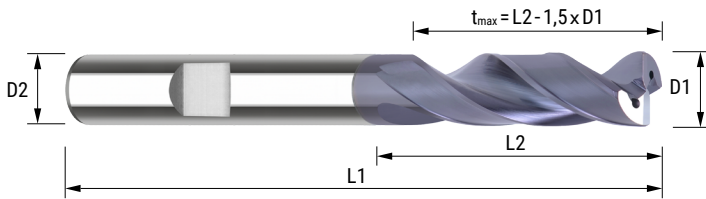


HP VHM - Flachbohrer mit Innenkühlung 3xD Solid carbide flat drill with internal coolant hole

NEW

817...



Werkzeugdaten / Tool data				Werkzeugempfehlung / Tool Recommendation		Einsatz / Capabilities										
TYP N	2	180°	4	IK	HA	HB	Norm	TIALN	Universal	z	3xD	i	i	i	i	i

D1 m7	D2 h6	L2	L1	Artikel-Nr./ Article-No.	HA	HB
3,00	6,00	20	62	817.030...	.00	.10
3,10	6,00	20	62	817.031...	.00	.10
3,20	6,00	20	62	817.032...	.00	.10
3,30	6,00	20	62	817.033...	.00	.10
3,40	6,00	20	62	817.034...	.00	.10
3,50	6,00	20	62	817.035...	.00	.10
3,60	6,00	20	62	817.036...	.00	.10
3,70	6,00	20	62	817.037...	.00	.10
3,80	6,00	24	66	817.038...	.00	.10
3,90	6,00	24	66	817.039...	.00	.10
4,00	6,00	24	66	817.040...	.00	.10
4,10	6,00	24	66	817.041...	.00	.10
4,20	6,00	24	66	817.042...	.00	.10
4,30	6,00	24	66	817.043...	.00	.10
4,40	6,00	24	66	817.044...	.00	.10
4,50	6,00	24	66	817.045...	.00	.10
4,60	6,00	24	66	817.046...	.00	.10
4,65	6,00	24	66	817.465...	.00	.10
4,70	6,00	24	66	817.047...	.00	.10
4,80	6,00	28	66	817.048...	.00	.10
4,90	6,00	28	66	817.049...	.00	.10
5,00	6,00	28	66	817.050...	.00	.10
5,10	6,00	28	66	817.051...	.00	.10
5,20	6,00	28	66	817.052...	.00	.10
5,30	6,00	28	66	817.053...	.00	.10
5,40	6,00	28	66	817.054...	.00	.10
5,50	6,00	28	66	817.055...	.00	.10
5,55	6,00	28	66	817.555...	.00	.10
5,60	6,00	28	66	817.056...	.00	.10
5,70	6,00	28	66	817.057...	.00	.10
5,80	6,00	28	66	817.058...	.00	.10
5,90	6,00	28	66	817.059...	.00	.10
6,00	6,00	28	66	817.060...	.00	.10
6,10	8,00	34	79	817.061...	.00	.10
6,20	8,00	34	79	817.062...	.00	.10
6,30	8,00	34	79	817.063...	.00	.10
6,40	8,00	34	79	817.064...	.00	.10
6,50	8,00	34	79	817.065...	.00	.10
6,60	8,00	34	79	817.066...	.00	.10
6,70	8,00	34	79	817.067...	.00	.10
6,80	8,00	34	79	817.068...	.00	.10
6,90	8,00	34	79	817.069...	.00	.10
7,00	8,00	34	79	817.070...	.00	.10
7,10	8,00	41	79	817.071...	.00	.10
7,20	8,00	41	79	817.072...	.00	.10
7,30	8,00	41	79	817.073...	.00	.10
7,40	8,00	41	79	817.074...	.00	.10
7,50	8,00	41	79	817.075...	.00	.10
7,60	8,00	41	79	817.076...	.00	.10
7,70	8,00	41	79	817.077...	.00	.10



HP VHM - Flachbohrer mit Innenkühlung 3xD Solid carbide flat drill with internal coolant hole

NEW

817...



Werkzeugdaten / Tool data				Werkzeugempfehlung / Tool Recommendation		Einsatz / Capabilities											
TYP N	z	180°	TK	HA	HB	Norm	TIALN	Universal	z	3xD	41	41	41	41	41	41	41
D1 m7	D2 h6	L2	L1	Artikel-Nr./ Article-No.	HA	HB											
7,80	8,00	41	79	817.078...	.00	.10											
7,90	8,00	41	79	817.079...	.00	.10											
8,00	8,00	41	79	817.080...	.00	.10											
8,10	10,00	47	89	817.081...	.00	.10											
8,20	10,00	47	89	817.082...	.00	.10											
8,30	10,00	47	89	817.083...	.00	.10											
8,40	10,00	47	89	817.084...	.00	.10											
8,50	10,00	47	89	817.085...	.00	.10											
8,60	10,00	47	89	817.086...	.00	.10											
8,70	10,00	47	89	817.087...	.00	.10											
8,80	10,00	47	89	817.088...	.00	.10											
8,90	10,00	47	89	817.089...	.00	.10											
9,00	10,00	47	89	817.090...	.00	.10											
9,10	10,00	47	89	817.091...	.00	.10											
9,20	10,00	47	89	817.092...	.00	.10											
9,30	10,00	47	89	817.093...	.00	.10											
9,40	10,00	47	89	817.094...	.00	.10											
9,50	10,00	47	89	817.095...	.00	.10											
9,60	10,00	47	89	817.096...	.00	.10											
9,70	10,00	47	89	817.097...	.00	.10											
9,80	10,00	47	89	817.098...	.00	.10											
9,90	10,00	47	89	817.099...	.00	.10											
10,00	10,00	47	89	817.100...	.00	.10											
10,10	12,00	55	102	817.101...	.00	.10											
10,20	12,00	55	102	817.102...	.00	.10											
10,30	12,00	55	102	817.103...	.00	.10											
10,40	12,00	55	102	817.104...	.00	.10											
10,50	12,00	55	102	817.105...	.00	.10											
10,60	12,00	55	102	817.106...	.00	.10											
10,70	12,00	55	102	817.107...	.00	.10											
10,80	12,00	55	102	817.108...	.00	.10											
10,90	12,00	55	102	817.109...	.00	.10											
11,00	12,00	55	102	817.110...	.00	.10											
11,10	12,00	55	102	817.111...	.00	.10											
11,20	12,00	55	102	817.112...	.00	.10											
11,30	12,00	55	102	817.113...	.00	.10											
11,40	12,00	55	102	817.114...	.00	.10											
11,50	12,00	55	102	817.115...	.00	.10											
11,60	12,00	55	102	817.116...	.00	.10											
11,70	12,00	55	102	817.117...	.00	.10											
11,80	12,00	55	102	817.118...	.00	.10											
11,90	12,00	55	102	817.119...	.00	.10											
12,00	12,00	55	102	817.120...	.00	.10											
12,50	14,00	60	107	817.125...	.00	.10											
12,80	14,00	60	107	817.128...	.00	.10											
13,00	14,00	60	107	817.130...	.00	.10											
13,50	14,00	60	107	817.135...	.00	.10											
13,80	14,00	60	107	817.138...	.00	.10											
14,00	14,00	60	107	817.140...	.00	.10											
14,50	16,00	65	115	817.145...	.00	.10											
14,80	16,00	65	115	817.148...	.00	.10											
15,00	16,00	65	115	817.150...	.00	.10											
15,50	16,00	65	115	817.155...	.00	.10											
15,80	16,00	65	115	817.158...	.00	.10											
16,00	16,00	65	115	817.160...	.00	.10											
16,50	18,00	73	123	817.165...	.00	.10											

HP VHM - Flachbohrer mit Innenkühlung 3xD Solid carbide flat drill with internal coolant hole



817...



Werkzeugdaten / Tool data				Werkzeugempfehlung / Tool Recommendation		Einsatz / Capabilities				
D1 m7	D2 h6	L2	L1	Artikel-Nr./ Article-No.						
16,80	18,00	73	123	817.168...	.00	.10				
17,00	18,00	73	123	817.170...	.00	.10				
17,50	18,00	73	123	817.175...	.00	.10				
17,80	18,00	73	123	817.178...	.00	.10				
18,00	18,00	73	123	817.180...	.00	.10				
18,50	20,00	79	131	817.185...	.00	.10				
18,80	20,00	79	131	817.188...	.00	.10				
19,00	20,00	79	131	817.190...	.00	.10				
19,50	20,00	79	131	817.195...	.00	.10				
19,80	20,00	79	131	817.198...	.00	.10				
20,00	20,00	79	131	817.200...	.00	.10				

Vorschubfaktor für f [mm/U] beim Anbohren/ Feed rate factor f (mm per turn) during spot drilling

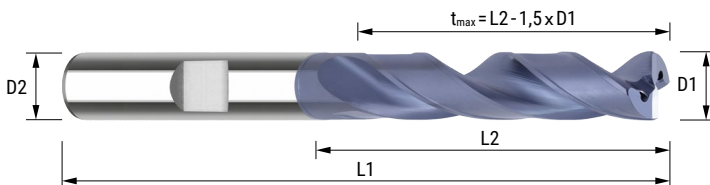
Neigung Werkstückoberfläche/ Pitch of component part surface	Faktor/ Factor
0°	0,4
15°	0,25
30°	nicht empfehlenswert / not recommendable
45°	nicht empfehlenswert / not recommendable

Beim Anbohren auf eine Länge von 0,25xD1 den Vorschub [mm/U] mit dem Faktor multiplizieren.

Multiply feed rate f (mm per turn) with the factor during spot drilling to a length of 0.25xD1.

HP VHM - Flachbohrer mit Innenkühlung 5xD Solid carbide flat drill with internal coolant hole

818...



Werkzeugdaten / Tool data				Werkzeugempfehlung / Tool Recommendation		Einsatz / Capabilities					
D1 m7	D2 h6	L2	L1	EF	Artikel-Nr./ Article-No.						
3,00	6,00	28	66	0,15	818.030...	.00	.10				
3,10	6,00	28	66	0,16	818.031...	.00	.10				
3,20	6,00	28	66	0,16	818.032...	.00	.10				
3,30	6,00	28	66	0,17	818.033...	.00	.10				
3,40	6,00	28	66	0,17	818.034...	.00	.10				
3,50	6,00	28	66	0,18	818.035...	.00	.10				
3,60	6,00	28	66	0,18	818.036...	.00	.10				
3,70	6,00	28	66	0,19	818.037...	.00	.10				
3,80	6,00	36	74	0,19	818.038...	.00	.10				
3,90	6,00	36	74	0,20	818.039...	.00	.10				
4,00	6,00	36	74	0,20	818.040...	.00	.10				
4,10	6,00	36	74	0,21	818.041...	.00	.10				
4,20	6,00	36	74	0,21	818.042...	.00	.10				
4,30	6,00	36	74	0,22	818.043...	.00	.10				
4,40	6,00	36	74	0,22	818.044...	.00	.10				
4,50	6,00	36	74	0,23	818.045...	.00	.10				

