

NEW

PTC - 3 x d - 6 x d

ANWENDUNGSEMPFEHLUNG

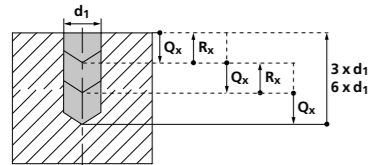
● Sehr gut geeignet | ● Gut geeignet | ○ bedingt geeignet | ☒ Nicht empfohlen

| | | |
|---|----------------|----------------|
| P | N | S ₃ |
| M | S ₁ | H ₁ |
| K | S ₂ | H ₂ |

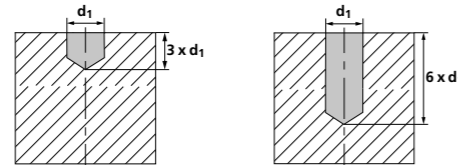
BOHREN MIT INNENKÜHLUNG | SCHNITTDATENÜBERSICHT

| Werkstoffgruppe | Werkstoff | Wr.Nr. | DIN | AISI/ASTM/UNS | v _c [m/min] | | Q _s [mm] | R _s [mm] | f [mm/U] | | | | | | | | | | | | | | | | | |
|-----------------|-----------|--------|---------|-----------------|------------------------|------|---------------------|---------------------|----------|-------|---------|-------|-----------------|-------|--------|-------|------------------------|-------|----------------|-------|-----------------|-------|-------------------------|-------|----------------|-------|
| | | | | | Mittel | Hoch | 0.2 - 0.5 x d1 | 0.2 - 0.5 x d1 | 1.0 mm | | 1.25 mm | | 1.5 mm 1/16" | | 2.0 mm | | Ød1 2.5 mm 3/32" | | 3.0 mm 1/8" | | 4.0 mm 5/32" | | 5.0 mm 3/16" - 7/32" | | 6.0 mm 1/4" | |
| | | | | | | | | | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch | Mittel | Hoch |
| S ₂ | Reintitan | 3.7035 | Ti Gr.2 | ASTM B348 / F67 | | | 0.2 - 0.5 x d1 | 0.2 - 0.5 x d1 | | | | | | | | | | | | | | | | | | |
| | | 3.7065 | Ti Gr.4 | ASTM B348 / F68 | 30 | 60 | - | - | 0.010 | 0.020 | 0.013 | 0.025 | 0.015 | 0.030 | 0.020 | 0.040 | 0.025 | 0.050 | 0.030 | 0.055 | 0.040 | 0.070 | 0.050 | 0.080 | 0.060 | 0.090 |

Für Ti Gr.2



Für Ti Gr.4



Spanbruchzyklus (z.B.: G73)