

HASSAS DELİK İŞLEME BARALARI İÇİN

Cutting Data for finis Boring tools / Schnittdaten für Fein Ausdrehwerkzeuge

	Malzeme / Material	HB	Vc	D 9-14	D 14-24	D 22-32	D 28-44	D 36-56	D 50-82	D 80-130
ÇELİKLER Stel / Stahl P	Karbonsuz Low carbon Steel / C-Stahl	80-125	120-180	0.04-0.08	0.05-0.10	0.06-0.11	0.05-0.13	0.05-0.15	0.06-0.15	0.08-0.20
	Düşük Karbonlu Low carbon Steel / C-Stahl	180-280	120-170	0.03-0.08	0.05-0.08	0.06-0.10	0.06-0.13	0.06-0.15	0.08-0.15	0.10-0.20
	Düşük Alaşım Low alloy Stel / Niderig legiettre Stahl	140-275	120-160	0.02-0.08	0.04-0.08	0.05-0.10	0.08-0.13	0.08-0.15	0.08-0.15	0.10-0.15
	Yüksek Alaşım High alloy Stel / Hoch legiettre Stahl	220-325	130-160	0.02-0.08	0.03-0.08	0.05-0.10	0.06-0.13	0.06-0.5	0.06-0.15	0.10-0.15
	Paslanmaz Austenite / Niro autenitisch (rostfrei)	135-275	110-150	0.03-0.04	0.04-0.07	0.04-0.07	0.05-0.10	0.05-0.13	0.05-0.15	0.10-0.15
	Döküm Grey cast iron / Grauguss	150-260	90-180	0.03-0.08	0.04-0.06	0.04-0.10	0.08-0.12	0.08-0.15	0.10-0.15	0.10-0.15
	Alüminyum Aluminium	30-150	130-230	0.03-0.10	0.05-0.10	0.05-0.13	0.07-0.15	0.07-0.15	0.10-0.15	0.10-0.15

KABA DELİK İŞLEME BARALARI İÇİN

Cutting Data for Boring tools for rough machining / Schnittdaten für Universal Ausbohröpfe

	Malzeme / Material	HB	Vc	D 9-14	D 14-24	D 22-32	D 28-44	D 36-56	D 50-82	D 80-130
ÇELİKLER Stel / Stahl P	Karbonsuz Low carbon Steel / C-Stahl	80-125	120-180	0.05-0.10	0.05-0.12	0.10-0.15	0.10-0.20	0.10-0.22	0.10-0.25	0.10-0.25
	Düşük Karbonlu Low carbon Steel / C-Stahl	180-280	120-160	0.05-0.10	0.05-0.12	0.10-0.15	0.10-0.20	0.10-0.22	0.10-0.25	0.10-0.25
	Düşük Alaşım Low alloy Stel / Niderig legiettre Stahl	140-275	120-160	0.05-0.10	0.05-0.10	0.10-0.15	0.10-0.20	0.10-0.22	0.10-0.25	0.10-0.25
	Yüksek Alaşım High alloy Stel / Hoch legiettre Stahl	220-325	130-160	0.05-0.10	0.05-0.10	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.25	0.10-0.25
	Paslanmaz Austenite / Niro autenitisch (rostfrei)	135-275	110-150	0.05-0.10	0.07-0.10	0.08-0.12	0.10-0.20	0.10-0.20	0.10-0.25	0.10-0.25
	Döküm Grey cast iron / Grauguss	150-260	90-180	0.08-0.10	0.084-0.10	0.10-0.20	0.10-0.20	0.10-0.25	0.10-0.25	0.10-0.25
	Alüminyum Aluminium	30-150	150-220	0.08-0.12	0.10-0.15	0.10-0.15	0.10-0.20	0.10-0.25	0.10-0.25	0.10-0.25

3D U-DRILL' LER İÇİN

Cutting Data for 3XD Insert Drills / Schnittdaten für 3xD Vollbohrer

	Malzeme / Material	HB	Vc	D 13-15	D 16-24	D 25-32	D 33-40	D 41-56	
ÇELİKLER Stel / Stahl P	Karbonsuz Low carbon Steel / C-Stahl	<0.15%C 0.15-0.45%C	80-170	120-220	0.04-0.08	0.05-0.10	0.05-0.10	0.04-0.10	0.08-0.12
	Düşük Karbonlu Low carbon Steel / C-Stahl	>=0.45%C	180-280	80-180	0.04-0.08	0.04-0.10	0.05-0.12	0.08-0.15	0.10-0.20
	Düşük Alaşım Low alloy Stel / Niderig legiettre Stahl		140-275	70-150	0.04-0.10	0.06-0.13	0.01-0.18	0.11-0.20	0.13-0.25
	Yüksek Alaşım High alloy Stel / Hoch legiettre Stahl		220-325	30-150	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.10-0.18
	Paslanmaz Austenite / Niro autenitisch (rostfrei)		135-275	50-130	0.04-0.08	0.04-0.10	0.06-0.12	0.08-0.14	0.10-0.18
			135-275	60-150	0.04-0.08	0.04-0.12	0.06-0.14	0.08-0.18	0.12-0.20
	Döküm Grey cast iron / Grauguss		150-220	130-220	0.04-0.12	0.06-0.14	0.08-0.18	0.10-0.20	0.12-0.25
	Alüminyum Aluminium		30-150	150-280	0.04-0.12	0.06-0.14	0.08-0.16	0.10-0.20	0.12-0.25