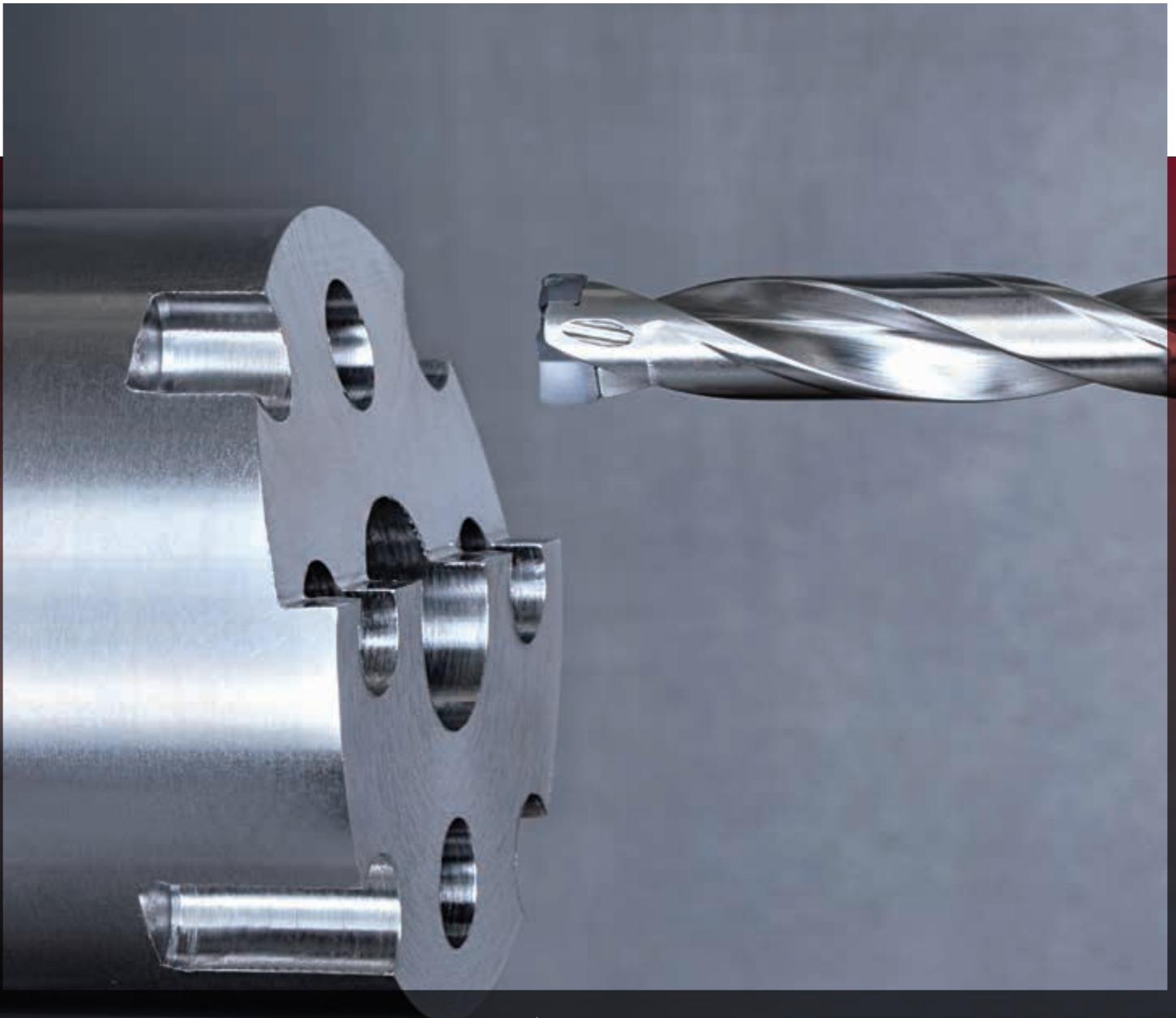


Auswechselbarer Bohrkopf

DRILLMEISTER

Tungaloy-Bericht Nr. 412S6-G

Erweiterungen der Bohrköpfe DMF und DMP
mit neuen Durchmessern und AH9130





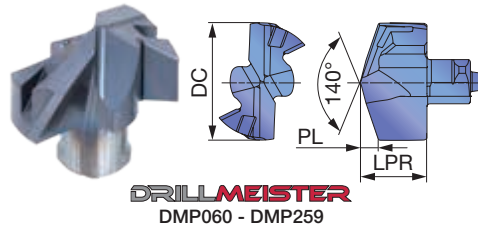
weitere Infos

BOHRKÖPFE

DMP Universeller Einsatzbereich



ADD M WITH DRILL
DMP040 - DMP059



DRILLMEISTER
DMP060 - DMP259

Werkzeug Durchmesser	Toleranz beim Kopf-Ø
ø4 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0

P	Stahl	☆	★
M	Rostfreier Stahl	☆	★
K	Gusseisen	☆	★
N	Nichteisenmetalle	☆	★
S	Superlegierungen	☆	★
H	Harte Materialien	☆	★

P	Stahl	☆	★
M	Rostfreier Stahl	☆	★
K	Gusseisen	☆	★
N	Nichteisenmetalle	☆	★
S	Superlegierungen	☆	★
H	Harte Materialien	☆	★

★ : Erste Wahl
☆ : Zweite Wahl

Bezeichnung	DC	LPR	beschichtet		PL	Halter
			AH725	AH9130		
DMP040	4	3.1	●		0.62	TID*040...
DMP041	4.1	3.1	●		0.64	TID*040...
DMP042	4.2	3.1	●		0.66	TID*040...
DMP043	4.3	3.1	●		0.67	TID*040...
DMP044	4.4	3.1	●		0.69	TID*040...
DMP045	4.5	3.55	●		0.66	TID*045...
DMP046	4.6	3.55	●		0.68	TID*045...
DMP047	4.7	3.55	●		0.70	TID*045...
DMP048	4.8	3.55	●		0.71	TID*045...
DMP049	4.9	3.55	●		0.73	TID*045...
DMP050	5	3.7	●		0.73	TID*050...
DMP051	5.1	3.7	●		0.75	TID*050...
DMP052	5.2	3.7	●		0.77	TID*050...
DMP053	5.3	3.7	●		0.78	TID*050...
DMP054	5.4	3.7	●		0.8	TID*050...
DMP055	5.5	3.85	●		0.81	TID*055...
DMP056	5.6	3.85	●		0.83	TID*055...
DMP057	5.7	3.85	●		0.85	TID*055...
DMP058	5.8	3.85	●		0.86	TID*055...
DMP059	5.9	3.85	●		0.88	TID*055...
DMP060	6	3.85	●	●	1.09	TID*060...
DMP061	6.1	3.85	●	●	1.11	TID*060...
DMP062	6.2	3.85	●	●	1.13	TID*060...
DMP063	6.3	3.85	●	●	1.14	TID*060...
DMP064	6.4	3.85	●	●	1.16	TID*060...
DMP065	6.5	4.15	●	●	1.27	TID*065...
DMP066	6.6	4.15	●	●	1.29	TID*065...
DMP067	6.7	4.15	●	●	1.31	TID*065...
DMP068	6.8	4.15	●	●	1.33	TID*065...
DMP069	6.9	4.15	●	●	1.34	TID*065...
DMP070	7	4.45	●	●	1.03	TID*070...
DMP071	7.1	4.45	●	●	1.05	TID*070...
DMP072	7.2	4.45	●	●	1.07	TID*070...
DMP073	7.3	4.45	●	●	1.08	TID*070...
DMP074	7.4	4.45	●	●	1.1	TID*070...
DMP075	7.5	4.45	●	●	1.12	TID*075...
DMP076	7.6	4.45	●	●	1.14	TID*075...

Bezeichnung	DC	LPR	beschichtet		PL	Halter
			AH725	AH9130		
DMP077	7.7	4.45	●	●	1.16	TID*075...
DMP078	7.8	4.45	●	●	1.18	TID*075...
DMP079	7.9	4.45	●	●	1.19	TID*075...
DMP080	8	5.25	●	●	1.2	TID*080...
DMP081	8.1	5.25	●	●	1.22	TID*080...
DMP082	8.2	5.25	●	●	1.24	TID*080...
DMP083	8.3	5.25	●	●	1.25	TID*080...
DMP084	8.4	5.25	●	●	1.27	TID*080...
DMP085	8.5	5.25	●	●	1.29	TID*085...
DMP086	8.6	5.25	●	●	1.31	TID*085...
DMP087	8.7	5.25	●	●	1.33	TID*085...
DMP088	8.8	5.25	●	●	1.35	TID*085...
DMP089	8.9	5.25	●	●	1.36	TID*085...
DMP090	9	5.65	●	●	1.37	TID*090...
DMP091	9.1	5.65	●	●	1.39	TID*090...
DMP092	9.2	5.65	●	●	1.41	TID*090...
DMP093	9.3	5.65	●	●	1.42	TID*090...
DMP094	9.4	5.65	●	●	1.44	TID*090...
DMP095	9.5	5.65	●	●	1.46	TID*095...
DMP096	9.6	5.65	●	●	1.48	TID*095...
DMP097	9.7	5.65	●	●	1.5	TID*095...
DMP098	9.8	5.65	●	●	1.52	TID*095...
DMP099	9.9	5.65	●	●	1.53	TID*095...
DMP100	10	6.05	●	●	1.47	TID*100...
DMP101	10.1	6.05	●	●	1.49	TID*100...
DMP102	10.2	6.05	●	●	1.51	TID*100...
DMP103	10.3	6.05	●	●	1.52	TID*100...
DMP104	10.4	6.05	●	●	1.54	TID*100...
DMP105	10.5	6.05	●	●	1.56	TID*105...
DMP106	10.6	6.05	●	●	1.58	TID*105...
DMP107	10.7	6.05	●	●	1.6	TID*105...
DMP108	10.8	6.05	●	●	1.62	TID*105...
DMP109	10.9	6.05	●	●	1.63	TID*105...
DMP110	11	6.45	●	●	1.67	TID*110...
DMP111	11.1	6.45	●	●	1.69	TID*110...
DMP112	11.2	6.45	●	●	1.71	TID*110...
DMP113	11.3	6.45	●	●	1.72	TID*110...

ø4 - ø19.9 = 2 Stück pro Paket
ø20 - ø25.9 = 1 Stück pro Paket

● : Lagerstandard

P	Stahl	☆	★
M	Rostfreier Stahl	☆	★
K	Gusseisen	☆	★
N	Nichteisenmetalle	☆	★
S	Superlegierungen	☆	★
H	Harte Materialien	☆	★

P	Stahl	☆	★
M	Rostfreier Stahl	☆	★
K	Gusseisen	☆	★
N	Nichteisenmetalle	☆	★
S	Superlegierungen	☆	★
H	Harte Materialien	☆	★

★ : Erste Wahl
☆ : Zweite Wahl

Bezeichnung	DC	LPR	beschichtet		PL	Halter
			AH725	AH9130		
DMP114	11.4	6.45	●	●	1.74	TID*110...
DMP115	11.5	6.45	●	●	1.76	TID*115...
DMP116	11.6	6.45	●	●	1.78	TID*115...
DMP117	11.7	6.45	●	●	1.8	TID*115...
DMP118	11.8	6.45	●	●	1.82	TID*115...
DMP119	11.9	6.45	●	●	1.83	TID*115...
DMP120	12	6.8	●	●	1.82	TID*120...
DMP121	12.1	6.8	●	●	1.84	TID*120...
DMP122	12.2	6.8	●	●	1.86	TID*120...
DMP123	12.3	6.8	●	●	1.87	TID*120...
DMP124	12.4	6.8	●	●	1.89	TID*120...
DMP125	12.5	6.8	●	●	1.91	TID*125...
DMP126	12.6	6.8	●	●	1.93	TID*125...
DMP127	12.7	6.8	●	●	1.95	TID*125...
DMP128	12.8	6.8	●	●	1.97	TID*125...
DMP129	12.9	6.8	●	●	1.98	TID*125...
DMP130	13	7.4	●	●	1.96	TID*130...
DMP131	13.1	7.4	●	●	1.98	TID*130...
DMP132	13.2	7.4	●	●	2	TID*130...
DMP133	13.3	7.4	●	●	2.01	TID*130...
DMP134	13.4	7.4	●	●	2.03	TID*130...
DMP135	13.5	7.4	●	●	2.05	TID*135...
DMP136	13.6	7.4	●	●	2.07	TID*135...
DMP137	13.7	7.4	●	●	2.09	TID*135...
DMP138	13.8	7.4	●	●	2.11	TID*135...
DMP139	13.9	7.4	●	●	2.12	TID*135...
DMP140	14	7.95	●	●	2.12	TID*140...
DMP141	14.1	7.95	●	●	2.14	TID*140...
DMP142	14.2	7.95	●	●	2.16	TID*140...
DMP143	14.3	7.95	●	●	2.17	TID*140...
DMP144	14.4	7.95	●	●	2.19	TID*140...
DMP145	14.5	7.95	●	●	2.21	TID*145...
DMP146	14.6	7.95	●	●	2.23	TID*145...
DMP147	14.7	7.95	●	●	2.25	TID*145...
DMP148	14.8	7.95	●	●	2.27	TID*145...
DMP149	14.9	7.95	●	●	2.28	TID*145...
DMP150	15	8.53	●	●	2.27	TID*150...
DMP151	15.1	8.53	●	●	2.29	TID*150...
DMP152	15.2	8.53	●	●	2.31	TID*150...
DMP153	15.3	8.53	●	●	2.32	TID*150...
DMP154	15.4	8.53	●	●	2.34	TID*150...
DMP155	15.5	8.53	●	●	2.36	TID*150...
DMP156	15.6	8.53	●	●	2.38	TID*150...
DMP157	15.7	8.53	●	●	2.4	TID*150...
DMP158	15.8	8.53	●	●	2.42	TID*150...
DMP159	15.9	8.53	●	●	2.43	TID*150...
DMP160	16	9.1	●	●	2.42	TID*160...

Bezeichnung	DC	LPR	beschichtet		PL	Halter
			AH725	AH9130		
DMP161	16.1	9.1	●	●	2.44	TID*160...
DMP162	16.2	9.1	●	●	2.46	TID*160...
DMP163	16.3	9.1	●	●	2.47	TID*160...
DMP164	16.4	9.1	●	●	2.49	TID*160...
DMP165	16.5	9.1	●	●	2.51	TID*160...
DMP166	16.6	9.1	●	●	2.53	TID*160...
DMP167	16.7	9.1	●	●	2.55	TID*160...
DMP168	16.8	9.1	●	●	2.57	TID*160...
DMP169	16.9	9.1	●	●	2.58	TID*160...
DMP170	17	9.7	●	●	2.59	TID*170...
DMP171	17.1	9.7	●	●	2.61	TID*170...
DMP172	17.2	9.7	●	●	2.63	TID*170...
DMP173	17.3	9.7	●	●	2.64	TID*170...
DMP174	17.4	9.7	●	●	2.66	TID*170...
DMP175	17.5	9.7	●	●	2.68	TID*170...
DMP176	17.6	9.7	●	●	2.7	TID*170...
DMP177	17.7	9.7	●	●	2.72	TID*170...
DMP178	17.8	9.7	●	●	2.74	TID*170...
DMP179	17.9	9.7	●	●	2.75	TID*170...
DMP180	18	10.3	●	●	2.73	TID*180...
DMP181	18.1	10.3	●	●	2.75	TID*180...
DMP182	18.2	10.3	●	●	2.77	TID*180...
DMP183	18.3	10.3	●	●	2.78	TID*180...
DMP184	18.4	10.3	●	●	2.8	TID*180...
DMP185	18.5	10.3	●	●	2.82	TID*180...
DMP186	18.6	10.3	●	●	2.84	TID*180...
DMP187	18.7	10.3	●	●	2.86	TID*180...
DMP188	18.8	10.3	●	●	2.88	TID*180...
DMP189	18.9	10.3	●	●	2.89	TID*180...
DMP190	19	10.8	●	●	2.88	TID*190...
DMP1905	19.05	10.8	●	●	2.89	TID*190...
DMP191	19.1	10.8	●	●	2.9	TID*190...
DMP192	19.2	10.8	●	●	2.92	TID*190...
DMP1927	19.27	10.8	●	●	2.93	TID*190...
DMP193	19.3	10.8	●	●	2.93	TID*190...
DMP194	19.4	10.8	●	●	2.95	TID*190...
DMP195	19.5	10.8	●	●	2.97	TID*190...
DMP196	19.6	10.8	●	●	2.99	TID*190...
DMP197	19.7	10.8	●	●	3.01	TID*190...
DMP198	19.8	10.8	●	●	3.03	TID*190...
DMP199	19.9	10.8	●	●	3.04	TID*190...
DMP200	20	11.4	●	●	3.02	TID*200...
DMP201	20.1	11.4	●	●	3.04	TID*200...
DMP202	20.2	11.4	●	●	3.06	TID*200...
DMP203	20.3	11.4	●	●	3.07	TID*200...
DMP204	20.4	11.4	●	●	3.09	TID*200...
DMP205	20.5	11.4	●	●	3.11	TID*200...

ø4 - ø19.9 = 2 Stück pro Paket
ø20 - ø25.9 = 1 Stück pro Paket

● : Lagerstandard

P	Stahl	☆	★
M	Rostfreier Stahl	☆	★
K	Gusseisen	☆	★
N	Nichteisenmetalle	☆	★
S	Superlegierungen	☆	★
H	Harte Materialien	☆	★

Bezeichnung	DC	LPR	beschichtet		PL	Halter
			AH725	AH9130		
DMP206	20.6	11.4	●	●	3.13	TID*200...
DMP207	20.7	11.4	●	●	3.15	TID*200...
DMP208	20.8	11.4	●	●	3.17	TID*200...
DMP209	20.9	11.4	●	●	3.18	TID*200...
DMP210	21	11.98	●	●	3.18	TID*210...
DMP211	21.1	11.98	●	●	3.2	TID*210...
DMP212	21.2	11.98	●	●	3.22	TID*210...
DMP213	21.3	11.98	●	●	3.23	TID*210...
DMP214	21.4	11.98	●	●	3.25	TID*210...
DMP215	21.5	11.98	●	●	3.27	TID*210...
DMP216	21.6	11.98	●	●	3.29	TID*210...
DMP217	21.7	11.98	●	●	3.31	TID*210...
DMP218	21.8	11.98	●	●	3.33	TID*210...
DMP219	21.9	11.98	●	●	3.34	TID*210...
DMP220	22	12.56	●	●	3.32	TID*220...
DMP221	22.1	12.56	●	●	3.34	TID*220...
DMP222	22.2	12.56	●	●	3.36	TID*220...
DMP223	22.3	12.56	●	●	3.37	TID*220...
DMP224	22.4	12.56	●	●	3.39	TID*220...
DMP225	22.5	12.56	●	●	3.41	TID*220...
DMP226	22.6	12.56	●	●	3.43	TID*220...
DMP227	22.7	12.56	●	●	3.45	TID*220...
DMP228	22.8	12.56	●	●	3.47	TID*220...
DMP229	22.9	12.56	●	●	3.48	TID*220...
DMP230	23	13.13	●	●	3.46	TID*230...
DMP231	23.1	13.13	●	●	3.48	TID*230...
DMP232	23.2	13.13	●	●	3.5	TID*230...
DMP233	23.3	13.13	●	●	3.51	TID*230...
DMP234	23.4	13.13	●	●	3.53	TID*230...
DMP235	23.5	13.13	●	●	3.55	TID*230...
DMP236	23.6	13.13	●	●	3.57	TID*230...
DMP237	23.7	13.13	●	●	3.59	TID*230...
DMP238	23.8	13.13	●	●	3.61	TID*230...
DMP239	23.9	13.13	●	●	3.62	TID*230...
DMP240	24	13.7	●	●	3.62	TID*240...
DMP241	24.1	13.7	●	●	3.64	TID*240...
DMP242	24.2	13.7	●	●	3.66	TID*240...
DMP243	24.3	13.7	●	●	3.67	TID*240...
DMP244	24.4	13.7	●	●	3.69	TID*240...
DMP245	24.5	13.7	●	●	3.71	TID*240...
DMP246	24.6	13.7	●	●	3.73	TID*240...
DMP247	24.7	13.7	●	●	3.75	TID*240...
DMP248	24.8	13.7	●	●	3.77	TID*240...
DMP249	24.9	13.7	●	●	3.78	TID*240...
DMP250	25	14.3	●	●	3.8	TID*250...
DMP251	25.1	14.3	●	●	3.82	TID*250...
DMP252	25.2	14.3	●	●	3.84	TID*250...

ø4 - ø19.9 = 2 Stück pro Paket
 ø20 - ø25.9 = 1 Stück pro Paket

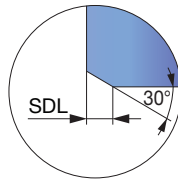
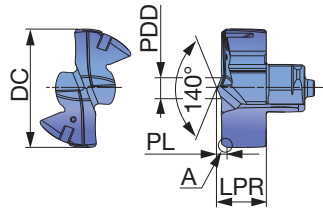
P	Stahl	☆	★
M	Rostfreier Stahl	☆	★
K	Gusseisen	☆	★
N	Nichteisenmetalle	☆	★
S	Superlegierungen	☆	★
H	Harte Materialien	☆	★

★ : Erste Wahl
 ☆ : Zweite Wahl

Bezeichnung	DC	LPR	beschichtet		PL	Halter
			AH725	AH9130		
DMP253	25.3	14.3	●	●	3.85	TID*250...
DMP254	25.4	14.3	●	●	3.87	TID*250...
DMP255	25.5	14.3	●	●	3.89	TID*250...
DMP256	25.6	14.3	●	●	3.91	TID*250...
DMP2567	25.67	14.3	●	●	3.92	TID*250...
DMP257	25.7	14.3	●	●	3.93	TID*250...
DMP258	25.8	14.3	●	●	3.95	TID*250...
DMP259	25.9	14.3	●	●	3.96	TID*250...

● : Lagerstandard

DMF Flache Kopfgeometrie



Detail in A

Werkzeug Durchmesser	Toleranz beim Kopf-Ø
ø6 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0

P	Stahl	★		
M	Rostfreier Stahl	★		
K	Gusseisen	★		
N	Nichteisenmetalle	☆		
S	Superlegierungen	★		
H	Harte Materialien	★		

P	Stahl	★		
M	Rostfreier Stahl	★		
K	Gusseisen	★		
N	Nichteisenmetalle	☆		
S	Superlegierungen	★		
H	Harte Materialien	★		

★ : Erste Wahl
☆ : Zweite Wahl

Bezeichnung	DC	LPR	Beschichtet		SDL	PL	PDD	Halter
			AH9130					
DMF060	6	3.01	●		0.4	0.61	1.15	TID*060...
DMF061	6.1	3.01	●		0.4	0.61	1.15	TID*060...
DMF062	6.2	3.01	●		0.4	0.61	1.15	TID*060...
DMF063	6.3	3.01	●		0.4	0.61	1.15	TID*060...
DMF064	6.4	3.01	●		0.4	0.61	1.15	TID*060...
DMF065	6.5	3.28	●		0.4	0.68	1.54	TID*065...
DMF066	6.6	3.28	●		0.4	0.68	1.54	TID*065...
DMF067	6.7	3.28	●		0.4	0.68	1.54	TID*065...
DMF068	6.8	3.28	●		0.4	0.68	1.54	TID*065...
DMF069	6.9	3.28	●		0.4	0.68	1.54	TID*065...
DMF070	7	3.58	●		0.4	0.68	1.54	TID*070...
DMF071	7.1	3.58	●		0.4	0.68	1.54	TID*070...
DMF072	7.2	3.58	●		0.4	0.68	1.54	TID*070...
DMF073	7.3	3.58	●		0.4	0.68	1.54	TID*070...
DMF074	7.4	3.58	●		0.4	0.68	1.54	TID*070...
DMF075	7.5	3.58	●		0.4	0.68	1.54	TID*075...
DMF076	7.6	3.58	●		0.4	0.68	1.54	TID*075...
DMF078	7.8	3.58	●		0.4	0.68	1.54	TID*075...
DMF079	7.9	3.58	●		0.4	0.68	1.54	TID*075...
DMF080	8	4.39	●		0.7	1.09	2.44	TID*080...
DMF081	8.1	4.39	●		0.7	1.09	2.44	TID*080...
DMF082	8.2	4.39	●		0.7	1.09	2.44	TID*080...
DMF083	8.3	4.39	●		0.7	1.09	2.44	TID*080...
DMF084	8.4	4.39	●		0.7	1.09	2.44	TID*080...
DMF085	8.5	4.39	●		0.7	1.09	2.44	TID*085...
DMF086	8.6	4.39	●		0.7	1.09	2.44	TID*085...
DMF087	8.7	4.39	●		0.7	1.09	2.44	TID*085...
DMF088	8.8	4.39	●		0.7	1.09	2.44	TID*085...
DMF089	8.9	4.39	●		0.7	1.09	2.44	TID*085...
DMF090	9	4.61	●		0.7	1.11	2.55	TID*090...
DMF091	9.1	4.61	●		0.7	1.11	2.55	TID*090...
DMF092	9.2	4.61	●		0.7	1.11	2.55	TID*090...
DMF093	9.3	4.61	●		0.7	1.11	2.55	TID*090...
DMF094	9.4	4.61	●		0.7	1.11	2.55	TID*090...
DMF095	9.5	4.61	●		0.7	1.11	2.55	TID*095...
DMF096	9.6	4.61	●		0.7	1.11	2.55	TID*095...
DMF097	9.7	4.61	●		0.7	1.11	2.55	TID*095...

Bezeichnung	DC	LPR	Beschichtet		SDL	PL	PDD	Halter
			AH9130					
DMF098	9.8	4.61	●		0.7	1.11	2.55	TID*095...
DMF099	9.9	4.61	●		0.7	1.11	2.55	TID*095...
DMF100	10	4.72	●		0.7	1.17	2.89	TID*100...
DMF101	10.1	4.72	●		0.7	1.17	2.89	TID*100...
DMF102	10.2	4.72	●		0.7	1.17	2.89	TID*100...
DMF103	10.3	4.72	●		0.7	1.17	2.89	TID*100...
DMF104	10.4	4.72	●		0.7	1.17	2.89	TID*100...
DMF105	10.5	4.72	●		0.7	1.17	2.89	TID*105...
DMF106	10.6	4.72	●		0.7	1.17	2.89	TID*105...
DMF107	10.7	4.72	●		0.7	1.17	2.89	TID*105...
DMF108	10.8	4.72	●		0.7	1.17	2.89	TID*105...
DMF109	10.9	4.72	●		0.7	1.17	2.89	TID*105...
DMF110	11	4.9	●		0.7	1.25	2.98	TID*110...
DMF111	11.1	4.9	●		0.7	1.25	2.98	TID*110...
DMF112	11.2	4.9	●		0.7	1.25	2.98	TID*110...
DMF113	11.3	4.9	●		0.7	1.25	2.98	TID*110...
DMF114	11.4	4.9	●		0.7	1.25	2.98	TID*110...
DMF115	11.5	4.9	●		0.7	1.25	2.98	TID*115...
DMF116	11.6	4.9	●		0.7	1.25	2.98	TID*115...
DMF117	11.7	4.9	●		0.7	1.25	2.98	TID*115...
DMF118	11.8	4.9	●		0.7	1.25	2.98	TID*115...
DMF119	11.9	4.9	●		0.7	1.25	2.98	TID*115...
DMF120	12	5.21	●		0.7	1.26	3.13	TID*120...
DMF121	12.1	5.21	●		0.7	1.26	3.13	TID*120...
DMF122	12.2	5.21	●		0.7	1.26	3.13	TID*120...
DMF123	12.3	5.21	●		0.7	1.26	3.13	TID*120...
DMF124	12.4	5.21	●		0.7	1.26	3.13	TID*120...
DMF125	12.5	5.21	●		0.7	1.26	3.13	TID*125...
DMF126	12.6	5.21	●		0.7	1.26	3.13	TID*125...
DMF127	12.7	5.21	●		0.7	1.26	3.13	TID*125...
DMF128	12.8	5.21	●		0.7	1.26	3.13	TID*125...
DMF129	12.9	5.21	●		0.7	1.26	3.13	TID*125...
DMF130	13	5.53	●		0.7	1.28	3.52	TID*130...
DMF131	13.1	5.53	●		0.7	1.28	3.52	TID*130...
DMF132	13.2	5.53	●		0.7	1.28	3.52	TID*130...
DMF133	13.3	5.53	●		0.7	1.28	3.52	TID*130...
DMF134	13.4	5.53	●		0.7	1.28	3.52	TID*130...

● : Lagerstandard

ø6 - ø19.9 = 2 Stück pro Paket
ø20 - ø25.9 = 1 Stück pro Paket

P	Stahl	★		
M	Rostfreier Stahl	★		
K	Gusseisen	★		
N	Nichteisenmetalle	☆		
S	Superlegierungen	★		
H	Harte Materialien	★		

P	Stahl	★		
M	Rostfreier Stahl	★		
K	Gusseisen	★		
N	Nichteisenmetalle	☆		
S	Superlegierungen	★		
H	Harte Materialien	★		

★ : Erste Wahl
☆ : Zweite Wahl

Bezeichnung	DC	LPR	beschichtet		SDL	PL	PDD	Halter
			AH9130					
DMF135	13.5	5.53	●		0.7	1.28	3.52	TID*135...
DMF136	13.6	5.53	●		0.7	1.28	3.52	TID*135...
DMF137	13.7	5.53	●		0.7	1.28	3.52	TID*135...
DMF138	13.8	5.53	●		0.7	1.28	3.52	TID*135...
DMF139	13.9	5.53	●		0.7	1.28	3.52	TID*135...
DMF140	14	5.96	●		0.7	1.31	3.81	TID*140...
DMF141	14.1	5.96	●		0.7	1.31	3.81	TID*140...
DMF142	14.2	5.96	●		0.7	1.31	3.81	TID*140...
DMF143	14.3	5.96	●		0.7	1.31	3.81	TID*140...
DMF144	14.4	5.96	●		0.7	1.31	3.81	TID*140...
DMF145	14.5	5.96	●		0.7	1.31	3.81	TID*145...
Neu DMF146	14.6	5.96	●		0.7	1.31	3.81	TID*145...
Neu DMF147	14.7	5.96	●		0.7	1.31	3.81	TID*145...
Neu DMF148	14.8	5.96	●		0.7	1.31	3.81	TID*145...
Neu DMF149	14.9	5.96	●		0.7	1.31	3.81	TID*145...
DMF150	15	6.43	●		0.7	1.35	4.24	TID*150...
Neu DMF151	15.1	6.43	●		0.7	1.35	4.24	TID*150...
DMF152	15.2	6.43	●		0.7	1.35	4.24	TID*150...
Neu DMF153	15.3	6.43	●		0.7	1.35	4.24	TID*150...
Neu DMF154	15.4	6.43	●		0.7	1.35	4.24	TID*150...
DMF155	15.5	6.43	●		0.7	1.35	4.24	TID*150...
Neu DMF156	15.6	6.43	●		0.7	1.35	4.24	TID*150...
DMF157	15.7	6.43	●		0.7	1.35	4.24	TID*150...
DMF158	15.8	6.43	●		0.7	1.35	4.24	TID*150...
Neu DMF159	15.9	6.43	●		0.7	1.35	4.24	TID*150...
DMF160	16	6.84	●		0.7	1.39	4.06	TID*160...
DMF161	16.1	6.84	●		0.7	1.39	4.06	TID*160...
Neu DMF162	16.2	6.84	●		0.7	1.39	4.06	TID*160...
Neu DMF163	16.3	6.84	●		0.7	1.39	4.06	TID*160...
Neu DMF164	16.4	6.84	●		0.7	1.39	4.06	TID*160...
DMF165	16.5	6.84	●		0.7	1.39	4.06	TID*160...
Neu DMF166	16.6	6.84	●		0.7	1.39	4.06	TID*160...
DMF167	16.7	6.84	●		0.7	1.39	4.06	TID*160...
Neu DMF168	16.8	6.84	●		0.7	1.39	4.06	TID*160...
Neu DMF169	16.9	6.84	●		0.7	1.39	4.06	TID*160...
DMF170	17	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF171	17.1	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF172	17.2	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF173	17.3	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF174	17.4	7.15	●		0.7	1.4	4.14	TID*170...
DMF175	17.5	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF176	17.6	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF177	17.7	7.15	●		0.7	1.4	4.14	TID*170...
Neu DMF178	17.8	7.15	●		0.7	1.4	4.14	TID*170...
DMF179	17.9	7.15	●		0.7	1.4	4.14	TID*170...
DMF180	18	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF181	18.1	7.45	●		0.7	1.42	4.16	TID*180...

Bezeichnung	DC	LPR	beschichtet		SDL	PL	PDD	Halter
			AH9130					
DMF182	18.2	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF183	18.3	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF184	18.4	7.45	●		0.7	1.42	4.16	TID*180...
DMF185	18.5	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF186	18.6	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF187	18.7	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF188	18.8	7.45	●		0.7	1.42	4.16	TID*180...
Neu DMF189	18.9	7.45	●		0.7	1.42	4.16	TID*180...
DMF190	19	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF191	19.1	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF192	19.2	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF193	19.3	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF194	19.4	7.79	●		0.7	1.44	4.25	TID*190...
DMF195	19.5	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF196	19.6	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF197	19.7	7.79	●		0.7	1.44	4.25	TID*190...
DMF198	19.8	7.79	●		0.7	1.44	4.25	TID*190...
Neu DMF199	19.9	7.79	●		0.7	1.44	4.25	TID*190...
DMF200	20	9.12	●		0.7	1.77	6.56	TID*200...
DMF205	20.5	9.12	●		0.7	1.77	6.56	TID*200...
DMF210	21	9.54	●		0.7	1.79	6.92	TID*210...
DMF215	21.5	9.54	●		0.7	1.79	6.92	TID*210...
DMF218	21.8	9.54	●		0.7	1.79	6.92	TID*210...
DMF220	22	9.86	●		0.7	1.81	7.13	TID*220...
DMF225	22.5	9.86	●		0.7	1.81	7.13	TID*220...
DMF230	23	10.28	●		0.7	1.83	7.42	TID*230...
DMF235	23.5	10.28	●		0.7	1.83	7.42	TID*230...
DMF240	24	10.71	●		0.7	1.86	7.45	TID*240...
DMF245	24.5	10.71	●		0.7	1.86	7.45	TID*240...
DMF250	25	11.15	●		0.7	1.9	7.54	TID*250...
DMF254	25.4	11.15	●		0.7	1.9	7.54	TID*250...
DMF255	25.5	11.15	●		0.7	1.9	7.54	TID*250...
DMF259	25.9	11.15	●		0.7	1.9	7.54	TID*250...

● : Neues Produkt
● : Lagerstandard

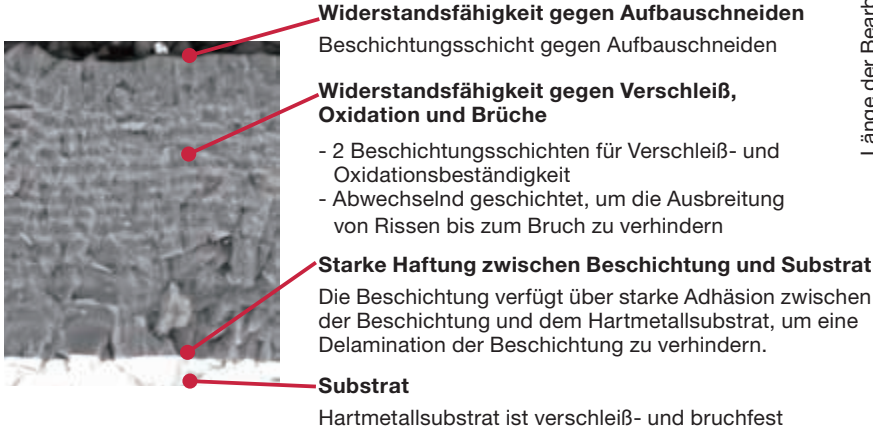
ø6 - ø19.9 = 2 Stück pro Paket
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Sorte

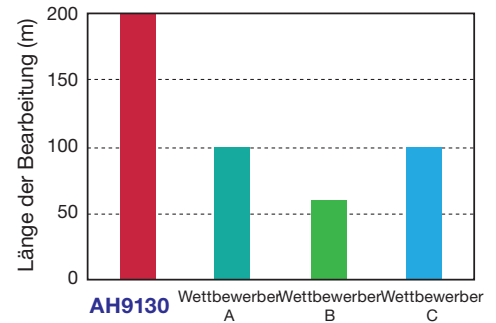
Neueste Beschichtung optimiert für längere Standzeiten

AH9130

- Die einzigartige Nano-Multilayer-Beschichtung wird durch die neueste Beschichtungstechnologie von Tungaloy ermöglicht und bietet 3 Hauptmerkmale
- Diese Beschichtung erreicht eine sehr ausgewogene Verschleiß- und Spanfestigkeit, ist säurebeständig, lösungsbeständig und hat eine hohe Haftfestigkeit.



Standzeit bei der Bearbeitung von Kohlenstoffstahl (S55C / C55)



- P** Werkzeug : $\phi 14$ mm, L/D = 5
 Schnittgeschw. : $V_c = 100$ m/min
 Vorschub : $f = 0.25$ mm/U
 Bohrtiefe : $H = 60$ mm (Sackloch)

STANDARD SCHNITTDATEN

ISO	Werkstoff	Schnittgeschwind. Vc (m/min)	Vorschub: f (mm/Umdrehung)										
			Werkzeugdurchmesser: DC (mm)										
			$\phi 4 - 4.4$	$\phi 4.5 - 4.9$	$\phi 5 - 5.9$	$\phi 6 - 7.9$	$\phi 8 - 9.9$	$\phi 10 - \phi 11.9$	$\phi 12 - \phi 13.9$	$\phi 14 - \phi 15.9$	$\phi 16 - \phi 19.9$	$\phi 20 - \phi 25.9$	
P	Stähle mit niedrigem Kohlenstoffgehalt (C < 0,3) SS400, SM490, S25C, usw. C15E4, E275A, E355D, usw.	80 - 140	0.04 - 0.07	0.04 - 0.08	0.07 - 0.13	0.09 - 0.13	0.12 - 0.25	0.15 - 0.28	0.18 - 0.3	0.20 - 0.35	0.25 - 0.45	0.25 - 0.45	
	Hochgekohlte Stähle (C > 0,3) S45C, S55C, usw. C45, C55, usw.	70 - 120	0.04 - 0.07	0.04 - 0.08	0.07 - 0.13	0.09 - 0.13	0.12 - 0.25	0.15 - 0.28	0.18 - 0.3	0.2 - 0.35	0.25 - 0.45	0.25 - 0.45	
	Niedrig legierte Stähle SCM415, usw. 18CrMo4, usw.	70 - 120	0.04 - 0.06	0.05 - 0.08	0.07 - 0.13	0.08 - 0.13	0.11 - 0.25	0.14 - 0.28	0.16 - 0.32	0.18 - 0.35	0.23 - 0.4	0.25 - 0.45	
	Legierte Stähle SCM440, SCr420, usw. 42CrMo4, 20Cr4, usw.	40 - 90	0.04 - 0.07	0.05 - 0.08	0.07 - 0.13	0.08 - 0.13	0.11 - 0.25	0.14 - 0.28	0.16 - 0.32	0.18 - 0.35	0.23 - 0.4	0.25 - 0.45	
M	Rostfreie Stähle SUS304, SUS316, usw. X5CrNi18-9, X5CrNiMo17-12-2, usw.	30 - 70	-	-	0.04 - 0.08	0.08 - 0.1	0.1 - 0.15	0.12 - 0.18	0.14 - 0.2	0.16 - 0.24	0.16 - 0.26	0.18 - 0.3	
K	Grauguss-Eisen FC250, usw. GG25, usw.	80 - 180	0.04 - 0.08	0.04 - 0.08	0.1 - 0.15	0.12 - 0.18	0.15 - 0.3	0.20 - 0.35	0.25 - 0.4	0.3 - 0.45	0.35 - 0.55	0.35 - 0.6	
	Kugelgraphitguss FCD700, usw. GGG70, usw.	80 - 140	0.04 - 0.08	0.04 - 0.08	0.1 - 0.15	0.12 - 0.18	0.15 - 0.3	0.20 - 0.35	0.25 - 0.4	0.3 - 0.45	0.35 - 0.55	0.35 - 0.6	
N	Aluminium-Legierungen ADC12, usw. AlSi11Cu3, usw.	80 - 220	-	-	-	0.1 - 0.2	0.2 - 0.35	0.25 - 0.4	0.3 - 0.45	0.35 - 0.5	0.4 - 0.6	0.5 - 0.75	
S	Titan-Legierungen Ti-6Al-4V, usw.	20 - 50	-	-	-	0.05 - 0.07	0.06 - 0.12	0.08 - 0.15	0.1 - 0.28	0.12 - 0.2	0.14 - 0.22	0.18 - 0.27	
	Nickel-Basis-Legierungen	20 - 50	-	-	-	0.05 - 0.07	0.06 - 0.11	0.08 - 0.13	0.1 - 0.15	0.12 - 0.18	0.12 - 0.22	0.14 - 0.22	
H	Gehärteter Stahl	20 - 50	-	-	-	0.05 - 0.07	0.06 - 0.12	0.08 - 0.15	0.1 - 0.18	0.12 - 0.2	0.14 - 0.22	0.16 - 0.25	

- Die Schnittdaten in der obigen Tabelle zeigen die Standardschnittdaten.
- Die Schnittdaten können sich aufgrund der Steifigkeit und Leistung der Maschine und des Werkstoffs ändern.
- Der Durchmesser der bearbeiteten Bohrung kann sich je nach Steifigkeit der Werkzeugmaschine oder den Schnittbedingungen ändern.



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Überreicht durch:



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November 2024 (TG)