inoxidabil și fontă.  Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>
TP3501		TP3501 este destinat aplicațiilor de alezare unde cerința principală este durezza și siguranța la prelucrarea oțelurilor și oțelurilor inoxidabile. Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> DURATOMIC®
TP200		TP200 este o calitate universală cu mare versatilitate. Această calitate este destinată unei game largi de aplicații de strunjire în oțel și oțel inoxidabil, ea este de asemenea o bună alegere în fontă. Ti(C,N) + Al <sub>2</sub> O <sub>3</sub> + TiN
TP40		TP40 este o calitate de bază în domeniul P40. Calitate foarte dură, pentru aplicații grele în oțel turnat și forjat și în toate tipurile de oțel inoxidabil. TiC/Ti(C,N) + TiN
TK0501		Tehnologie de acoperire <b>DURATOMIC®</b> . Calitate extrem de rezistentă la uzură optimizată pentru prelucrarea fontei cenușii și a fontei nodulare. Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>
TK1501		Tehnologie de acoperire <b>DURATOMIC®</b> . Calitate foarte rezistentă la uzură pentru prelucrarea fontei și a oțelurilor, în particular capabilă la așchiera fontei nodulare în aplicații solicitante și cu așchiere intermitentă. Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>
TH1500		Tehnologie de acoperire <b>DURATOMIC®</b> . Calitate foarte dură cu granulație superfină pentru debitarea oțelului călit și o alternativă pentru finisarea fontei. Ti(C,N) + Al <sub>2</sub> O <sub>3</sub>
25		Calitate universală. Calitate pentru o gamă largă de aplicații de alezare în oțel, oțel inoxidabil și fontă Comparație unică între rezistența la uzură și reziliență. Ti(C, N)

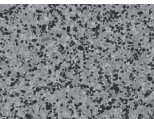
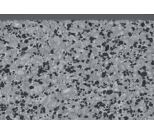
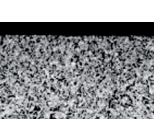
## Calități cu acoperire PVD pentru alezare

TS2000		Microstructură dură destinată în principal finisării în superaliaje și aliaje de titan. Se comportă bine la finisare în oțel inoxidabil. (Ti,Al)N + TiN
CP500 & 26G6		O microstructură foarte dură pentru finisarea și semifinisarea oțelului inoxidabil. Poate suporta așchiera întreruptă foarte bine. CP500 este de asemenea o alternativă la prelucrarea aliajelor din aluminiu. (Ti,Al)N + TiN
TH1000		Calitate foarte dură cu granulație superfină pentru debitarea componentelor din oțel călit sau superaliaje, iar datorită tenacității muchiei de așchiere se pretează la așchiere intermitentă sau la așchiera matrialelor cu crustă.

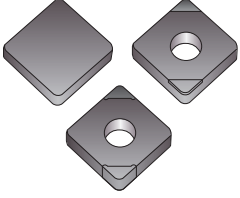

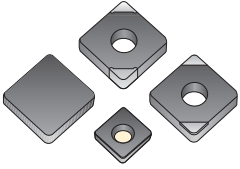
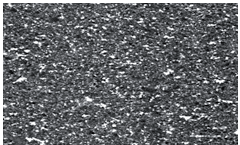
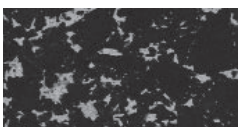
## Calități neacoperite pentru alezare

KX & 03G3		Microstructură destinată prelucrării aluminiului și altor materiale neferoase.
HX		Calitate universală neacoperită pentru prelucrarea fontei și oțelului călit, cu rezultate bune și în materiale neferoase.

## Cermet recomandat pentru alezare

TP1020		Cermet cu o rezistență la uzură foarte mare destinat operațiilor cu cerințe foarte mari la finisarea suprafețelor și cu un control și previziune bună la prelucrarea oțelului și a oțelului inoxidabil.
TP1030		Cermet cu acoperire PVD cu rezistență foarte mare la uzură folosite pentru finisări superioare în oțel și oțel inoxidabil, în operații cu productivitate mare datorită previzibilității. Acoperire nanolaminată Ti-Al-Si-N.
51G1		Cermet cu o rezistență la uzură foarte mare. Destinat finisării în oțel, atunci când există cerințe foarte stricte privind calitatea suprafeței.

## Calități CBN și PCD pentru alezare

CBN010		<p>Format: Solid, față brazată sau vârf brazat (o singură față sau două fețe). Compoziția: Conținut de 50% CBN cu mărimea medie a granulelor de 2 μm și cu liant ceramic TiC. Acoperirea: Fără acoperire.</p>
CBN10 & 81B1		<p>Calitate pe bază de nitrat cubic de bor, pentru finisarea oțelului tratat termic (Grupa 7) prelucrări ușoare continue sau cu întreruperi moderate.</p>
CBN060K		<p>Solid, vârf brazat (una sau două părți) sau strat sinterizat Prima alegere pentru aşchierea oțelului călit cu întreruperi moderate (<math>a_p &lt; 0.020</math> inch). Noi acoperiri (Ti,Si, Al)N PVD dezvoltate pentru prelucrare de mare viteză. Un nou liant unic pentru superaliaje</p>
CBN200		<p>Calitate pe bază de nitrat cubic de bor, pentru finisarea fontei perlitice cenușii și a oțelului sinterizat.</p>
PCD20 & 91J3		<p>PCD, diamant policristalin, pentru alezarea aluminiului și aliaje de aluminiu, alamă, bronz și materiale sintetice (Grupa 16-17).</p>

## Plăcuțe, recomandate pentru alezarea de degroșare, cu parametri de așchiere

Reper Nr.	Neacoperite, flanc rectificat și fragmentator de așchii presat			Acoperită Fragmentator presat					Acoperită Flanc rectificat cu fragmentator Așchiere pe stânga	Max adâncimea de așchiere a <sub>p</sub> mm (inچی)	Avansul f mm/rev (inچی)
	KX	HX	03D3	TP2501	TP3501	TP40	25C4	TK1501			
CPGT050204			02434654				02434652			2 (0.079)	0,08-0,2 (0.0031-0.0079)
CCMT060204-F1				02960857	03095430	00008505		03062942	00096854	2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMT060204-F2		74011732				74018652				2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCGT060204L-UX									02497631	2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCGT060204F-AL	00015710									2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMT060204-M3				02960858	03095431			03062944		2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMT09T308-F1				02960861	03095443	00008518		03063857	00096858	2,5 (0.098)	0,1-0,3 (0.0039- 0.0118)
CCMT09T308-MF2				02956309	03095446				02754822	2,5 (0.098)	0,1-0,3 (0.0039- 0.0118)
CCGT09T304L-UX									02497640	2,5 (0.098)	0,1-0,3 (0.0039- 0.0118)
CCGT09T308F-AL	00015754									2,5 (0.098)	0,1-0,3 (0.0039- 0.0118)
CCMT120408-F1				02960854	03095449			03062626		4 (0.157)	0,15-0,4 (0.0059-0.0157)
CCMT120408-MF2				02956311	03095452					4 (0.157)	0,15-0,4 (0.0059-0.0157)
CCGT120408L-UX									02610062	4 (0.157)	0,15-0,4 (0.0059-0.0157)
CCGT120408F-AL	00015790									5 (0.197)	0,15-0,4 (0.0059-0.0157)
SCMT060204-M3				02960423	03096621					2,5 (0.098)	0,1-0,22 (0.0039-0.0087)
SCMT09T308-F1				02960396	03096625			03062629	00099708	2,5 (0.098)	0,1-0,3 (0.0039- 0.0118)
SCMT09T308-MF2				02956318	03096627				02755042	2,5 (0.098)	0,1-0,3 (0.0039- 0.0118)
SCMT120408-F1				02960397	03096630				00099804	4 (0.157)	0,15-0,4 (0.0059-0.0055)
SCMT120408-M3				02960429	03096631			03063990		4 (0.157)	0,15-0,4 (0.0059-0.0055)
TCMT16T308-F1				02960408	03096643	74004572			00091357	5 (0.197)	0,15-0,4 (0.0059-0.0055)
TCMT16T308-MF2				02956323	03096645				02755046	5 (0.197)	0,15-0,4 (0.0059-0.0055)
TCGT16T308F-AL	00015875									4 (0.157)	0,15-0,4 (0.0059-0.0055)
SCMT150512-F2						74007348				7 (0.276)	0,2-0,5 (0.0079- 0.0197)

Pentru recomandări privind parametrii de așchiere, vezi pag. 650-653



## Plăcuțe CN., recomandate pentru alezare de degroșare (două fețe)

Reper Nr.	Acoperită Fragmentator presat				Max adâncimea de așchiere a <sub>p</sub> mm (inchi)	Avansul f mm/rev (inchi)
	TP3500	TP40	TM4000	TP200		
CNMG120408-M3					4,5 (0.177)	0,25-0,35 (0.00984-0.01378)
CNMG120408-MF3		74030598			4,5 (0.177)	0,25-0,35 (0.00984-0.01378)
CNMG120408-MF4					4,5 (0.177)	0,25-0,35 (0.00984-0.01378)
CNMG120408-MF1					4,5 (0.177)	0,25-0,35 (0.00984-0.01378)
CNMG120408-MR7		74017309			4,5 (0.177)	0,25-0,35 (0.00984-0.01378)

Pentru recomandări privind parametrii de așchiere, vezi pag. 650-653

## Plăcuțe, recomandate pentru alezarea de finisare, cu parametri de așchiere

Reper Nr.	Acoperită							Cermet			Max adâncimea de așchiere a <sub>p</sub> mm (inچی)	Avansul f mm/rev (inچی)
	TP1501	TS2000	TK1501	CP500	26G6	TH1000	TH1500	51G1	TP1020	TP1030		
CCGT060200								00083915			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT0602005-F1				02430287							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060201-F1				02430307							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060202					00039546			00096634			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060204					00081826			00048334			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060204L-UX				02497631							2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMT060202-F1	02960383	02614299		00096853					02754786	02754435	0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMT060204-F1	02960856	02615873	03062942	00096854		02825858	02825859		02754791	02754792	2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMW060202F-L1											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMW060204F-L1											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW060202S-01020-LF											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW060204S-01020-LF											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW060204E-L1-B											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T301-F1				02430311							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T302					00048337			00048339			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T304					00077338			00048344			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T304L-UX				02497640							2,5 (0.098)	0,1-0,3 (0.0039-0.0118)
CCMT09T302-F1	02960837			00096856					02754805	02754806	0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMT09T304-F1	02960844	02615874	03063856	00096857		02731806	02731808		02754811	02754812	0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMT09T308-F1	02960853	02615876	03063857	00096858		02731807	02731809		02754821		2,5 (0.098)	0,1-0,3 (0.0039-0.0118)
CCMW09T304F-L1											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMW09T308F-L1											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T304E-L1-B											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T308E-L1-B											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T304S-01020-LF											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T308S-01020-LF											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGT110204								00000721			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGT110201-F1				02430376							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMT110202-F1				02430419							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMT110204-F1	02960401			02430421							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMT110208-F1	02960403			00098986							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110204E-L1-C											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110208E-L1-C											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110204S-01020-LF											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110208S-01020-LF											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMW110204F-L1											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030100								00083089			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030102								00091845			0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030102L				02416632							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030102											0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)

The table continues on next page.

Pentru recomandări privind parametrii de așchiere, vezi pag. 650-653

## Plăcuțe, recomandate pentru alezarea de finisare, cu parametri de așchiere

Reper Nr.	CBN				PCD		Max adâncimea de așchiere $a_p$ mm (inچی)	Avansul f mm/rev (inچی)
	CBN010	CBN060K	CBN200	81B1	PCD20	91J3		
CCGT060200							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT0602005-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060201-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060202							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060204							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT060204L-UX							2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMT060202-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMT060204-F1							2 (0.079)	0,1-0,22 (0.0039-0.0087)
CCMW060202F-L1					00089760		0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMW060204F-L1					0005684		0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW060202S-01020-LF			02464698				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW060204S-01020-LF	02916281		02464699				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW060204E-L1-B	02843086	02776337	02649599				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T301-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T302							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T304							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGT09T304L-UX							2,5 (0.098)	0,1-0,3 (0.0039-0.0118)
CCMT09T302-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMT09T304-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMT09T308-F1							2,5 (0.098)	0,1-0,3 (0.0039-0.0118)
CCMW09T304F-L1					0005686		0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCMW09T308F-L1					00095357		0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T304E-L1-B	02843126	02776338	02649607				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T308E-L1-B	02937148		02649608				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T304S-01020-LF	02916282		02464702				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
CCGW09T308S-01020-LF			02464703				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGT110204							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGT110201-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMT110202-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMT110204-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMT110208-F1							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110204E-L1-C	02848657	02776346					0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110208E-L1-C	02848792						0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110204S-01020-LF			02464742				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCGW110208S-01020-LF			02464744				0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
TCMW110204F-L1					0005689		0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030100							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030102							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBG030102L							0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)
WBGW030102				00096761		00096763	0,01-0,3 (0.000394-0.01181)	0,03-0,15 (0.0011811-0.0059055)

Pentru recomandări privind parametri de așchiere, vezi pag. 650-653

Vitezele de aşchiere recomandate pentru alezare (în funcție de materialul semifabricatului și de calitatea plăcuței) – Metric

SMG	$v_c$ (m/min)										
	KX & HX	03	TP40	TP1501	TP2501	TP3501	TK0501	TK1501	TH1000	TH1500	CP500
P1			60-180	60-350	60-250	60-230					80-200
P2			60-180	60-350	60-250	60-230					80-200
P3			60-180	60-350	60-250	60-230					80-200
P4			60-180	60-350	60-250	60-230					80-200
P5			60-150	60-300	60-250	60-230					80-200
P6			60-140	60-300	60-230	60-200					80-180
P7			60-140	60-300	60-230	60-200					80-160
P8			60-120	60-250	60-230	60-200					80-130
P11			60-120	60-300	60-250	60-200					80-180
M1			60-130	100-200	60-200	60-200					60-160
M2			60-130	100-200	60-200	60-200					60-160
M3			60-120	100-180	60-200	60-200					60-150
M4			60-110	100-180	60-190	60-190					60-150
M5			60-110	100-180	60-180	60-180					60-150
K1			60-140	100-250		60-180	60-230	60-230			60-160
K2			60-140	100-250		60-180	60-230	60-230			60-160
K3			60-140	100-250		60-180	60-230	60-230			60-160
K4			60-140	100-250		60-180	60-200	60-200			60-160
K5			60-140	100-250		60-180	60-200	60-200			60-160
K6			60-130	100-250		60-180	60-200	60-200			60-160
K7			60-130	100-250		60-180	60-200	60-200			60-160
N1	150-800	150-800									150-800
N2	150-800	150-800									150-800
N3	150-500	150-500									150-500
N11	150-400	150-400									150-400
S1	20-50	20-50									20-50
S2	20-50	20-50									20-50
S3	20-50	20-50									20-50
S11	20-50	20-50									20-50
S12	20-50	20-50									20-50
S13	20-50	20-50									20-50
H3									50-150	50-150	
H5									50-140	50-140	
H7									50-150	50-150	
H8									30-130	30-130	
H11									30-120	30-120	
H12									30-120	30-120	
H21											
H31											

SMG = Grupa de material Seco  $v_c$  = m/min (sf/min) Toți parametri de așchiere reprezintă valori de pornire

## Vitezele de aşchiere recomandate pentru alezare (în funcție de materialul semifabricatului și de calitatea plăcuței) – inci

SMG	$v_c$ (sf/min)										
	KX & HX	03	TP40	TP1501	TP2501	TP3501	TK0501	TK1501	TH1000	TH1500	CP500
P1			197-591	197-1148	197-820	197-755					262-656
P2			197-591	197-1148	197-820	197-755					262-656
P3			197-591	197-1148	197-820	197-755					262-656
P4			197-591	197-1148	197-820	197-755					262-656
P5			197-492	197-984	197-820	197-755					262-656
P6			197-459	197-984	197-755	197-656					262-591
P7			197-459	197-984	197-755	197-656					262-525
P8			197-394	197-820	197-755	197-656					262-427
P11			197-394	197-984	197-820	197-656					262-591
M1			197-427	328-656	197-656	197-656					197-525
M2			197-427	328-656	197-656	197-656					197-525
M3			197-394	328-591	197-656	197-656					197-492
M4			197-361	328-591	197-623	197-623					197-492
M5			197-361	328-591	197-591	197-591					197-492
K1			197-459	328-820		197-591	197-755	197-755			197-525
K2			197-459	328-820		197-591	197-755	197-755			197-525
K3			197-459	328-820		197-591	197-755	197-755			197-525
K4			197-459	328-820		197-591	197-656	197-656			197-525
K5			197-459	328-820		197-591	197-656	197-656			197-525
K6			197-427	328-820		197-591	197-656	197-656			197-525
K7			197-427	328-820		197-591	197-656	197-656			197-525
N1	492-2625	492-2625									492-2625
N2	492-2625	492-2625									492-2625
N3	492-1640	492-1640									492-1640
N11	492-1312	492-1312									492-1312
S1	66-164	66-164									66-164
S2	66-164	66-164									66-164
S3	66-164	66-164									66-164
S11	66-164	66-164									66-164
S12	66-164	66-164									66-164
S13	66-164	66-164									66-164
H3									164-492	164-492	
H5									164-459	164-459	
H7									164-492	164-492	
H8									98-427	98-427	
H11									98-394	98-394	
H12									98-394	98-394	
H21											
H31											

SMG = Grupa de material Seco  $v_c = m/min$  (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

Vitezele de aşchiere recomandate pentru alezare (în funcție de materialul semifabricatului și de calitatea plăcuței) – Metric

SMG	v <sub>c</sub> (m/min)												
	26	25	TS2000	TP1020	TP1030	51	CBN10/ CBN010	81	CBN200	82	PCD20	91	Axiabore
P1	80-200	60-180		100-350	100-350	100-350							80-250
P2	80-200	60-180		100-350	100-350	100-350							80-250
P3	80-200	60-180		100-350	100-350	100-350							80-250
P4	80-200	60-180		100-350	100-350	100-350							80-250
P5	80-200	60-180		100-350	100-350	100-350							70-230
P6	80-180	60-160		100-300	100-300	100-300							70-230
P7	80-160	60-160		100-250	100-250	100-250							70-230
P8	80-130	60-130		100-250	100-250	100-250							70-200
P11	80-180	60-150		100-300	100-300	100-300							70-200
M1	60-160	60-140	60-200	80-200	80-200	80-200							60-200
M2	60-160	60-140	60-200	80-200	80-200	80-200							60-200
M3	60-150	60-130	60-200	80-200	80-200	80-200							60-180
M4	60-150	60-120	60-180	80-180	80-180	80-180							60-170
M5	60-150	60-120	60-180	80-180	80-180	80-180							60-170
K1	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K2	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K3	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-150
K4	60-160	60-160		100-250	100-250	100-250			300-1000	300-1000			60-130
K5	60-160	60-160		100-250	100-250	100-250							50-100
K6	60-160	60-160		100-180	100-180	100-180							50-100
K7	60-160	60-160		100-180	100-180	100-180							50-100
N1	150-800										300-1500	300-1500	200-800
N2	150-800										300-1500	300-1500	200-800
N3	150-500										200-800	200-800	200-800
N11	150-400										180-800	180-800	200-800
S1	20-50		20-80										20-60
S2	20-50		20-80										20-60
S3	20-50		20-80										60-50
S11	20-50		20-80										20-50
S12	20-50		20-80										20-50
S13	20-50		20-80										20-50
H3							80-180	80-180					
H5							80-200	80-200					
H7							80-150	80-150					
H8							80-150	80-150					
H11													
H12													
H21													
H31													

SMG = Grupa de material Seco V<sub>c</sub> = m/min (sf/min) Toți parametri de aşchiere reprezintă valori de pornire

## Vitezele de aşchiere recomandate pentru alezare (în funcție de materialul semifabricatului și de calitatea plăcuței) – inci

SMG	$v_c$ (sf/min)												
	26	25	TS2000	TP1020	TP1030	51	CBN10/ CBN010	81	CBN200	82	PCD20	91	Axiabore
P1	262-656	197-591		328-1148	328-1148	328-1148							262-820
P2	262-656	197-591		328-1148	328-1148	328-1148							262-820
P3	262-656	197-591		328-1148	328-1148	328-1148							262-820
P4	262-656	197-591		328-1148	328-1148	328-1148							262-820
P5	262-656	197-591		328-1148	328-1148	328-1148							230-755
P6	262-591	197-525		328-984	328-984	328-984							230-755
P7	262-525	197-525		328-820	328-820	328-820							230-755
P8	262-427	197-427		328-820	328-820	328-820							230-656
P11	262-591	197-492		328-984	328-984	328-984							230-656
M1	197-525	197-459	197-656	262-656	262-656	262-656							197-656
M2	197-525	197-459	197-656	262-656	262-656	262-656							197-656
M3	197-492	197-427	197-656	262-656	262-656	262-656							197-591
M4	197-492	197-394	197-591	262-591	262-591	262-591							197-558
M5	197-492	197-394	197-591	262-591	262-591	262-591							197-558
K1	197-525	197-525		328-820	328-820	328-820		984-3281	984-3281				197-492
K2	197-525	197-525		328-820	328-820	328-820		984-3281	984-3281				197-492
K3	197-525	197-525		328-820	328-820	328-820		984-3281	984-3281				197-492
K4	197-525	197-525		328-820	328-820	328-820		984-3281	984-3281				197-427
K5	197-525	197-525		328-820	328-820	328-820							164-328
K6	197-525	197-525		328-591	328-591	328-591							164-328
K7	197-525	197-525		328-591	328-591	328-591							164-328
N1	492-2625									984-4921	984-4921	656-2625	
N2	492-2625									984-4921	984-4921	656-2625	
N3	492-1640									656-2625	656-2625	656-2625	
N11	492-1312									591-2625	591-2625	656-2625	
S1	66-164		66-262										66-197
S2	66-164		66-262										66-197
S3	66-164		66-262										197-164
S11	66-164		66-262										66-164
S12	66-164		66-262										66-164
S13	66-164		66-262										66-164
H3						262-591	262-591						
H5						262-656	262-656						
H7						262-492	262-492						
H8						262-492	262-492						
H11													
H12													
H21													
H31													

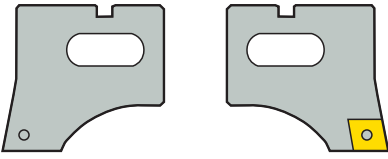
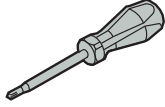

SMG = Grupa de material Seco  $v_c$  = m/min (sf/min) Toți parametri de achiere reprezintă valori de pornire

## Șuruburile de blocare a plăcuței și cheile pentru toate portplăcuțele, sculele și cartușele de alezare

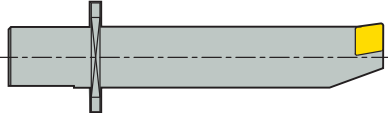
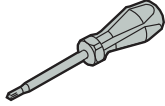

Piese de schimb specifice clemei de prindere pentru plăcuțele CN.. sunt arătate în pagina produsului portplăcuțe tip CN.. Piese de schimb pentru clema plăcuței pentru portplăcuțele de pe RB 610 sunt arătate în pagina portplăcuțe pentru capete RB 610, pag. 575.

Ține minte: Piese de schimb fac parte din pachetul de livrare original al portplăcuțelor, sculelor sau cartușelor.

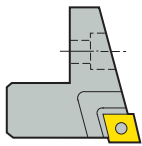
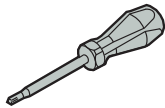

Accesorii nu fac parte din pachetul de livrare, ele trebuie să fie comandate separat.

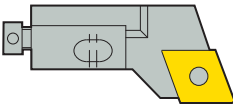
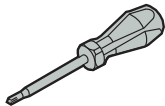

		Accesorii		Piese de schimb	
		Șurubelniță Torx pentru șurubul de blocare a plăcuței*		Șurubul de blocare a plăcuței	
					
Pentru portplăcuțe de alezare de degroșare	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
	CP...0502	T07P-3	07	C02245-T07P	07
	CC...0602	T07P-3	07	C02504-T07P	07
	CC...09T3	T15P-3	15	C04008-T15P	15
	CC...1204	T15P-3	15	C05012-T15P	15
	CC...1605	T15P-3	15	C05012-T15P	15
	SC...0502	T07P-3	07	C02245-T07P	07
	SC...0602	T07P-3	07	C02504-T07P	07
	SC...09T3	T15P-3	15	C04008-T15P	15
	SC...1204	T15P-3	15	C05012-T15P	15
SC...1505	T15P-3	15	C05012-T15P	15	

\* O cheie Torx este livrată împreună cu fiecare cap de alezare de degroșare.

		Accesorii		Piese de schimb	
		Șurubelniță Torx pentru șurubul de blocare a plăcuței*		Șurubul de blocare a plăcuței	
					
For Axiabore™ tip sculă	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
	WB...0301...	T06P-3	06	C02035-T06P	06
	CC...0602...	T07P-3	07	C02504-T07P	07
	-	T15P-3	15	C04008-T15P	15

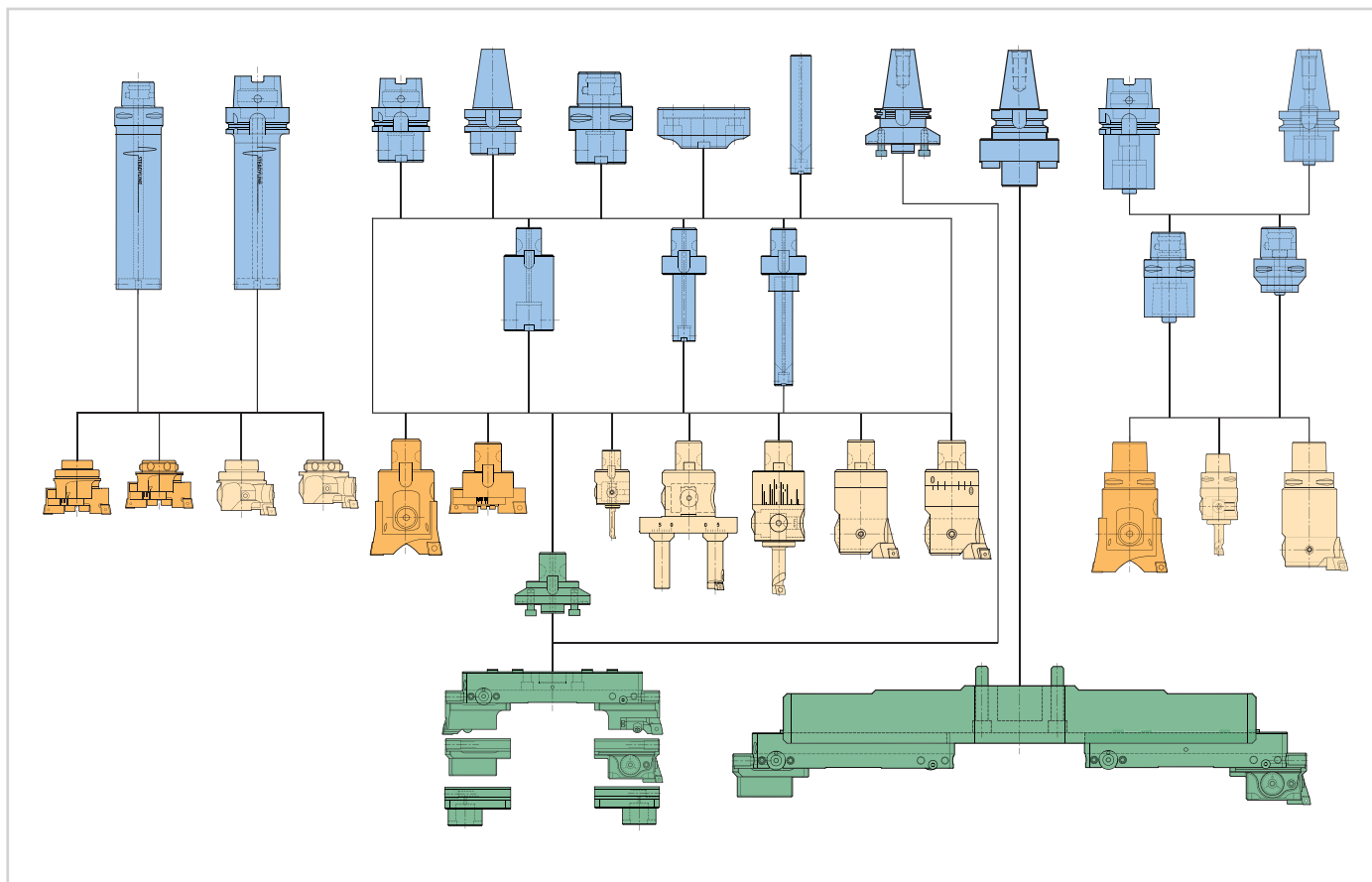
## Piese de schimb pentru portplăcuțe

		Piese de schimb			
		Cheie plăcuță		Șurub plăcuță	
					
Pentru portplăcuțe de alezare, portplăcuțe de șanfenare și portplăcuțe de alezare inversă	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
	WB...0301...	T06P-2	06	C02035-T06P	06
	CC...0602...	T07P-3	07	C02504-T07P	07
	CC...09T3...	T15P-3	15	C04008-T15P	15
TC...1102...	T07P-3	07	C02504-T07P	07	

		Accesorii		Piese de schimb	
		Șurubelniță Torx pentru șurubul de blocare a plăcuței*		Șurubul de blocare a plăcuței	
					
Pentru cartușe	Pentru dimensiunea plăcuței	Reper Nr.	Torx Plus	Reper Nr.	Torx Plus
	CC...16...	T15P-2	15	C05012-T15P	15
	SC...15...	T15P-2	15	C05012-T15P	15
	TC...16...	T15P-2	15	C03509-T15P	15
	TC...22...	T15P-2	15	C05012-T15P	15



## Portscule potrivite pentru capetele de alezare



## Capetele de alezare dispun de conexiune Graflex®, Seco-Capto™, GL sau BA pe partea utilajului

Capetele de alezare pot fi folosite în orice tip de mașină, împreună cu adaptoare potrivite Graflex® sau Seco-Capto™ sau bare antivibrație Steadylite® pentru alezare/strunjire.

### Amortizare a vibrațiilor Steadylite® pentru operații de alezare

Capetele de alezare cu conexiune GL sau BA pe partea utilajului sunt concepute pentru a fi montate pe barele de alezare/strunjire Steadylite® cu conexiune HSK-T/A și Seco-Capto™ pe partea utilajului. Se pot executa astfel operații de alezare de degroșare sau finisare cu console de 6xD, 8xD și 10xD în condiții foarte stabile.

### Bare de alezare modulare Graflex® și Seco-Capto™

Toate alezajele cu lungimea de 6xD pot fi executate cu intermediari Graflex®, ex. variantele extralungi din carbură. Cea mai bună stabilitate se obține alegând intermediarul cel mai lung și mai solid posibil, completând cu intermediare mai mici.

Conexiunile Graflex® și Seco-Capto™ garantează o orientare unică a capului de alezat, orientarea muchiei fiind în concordanță cu ISO. Modulele Graflex® sunt concepute să poată fi conectate împreună din lateral.

Pentru capete de alezare cu conexiune GL pe partea utilajului pentru Steadylite®, selectați cea mai scurtă bară Steadylite® din catalogul de port-scule. Aceste bare au spre mașină conexiune HSK-T/A și Seco-Capto™. Se pot echipa și alte tipuri de arbori utilizând cele mai scurte adaptoare Seco-Capto™.

Pentru capete de alezare clasice (oțel), selectați arborii și intermediarele Graflex® și Seco-Capto™ clasice din catalogul de port-scule.

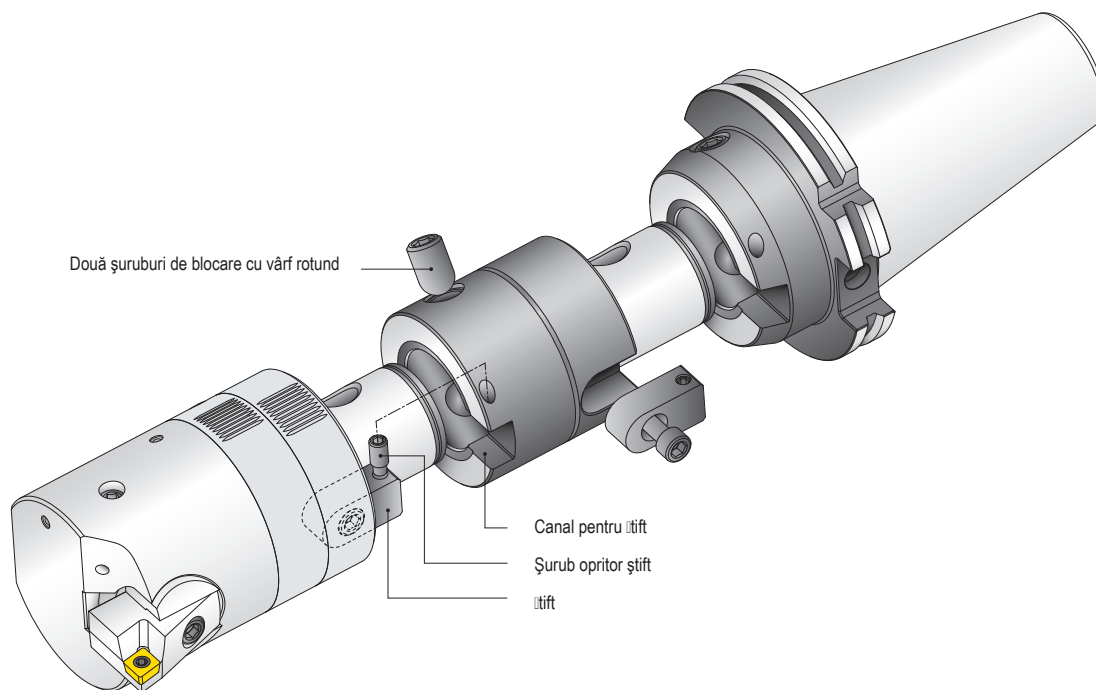
Pentru Bridge bars, vezi adaptorii și prinderi directe Graflex® la pag. 635.

**Notă!** Jumbo Bridge bar sunt concepute pentru prinderea într-o port-sculă de alezare sau direct în arborele mașinii.

## Instrucțiuni pentru blocarea cozilor G cu conexiune clasică Graflex® în capetele de alezare (utilizând un cep cu șurub opritor).

La alezare, nu este necesară strângerea șurubului opritor, deoarece conexiune este autoblocabilă.  
La degroșarea în condiții grele, se recomandă aplicarea unui cuplu de strângere mai mare pentru șuruburile cu vârf sferic din conexiunea Graflex®.

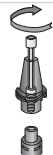
Consultați, de asemenea, „Procedura de asamblare cu conexiune Graflex®” din catalogul de port-scule.



**Instrucțiuni de blocare a conexiunii Seco-Capto™ cozi C. în capetele de alezat: Nu sunt necesare instrucțiuni specifice. Pentru capetele de alezat, se aplică instrucțiunile generale, vezi mai jos.**

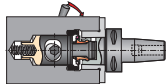
Cuplurile de strângere pentru conexiunile receptoarelor Seco-Capto™ cu prindere cu bolț central (port-scula de bază, intermediare).

Seco-Capto Mărimea	Cuplul de strângere bolț central (Nm)	Cuplul de strângere bolț central (ft/lbs)
C3	40-50	30-37
C4	50-60	37-44
C5	90-100	66-74
C6	160-180	118-133
C8	160-180	118-133



Cuplurile de strângere pentru conexiunile receptoarelor Seco-Capto™ cu prindere pe segment, acționate de blocare laterală a arborelui cu came (montare pe flanșă).

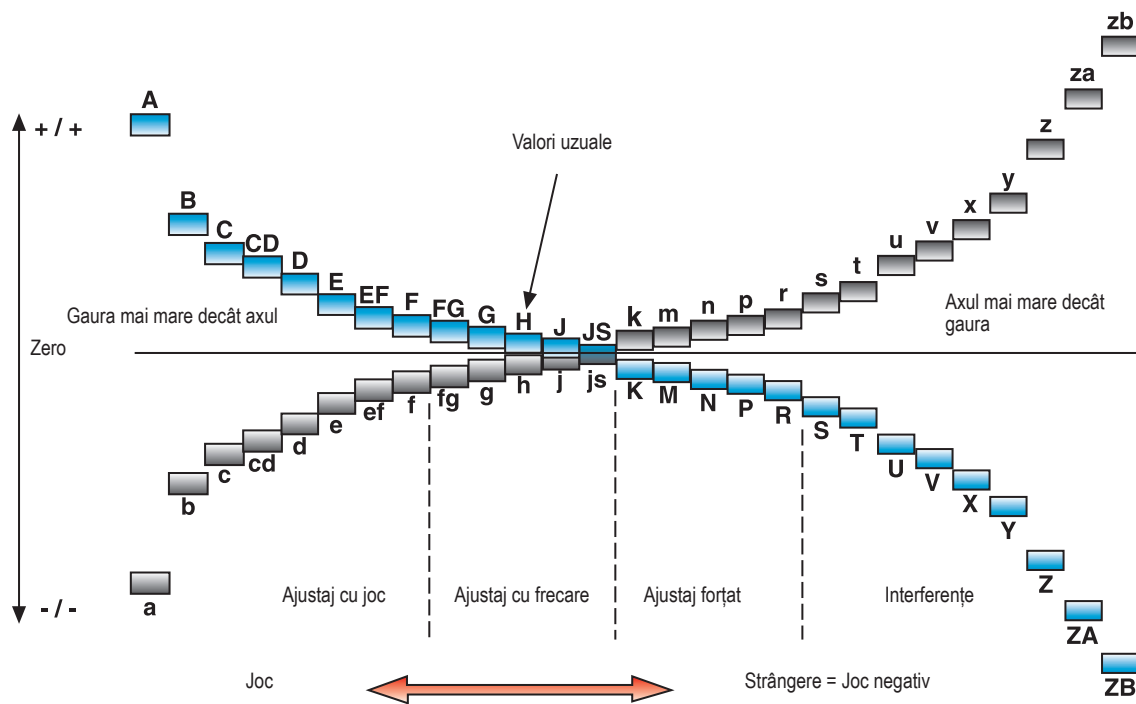
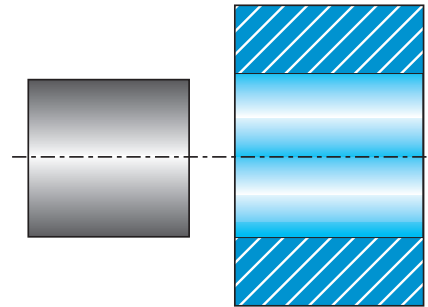
Seco-Capto Mărimea	Cuplul de strângere (Nm)	Cuplul de strângere (ft/lbs)
C3	35	26
C4	50	37
C5	70	52
C6	90	66
C8	130	96



Conexiunea Seco-Capto™ are un con cu autoblocare. Atunci când se utilizează sistemul cu bolț central, deșurubați bolțul central până când capul bolțului intră în contact cu port-scula, făcând ca bolțul să forțeze decuplarea conului. Atunci când se utilizează sistemul de cuplare lateral cu camă, decuplarea camei va forța decuplarea conului.

## Toleranțe standard ISO pentru gaură și ax - Toleranțele axului

Poziția toleranței axului este scrisă cu **litere mici**  
 Poziția toleranța găurii este scrisă cu **MAJUSCULE**



Introducere

Găurire

Alezare

Alezare adâncă

Anexă

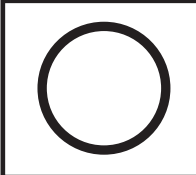
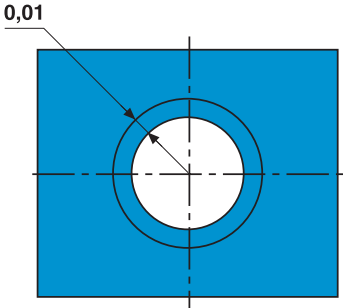

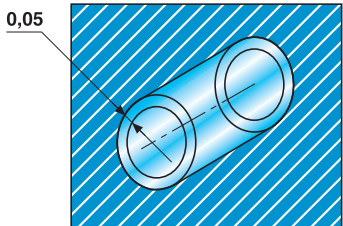

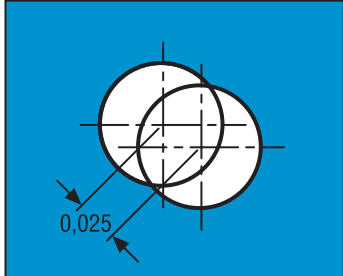
## Tabel de toleranțe ISO

Toleranțele ISO pentru găuri (μm)													
Gaură Ø mm (inci)	D10	E9	F7	F8	G7	G9	H6	H7	H8	H9	H10	H11	H12
≤ 3 (0.118")	+60 +20	+39 +14	+16 +6	+20 +6	+12 +2	+27 +2	+6 0	+10 0	+14 0	+25 0	+40 0	+60 0	+100 0
3 ≥ 6 (0.236")	+78 +30	+50 +20	+22 +10	+28 +10	+16 +4	+34 +4	+8 0	+12 0	+18 0	+30 0	+48 0	+75 0	+120 0
6 ≥ 10 (0.394")	+98 +40	+61 +25	+28 +13	+35 +13	+20 +5	+41 +5	+9 0	+15 0	+22 0	+36 0	+58 0	+90 0	+150 0
10 ≥ 18 (0.708")	+120 +50	+75 +32	+34 +16	+43 +16	+24 +6	+49 +6	+11 0	+18 0	+27 0	+43 0	+70 0	+110 0	+180 0
18 ≥ 30 (1.181")	+149 +65	+92 +40	+41 +20	+53 +20	+28 +7	+59 +7	+13 0	+21 0	+33 0	+52 0	+84 0	+130 0	+210 0
30 ≥ 50 (1.969")	+180 +80	+112 +50	+50 +25	+64 +25	+34 +9	+71 +9	+16 0	+25 0	+39 0	+62 0	+100 0	+160 0	+250 0
50 ≥ 65 (2.559")	+220 +100	+134 +60	+60 +30	+76 +30	+40 +10	-	+19 0	+30 0	+46 0	+74 0	+120 0	+190 0	+300 0
65 ≥ 80 (3.150")													
80 ≥ 100 (3.937")	+260 +120	+159 +72	+71 +36	+90 +36	+47 +12	-	+22 0	+35 0	+54 0	+87 0	+140 0	+220 0	+350 0
100 ≥ 120 (4.724")													
120 ≥ 140 (5.512")	+305 +145	+185 +85	+83 +43	+106 +43	+54 +14	-	+25 0	+40 0	+63 0	+100 0	+160 0	+250 0	+400 0
140 ≥ 160 (6.299")													
160 ≥ 180 (7.087")													
180 ≥ 200 (7.874")	+355 +170	+215 +110	+96 +50	+122 +50	+61 +15	-	+29 0	+46 0	+72 0	+115 0	+185 0	+290 0	+460 0
200 ≥ 225 (8.858")													
225 ≥ 250 (9.843")													
250 ≥ 280 (11.0236")	+400 +190	+240 +110	+108 +56	+137 +56	+69 +17	-	+32 0	+52 0	+81 0	+130 0	210 0	+320 0	+520 0
280 ≥ 315 (12.402")													
315 ≥ 355 (13.976")	+440 +210	+265 +125	+119 +62	+151 +62	+75 +18	-	+36 0	+57 0	+89 0	+140 0	+230 0	+360 0	+570 0
355 ≥ 400 (15.748")													

## Tabel de toleranțe ISO

Toleranțele ISO pentru găuri (μm)												
Gaură Ø mm (inci)	H13	JS7	JS9	K6	K7	M6	M7	N7	N9	P7	P9	R7
≤ 3 (0.118")	+140 0	+/-5	+/-12,5	0 -6	0 -10	-2 -8	-2 -12	-4 -14	-4 -29	-6 -16	-6 -31	-10 -20
3 ≥ 6 (0.236")	+180 0	+/-6	+/-15	+2 -6	+3 -9	-1 -9	0 -12	-4 -16	0 -30	-8 -20	-12 -42	-11 -23
6 ≥ 10 (0.394")	+220 0	+/-7,5	+/-18	+2 -7	+5 -10	-3 -12	0 -15	-4 -19	0 -36	-9 -24	-15 -51	-13 -28
10 ≥ 18 (0.708")	+270 0	+/-9	+/-21,5	+2 -9	+6 -12	-4 -15	0 -18	-5 -23	0 -43	-11 -29	-18 -61	-16 -34
18 ≥ 30 (1.181")	+330 0	+/-10,5	+/-26	+2 -11	+6 -15	-4 -17	0 -21	-7 -28	0 -52	-14 -35	-22 -74	-20 -41
30 ≥ 50 (1.969")	+390 0	+/-12,5	+/-31	+3 -13	+7 -18	-4 -20	0 -25	-8 -33	0 -62	-17 -42	-26 -88	-25 -50
50 ≥ 65 (2.559")	+460 0	+/-15	+/-37	+4 -15	+9 -21	-5 -24	0 -30	-9 -39	0 -74	-21 -51	-32 -106	-30 -62
65 ≥ 80 (3.150")												
80 ≥ 100 (3.937")	+260 +120	+159 +72	+71 +36	+90 +36	+47 +12	-	+22 0	+35 0	+54 0	+87 0	+140 0	+350 0
100 ≥ 120 (4.724")												
120 ≥ 140 (5.512")	+305 +145	+185 +85	+83 +43	+106 +43	+54 +14	-	+25 0	+40 0	+63 0	+100 0	+160 0	+400 0
140 ≥ 160 (6.299")												
160 ≥ 180 (7.087")												
180 ≥ 200 (7.874")	+355 +170	+215 +110	+96 +50	+122 +50	+61 +15	-	+29 0	+46 0	+72 0	+115 0	+185 0	+460 0
200 ≥ 225 (8.858")												
225 ≥ 250 (9.843")												
250 ≥ 280 (11.0236")	+400 +190	+240 +110	+108 +56	+137 +56	+69 +17	-	+32 0	+52 0	+81 0	+130 0	210 0	+520 0
280 ≥ 315 (12.402")												
315 ≥ 355 (13.976")	+440 +210	+265 +125	+119 +62	+151 +62	+75 +18	-	+36 0	+57 0	+89 0	+140 0	+230 0	+570 0
355 ≥ 400 (15.748")												

## Toleranța geometrică

	Simbol desen	Aria de toleranță
Circularitate	 0,01 mm (0.0004")	
Cilindricitate	 0,05 mm (0.0020")	
Localizarea pozițională	 0,05 mm (0.0020")	

## Oțeluri, oțeluri inoxidabile feritice și martensitice.

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
P1	Oțeluri cu așchiere ușoară	$360 < R_m < 880$	11 SMn30 $R_m = 385 \text{ N/mm}^2$	1500	0,14
P2	Oțeluri feritice slab aliate, $C < 0.25\%wt$ Oțeluri structurale generale slab aliate	$320 < R_m < 600$	S235JRG2 $R_m = 420 \text{ N/mm}^2$	1600	0,23
P3	Oțeluri feritice și ferito-perlitice, $C < 0.25\%wt$ Oțeluri structurale generale Oțeluri de cementare	$430 < R_m < 610$	16 MnCr 5 $R_m = 550 \text{ N/mm}^2$	1800	0,14
P4	Oțeluri structurale slab aliate, $0.25\% < C < 0.67\%wt$ Oțeluri slab aliate călite și temperate	$520 < R_m < 1200$	C 45E $R_m = 660 \text{ N/mm}^2$	2000	0,15
P5	Oțeluri structurale, $0.25\% < C < 0.67\%wt$ Oțeluri călite și revenite	$550 < R_m < 1200$	42 CrMo 4 $R_m = 700 \text{ N/mm}^2$	2020	0,18
P6	Oțeluri căliteslab aliate, $C > 0.67\%wt$ Oțeluri pentru arcuri și bile slab aliate	$520 < R_m < 1200$	C 100S $R_m = 600 \text{ N/mm}^2$	2100	0,17
P7	Oțeluri călite, $C > 0.67\%wt$ Oțeluri pentru arcuri și bile	$600 < R_m < 1200$	100 Cr 6 $R_m = 650 \text{ N/mm}^2$	2160	0,17
P8	Oțeluri pentru scule Oțeluri rapide (HSS)	$600 < R_m < 1200$	X 40 CrMoV 5 1 $R_m = 700 \text{ N/mm}^2$	2400	0,20
P11	Oțeluri inoxidabile feritice și martensitice	$415 < R_m < 1200$	X 20 Cr 13 $R_m = 675 \text{ N/mm}^2$	2000	0,15
P12	Oțeluri inoxidabile durificate prin precipitare	$500 < R_m < 1200$	X 5 CrNiCuNb 16 4 $R_m = 1100 \text{ N/mm}^2$	2100	0,17

## Oțeluri inoxidabile austenitice și duplex cu așchiere ușoară

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
M1	Oțeluri inoxidabile austenitice cu așchiere ușoară		X 10 CrNiS 18 9	1700	0,14
M2	Oțeluri inoxidabile austenitice slab aliate		X 5 CrNi 18 10	1920	0,18
M3	Oțeluri inoxidabile austenitice mediu aliate		X 2 CrNiMo 18 14 3	2070	0,17
M4	Oțeluri inoxidabile austenitice și duplex înalt aliate		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Oțeluri inoxidabile austenitice și duplex înalt aliate dificile		X 2 CrNiMoN 25 7 4	2510	0,13



## Fonte

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
K1	Fonte cenușii (GCI)		EN-GJL-250	930	0,32
K2	Fontă cu grafit compact (CGI)		EN-GJV-400	1000	0,35
K3	Fonte maleabile (MCI)		EN-GJMB-550-4	1050	0,37
K4	Fonte cu grafit nodular (SGI)		EN-GJS-500-7	1160	0,37
K5	Fonte ductiel călite (ADI)		EN-GJS-1000-5		
K6	Fontă cenușie austenitică cu grafit lamelar		EN-GJLA-XNiCuCr15-6-2		
K7	Fontă cenușie austenitică cu grafit nodular		EN-GJSA-XNiMn23-4		

## Metale neferoase

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
N1	Aliaje de aluminiu, Si < 9%		AW-7075		
N2	Aliaje de aluminiu, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Aliaje de aluminiu, Si > 16%		AISI17Cu5		
N11	Aliaje de cupru		CW614N	740	0,26

## Super aliaje și aliaje din titan

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
S1	Superaliaje pe bază de fier		Disalloy		
S2	Superaliaje pe bază de cobalt		Stellite 21		
S3	Superaliaje pe bază de nichel		Inconel 718	2530	0,21
S11	Titan, slab aliat, ( $\alpha$ )		Ti		
S12	Titan, mediu aliat, ( $\alpha+\beta$ )		TiAl6V4	1500	0,24
S13	Titan, înalt aliat, (similar $\beta$ și $\beta$ )		Ti10V2Fe3Al		

## Materiale dure

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
H3	Oțeluri tratat termic	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Oțeluri călite	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Oțeluri călite și temperate Oțeluri pentru rulmenți	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Oțeluri pentru scule Oțeluri rapide (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Oțeluri inoxidabile martensitice	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Oțeluri inoxidabile durificate prin precipitare	1200 < $R_m$ < 1650	X 5 CrNiCuNb 16 4 $R_m = 1450 \text{ N/mm}^2$	2410	0,17
H21	Oțel manganos	23 < HRC < 64	X 120 Mn 12 50 HRC		
H31	Fortă albă	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

## Alte materiale dificile

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
PM1	Materiale PM slab aliate		F-0008 Fe-0.7C		
PM2	Materiale PM mediu aliate		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	Materiale PM înalt aliate Materiale pentru scaunul supapei de evacuare, etc.				
HF1	Aliaje ecruisate Aliaje pe bază de fier sudate sau îmbinate cu plasmă				
HF2	Aliaje ecruisate Aliaje pe bază de cobalt și pe bază de nichel sudate sau îmbinate cu plasmă				
CC1	Carbură de tungsten sinterizată		G50		

## Plastic și compozite

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
TS1	Polimeri termoset		Uree formaldehidică (UF)		
TS2	Compozite termoset din fibră de carbon		T300 T700 T800 HTA-S IMA - Epoxy (M21)...		
TS3	Compozite termoset din fibră de sticlă		Epoxy - HX..(42..)E glass (7781...)...		
TS4	Compozite termoset din fibre aramide		Kevlar 49		
TP1	Polimeri termoplastici		Policarbonat (PC)		
TP2	Compozite termoplast din fibră de carbon		PPS/PEEK - T300..		
TP3	Compozite termoplast din fibră de sticlă		Sticlă PPS/PEEK - E sau sticlă A...		
TP4	Compozite termoplast din fibre aramide				

## Grafit

SMG	Descriere	Proprietăți	Reper	$k_{c1.1}$	$m_c$
GR1	Grafit		R 8500		

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS	
P1	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130	
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134	
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20				
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20				
	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922		
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400	
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460	
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150	
11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150		
S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311			
S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313			
S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414			
C 10	1.0301	1.0301	C 10	34 C 10, XC 10	045 M 10	C 10	S 10 C			G10100	
		1.0401	C 15	37 C 12, XC 18	080 M 15	C 15, C 16		1350		G10170	
C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450		G10200	
S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132			
C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16		1370		G10170	
		1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C			G10250	
		1.2162	21 MnCr 5	20 NC 5			SCR 420 H				
P3	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912		
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200	
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106	
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4				
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7				
	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511		G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5							
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)			G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H			
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3.5	1501-620 Gr. 27	14 CrMo 4 5		2216		
		1.7337	16 CrMo 4 4	15 CD 4.5	1501-620 Gr. 27	14 CrMo 4 5		2216			
10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218		J21890	
P4	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350	
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430	
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C			
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655		
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600	
			1.1157	40 Mn 4	35 M 5	150 M 36				G10390	
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300	
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340	
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420	
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640	
P5			1.1740	C 60 W	Y3 55			SK 7			
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090		
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4			T51620	
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901	
			1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206	
			1.5121	46 MnSi 4							
			1.5710	36 NiCr 6	35 NC 6	640 A 35			SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9		SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400	
	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400	
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCR 430 (H)		G51320	
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCR 440 (H)		G51400	
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300	
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400	
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400	
		1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240			
50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500		
41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065		
C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700		
C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950		
C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880			
		1.1645	C 105 W2	Y1 105		C 100 KU	SK 3				
		1.1663	C 125 W	Y2 120		C 120 KU	SK 2				

Introducere

Găuire

Alezare

Alezare acănă

Anexă

# SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiție	Structura
	1213				Recept	
	12 L 13				Recept	
	1108				Recept	
	11 L 08				Recept	
					Recept	
	1140	40			Recept	
	1146				Recept	
	1215				Recept	
	12 L 14				Recept	
		16D			Recept	
	A573 Grade 58	18kp	11 378		Recept	
	A573 Grade 70	St14kP	11 448		Recept	
	1010	10			Recept	
F.1110	1015	15			Recept	
	1020, 1023	20	12 024		Recept	
		17G1S	11 523		Recept	
F.1511	1015	15			Recept	
F.1120	1025	25			Recept	
					Recept	
	A204 Grade A		15 020		Recept	
	4520				Recept	
	3310, 9314	20X2H4A	16 420		Recept	
	4320		16 220		Recept	
					Recept	
F.1516	5115	12KHN2	14 220		Recept	
		18HG			Recept	
	5120	20KH	14 221		Recept	
	5120 H	20KH			Recept	
	A182-F11, A182-F12	12KHM	15 121		Recept	
	A387 Grade 12 Cl. 2				Recept	
F.155	A182-F22	12KH8	15 313		Recept	
F.1130	1035	35	12 040		Recept	
F.5110	1045	45	12 050		Recept	
	1040	40	12 041		Recept	
F.1150	1055	55			Recept	
	1060	60	12 061		Recept	
	1039	40G			Recept	
	1330	30G2			Recept	
F.1135	1035	35			Recept	
F.1140	1045	45	12 050		Recept	
F.1150	1064	60			Recept	
	1060	60			Recept	
F.144	9255	55S2			Recept	
F.1250	4135	35KHM			Recept	
F.5241	S1	5KHV2S			Recept	
	L6	5KHNV			Recept	
	5045				Recept	
	3135				Călit și temperat	
	3435				Recept	
	9840				Călit și temperat	
F.1280	4340	38H2N2MA	16 343		Recept	
	5132	35KH			Călit și temperat	
	5140	40H	14 140		Călit și temperat	
F.1251	4130	20KHM	15 130		Călit și temperat	
F.1252	4142, 4140	38HM	15 142		Recept	
F.1252	4142, 4140	38HM	15 142		Călit și temperat	
					Călit și temperat	
F.143	6150	50KHFA	15 260		Călit și temperat	
F.1740	A355 Cl. A				Recept	
F.5103	1070	70			Recept	
F.5117	1095				Recept	
F.5118	W1	U10A			Recept	
		U10			Recept	
	W1	U13			Recept	

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS	
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202	
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501	
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502	
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986	
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403	
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811	
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813	
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102	
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810	
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2		2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU			2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4			T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55		2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWW 09-08-04	BM 42	HS 2-9-1-8	SKH 51			T11342
HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCW 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3			T12004	
HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51		2722	T11302	
HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWW 09-04-02-02		HS 2-9-2	SKH 58		2782	T11307	
HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2			T12001	
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008	
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000	
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000	
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000	
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280	
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002	
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003	
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004	
	X 3 CrNiMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13 4	425 C 11	X 6 CrNi 13 04	SCS 5		2385	S41500
	X 18 CrNi 28	1.4749	1.4749	X 18 CrNi 28	Z 18 C 25					2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800	
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500	
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500	
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500	
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400	
	X 5 CrNiCuNb 17 4	1.4548	1.4548	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400	
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700	
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160	
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120	
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120	
M1	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890	
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890	
	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300	
	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403	
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400	
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600	
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700	
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100	
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200	
	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603	
M3	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653	
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453	
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700	
	X 9 CrNiSiN 21 11 2	1.4835	1.4893	X 9 CrNiSiN 21 11 2		310 S 31			2368	S30815	
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008	
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803	
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500	
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904	
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900	
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286	
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254	
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654	
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800	
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750	

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U.N.E./ I.H.A.	AIISI / ASTM	GOST	ČSN	Diverse Mărci	Condiție	Structura
F.520L	L2	11KHF			Recopt	
F.5220	O1	9KHVG			Recopt	
	O2	9G2F			Recopt	
F.5230	52100	SHKH15	14 109		Recopt	
F.5212	D3	KH12			Recopt	
	H11	4KH5MFS			Recopt	
F.5318	H13	4KH5MF1S			Recopt	
F.5227	A2	9KH5VF			Recopt	
	H10	3KH3M3F			Recopt	
F.5213		KH12			Recopt	
		KH12MF			Recopt	
F.520.S	L6	5KHNM			Recopt	
F.5613	M35	R6M5K5			Recopt	
	M42	R2AM9K5			Recopt	
	T4	R18K5F2			Recopt	
F.5603	M2	R6M5			Recopt	
	M7				Recopt	
	T1	R18			Recopt	
	403	08KH13			Recopt	Feritic
F.3401	410, CA-15	12KH13, 08KH13			Recopt	Martensitic
F.3113	430	12KH17			Recopt	Feritic
F.5261	420	20KH13	17 022		Recopt	Martensitic
F.3404	420	40KH13			Recopt	Martensitic
	440 A				Recopt	Martensitic
	440 B	95KH18			Recopt	Martensitic
	440 C	95KH18			Recopt	Martensitic
	A182 F6NM			F6NM	Recopt	Martensitic
	446	15KH28			Recopt	Feritic
	XM-13			PH 13-8 Mo	Normalizat în soluție	Austenitic
	XM-12			15-5 PH	H1150	Martensitic
	XM-12			15-5 PH	Normalizat în soluție	Martensitic
	XM-12			15-5 PH	H1025	Martensitic
	SAE 630			17-4 PH	H1150	Martensitic
	630			17-4 PH	Normalizat în soluție	Martensitic
	631	09KH17N7YU1		17-7 PH	Normalizat în soluție	Austenitic/Feritic
	AMS 6515			Marage 350	Normalizat în soluție	Martensitic
	AMS 6521			Marage 300	Normalizat în soluție	Martensitic
	AMS 6514			Marage 300, Vascomax C300	Normalizat în soluție	Martensitic
	AMS 6512			Marage 250	Normalizat în soluție	Martensitic
	AMS 6512			Marage 250, Vascomax C250	Normalizat în soluție	Martensitic
F.3508	303	12KH19N9			Recopt	Austenitic
F.3504	304 L	03KH18N11			Recopt	Austenitic
F.3504	304	08KH18N10	17 240		Recopt	Austenitic
F.3534	316	08KH17H13M2T	17 346		Recopt	Austenitic
F.3524	347	08KH18N12B			Recopt	Austenitic
F.3517	301	07KH16N6			Recopt	Austenitic
	302	12KH18N9			Recopt	Austenitic
F.3533	(316 L)	03KH17N14M3	17 349		Recopt	Austenitic
	316 LN	03KH16N15M3			Recopt	Austenitic
F.3541	304 LN	03KH18N11			Recopt	Austenitic
	317	08KH17H15M3T			Recopt	Austenitic
				253 MA	Recopt	Austenitic
	310 S	12KH25N20			Recopt	Austenitic
	329 LN			SAF 2205	Recopt	Duplex
				3RE60	Recopt	Duplex
	904L				Recopt	Super austenitic
	329				Recopt	Duplex
	660			A286	Normalizat în soluție	Austenitic
				254 SMO	Recopt	Super austenitic
				654 SMO	Recopt	Super austenitic
				Alloy 800	Recopt	Austenitic
	F 53			SAF 2507	Recopt	Super duplex

SMG

SMG	EN	EN-Nr	W-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS	
K1	EN-GJL-150	0.6150	0.6150	GG-15	Fl 15 D	Grade 150	G15	FC 150	01 15-00	F11601	
	EN-GJL-200	0.6200	0.6200	GG-20	Fl 20 D	Grade 220	G20	FC 200	01 20-00	F12101	
	EN-GJL-250	0.6250	0.6250	GG-25	Fl 25 D	Grade 260	G25	FC 250	01 25-00	F12401	
	EN-GJL-350	0.6350	0.6350	GG-35	Fl 35 D	Grade 350	G35	FC 350	01 35-00	F13502	
	EN-GJL-215			GG-220 HB					02 19		
K2	EN-GJV-300			GJV-300							
	EN-GJV-350			GJV-350							
	EN-GJV-400			GJV-400							
	EN-GJV-450			GJV-450							
	EN-GJV-500			GJV-500							
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130	
K4	EN-GJS-350-22	0.7033	0.7033	GGG-35.3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15		
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800	
	EN-GJS-400-18	0.7043	0.7043	GGG-40.3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800	
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800	
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100	
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800	
K5	EN-GJS-1000-5			GJS-1000-5						ADI grade 5	
	EN-GJS-1200-2			GJS-1200-2						ADI grade 2	
	EN-GJS-1400-1			GJS-1400-1						ADI grade 3	
	EN-GJS-800-8			GJS-800-8						ADI grade 4	
										ADI grade 1	
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002	
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004	
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000	
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00		
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000	
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010	
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003	
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006	
	AW-1050A	Al99.5	3.0255	Al99.5	A-5/1050A	1B		(A1050)	4007		AA1050A
AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355		AA2011	
AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338		AA2014	
AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106		AA5005	
AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103		AA6060	
AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107		AA6005	
AW-3103	AlMn1	3.0515	AlMn1		N3			4054		AA3103	
AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003			AA3003	
AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425		AA7020	
AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96			A7075		AA7075	
AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599		AC 4C	4244		
AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3						4251	A13800	
MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121					M11600	
MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)							
MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE					M12330	
AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9				4253	A13600	
AC-44200	AlSi12	3.2382	GD-AlSi12								
AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30				4212	AA6082	
N3	AlSi17Cu5							ADC14			
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200	
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500	
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600	
				CuNi10Zn45							
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1						C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700	
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700	
			2.1087	CuSn10Zn					5458	C90500	
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900	
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000	
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300	
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200	
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400	
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500	
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800	
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700	

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SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3 NiCr20Co13Mo4Ti3Al		2.4654							N07500 N07001
S11			3.7024							R54620
S12										R56320 R56400
	TiAl6V4		3.7164							
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
H7	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
H8	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoV 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
H11	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

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U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Diverse Mărci	Condiție	Structura
				Discalloy	Îmbătrânit	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Normalizat în soluție	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Pur comercial	Ti (α)
	AMS 4919			Ti 6-2-4-2	Recopt	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Recopt	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Recopt	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Recopt	Ti (β)
F.1516	5115	12KHN2	14 220		Cementat	
F.5103	1070	70			Călit și temperat	
F.5107	1078, 1080	75			Călit și temperat	
F.5117	1095				Călit și temperat	
F.5118	W1	U10A			Călit și temperat	
	S1	5KHV2SF			Călit și temperat	
	5155				Călit și temperat	
F.1252	4142, 4140	38HM	15 142		Călit și temperat	
F.520L	L2	11KHF			Călit și temperat	
F.5220	O1	9KHVG			Călit și temperat	
	O2	9G2F			Călit și temperat	
F.5230	52100	SHKH15	14 109		Călit și temperat	
F.5318	H13	4KH5MF1S			Călit și temperat	
F.5227	A2	9KH5VF			Călit și temperat	
F.5211	D2	KH12MF			Călit și temperat	
F.5213		KH12			Călit și temperat	
		KH12MF			Călit și temperat	
F.520.S	L6	5KHNM			Călit și temperat	
F.5613	M35	R6M5K5			Călit și temperat	
	M42	R2AM9K5			Călit și temperat	
	T1	R18			Călit și temperat	
F.5261	420	20KH13	17 022		Călit și temperat	Martensitic
	440 A				Călit și temperat	Martensitic
	440 B	95KH18			Călit și temperat	Martensitic
	440 C	95KH18			Călit și temperat	Martensitic
	XM-12			15-5 PH	H900	Martensitic
	SAE 630			17-4 PH	H1025	Martensitic
	SAE 630			17-4 PH	H900	Martensitic
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitic
	632			PH 15-7 Mo	TH1050	Martensitic
	660			A286	Îmbătrânit	Austenitic
	AMS 6512			Marage 250	Îmbătrânit	Martensitic
	AMS 6521			Marage 300	Îmbătrânit	Martensitic
	AMS 6521			Marage 300	Îmbătrânit	Martensitic
	AMS 6515			Marage 350	Îmbătrânit	Martensitic
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC)			Ni-Hard 2		Fontă albă
	A532 IA (NiCr-HC)			Ni-Hard 1		Fontă albă
	A532 ID (Ni-HiCr)			Ni-Hard 4		Fontă albă

## Plăcuțe amovibile și scule din carbură cementată

Plăcuțele amovibile cementate și sculele din carbură solidă de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerințe. Cu toate acestea, Seco Tools poate face următoarea declarație:

Aceste produse îndeplinesc toate cerințele în RoHS "Restriction of the use of certain Hazardous Substances in electrical and electronic equipment" (Restricționarea utilizării de anumite Substanțe Periculoase în echipamentele electronice și electrice) WEEE "Waste Electrical & Electronic Equipment" ( Deșeurile Electrice și Electronice) și ELV "End of Life Vehicles" (Sfârșitul duratei de viață a autovehiculelor)

Produsele nu conțin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenți în concentrații care depășesc limitele legale.

### Rectificare:

Rectificarea umedă sau uscată poate produce nori de praf și ceață care pot fi dăunătoare și pot irita pielea, ochii, nasul și gâtul care poate rezulta în afecțiuni ale plămânilor. Pentru a evita acestea folosiți echipamente și măsuri de protecție.

### Reciclare:

Seco Tools va cumpăra înapoi plăcuțele amovibile și sculele din carbură folosite, pentru reciclare. Plăcuțele amovibile trebuie să fie separate de alte reziduri de metale (oțel, aluminiu, cupru, etc).

Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

## Plăcuțe amovibile CBN și PCD

Plăcuțele amovibile de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerințe. Cu toate acestea, Seco Tools poate face următoarea declarație:

Aceste produse îndeplinesc toate cerințele în RoHS "Restriction of the use of certain Hazardous Substances in electrical and electronic equipment" (Restricționarea utilizării de anumite Substanțe Periculoase în echipamentele electronice și electrice) WEEE "Waste Electrical & Electronic Equipment" ( Deșeurile Electrice și Electronice) și ELV "End of Life Vehicles" (Sfârșitul duratei de viață a autovehiculelor)

Produsele nu conțin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenți în concentrații care depășesc limitele legale.

### Rectificare:

Rectificarea umedă sau uscată poate produce nori de praf și ceață care pot fi dăunătoare și pot irita pielea, ochii, nasul și gâtul care poate rezulta în afecțiuni ale plămânilor. Pentru a evita acestea folosiți echipamente și măsuri de protecție.

### Reciclare:

Seco Tools va cumpăra înapoi plăcuțele amovibile CBN și PCD folosite, pentru reciclare. Plăcuțele amovibile trebuie să fie separate de alte reziduri de metale (oțel, aluminiu, cupru, etc). Plăcuțele solide CBN pot fi prelucrate ca deșeurile ordinare.

Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

## Suporturi pentru plăcuțe din oxid negru

Sculele de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerințe. Cu toate acestea, Seco Tools poate face următoarea declarație:

Aceste produse îndeplinesc toate cerințele în RoHS "Restriction of the use of certain Hazardous Substances in electrical and electronic equipment" (Restricționarea utilizării de anumite Substanțe Periculoase în echipamentele electronice și electrice) WEEE "Waste Electrical & Electronic Equipment" ( Deșeurile Electrice și Electronice) și ELV "End of Life Vehicles" (Sfârșitul duratei de viață a autovehiculelor)

Produsele nu conțin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenți în concentrații care depășesc limitele legale.

### Reciclare:

Sculele pot fi trimise spre reciclare împreună cu alte reziduuri din oțel.

Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

## Plăcuțe amovibile Cermet

Plăcuțele amovibile de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerințe. Cu toate acestea, Seco Tools poate face următoarea declarație: Aceste produse întruiesc toate cerințele în RoHS "Restriction of the use of certain Hazardous Substances in electrical and electronic equipment" (Restricționarea utilizării de anumite Substanțe Periculoase în echipamentele electronice și electrice) WEEE "Waste Electrical & Electronic Equipment" ( Deșeuri Electrice și Electronice) și ELV "End of Life Vehicles" (Sfârșitul duratei de viață a autovehiculelor)

Plăcuțele cermet C15M conțin nichel și vor lăsa pete în contact cu pielea. Concentrația de nichel este mai mare decât cea specificată în norma SS-EN-1811, metoda de referință pentru produsele ce conțin nichel și sunt destinate pentru a veni în contact cu pielea în mod direct și prelungit. Aceste norme sunt destinate pentru produsele care vin în contact direct și prelungit cu pielea și de aceea nu sunt aplicabile pentru plăcuțele amovibile cermet. Persoanele care știu că au reacții alergice la contactul cu nichelul sunt sfătuiți să poarte mănuși protectoare când manipulează plăcuțele amovibile din cermet.

### Rectificare:

Rectificarea umedă sau uscată poate produce nori de praf și ceață care pot fi dăunătoare și pot irita pielea, ochii, nasul gâtul care poate rezulta în afecțiuni ale plămânilor. Pentru a evita acestea folosiți echipamente și măsuri de protecție.

### Reciclare:

Plăcuțele amovibile folosite pot fi reciclate. Plăcuțele amovibile trebuie să fie separate de alte reziduri de metale (oțel, aluminiu, cupru, etc) inclusiv plăcuțele din carbură. Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

## Scule acoperite cu nichel

Sculele de la Seco Tools nu sunt cuprinse în gama de produse la care se referă următoarele cerințe. Cu toate acestea, Seco Tools poate face următoarea declarație: Aceste produse întruiesc toate cerințele în RoHS "Restriction of the use of certain Hazardous Substances in electrical and electronic equipment" (Restricționarea utilizării de anumite Substanțe Periculoase în echipamentele electronice și electrice) WEEE "Waste Electrical & Electronic Equipment" ( Deșeuri Electrice și Electronice) și ELV "End of Life Vehicles" (Sfârșitul duratei de viață a autovehiculelor)

Produsele nu conțin mercur, plumb, crom hexavalent, cadmiu, CFC, HCFC, materiale ignifuge sau solvenți în concentrații care depășesc limitele legale.

Sculele conțin nichel și vor lăsa pete în contact cu pielea. Concentrația de nichel este mai mare decât cea specificată în norma SS-EN-1811, metoda de referință pentru produsele ce conțin nichel și sunt destinate pentru a veni în contact cu pielea în mod direct și prelungit.

Aceste norme sunt destinate pentru produsele care vin în contact direct și prelungit cu pielea și de aceea nu sunt aplicabile pentru sculele acoperite cu nichel. Persoanele care știu că au reacții alergice la contactul cu nichelul sunt sfătuiți să poarte mănuși protectoare când manipulează sculele acoperite cu nichel.

### Reciclare:

Sculele pot fi trimise spre reciclare împreună cu alte reziduuri din oțel.

Toate materialele în care sunt împachetate produsele Seco sunt reciclabile.

## Materialele din compoziția plăcuțelor amovibile

Calitate	Carbură cementată											Acoperirea						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
CP20	■				■				■			■			■			
CP200	■				■	■			■			■			■			
CP300	■	■	■	■	■				■			■			■			
CP500	■				■	■			■			■			■			
CP600	■				■	■			■			■			■			
C15M	■	■	■	■	■		■	■	■									
CF	■				■		■		■									
CM	■				■		■		■									
DP2000	■				■				■			■			■			
DP3000	■	■	■	■	■				■			■		■	■			
DS2050	■				■	■			■			■			■			
DS4050	■				■	■			■			■			■			■
F15M	■				■	■			■			■			■			
F25M	■	■	■	■	■				■			■			■			
F30M	■				■	■			■			■			■			
F40M	■				■	■			■			■			■			
HX	■		■		■				■			■			■			
H02	■		■		■				■			■			■			
H15	■				■				■			■			■			
H25	■				■				■			■			■			
KX	■				■				■			■			■			
MH1000	■				■				■			■			■			
MK1500	■		■		■				■			■			■			
MK2050	■		■		■				■			■			■		■	
MM4500	■				■				■			■			■			
MP1501	■		■	■	■				■			■			■			
MP2050	■				■				■		■	■			■			
MP2501	■		■	■	■				■			■			■			
MP3000	■				■	■			■			■			■			
MS2500	■		■	■	■				■			■			■			
MS2050	■				■				■			■			■			
RX1500	■		■		■		■	■	■			■			■			■
RX2000	■		■		■				■			■			■			
RM2020	■				■				■			■			■			
RM2090	■				■				■			■			■			
RN2010	■				■				■			■			■			
RS2090	■				■				■			■			■			
T350M	■		■	■	■				■			■			■			
T25M	■		■	■	■				■			■			■			
TGH1050	■				■				■			■			■			
TGK1500	■				■				■			■			■			
TGP25	■	■	■	■	■				■			■			■			
TGP35	■		■	■	■				■			■			■			
TGP45	■		■	■	■				■			■			■			
TGS2050	■				■				■			■			■			
TH1000	■				■				■			■			■			
TH1500	■				■				■			■			■			
TK0501	■				■				■			■			■			
TK1501	■		■		■				■			■			■			
TM1501	■	■	■	■	■				■			■			■			
TM2000	■	■	■	■	■				■			■			■			
TM2501	■	■	■	■	■				■			■			■			
TM3501	■				■				■			■			■			
TM4000	■	■	■	■	■				■			■			■			
TP0501	■	■	■	■	■				■			■			■			
TP1020	■	■	■	■	■				■			■			■			
TP1030	■	■	■	■	■				■			■			■			
TP1501	■	■	■	■	■				■			■			■			
TP25	■	■	■	■	■				■			■			■			
TP200	■	■	■	■	■				■			■			■			
TP2501	■	■	■	■	■				■			■			■			
TP3501	■	■	■	■	■				■			■			■			
TP40	■				■				■			■			■			
TS2000	■				■				■			■			■			
TS2050	■				■				■			■			■			
TS2500	■		■		■				■			■			■			
TTP2050	■				■				■			■			■			
T250D	■				■				■			■			■			
T400D	■				■				■			■			■			
T100R	■				■				■			■			■			
T60M	■	■	■	■	■				■			■			■			
883	■		■		■				■			■			■			
890	■				■	■			■			■			■			

Introducere

Găuire

Alezare

Alezare adâncă

Anexă

Această lucrare este publicată de Seco Tools și editorii ei cu scopul de a oferi informații generale și orientative referitoare la prelucrarea metalelor prin așchiere și știința și ingineria materialelor. Dacă se dorește un serviciu profesional pentru o aplicație specifică, vă putem oferi asistența unui specialist în domeniu.

Informațiile sunt oferite “ca atare”; Seco Tools și editorii săi declină toate declarațiile și garanțiile, exprimate sau implicite, inclusiv, fără a se limita, orice garanții de vandabilitate, potrivire pentru un anumit scop, titlu sau non-infringement. În nici un caz Seco Tools sau editorii săi nu poate fi răspunzător pentru daunele directe, indirecte, speciale sau de orice natură rezultate din utilizarea informațiilor, chiar dacă Seco Tools și editorii săi sunt informați despre posibilitatea unei astfel de daune.

Informațiile furnizate aici au scop informativ. Prețurile actualizate, specificațiile și descrierea produselor sunt finalizate în momentul vânzării și pot varia în funcție de locație. Informațiile furnizate aici pot fi modificate fără notificare prealabilă.

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